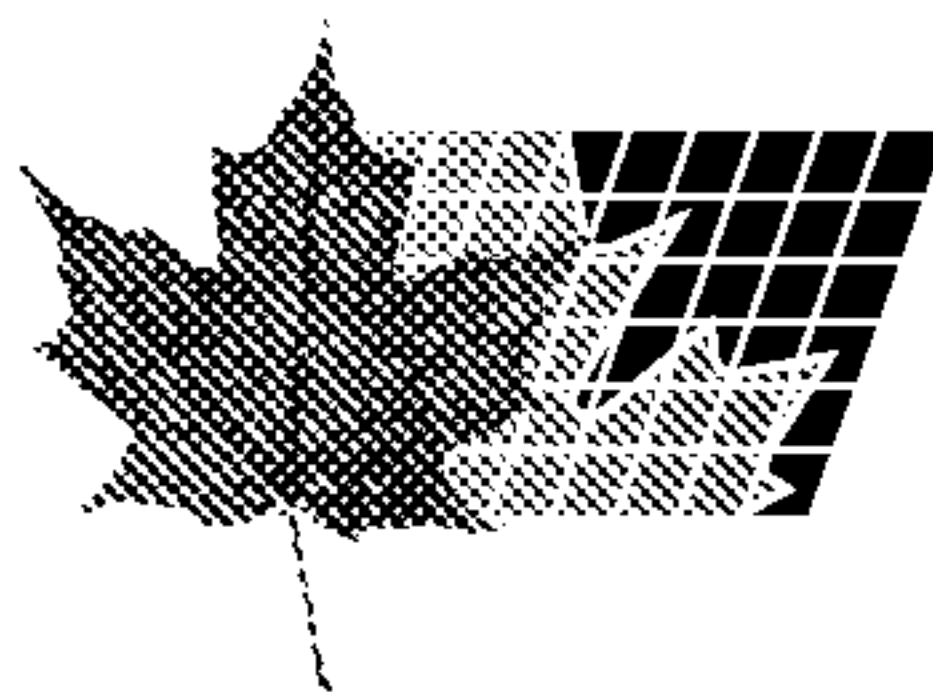




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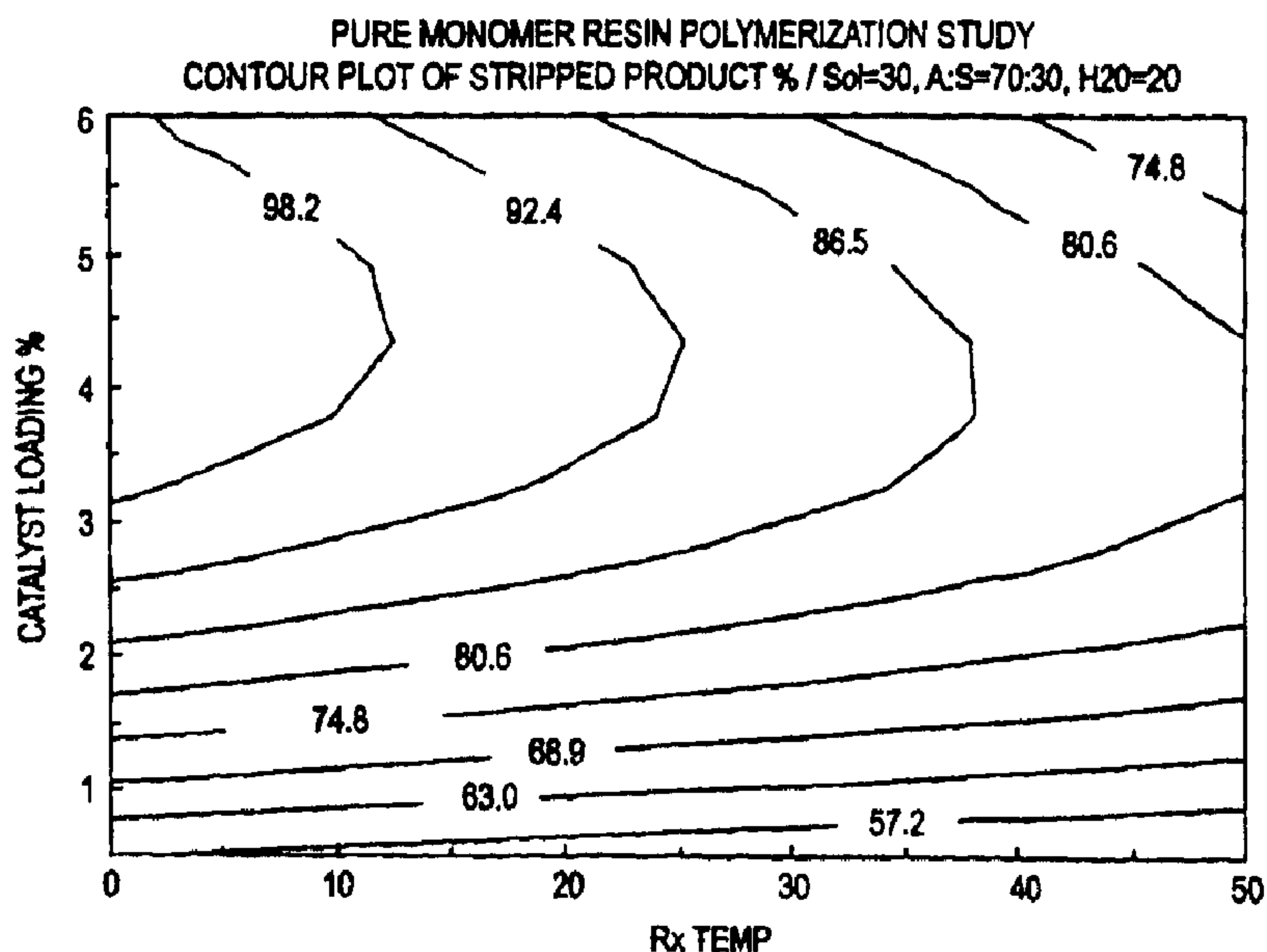
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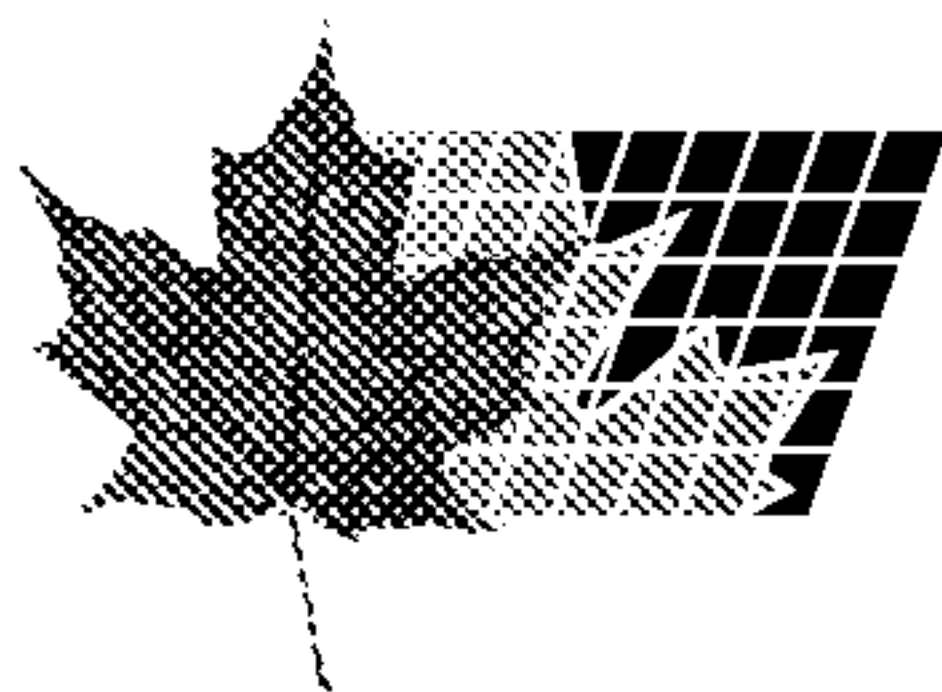
(54) **ACIDES SOLIDES UTILISES COMME CATALYSEURS POUR
LA PREPARATION DE RESINES D'HYDROCARBURE**

(54) **SOLID ACIDS AS CATALYSTS FOR THE PREPARATION OF
HYDROCARBON RESINS**



(57) On utilise des acides solides en tant que catalyseurs servant à la polymérisation d'un flux d'alimentation contenant au moins un monomère pur, des monomères C5 et des monomères C9, afin de produire des résines d'hydrocarbure. On peut enlever du catalyseur acide solide l'eau associée librement à celui-ci, avant utilisation du catalyseur. On peut préparer des résines à points de ramollissement (déterminés par la méthode bille et anneau) se situant dans la plage comprise entre environ 5 et 170 °C. Ces catalyseurs présentent des avantages sur les catalyseurs classiques de polymérisation de Friedel-Crafts, en ce que leurs sites

(57) Solid acids are used as catalysts for the polymerization of a feed stream containing at least one of pure monomer, C5 monomers, and C9 monomers to produce hydrocarbon resins. Freely-associated water may be removed from the solid acid catalyst prior to use. Resins with softening points (Ring and Ball) in the range of about 5 °C to 170 °C can be prepared. These catalysts offer advantages over the traditional Friedel-Crafts polymerisation catalysts since the acid sites are an integral part of the solid. The solid acid catalysts are relatively nonhazardous, reusable catalysts which eliminate or at least reduce contamination of the



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acides font partie intégrante du solide. Ces catalyseurs acides solides sont relativement non dangereux et réutilisables, et ils permettent de supprimer ou au moins de diminuer la contamination des produits résineux résultants par des restes acides ou des sous-produits.

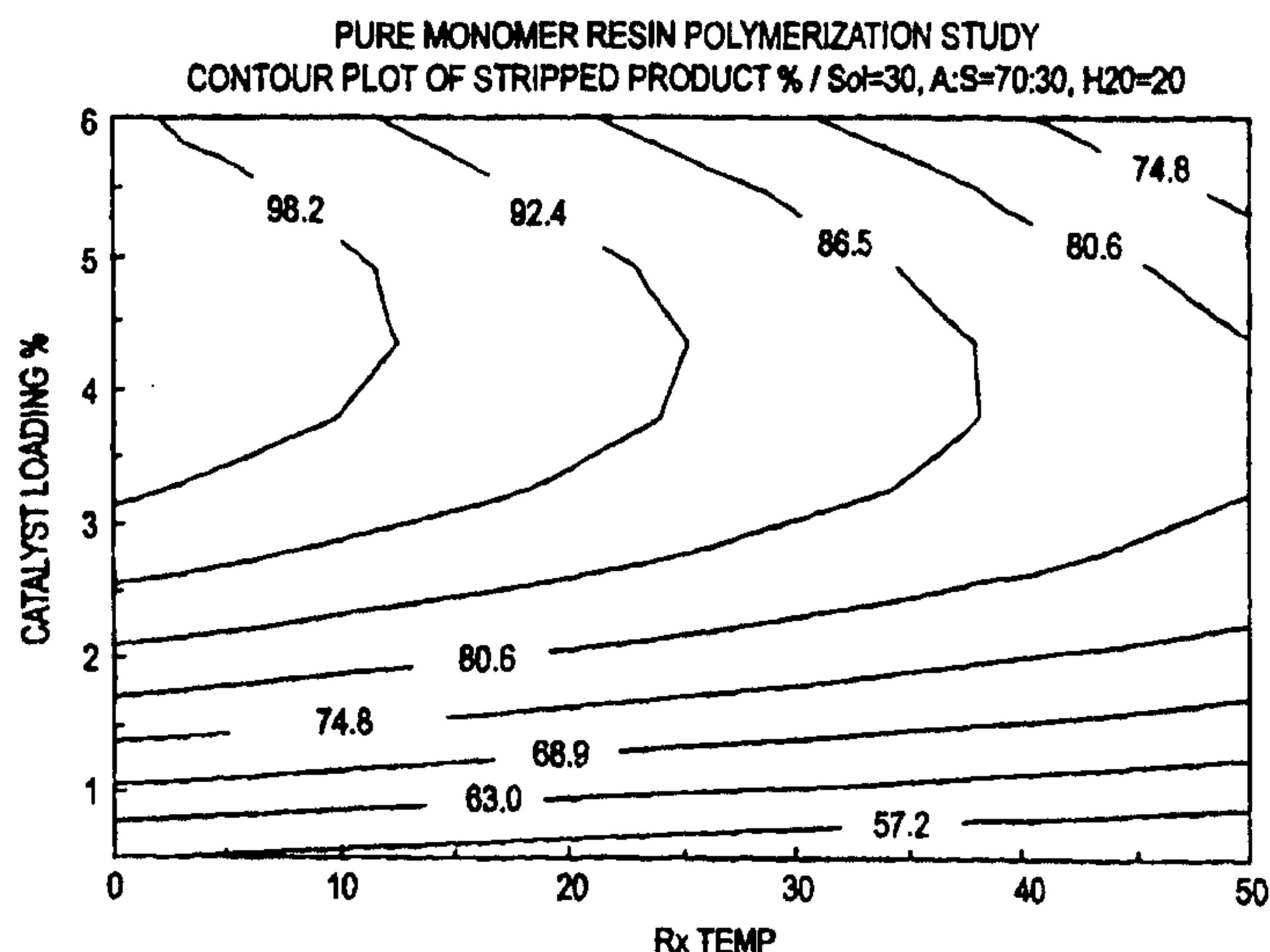
resulting resin products with acid residues or by-products.

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(54) Title: SOLID ACIDS AS CATALYSTS FOR THE PREPARATION OF HYDROCARBON RESINS



(57) Abstract

Solid acids are used as catalysts for the polymerization of a feed stream containing at least one of pure monomer, C5 monomers, and C9 monomers to produce hydrocarbon resins. Freely-associated water may be removed from the solid acid catalyst prior to use. Resins with softening points (Ring and Ball) in the range of about 5 °C to 170 °C can be prepared. These catalysts offer advantages over the traditional Friedel-Crafts polymerisation catalysts since the acid sites are an integral part of the solid. The solid acid catalysts are relatively nonhazardous, reusable catalysts which eliminate or at least reduce contamination of the resulting resin products with acid residues or by-products.

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SOLID ACIDS AS CATALYSTS FOR THE PREPARATION OF HYDROCARBON RESINS

CROSS-REFERENCE TO RELATED APPLICATIONS

The present application claims the priority under 35 U.S.C. §119(e) of U.S. Provisional Application No. 60/035,217, filed January 8, 1997; U.S. Provisional Application No. 60/034,579, filed January 9, 1997; and U.S. Provisional Application No. 60/035,797, filed January 10, 1997; the disclosures of which are expressly incorporated by reference herein in their entirety.

BACKGROUND OF THE INVENTION

1. Field of the Invention

This invention relates to solid acids useful as catalysts for the polymerization of a feed stream containing at least one of pure monomer, C5 monomers, and C9 monomers to produce a hydrocarbon resin, to processes of preparing hydrocarbon resins using solid acid catalysts, and to hydrocarbon resins produced by such processes.

2. Discussion of Background

Hydrocarbon resins are low molecular weight, thermoplastic materials prepared via thermal or catalytic polymerization. The resins may be derived from several different sources of monomers. The monomer sources include cracked petroleum distillate from oil refining, turpentine fractions (e.g., terpenes from natural product distillation), paper mill by-product streams, coal tar, and a variety of pure olefinic monomers.

The resulting hydrocarbon resins can range from viscous liquids to hard, brittle solids with colors ranging from water white to pale yellow, amber, or dark brown depending on the monomers used and the specific reaction conditions. Typically, pure monomer resins tend to be water white, C9 monomer resins tend to be brown, and C5 monomer resins tend to be yellow.

Hydrocarbon resins are used extensively as modifiers in adhesives, rubber, hot-melt coatings, printing inks, paint, flooring, and other applications. The resins are usually used to modify other materials.

Pure monomer hydrocarbon resins can be prepared by cationic polymerization of styrene-based monomers such as styrene, alpha-methyl styrene, vinyl toluene, and other alkyl substituted styrenes using Friedel-Crafts polymerization catalysts such as Lewis acids

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(e.g., boron trifluoride (BF_3), complexes of boron trifluoride, aluminum trichloride (AlCl_3), alkyl aluminum chlorides).

Similarly, aliphatic C5 hydrocarbon resins can be prepared by cationic polymerization of a cracked petroleum feed containing C5 and C6 paraffins, olefins, and diolefins also referred to as "C5 monomers". These monomer streams are comprised of cationically polymerizable monomers such as 1,3-pentadiene which is the primary reactive component along with cyclopentene, pentene, 2-methyl-2-butene, 2-methyl-2-pentene, cyclopentadiene, and dicyclopentadiene. The polymerizations are catalyzed using Friedel-Crafts polymerization catalysts such as Lewis acids (e.g., boron trifluoride (BF_3), complexes of boron trifluoride, aluminum trichloride (AlCl_3), or alkyl aluminum chlorides). In addition to the reactive components, nonpolymerizable components in the feed include saturated hydrocarbons which can be codistilled with the unsaturated components such as pentane, cyclopentane, or 2-methylpentane. This monomer feed can be copolymerized with C4 or C5 olefins or dimers as chain transfer agents.

Also, aromatic C9 hydrocarbon resins can be prepared by cationic polymerization of aromatic C8, C9, and/or C10 unsaturated monomers derived from petroleum distillates resulting from naphtha cracking and are referred to as "C9 monomers". These monomer streams are comprised of cationically polymerizable monomers such as styrene, alpha-methyl styrene, beta-methyl styrene, vinyl toluene, indene, dicyclopentadiene, divinylbenzene, and other alkyl substituted derivatives of these components. The polymerizations are catalyzed using Friedel-Crafts polymerization catalysts such as Lewis acids (e.g., boron trifluoride (BF_3), complexes of boron trifluoride, aluminum trichloride (AlCl_3), alkyl aluminum chlorides). In addition to the reactive components, nonpolymerizable components include aromatic hydrocarbons such as xylene, ethyl benzene, cumene, ethyl toluene, indane, methylindane, naphthalene and other similar species. These nonpolymerizable components of the feed stream can be incorporated into the resins via alkylation reactions.

Although Lewis acids are effective catalysts for the cationic polymerization reactions to produce hydrocarbon resins, they have several disadvantages. Conventional Lewis acids are single use catalysts which require processing steps to quench the reactions and neutralize the acids.

Further, conventional Lewis acids also require removal of catalyst salt residues from

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the resulting resin products. Once the salt residues generated from the catalyst neutralization are removed, the disposal of these residues presents an additional cost. Therefore, it is of particular interest to reduce the amount of catalyst residues, particularly halogen-containing species generated in these reactions.

5 Another problem involved in using conventional Lewis acid catalysts, such as AlCl_3 and BF_3 , is that they are hazardous materials. These conventional Lewis acid catalysts generate highly corrosive acid gases on exposure to moisture, (e.g., HF , HCl).

10 In addition to the traditional Lewis acids, work has been done with certain solid acid catalysts. BITTLES et al., "Clay-Catalyzed Reactions of Olefins. I. Polymerization of Styrene", Journal of Polymer Science: Part A, Vol. 2, pp. 1221-31 (1964) and BITTLES et al., "Clay-Catalyzed Reactions of Olefins. II. Catalyst Acidity and Measurement", Journal of Polymer Science: Part A, Vol. 2, pp. 1847-62 (1964), the disclosures of which are herein incorporated by reference in their entirety, together disclose polymerization of styrene with acid clay catalysts to obtain polymers having molecular weights between 440 and 2000 as
15 determined by freezing point depression of benzene solutions. These documents disclose that the catalyst was prepared for polymerization by heating under vacuum, and that if the catalyst adsorbed moisture, the activity of the catalyst could be restored by reheating under vacuum.

20 SALT, "The Use of Activated Clays as Catalysts in Polymerisation Processes, with Particular Reference to Polymers of Alpha Methyl Styrene", Clay Minerals Bulletin, Vol. 2, pp. 55-58 (1948), the disclosure of which is herein incorporated by reference in its entirety, discloses polymerization of styrene and/or alpha-methyl styrene by using a clay catalyst to obtain polymers that range from dimers to molecular weights of about 3000.

25 U.S. Patent No. 5,561,095 to CHEN et al., the disclosure of which is herein incorporated by reference in its entirety, discloses a supported Lewis acid catalyst for polymerization of olefins, including C3-C23 alpha-olefins, to obtain polymers having number average molecular weights (M_n) ranging from about 300 to 300,000. Exemplary Lewis acid supports include silica, silica-alumina, zeolites, and clays. Example 1 of CHEN et al. discloses that a Lewis acid supported on silica is heated under vacuum.

30 U.S. Patent No. 3,799,913 to WHEELER et al., the disclosure of which is herein incorporated by reference in its entirety, discloses Friedel-Crafts catalysts for polymerization of polymerizable constituents, including alpha-methyl styrene, indene, vinyl toluene and

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styrene, to obtain polymers having a number average molecular weight (Mn) ranging from about 350 to 1200. Zinc chloride is disclosed as one of the Friedel-Crafts catalysts.

U.S. Patent No. 3,652,707 to SAINES, the disclosure of which is herein incorporated by reference in its entirety, discloses Friedel-Crafts metal halide catalysts for polymerization of olefin hydrocarbons, including pentene, styrene and methylstyrene, to obtain polymers having a molecular weight of from about 700 to about 2500. Zinc chloride is disclosed as one of the Friedel-Crafts metal halide catalysts.

PENG et al., "Electrophilic Polymerization of 1,3-Pentadiene Initiated by Aluminum Triflate", Eur. Polym. J., Vol. 30, No. 1, pp. 69-77 (1994), the disclosure of which is herein incorporated by reference in its entirety, discloses aluminum triflate for polymerization of piperylene to obtain polymers having varying number average molecular weights.

European Patent Application 0 352 856 A1, the disclosure of which is herein incorporated by reference in its entirety, discloses use of aluminum triflate, cerium triflate, e.g., for oligomerization of C3 to C6 olefins to obtain oligomers having 6 to 24 carbon atoms.

GANDINI et al., "The Heterogeneous Cationic Polymerization of Aromatic Monomers by Aluminum Triflate", Polymer Preprints, American Chemical Society, pp. 359-360 (1996), the disclosure of which is herein incorporated by reference in its entirety, discloses use of aluminum triflate for polymerization of C9 related monomers to obtain a polymer having a number average molecular weight (Mn) around 3000. This document also discloses that aluminum triflate could be useful for the direct "resinification" of mixtures of aromatic monomers and solvents arising from specific petroleum cuts.

Other documents, the disclosures of which are incorporated by reference in their entireties, which generally disclose the use of solid acid catalysts to polymerize monomers for the preparation of resins include U.S. Patent No. 4,068,062 to LEPERT, U.S. Patent No. 4,130,701 to LEPERT, U.S. Patent No. 4,245,075 to LEPERT, and U.S. Patent No. 4,824,921 to LUVINH.

SUMMARY OF THE INVENTION

The present invention involves the preparation of hydrocarbon resins. More particularly, the present invention involves the use of solid acid catalysts to polymerize a feed of hydrocarbon monomers.

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Hydrocarbon resins are prepared from at least one of pure styrene-based monomers, C5 monomers, and aromatic C9 monomers using relatively environmentally benign, recyclable, solid acid catalysts in which freely-associated water has been removed. In the present invention, hydrocarbon resins are prepared by cationic polymerization (e.g., Friedel-Crafts) wherein a feed stream containing at least one of pure monomer, C5 monomers, and C9 monomers is preferably treated with a solid acid catalyst.

Before use, the solid acid catalysts are treated to remove freely-associated water associated with the solids to maximize catalyst acidity and activity toward the polymerization. For example, prior to use, the catalyst may be calcined for a sufficient time to remove freely-associated water and/or the catalyst can be exposed to reduced atmospheric pressure. As an example of calcination, the calcining is at a temperature up to about 700°C, preferably at a temperature between about 50°C and 500°C. The calcining may be under reduced atmospheric pressure for up to about 8 hours, preferably between about 1 hour to 4 hours.

In accordance with one aspect, the present invention is directed to a process for making a hydrocarbon resin which includes polymerizing a feed stream including at least one member selected from the group consisting of C5 monomers and C9 monomers in the presence of a solid acid catalyst to produce a hydrocarbon resin, wherein substantially all freely-associated water has been removed from the solid acid catalyst, and wherein the solid acid catalyst includes at least one member selected from the group consisting of acid activated clays, silica-alumina, amorphous silica-alumina, Brønsted acid on silica, Brønsted acid on silica-alumina, zeolites, mesoporous silica-alumina, Brønsted acid on mesoporous silica, and Brønsted acid on mesoporous silica-alumina.

In accordance with one aspect, the present invention is directed to a process for making a hydrocarbon resin which includes polymerizing a feed stream including pure monomer in the presence of a solid acid catalyst to produce a hydrocarbon resin, wherein substantially all freely-associated water has been removed from the solid acid catalyst, and wherein the solid acid catalyst includes at least one member selected from the group consisting of modified clays, Brønsted acid on clay, amorphous silica-alumina, Brønsted acid on silica, Brønsted acid on silica-alumina, zeolites, mesoporous silica-alumina, Brønsted acid on mesoporous silica, and Brønsted acid on mesoporous silica-alumina.

The acid activated clay may include naturally occurring clay mineral such as

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kaolinite, bentonite, attapulgite, montmorillonite, clarit, Fuller's earth, hectorite, or beidellite. The montmorillonite can be treated with at least one member selected from the group consisting of sulfuric acid and hydrochloric acid. The acid activated clay may include synthetic clay. The synthetic clay may include at least one member selected from the group consisting of saponite and hydrotalcite. The acid activated clay may include modified clay such as pillared clay. The pillared clay may include at least one member selected from the group consisting of aluminum oxide pillared clay, cerium modified alumina pillared clay, and metal oxide pillared clay. The acid activated clay may include Brønsted acid on clay, wherein the Brønsted acid includes at least one member selected from the group consisting of hydrofluoric acid, sulfuric acid, nitric acid, phosphoric acid, and hydrochloric acid.

For the supported Brønsted acid solid acids, the Brønsted acid may be at least one member selected from the group consisting of hydrofluoric acid, sulfuric acid, nitric acid, phosphoric acid, and hydrochloric acid.

The zeolite may include at least one member selected from the group consisting of zeolite Y, zeolite β , MFI, MEL, NaX, NaY, faujasite, and mordenite.

In accordance with another feature of the invention, the feed stream includes between about 20 wt% and 80 wt% monomers and about 80 wt% to 20 wt% of solvent. Preferably, the feed stream includes about 30 wt% to 70 wt% monomers and about 70 wt% to 30 wt% of solvent. More preferably, the feed stream includes about 50 wt% to 70 wt% monomers and about 50 wt% to 30 wt% of solvent. The solvent may include an aromatic solvent. The aromatic solvent may include at least one member selected from the group consisting of toluene, xylenes, and aromatic petroleum solvents. The solvent may include an aliphatic solvent. The invention may further include recycling the solvent.

In accordance with a feature of the invention, the feed stream includes at least C5 monomers. The feed stream may include at least C5 monomers, wherein cyclopentadiene and methylocyclopentadiene components are removed from the feed stream by heating at a temperature between about 100°C and 160°C and fractionating by distillation. The C5 monomers may include at least one member selected from the group consisting of isobutylene, 2-methyl-2-butene, 1-pentene, 2-methyl-1-pentene, 2-methyl-2-pentene, 2-pentene, cyclopentene, cyclohexene, 1,3-pentadiene, 1,4-pentadiene, isoprene, 1,3-hexadiene, 1,4-hexadiene, cyclopentadiene, and dicyclopentadiene. The feed stream may include at least C5 monomers, wherein the feed stream includes at least about 70 wt% of

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polymerizable monomers with at least about 50 wt% 1,3-pentadiene. The C5 feed stream may contain low levels of isoprene, generally contains a portion of 2-methyl-2-butene, and may contain one or more cyclodiolefins.

5 The feed stream may include at least C5 monomers, wherein the feed stream further includes up to about 40 wt% of chain transfer agent, preferably up to about 20 wt% of chain transfer agent. The chain transfer agent may include at least one member selected from the group consisting of C4 olefins, C5 olefins, dimers of C4 olefins, and dimers of C5 olefins. The chain transfer agent may include at least one member selected from the group consisting of isobutylene, 2-methyl-1-butene, 2-methyl-2-butene, dimers thereof, and oligomers
10 thereof.

In accordance with a feature of the invention, the feed stream includes about 30 wt% to 95 wt% of C5 monomers and about 70 wt% to 5 wt% of a cofeed including at least one member selected from the group consisting of pure monomer, C9 monomers, and terpenes. Preferably, the feed stream includes about 50 wt% to 85 wt% of C5 monomers and about
15 50 wt% to 15 wt% of a cofeed including at least one member selected from the group consisting of pure monomer, C9 monomers, and terpenes.

In accordance with another feature of the invention, the feed stream includes at least C9 monomers. The C9 monomers may include at least one member selected from the group consisting of styrene, vinyl toluene, indene, dicyclopentadiene, and alkylated derivatives
20 thereof. The C9 monomers may include at least about 20 wt% polymerizable unsaturated hydrocarbons. The C9 monomers may include about 30 wt% to 75 wt% polymerizable unsaturated hydrocarbons. The C9 monomers may include about 35 wt% to 70 wt% polymerizable unsaturated hydrocarbons.

In accordance with a feature of the invention, the feed stream includes about 30 wt% to 95 wt% of the C9 monomers and about 70 wt% to 5 wt% of a cofeed including at least
25 one member selected from the group consisting of pure monomer, C5 monomers, and terpenes. Preferably, the feed stream includes about 50 wt% to 85 wt% of the C9 monomers and about 50 wt% to 15 wt% of a cofeed including at least one member selected from the group consisting of pure monomer, C5 monomers, and terpenes.

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Many of the solid acid catalysts function most effectively in the presence of a controlled amount of water in the monomer feed stream. In accordance with this feature of the invention, the feed stream should include less than about 500 ppm water, preferably less than about 200 ppm water, more preferably less than about 100 ppm water, and most preferably less than about 50 ppm water.

In accordance with yet another feature of the invention, the feed stream is contacted with about 0.5 wt% to 30 wt%, preferably about 1 wt% to 20 wt%, more preferably about 3 wt% to 15 wt%, and most preferably 0.5 wt% to 5 wt% of the solid acid catalyst based on monomer weight in a batch reactor.

In accordance with a feature of the invention, the solid acid catalyst is added to the feed stream.

In accordance with another feature of the invention, the feed stream is added to a slurry of the solid acid catalyst in solvent. The feed stream may be passed over a fixed bed of the solid acid catalyst.

In accordance with yet another feature of the invention, the feed stream is cofed with a slurry of the solid acid catalyst into a reactor.

In accordance with a feature of the invention, the polymerization is carried out as a continuous process or as a batch process. A reaction time in the batch process is about 30 minutes to 8 hours, preferably about 1 hour to 4 hours at reaction temperature.

In accordance with a feature of the invention, the feed stream is polymerized at a reaction temperature between about -50°C and 150°C, preferably between about -20°C and 100°C, and more preferably between about 0°C and 70°C.

In accordance with another feature of the invention, the polymerization is stopped by removing the solid acid catalyst from the hydrocarbon resin. The solid acid catalyst may be removed from the hydrocarbon resin by filtration. The hydrocarbon resin may be removed from a fixed bed reactor which includes the solid acid catalyst.

In accordance with a feature of the invention, the hydrocarbon resin is stripped to remove unreacted monomers, solvents, and low molecular weight oligomers. The unreacted monomers, solvents, and low molecular weight oligomers may be recycled.

In accordance with a feature of the invention, the hydrocarbon resin is separated from a hydrocarbon resin solution.

In accordance with a feature of the invention, the feed stream includes at least pure

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monomer and the resulting hydrocarbon resin has a softening point as measured by ASTM-E28 "Standard Test Method for Softening Point by Ring and Ball Apparatus", between about 5°C and 170°C. The feed stream may include at least C5 monomers, wherein the softening point of the resulting hydrocarbon resin is between about 50°C and 150°C. The feed stream may include at least C9 monomers, wherein the softening point of the resulting hydrocarbon resin is between about 70°C and 160°C.

In accordance with a feature of the invention, the feed stream includes at least pure monomer, wherein the hydrocarbon resin has a number average molecular weight (Mn) ranging from about 400 to 2000, a weight average molecular weight (Mw) ranging from about 500 to 5000, a Z average molecular weight (Mz) ranging from about 500 to 10,000, and a polydispersity (PD) as measured by Mw/Mn between about 1.2 and 3.5, where Mn, Mw, and Mz are determined by size exclusion chromatography (SEC).

In accordance with a feature of the invention, the feed stream includes at least C5 monomers, wherein the hydrocarbon resin has a number average molecular weight (Mn) of about 400 to 2000, a weight average molecular weight (Mw) of about 500 to 3500, a Z average molecular weight (Mz) of about 700 to 15,000, and a polydispersity (PD) as measured by Mw/Mn between about 1.2 and 5, where Mn, Mw, and Mz are determined by size exclusion chromatography (SEC).

In accordance with another feature of the invention, the feed stream includes at least C9 monomers, wherein the hydrocarbon resin has a number average molecular weight (Mn) of about 400 to 1200, a weight average molecular weight (Mw) of about 500 to 2000, a Z average molecular weight (Mz) of about 700 to 6000, and a polydispersity (PD) as measured by Mw/Mn between about 1.2 and 3.5, preferably 1.2 and 2.5, where Mn, Mw, and Mz are determined by size exclusion chromatography (SEC).

In accordance with another feature of the invention, the hydrocarbon resin is hydrogenated.

BRIEF DESCRIPTION OF THE DRAWINGS

The present invention is further described in the detailed description which follows, in reference to the noted plurality of non-limiting drawings, and wherein:

Figures 1-5 depict contour plots generated from regression analysis of various pure monomer resin polymerizations.

Figures 6-15 depict contour plots generated from regression analysis of various C9 resin polymerizations.

DETAILED DESCRIPTION OF THE INVENTION

The particulars shown herein are by way of example and for purposes of illustrative discussion of the various embodiments of the present invention only and are presented in the cause of providing what is believed to be the most useful and readily understood description of the principles and conceptual aspects of the invention. In this regard, no attempt is made to show details of the invention in more detail than is necessary for a fundamental understanding of the invention, the description taken with the drawings making apparent to those skilled in the art how the several forms of the invention may be embodied in practice.

All percent measurements in this application, unless otherwise stated, are measured by weight based upon 100% of a given sample weight. Thus, for example, 30% represents 30 weight parts out of every 100 weight parts of the sample.

Unless otherwise stated, a reference to a compound or component, includes the compound or component by itself, as well as in combination with other compounds or components, such as mixtures of compounds.

Before further discussion, a definition of the following terms will aid in the understanding of the present invention.

SOLID ACID: a solid which changes the color of a basic Hammett indicator with a $pK_a < 0$.

HYDROCARBON RESIN: a low molecular weight (i.e., a number average molecular weight of about 200 to less than about 3000 as determined by size exclusion chromatography (SEC)) thermoplastic polymer synthesized via thermal or catalytic polymerization of cracked petroleum distillates, terpenes, coal tar fractions, or pure olefinic monomers, wherein one of the monomers is at least a C5 or higher.

PURE MONOMER: a composition comprising synthetically generated or highly purified monomer species, e.g., styrene from ethyl benzene or alpha methyl styrene from cumene.

PURE MONOMER FEED STREAM: a composition comprising any number of pure monomer species.

C5 MONOMERS: a composition derived from petroleum processing, e.g., cracking, containing unsaturated hydrocarbons comprising C5 and/or C6 olefin species boiling in the

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range from about 20°C to 100°C at atmospheric pressure.

C9 MONOMERS: a composition derived from petroleum processing, e.g., cracking, containing unsaturated aromatic C8, C9, and/or C10 olefin species with a boiling range of about 100°C to 300°C at atmospheric pressure.

5 FREELY-ASSOCIATED WATER: water associated with a solid acid catalyst where the water is chemisorbed and/or physisorbed.

As a general overview of the present invention, hydrocarbon resins are produced by using solid acids as catalysts for the cationic polymerization of a feed stream containing at least one of pure monomer (e.g., styrene based monomers), C5 monomers, and C9
10 monomers. Resins with softening points (Ring and Ball) preferably in the range of about 5°C to 170°C, more preferably about 30°C to 150°C, can be prepared. These catalysts offer advantages over the traditional Lewis acid polymerization catalysts since the acid sites are an integral part of the solid.

Looking at the present invention in more detail, hydrocarbon resins are prepared
15 through a polymerization reaction wherein a feed stream containing at least one of pure monomer, C5 monomers, and C9 monomers are contacted with a solid acid catalyst. Solid acid catalysts which are useful in the current invention include, but are not limited to, the following.

20 Clay minerals, naturally occurring

Kaolinite
Bentonite
Attapulgite
Montmorillonite
25 Clarit
Fuller's Earth
Hectorite
Beidellite

30 Synthetic Clays, for example

Saponite
Hydrotalcite

Montmorillonite Clays treated with sulfuric or hydrochloric acid

35 Modified clays (i.e., clays modified by backbone element replacement), for example
Aluminum oxide pillared clays
Cerium modified alumina pillared clays
Metal oxide pillared clays

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Brønsted acids on clay, for example

Hydrofluoric acid

Sulfuric acid

Nitric acid

Phosphoric acid

Hydrochloric acid

Silica-Aluminas, $\text{SiO}_2 \cdot \text{Al}_2\text{O}_3$

Amorphous silica-aluminas

Brønsted acids on silica or silica-alumina, for example

Hydrofluoric acid

Sulfuric acid

Nitric acid

Phosphoric acid

Hydrochloric acid

Zeolites, natural or synthetic, for example

Zeolite Y

Zeolite β (i.e., BEA)

MFI (e.g., "Zeolite Sacony Mobil-5" ("ZSM-5"))

MEL (e.g., "Zeolite Sacony Mobil-11" ("ZSM-11"))

NaX

NaY

Faujasite (i.e., FAU)

Mordenite (i.e., MOR)

Mesoporous silica-aluminas

Brønsted acids on mesoporous silica or mesoporous silica-alumina, for example

Hydrofluoric acid

Sulfuric acid

Nitric acid

Phosphoric acid

Hydrochloric acid

As mentioned previously, the above list of solid acid catalysts is not intended to be an exhaustive list. In selecting other solid acid catalysts which may be useful in the present invention, it is generally true that the solid acid catalyst should be more acidic than about -3 on the Hammett scale.

Concerning the zeolites, the names BEA, MFI, MEL, FAU, and MOR are the framework structure type IUPAC definitions of the listed species.

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Before use, the solid acid catalysts are treated to remove freely-associated water to maximize the catalyst acidity and activity toward the polymerization. The freely-associated water may be removed by various techniques, including thermal treatment, reduced pressure treatment, dry atmosphere treatment such as nitrogen or air, or a combination thereof. While not wishing to be bound by theory, removing freely-associated water maximizes the acid strength of Brønsted solid acid catalysts and makes the polymerizations more reproducible. The activity of acid-treated clay and silica-alumina is especially enhanced by removing the freely-associated water.

The freely-associated water may be removed from the solid acid catalyst by calcining which generally means heating the solid acid catalyst to high temperature without fusing the catalyst. The solid acid catalyst may be calcined under an inert atmosphere, such as nitrogen or dry air, or under reduced pressure. The calcining is performed for preferably up to about 8 hours or more, more preferably about 1 hour to 4 hours, preferably at temperatures up to about 700°C, more preferably about 100°C to 400°C.

The freely-associated water removed from the solid acid catalyst may have been derived from water (physisorbed water) or hydroxyl groups (chemisorbed water) associated with the solid acid catalyst. By removal of substantially all freely-associated water is meant removing all or essentially all physisorbed water and removing at least a majority of chemisorbed water.

It has been discovered that by controlling the conditions under which the solid acid catalyst is calcined, such as controlling the temperature or time under which the calcination step takes place, tailoring of the physical properties of the resultant resin, such as its softening point or its molecular weight, may be achieved.

Many of the solid acid catalysts of the present invention are most effective in the presence of a controlled amount of water in the feed stream. For instance, the feed stream should include less than about 500 ppm water, preferably less than about 200 ppm water, more preferably less than about 100 ppm water, and most preferably less than about 50 ppm water.

Pure monomer feed streams may contain relatively pure styrene-based monomers such as styrene, alpha-methyl styrene, beta-methyl styrene, 4-methyl styrene, and vinyl toluene fractions. The monomers can be used as pure components or as blends of two or more monomer feeds to give desired resin properties. Preferred blends include about 20

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wt% to 90 wt% alpha-methyl styrene with about 80 wt% to 10 wt% of one or more comonomers, preferably styrene, vinyl toluene, 4-methyl styrene or blends of these components. In addition, other alkylated styrenes can be used as monomers in this invention such as t-butyl styrene or phenyl styrene. Feed streams can be dried, if desired, and preferably contain less than about 200 ppm water, more preferably less than about 100 ppm water, and most preferably less than about 50 ppm water.

In the case of C5 resins, the petroleum feed streams contain unsaturated C5 and/or C6 olefins and diolefins boiling in the range from about 20°C to 100°C, preferably about 30°C to 70°C. In some cases, cyclopentadiene and methylcyclopentadiene components are removed from the feed by heat soaking at temperatures between preferably about 100°C and 160°C, and fractionating by distillation. Monomers found in these feedstocks may include but are not limited to olefins such as isobutylene, 2-methyl-2-butene, 1-pentene, 2-methyl-1-pentene, 2-methyl-2-pentene, as well as 2-pentene, cycloolefins such as cyclopentene, and cyclohexene, diolefins such as 1,3-pentadiene, 1,4-pentadiene, isoprene, 1,3-hexadiene, and 1,4-hexadiene, cyclodiolefins such as cyclopentadiene, dicyclopentadiene, and alkyl substituted derivatives and codimers of these cyclodiolefins. Commercial samples of this type of feed include, but are not limited to "Naphtha Petroleum 3 Piperylenes" from Lyondell Petrochemical Company, Houston, TX, regular "Piperylene Concentrate" or "Super Piperylene Concentrate" both from Shell Nederland Chemie B.V., Hoogvilet, the Netherlands. The C5 feed streams generally contain at least about 70 wt% polymerizable monomers with at least about 50 wt% 1,3-pentadiene. The C5 feed stream may contain low levels of isoprene, generally contains a portion of 2-methyl-2-butene, and may contain one or more cyclodiolefins.

Also concerning C5 monomer feed streams, in addition to the reactive components, nonpolymerizable components in the feed may include saturated hydrocarbons which can be codistilled with the unsaturated components such as pentane, cyclopentane, or 2-methylpentane. This monomer feed can be copolymerized with C4 or C5 olefins or dimers as chain transfer agents. Chain transfer agents may be added to obtain resins with lower and narrower molecular weight distributions than can be prepared from using monomers alone. Chain transfer agents stop the propagation of a growing polymer chain by terminating the chain in a way which regenerates a polymer initiation site. Components which behave as chain transfer agents in these reactions include but are not limited to isobutylene, 2-methyl-

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1-butene, 2-methyl-2-butene or dimers or oligomers of these species. The chain transfer agent can be added to the reaction in pure form or diluted in a solvent. Feed streams can be dried if desired and preferably contain less than about 500 ppm water, more preferably less than about 200 ppm water, and most preferably less than about 50 ppm water.

5 In the case of C9 monomer resins, the feed streams contain unsaturated aromatic C8, C9, and/or C10 monomers with a boiling range of about 100°C to 300°C at atmospheric pressure. Aromatic C8-C10 feed streams (also referred to as C9 feed streams) can be derived from steam cracking of petroleum distillates. Monomers found in these feed stocks may include but are not limited to styrene, vinyl toluene, indene, dicyclopentadiene, and
10 alkylated derivatives of these components. Commercial samples of this type of feed include but are not limited to "LRO-90" from Lyondell Petrochemical Company, Houston, TX, "DSM C9 Resinfeed Classic" from DSM, Geleen, the Netherlands, "RO-60" and "RO-80" from Dow Chemical Company of Midland, Michigan, and "Dow Resin Oil 60-L" from the Dow Chemical Company of Terneuzen, the Netherlands. The C9 feed stream generally
15 contains at least about 20% by weight, preferably about 30% to 75% by weight, and most preferably about 35% to 70% by weight polymerizable unsaturated hydrocarbons. The remainder is generally alkyl substituted aromatics which can be incorporated into the resins by alkylation reactions. Feed streams can be dried if desired and preferably contain less than about 500 ppm water, more preferably less than about 200 ppm water, and most preferably
20 less than about 50 ppm water.

The feed streams may be limited to pure monomer, C5 monomers, or C9 monomers. Alternatively, cofeed streams can be used in combination with main feed streams of pure monomer, C5 monomers, or C9 monomers. Depending upon the main feed stream, pure monomer, C5 monomers, C9 monomers, or even terpenes, and any combination thereof,
25 may serve as a cofeed stream. Terpene feed stocks include but are not limited to d-limonene, alpha- and beta-pinene, as well as dipentene. Resins from blends of main feed streams with cofeed streams may be prepared in the range of about 30 wt% to 95 wt% main feed with about 70 wt% to 5 wt% of a cofeed, preferably about 50-85 wt% main feed and about 50 wt% to 15 wt% cofeed.

30 The polymerization feed stream preferably contains between about 20 wt% and 80 wt% monomers, more preferably about 30 wt% to 70 wt%, and most preferably about 40 wt% to 70 wt%. In the case of C5 resins, the feed may contain up to about 40 wt% of a

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chain transfer agent, more preferably up to about 20 wt%, chain transfer agents as discussed above. The feed stream also contains about 80 wt% to 20 wt% of a solvent such as toluene, octane, higher boiling aromatic solvent, aliphatic solvent, or solvent blend.

Regarding the solvents, for pure monomer polymerization, the preferred solvents are aromatic solvents. Typically toluene, xylenes, or light aromatic petroleum solvents such as "Aromatic 100" from Exxon Chemical Company, Houston, TX, "HiSol 10" from Ashland Chemical Incorporated, Columbus, OH, and "Cyclosol 53" from Shell Chemical Company, Houston, TX can be used. These solvents can be used fresh or recycled from the process. The solvents generally contain less than about 200 ppm water, preferably less than about 100 ppm water, and most preferably less than about 50 ppm water.

For C5 polymerization, the preferred solvents are aromatic solvents. Generally, unreacted resin oil components are recycled through the process as solvent. In addition to the recycled solvents, toluene, xylenes, or aromatic petroleum solvents such as "Solvesso 100" from Exxon Chemical Company, Houston, TX and "Shellsol A" from Shell Chemical Company, Houston, TX can be used. These solvents can be used fresh or recycled from the process. The solvents generally contain less than about 500 ppm water, preferably less than about 200 ppm water, and most preferably less than about 50 ppm water.

For C9 polymerization, the preferred solvents are aromatic solvents. Generally, unreacted resin oil components are recycled through the process as solvent. In addition to the recycled solvents, toluene, xylenes, or aromatic petroleum solvents such as "Solvesso 100" from Exxon Chemical Company, Houston, TX and "Shellsol A" from Shell Chemical Company, Houston, TX can be used. These solvents can be used fresh or recycled from the process. The solvents generally contain less than about 200 ppm water, preferably less than about 100 ppm water, and most preferably less than about 50 ppm water.

Concerning the polymerization reaction conditions, a first important variable is the amount of solid acid catalyst which is used. The solid acids are preferably used at a level of about 0.1 wt% to 30 wt% based on the weight of the monomer. For pure monomer resins, the solid acid concentration is preferably about 0.1 to 15 wt%, more preferably about 0.5 wt% to 10 wt%, and most preferably about 0.5 wt% to 8 wt%. For C5 monomers, the solid acid concentration is preferably about 0.5 wt% to 30 wt%, more preferably about 1 wt% to 20 wt%, and most preferably about 3 wt% to 15 wt%. For C9 monomers, the solid acid concentration is preferably about 0.5 wt% to 30 wt%, more preferably about 1 wt% to 20

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wt%, and most preferably about 3 wt% to 15 wt%. For acid-treated clays, the preferred concentration is about 0.5 to 5 wt% based on the weight of the monomer.

A second important variable in the reaction is the reaction sequence, i.e., the order and manner in which reactants are combined. In one reaction sequence, the catalyst can be added to a solution of the monomers incrementally while controlling the reaction temperature. Alternatively, in another reaction sequence, the monomer can be added incrementally to a slurry of the solid acid catalyst in a solvent. For a set catalyst level and reaction temperature, substantially lower softening point resins are obtained when the monomer is added to a catalyst slurry. As discussed in more detail in the following paragraphs, lower molecular weights and narrow polydispersity, i.e., M_w/M_n , as measured by size exclusion chromatography, are obtained when the monomer is added to the catalyst solution compared with resins where the catalyst is added to the monomer.

The molecular weight averages of the resins were measured using size exclusion chromatography, SEC. The column set for the analysis consisted of four Waters "Ultrastaygel" columns of 500, 500, 1000, and 100 Å pore size, in series, (Part Nos. WAT 010571, 010571, 010572, 010570 respectively) available from Waters Corporation, Milford, MA. The molecular weight calibration was calculated from the peak elution times of a standard set of narrow molecular weight distribution polystyrene polymers. The calibration set encompassed 18 standards ranging in peak molecular weight from 162 to 43,900. The peak molecular weight of a narrow molecular weight standard is defined as equal to $(M_w M_n)^{1/2}$ (ASTM test method D3536-76). The calibration curve is defined by a third degree polynomial curve fit of a plot of $\log MW$ vs. V_e/V_r , where V_e is the elution volume of the standard and V_r is the elution volume of the reference peak, oxygen, present as dissolved air in the injected solution. The columns and detector cell (Hewlett-Packard Differential Refractometer) are maintained at 40°C. The solvent (mobile phase) is tetrahydrofuran containing 250 ppm butylated hydroxytoluene (BHT, 2,6-di-tert-butyl-4-methylphenol) as a stabilizer (the tetrahydrofuran with BHT being available from Burdick and Jackson, Muskegon, MI). The mobile phase reservoir is purged with helium and is maintained at a flow rate of 1 milliliter per minute. Under these conditions, BHT eluted at 35.86 minutes. Samples are dissolved in THF, 0.25% wt/vol, and filtered through a 0.45 micron pore size "TEFLON" (polytetrafluoroethylene) membrane filter prior to injection (200 microliters) into the chromatograph. The reported molecular weights are the

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“polystyrene equivalent” molecular weights as calculated from the calibration curve.

For the pure monomer resins, the resins produced using the current invention have number average molecular weights (Mn) ranging from about 400 to 2000, weight average molecular weights (Mw) ranging from about 500 to 5000, Z average molecular weights (Mz) ranging from about 500 to 10,000, and polydispersities (PD) as measured by Mw/Mn between about 1.2 and 3.5, typically between about 1.2 and 2.5. For the C5 hydrocarbon resins, the resins produced using the current invention have number average molecular weights (Mn) ranging from about 400 to 2000, weight average molecular weights (Mw) ranging from about 500 to 3500, Z average molecular weights (Mz) ranging from about 700 to 15,000, and polydispersities (PD) as measured by Mw/Mn between about 1.2 and 5, typically between about 1.2 and 3.5. For the C9 hydrocarbon resins, the resins produced using the current invention have number average molecular weights (Mn) ranging from about 400 to 1200, weight average molecular weights (Mw) ranging from about 500 to 2000, Z average molecular weights (Mz) ranging from about 700 to 6000, and polydispersities (PD) as measured by Mw/Mn between about 1.2 and 3.5, typically between about 1.2 and 2.5.

As mentioned previously, narrower polydispersities (PD) and lower molecular weights are obtained when the monomer is added to the catalyst solution than when the catalyst is added to the monomer. Taking into consideration the effect of the reaction sequence, polydispersities (PD) more narrow than those obtained using traditional Lewis acid Friedel-Crafts catalysts can be obtained using solid acids if desired. For instance, when pure monomer is added to 3 wt% “F-22” clay catalyst (Engelhard Corporation, Iselin, NJ) at a temperature of 0°C over 15 minutes, the hydrocarbon resin product has an Mw of 810, an Mn of 580, an Mz of 1230, and a polydispersity (PD) of 1.40. In comparison, when 3 wt% of the “F-22” clay catalyst is added to pure monomer at a temperature of 0°C over 15 minutes, the hydrocarbon resin product has an Mw of 3310, an Mn of 1290, an Mz of 8310, and a polydispersity (PD) of 2.56.

In view of the above, polydispersities (PD) more narrow than those obtained using traditional Lewis acid Friedel-Crafts catalysts can be obtained using solid acids if desired. Narrow polydispersity is important to ensure compatibility of resin with polymers in end use applications.

A third important reaction variable is the reaction temperature. Polymerization

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temperatures between about -50°C and 150°C can be used in these reactions, however, more preferred reaction temperatures are between about -20°C and 100°C, most preferred temperatures are between about 0°C and 70°C. For pure monomer, the reaction temperature is preferably between about -50°C and 100°C, more preferably between about -20°C and 75°C, and most preferably between about -10°C and 60°C. For C5 monomers, the reaction temperature is preferably between about -50°C and 100°C, more preferably between about -20°C and 75°C, and most preferably between about -10°C and 70°C. For C9 monomers, the reaction temperature is preferably between about 0°C and 150°C, more preferably between about 10°C and 120°C, and most preferably between about 20°C and 110°C. Temperature is found to have a significant effect on the properties of the resulting resins. Higher molecular weight and high softening point resins are prepared at lower reaction temperatures. The reaction time at reaction temperature is preferably between about 30 minutes and 8 hours, and more preferably between about 1 hour and 4 hours.

The polymerization process can be carried out as a continuous, semi-batch, or batch process in such diverse reactors as continuous, batch, semi-batch, fixed bed, fluidized bed, and plug flow. For instance, in continuous processes, a solution of the monomers can be passed over the catalyst in a fixed bed, or the monomers can be cofed with a catalyst slurry into a continuous reactor.

The reaction may be stopped by physically separating the solid catalysts from the products. Physical separation may render the reaction solution neutral. Furthermore, physical separation can be performed by simple filtration or by separation of the resin solutions from a fixed catalyst bed. As a result, physical separation is easy and complete such that, for many solid acid catalysts, acid functionality and catalyst residue are not left in the resin product.

If leaching of acid is possible, then acid neutralization is required. This step is commonly known in the art as "quenching". For the solid acid catalysts which require quenching, less salt is generated than by traditional Lewis acid catalysts.

Thus, use of solid acid catalysts minimizes or eliminates the need for extra processing steps to quench the reactions, neutralize the catalyst, and filter the catalyst salt residues from the resulting products.

Once the solid acid catalyst and resin solution are separated, the resin solution can be stripped to remove unreacted hydrocarbons, solvents, and low molecular weight

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oligomers which can be recycled through the process. When pure monomer is reacted, water white resins can be obtained from this invention in yields of up to about 99% based on starting monomer.

Resins obtained from this invention typically have softening points as measured by ASTM-E28 "Standard Test Method for Softening Point by Ring and Ball Apparatus" (revised 1996), varying from preferably about 5°C to 170°C, more preferably from about 30°C to 150°C. For pure monomer resins, removing the freely-associated water from the catalyst results in higher softening point, higher molecular weight resins than previously observed for clay catalysts. For pure monomer, the softening points preferably range from about 5°C to 170°C, more preferably from about 50°C to 150°C. For C5 hydrocarbon resins, the softening point preferably ranges from about 5°C to 170°C, more preferably from about 50°C to 150°C, and most preferably about 70°C to 130°C. For C9 hydrocarbon resins, the softening point is preferably up to about 170°C, and the softening point range is most preferably from about 70°C to 160°C. Flowable resin or those that are liquids at room temperature can also be prepared if desired using proper reaction conditions.

After the resin is produced, it may be subsequently subjected to hydrogenation to reduce coloration and improve color stability. Hydrogenation of resins is well known in the art. For a discussion of hydrogenation, reference is made to U.S. Patent No. 5,491,214 to DAUGHENBAUGH et al., which is herein incorporated by reference in its entirety.

The resins of the current invention can be used as modifiers in adhesives, sealants, printing inks, protective coatings, plastics, road markings, flooring, and as dry cleaning retexturizing agents.

The solid acid catalysts of the present invention offer several advantages over Lewis acids (e.g., AlCl_3 , AlBr_3 , BF_3 , complexes of BF_3 , TiCl_4 , and others which are traditionally used for Friedel-Crafts polymerizations). Many of these advantages are a result of the acid sites being an integral part of the solid catalysts.

Because the acid sites are an integral part of the solid catalyst, contamination of the resin products or solvents with catalyst residues is minimal. As a result, the solid acid catalysts do not impart color to the hydrocarbon resins due to catalyst residues. If pure styrene-based monomers are used, the resulting resins can be water white.

The solid acid catalysts of the present invention can generally be regenerated and recycled to thereby minimize waste disposal of spent catalyst. In contrast, the Lewis acids

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are generally single use catalysts.

Further, the solid acid catalysts of the present invention are nonhazardous when compared with traditional Lewis acid catalysts such as BF_3 and AlCl_3 . The catalysts of the present invention generally do not generate corrosive or hazardous liquid or gaseous acids on exposure to moisture.

The present invention will be further illustrated by way of the following Examples. Examples 1-102 involve pure monomer resins, Examples 103-121 involve C5 resins, and Examples 122-181 involve C9 resins. Example 182 involves a pure monomer resin which is hydrogenated. These examples are non-limiting and do not restrict the scope of the invention.

Unless stated otherwise, all percentages, parts, etc. presented in the examples are by weight.

EXAMPLES 1-10

These examples illustrate the use of acid-treated clays as solid acid catalysts for the preparation of high softening point, water white, pure monomer hydrocarbon resins.

A 500 milliliter three neck flask was equipped with an overhead stirrer, reflux condenser, gas inlet and outlet ports, thermometer, and a dropping addition funnel. The flask was charged with 86.6 grams of alpha-methyl styrene (reagent grade, Aldrich, Milwaukee, WI), 36.6 grams of styrene (reagent grade, Aldrich, Milwaukee, WI), and 36.6 grams of toluene (reagent grade, Aldrich, Milwaukee, WI). The monomers and solvent were dried as follows: the monomers were dried by passing through a column of activated alumina (Fischer 8-16 mesh, 0.3 grams alumina to 1 milliliter monomer) immediately prior to use, the toluene was dried over 3 angstrom molecular sieves prior to use. Acid-treated clay "F-1", "F-2", "F-6", "F-13", "F-20X", "F-22", "F-24", "F-105", "F-160" (Engelhard Corporation, Iselin, NJ) and "XP-100" (W. R. Grace, Davison Division, Baltimore, MD) were treated at 200°C at 2-5 mm Hg for 4-6 hours prior to use. The catalysts were transferred to the dropping addition funnel in a moisture free atmosphere of nitrogen. The reaction solution was cooled to -10°C. Three (3) wt% of acid-treated clay catalyst was added to the reaction from the dropping addition funnel at a rate to maintain the reaction temperature at 0°C while externally cooling the reaction flask in a -50°C bath. Catalyst addition times ranged from 15 to 45 minutes. The reaction solution was stirred at 0°C for a total reaction time of 3 hours.

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After completion of the reaction time, the resin solutions were vacuum filtered from the acid-treated clay catalyst at room temperature. The reaction flask and catalyst filter cake were rinsed with approximately 100 milliliters of toluene. After catalyst filtration, the resin was stripped of solvent and volatile products at 2-5 mm Hg by gradually heating the solution to 185°C and maintaining this strip temperature for 15 minutes upon complete removal of volatiles.

The resins produced had the properties listed in Table 1.

TABLE 1

Example	Catalyst	Yield	Softening Point (R&B)	Molecular Weight		
				Mn	Mw	Mz
1	F-1	97%	128°C	980	3470	9070
2	F-2	78%	150°C	1830	4620	9930
3	F-6	99%	127°C	1000	3220	8480
4	F-13	99%	132°C	1060	3610	9900
5	F-20X	99%	129°C	1020	3360	8870
6	F-22	99%	131°C	1070	3210	8010
7	F-24	87%	156°C	1560	4210	9710
8	F-105	99%	133°C	1070	3390	9840
9	F-160	99%	138°C	1130	3640	9870
10	XP-100	9%	-	690	2100	5980

COMPARATIVE EXAMPLE 11

This comparative example illustrates the effect of omitting calcining of the acid-treated clay catalyst prior to reaction of pure monomer.

Reaction apparatus and procedures were essentially the same as those outlined in Examples 1-10, except where noted. The catalyst used was "F-22" from Engelhard, Iselin, NJ. The catalyst was used as received with no thermal pretreatment.

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The resin produced had the following properties.

Catalyst	F-22
Yield	8%
Softening Point (R&B)	108°C
Molecular Weight	
Mn	880
Mw	1480
Mz	3660

Comparing the above results of Comparative Example 11 with those of Example 6, it is clear that calcining the solid acid catalyst increased the yield and produced a resin with higher molecular weights and a higher softening point.

EXAMPLES 12-14

These examples illustrate the addition of the catalyst to a pure monomer solution and the effects of reaction temperature and catalyst loading on the resulting softening point and molecular weight of pure monomer hydrocarbon resins prepared with acid-treated clay catalysts. Resin properties can be controlled through the use of alternate reaction conditions.

The reaction apparatus and procedures were essentially the same as those outlined in Examples 1-10, except where noted. Catalyst loading, and reaction temperature are summarized in the Table 2. Catalyst loading was based on total monomer charge. The catalyst used was "F-22" from Engelhard, Iselin, NJ. The catalyst was treated at 200°C at 2-5 mm Hg for 4-6 hours prior to use. The monomer solutions were cooled to 5-10°C below the target reaction temperature prior to catalyst addition and the reaction was allowed to warm to the target reaction temperature as the catalyst was added. Catalyst addition time was typically 15 minutes and the reaction was held at the desired temperature to give a total reaction time of 1 hour.

After catalyst filtration, the solvent was removed from the resin solution at 100°C at 2-5 mm Hg. Light oils were removed from the resin products by steam distillation as follows: a single neck flask containing the resin was fitted with a distillation head with an adaptor for an inlet tube and a thermometer, and attached to a condenser and receiving flask. The resin oil was heated to 235°C with a nitrogen purge followed by a steam purge at 235-245°C to remove light oil products. The steam purge was continued until less than 1 ml of

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resin was collected per 100 ml of steam condensate or until 1000 ml of steam condensate was collected. The steam purge was followed by a nitrogen purge at 235°C to remove water from the remaining resin.

The resins produced had the properties listed in Table 2.

TABLE 2

Ex.	Catalyst Loading	Reaction Temp.	Yield	Softening Point (R&B)	Molecular Weight			
					Mn	Mw	Mz	PD
12	3 wt%	0°C	92%	143°C	1290	3310	8310	2.56
13	1.5 wt%	0°C	68%	129°C	1080	2050	3960	1.90
14	1 wt%	20°C	84%	130°C	1050	2020	4130	1.92

EXAMPLES 15-17

These examples illustrate the addition of pure monomer to a slurry of the catalyst in solvent and the effects of reaction temperature and catalyst loading on the resulting softening point and molecular weight of pure monomer hydrocarbon resins prepared with acid-treated clay catalysts. Resin properties can be controlled through the use of alternate reaction conditions.

A 500 milliliter three neck flask was equipped with an overhead stirrer, reflux condenser, gas inlet and outlet ports, thermometer, and a dropping addition funnel. The flask was charged with 36.6 grams of toluene (reagent grade, Aldrich, Milwaukee, WI) which had been dried over 3 angstrom molecular sieves and the desired level of acid-treated clay catalyst, "F-22" (Engelhard Corporation, Iselin, NJ). The clay was treated at 200°C at 2-5 mm Hg for 4-6 hours prior to use. The monomers, 86.6 grams of alpha-methyl styrene (reagent grade, Aldrich, Milwaukee, WI), 36.6 grams of styrene (reagent grade, Aldrich, Milwaukee, WI), and 36.6 grams of toluene (reagent grade, Aldrich, Milwaukee, WI) were added to the dropping addition funnel. The monomers and solvent were dried as follows: the monomers were dried by passing through a column of activated alumina (Fischer 8-16 mesh, 0.3 grams alumina to 1 milliliter monomer) immediately prior to use, the toluene was dried over 3 angstrom molecular sieves prior to use. The reaction solution was cooled to 10°C below the desired reaction temperature. The monomer solution was added to the

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reaction flask from the dropping addition funnel at a rate to maintain the desired reaction temperature while externally cooling the reaction flask in a -50°C bath. Monomer addition time ranged from 10 to 15 minutes. The reaction solution was stirred at the desired reaction temperature for a total reaction time of 1 hour.

After completion of the reaction time, the resin solution was vacuum filtered from the acid-treated clay catalyst at room temperature. The reaction flask and catalyst filter cake were rinsed with approximately 100 milliliters of toluene.

After catalyst filtration, the solvent was removed from the resin solution at 100°C at 2-5 mm Hg. Light oils were removed from the resin products by steam distillation as follows: a single neck flask containing the resin was fitted with a distillation head with an adaptor for an inlet tube and a thermometer, and attached to a condenser and receiving flask. The resin was heated to 235°C with a nitrogen purge followed by a steam purge at 235 - 245°C to remove light oil products. The steam purge was continued until less than 1 ml of resin was collected per 100 ml of steam condensate or until 1000 ml of steam condensate was collected. The steam purge was followed by a nitrogen purge at 235°C to remove water from the remaining resin.

The resins produced had the properties listed in Table 3.

TABLE 3

Ex.	Catalyst Loading	Reaction Temp.	Yield	Softening Point (R&B)	Molecular Weight			
					Mn	Mw	Mz	PD
15	3 wt%	0°C	89%	85°C	580	810	1230	1.40
16	1.5 wt%	0°C	62%	75°C	550	700	930	1.27
17	1 wt%	20°C	54%	70°C	530	650	800	1.23

Examples 12 through 17 illustrate the substantial differences in resin products which can be obtained by changing the order of catalyst and monomer addition. For a set catalyst level and reaction temperature, substantially lower softening point resins are obtained when the monomer is added to the catalyst slurry. Lower molecular weights and narrow polydispersity (M_w/M_n), as measured by size exclusion chromatography, are obtained when the monomer is added to the catalyst solution compared with resins where the catalyst is

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added to the monomer.

EXAMPLES 18 and 19

These examples illustrate the use of amorphous silica-alumina as solid acid catalysts for the preparation of water white, pure monomer hydrocarbon resins.

5 A 500 milliliter three neck flask was equipped with an overhead stirrer, reflux condenser, gas inlet and outlet ports, thermometer, and a dropping addition funnel. The flask was charged with 86.6 grams of alpha-methyl styrene (reagent grade, Aldrich, Milwaukee, WI), 36.6 grams of styrene (reagent grade, Aldrich, Milwaukee, WI), and 36.6 grams of toluene (reagent grade, Aldrich, Milwaukee, WI). The monomers and solvent were
10 dried as follows: the monomers were dried by passing through a column of activated alumina (Fischer 8-16 mesh, 0.3 grams alumina to 1 milliliter monomer) immediately prior to use, the toluene was dried over 3 angstrom molecular sieves prior to use. Amorphous silica-aluminas, "SAB-10" and "SAB-30" from UOP, DesPlaines, IL, were crushed using a mortar and pestle to a coarse powder and were treated at 400°C at 2-5 mm Hg for 4-6
15 hours prior to use. The catalysts were transferred to the dropping addition funnel in a moisture free atmosphere of nitrogen. The reaction solution was cooled to -10°C. The silica-alumina catalyst was added to the reaction solution from the dropping addition funnel at a rate to maintain the reaction temperature at 0°C while externally cooling the reaction flask in a -50°C bath. Catalyst addition times ranged from 20 to 30 minutes. The reaction
20 solution was stirred at 0°C for a total reaction time of 3 hours.

After completion of the reaction time, the resin solution was vacuum filtered from the silica-alumina catalyst at room temperature. The reaction flask and catalyst filter cake were rinsed with approximately 100 milliliters of toluene. After catalyst filtration, the resin was stripped of solvent and volatile products at 2-5 mm Hg by gradually heating the solution
25 to 185°C and maintaining this strip temperature for 15 minutes upon complete removal of volatiles.

The resins produced had the properties listed in Table 4.

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TABLE 4

Ex.	Catalyst	Catalyst Loading	Yield	Softening Point (R&B)	Molecular Weight		
					Mn	Mw	Mz
18	SAB-10	5 wt%	83%	-	400	1080	5310
19	SAB-30	5 wt%	88%	69°C	560	1540	3990

EXAMPLES 20-23

These examples illustrate the addition of the catalyst to a pure monomer solution and the effects of reaction temperature and catalyst loading on the resulting softening point and molecular weight of pure monomer hydrocarbon resins prepared with silica-alumina catalysts. Resin properties can be controlled through the use of alternate reaction conditions.

The reaction apparatus and procedures were essentially the same as those outlined in Examples 18 and 19, except where noted. Catalyst loading, and reaction temperature are summarized in the Table 5. Catalyst loading is based on total monomer charge. The catalyst used was "SAB-30" from UOP, DesPlaines, IL. The catalyst was ground using a mortar and pestle to a coarse powder and treated at 400°C at 2-5 mm Hg for 4-6 hours prior to use. The monomer solutions were cooled to 5-10°C below the target reaction temperature prior to catalyst addition and the reaction was allowed to warm to the target reaction as the catalyst was added. Catalyst addition time was typically 15 minutes and the total reaction time was 1 hour.

After catalyst filtration, the solvent was removed from the resin solution at 100°C at 2-5 mm Hg. Light oils were removed from the resin products by steam distillation as follows: a single neck flask containing the resin was fitted with a distillation head with an adaptor for an inlet tube and a thermometer, and attached to a condenser and receiving flask. The resin oil was heated to 235°C with a nitrogen purge followed by a steam purge at 235-245°C to remove light oil products. The steam purge was continued until less than 1 ml of resin was collected per 100 ml of steam condensate or until 1000 ml of steam condensate was collected. The steam purge was followed by a nitrogen purge at 235°C to remove water from the remaining resin.

The resins produced had the properties listed in Table 5.

TABLE 5

Ex.	Catalyst Loading	Reaction Temperature	Yield	Softening Point (R&B)	Molecular Weight		
					Mn	Mw	Mz
20	1 wt%	0°C	38%	120°C	900	1620	3430
21	2 wt%	0°C	62%	114°C	870	1580	3360
22	3 wt%	0°C	80%	109°C	830	1620	3560
23	2 wt%	10°C	72%	93°C	730	1220	2320

EXAMPLES 24-27

These examples illustrate addition of pure monomer to a slurry of catalyst in solvent and the effects of reaction temperature and catalyst loading on the resulting softening point and molecular weight of pure monomer hydrocarbon resins prepared with silica-alumina catalysts. Resin properties can be controlled through the use of alternate reaction conditions.

The reaction apparatus and procedures were essentially the same as those outlined in Examples 15-17, except where noted. Catalyst loading, and reaction temperature are summarized in the Table 6. Catalyst loading is based on total monomer charge. The catalyst used was "SAB-30" from UOP, DesPlaines, IL. The catalyst was ground using a mortar and pestle to a coarse powder and treated at 400°C at 2-5 mm Hg for 4-6 hours prior to use. The monomer solutions were cooled to 5-10°C below the target reaction temperature prior to catalyst addition and the reaction was allowed to warm to the target reaction temperature as the catalyst was added. Monomer addition time was typically 10 to 15 minutes and the total reaction time was 1 hour.

After catalyst filtration, the solvent was removed from the resin solution at 100°C at 2-5 mm Hg. Light oils were removed from the resin products by steam distillation as follows: a single neck flask containing the resin was fitted with a distillation head with an adaptor for an inlet tube and a thermometer, and attached to a condenser and receiving flask. The resin oil was heated to 235°C with a nitrogen purge followed by a steam purge at 235-245°C to remove light oil products. The steam purge was continued until less than 1 ml of resin was collected per 100 ml of steam condensate or until 1000 ml of steam condensate was collected. The steam purge was followed by a nitrogen purge at 235°C to remove water from the remaining resin.

The resins produced had the properties listed in Table 6.

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TABLE 6

Ex.	Catalyst Loading	Reaction Temperature	Yield	Softening Point (R&B)	Molecular Weight		
					Mn	Mw	Mz
24	1 wt%	0°C	24%	118°C	870	1400	2480
25	2 wt%	0°C	58%	97°C	700	1120	2020
26	3 wt%	0°C	60%	89°C	650	1010	1770
27	1 wt%	10°C	55%	81°C	590	830	1260

EXAMPLES 28-30

These examples illustrate the effect of the silica-alumina catalyst pretreatment prior to reaction of pure monomer.

Reaction apparatus and procedures were essentially the same as those outlined in Examples 15 through 17, except where noted. The catalyst used was "SAB-30" from UOP, DesPlaines, IL. The catalysts were crushed using a mortar and pestle to a coarse powder and used without pretreatment or with a thermal treatment at either 200°C or 400°C at 2-5 mm Hg for 4-6 hours.

The resin produced had the properties listed in Table 7. Examples 29 and 30 are in accordance with the present invention, whereas Comparative Example 28 is for comparison purposes.

TABLE 7

Ex.	Catalyst Pretreat	Catalyst Loading	Yield	Softening Point (R&B)	Molecular Weight		
					Mn	Mw	Mz
28	None	3 wt%	15%	98°C	890	1560	2730
29	200°C	3 wt%	86%	86°C	630	910	1480
30	400°C	3 wt%	60%	89°C	650	1010	1770

These examples demonstrate the effect calcining the catalyst has upon the final yield.

EXAMPLE 31

This example illustrates the use of a supported phosphoric acid as a catalyst for the

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polymerization of styrene based pure monomer to prepare hydrocarbon resins.

A 500 milliliter three neck flask was equipped with an overhead stirrer, reflux condenser, gas inlet and outlet ports, thermometer, and a dropping addition funnel. The flask was charged with 86.6 grams of alpha-methyl styrene (reagent grade, Aldrich, Milwaukee, WI), 36.6 grams of styrene (reagent grade, Aldrich, Milwaukee, WI), and 36.6 grams of toluene (reagent grade, Aldrich, Milwaukee, WI). The monomers and solvent were dried over 3 angstrom molecular sieves prior to use. Supported phosphoric acid, "CAT-17" from UOP, DesPlaines, IL, was ground to a powder and heated to 120°C at 2-5 mm Hg for 5 hours prior to use. The catalyst was transferred to the dropping addition funnel in a moisture free atmosphere of nitrogen. The reaction solution was cooled to -10°C. The acid-treated clay catalyst was added from the dropping addition funnel at a rate to maintain the reaction temperature at 0°C while cooling the reaction flask in a -50°C bath. Catalyst addition time was 5 minutes. The reaction solution was stirred at 0°C for a total reaction time of 3 hours.

After completion of the reaction time, the resin solution was vacuum filtered from the supported phosphoric acid catalyst at room temperature. The reaction flask and catalyst filter cake was rinsed with approximately 100 milliliters of toluene. After catalyst filtration, the resin was stripped of solvent and volatile products at 2-5 mm Hg by gradually heating the solution to 185°C and maintaining this strip temperature for 15 minutes upon complete removal of volatiles.

The resin produced had the following properties.

Catalyst	CAT-17
Catalyst Level	5 wt%
Yield	42%
Softening Point (R&B)	Flowable
Molecular Weight	
Mn	320
Mw	730
Mz	4760

EXAMPLES 32-47

These examples illustrate the reusability and recyclability of solid acid catalysts in

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the polymerization of pure monomer to prepare hydrocarbon resins. A clay catalyst is reused 15 times for a total of 16 uses.

The catalyst recycle tests were done in a jacketed one gallon reactor with a flat-bed turbine agitator, coiling coil, sample line, thermowell, bottom valve, and sintered metal filters. The filters were located on the end of the sample line and in the bottom valve seat of the reactor and had a nominal rating of 7 microns. The jacket of the reactor was controlled at $0^{\circ}\text{C} \pm 5^{\circ}\text{C}$.

Thirty-five (35) grams of an acid treated clay and 1000 grams of toluene were added to a 1 gallon reactor. The acid-treated clay catalyst was "F-22" (Engelhard Corporation, Iselin, NJ), which had been calcined in a tube furnace at 200°C for 2 hours. Dry nitrogen was flowed over the clay bed during the calcining process. The clay/toluene mixture was cooled to 0°C . A mixture of 866 grams of alpha-methyl styrene and 366 grams of styrene was pumped into the 1 gallon reactor at a rate such that the temperature was controlled to $0^{\circ}\text{C} \pm 5^{\circ}\text{C}$ by flowing -20°C fluid through the cooling coil. The time for pumping in the monomer was 100 minutes. The reactor was held at 0°C for an additional 3 hours. The catalyst was retained in the reactor by using the two in situ filters. One gram of catalyst was removed and one gram of fresh catalyst was added between each of the catalyst recycle tests. An aliquot of the filtered reaction mixture was rotary evaporated, with an end condition of 3 mm Hg and 190°C to produce a resin product.

Subsequent reactions using the same catalyst were done in essentially the same manner. The yield and properties of the resins are listed in Table 8.

TABLE 8

Example	Run	Yield (%)	Softening Point (R&B)	Molecular Weight			
				Mn	Mw	Mz	PD
32	1	99	47°C	445	658	2504	1.48
33	2	97	94°C	700	1060	2485	1.51
34	3	97	94°C	721	1066	1620	1.48
35	4	97	87°C	647	932	1439	1.44
36	5	97	86°C	573	854	1341	1.49
37	6	97	82°C	554	822	1336	1.48
38	7	96	97°C	656	1086	2314	1.66

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Example	Run	Yield (%)	Softening Point (R&B)	Molecular Weight			
				Mn	Mw	Mz	PD
39	8	97	92°C	618	951	1508	1.54
40	9	95	114°C	818	1373	2221	1.68
41	10	96	115°C	869	1370	2233	1.58
42	11	95	96°C	650	1065	1835	1.64
43	12	97	86°C	576	889	1414	1.54
44	13	93	99°C	682	1059	1638	1.55
45	14	94	106°C	738	1218	1977	1.65
46	15	99	92°C	639	1046	1790	1.64
47	16	98	111°C	838	1399	2269	1.67

EXAMPLES 48-51

These examples illustrate the reusability and recyclability of solid acid catalysts in the polymerization of pure monomer to prepare hydrocarbon resins.

The reaction apparatus and procedures were essentially the same as those outlined in Examples 15-17, except where noted. Three weight percent "F-22" acid-treated clay (Engelhard Corporation, Iselin, NJ) was used as the catalyst charge at a reaction temperature of 0°C. At the end of the reaction time, the catalyst was allowed to settle and the resin solution decanted from the solid catalyst. Additional monomer and solvent was added to the reaction flask from a dropping addition funnel. The reaction was run four times, A through D. After the fourth reaction the catalyst was collected by vacuum filtration through paper, extracted with toluene to remove organic residues, and recalcined at 150°C. This regenerated catalyst was reused for an additional six runs, E through J.

The average yield of resin for runs A through D was 77% while the average yield for runs E through J was 57%. The resins produced had the properties listed in Table 9.

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TABLE 9

Example	Catalyst Recycle	Softening Point (R&B)	Molecular Weight		
			Mn	Mw	Mz
48	Initial Use	81°C	560	760	1120
49	Fourth Reuse	85°C	580	790	1140
50	Fifth Reuse, First after Regeneration	104°C	740	1110	1780
51	Tenth Reuse, Sixth after Regeneration	127°C	1030	1880	3740

EXAMPLES 52-59

These examples illustrate the use of supported Brønsted acids on solid acid catalysts for the preparation of high softening point, water white pure monomer hydrocarbon resins.

Catalyst preparation involved supporting Brønsted acid on acid treated clay catalysts, ("F-20" and "F-22" clay catalysts available from Engelhard Corporation, Iselin, NJ). The clays were prepared by drying, impregnating by adding the "% Acid" of Brønsted acid listed in Table 10, and by drying again. The drying involved calcining for 2 hours by flowing dry nitrogen through a test tube containing the catalyst.

Polymerization involved a 500 milliliter three neck flask equipped with a cooling jacket overhead stirrer, a reflux condenser, gas inlet and outlet ports, a thermometer, and a dropping addition funnel. The flask was charged with 86.6 grams of alpha-methyl styrene (reagent grade, Aldrich, Milwaukee, WI), 36.6 grams of styrene (reagent grade, Aldrich, Milwaukee, WI), and 100 grams of toluene (reagent grade, Aldrich, Milwaukee, WI). The monomers were dried by passing through a column of activated alumina (Fischer 8-16 mesh, 0.3 grams alumina to 1 ml monomer) immediately prior to use. The toluene was dried over 3 angstrom molecular sieves prior to use. The catalyst, 3.8 grams, was added incrementally to control the reaction temperature at 0°C. The total reaction time was 3 hours after completion of the catalyst addition.

At the end of the reaction, the catalyst was filtered from the resin solution. The resin solution was rotary evaporated to a final condition by using a 190°C bath temperature, < 5 mm Hg, and 45 minutes at this condition.

The resins produced had the properties listed in Table 10.

TABLE 10

Ex.	Brønsted Acid	% Acid	Clay	Yield	Softening Point (R&B)	Molecular Weight		
						Mn	Mw	Mz
52	HF	1 wt%	F-22	83%	108°C	796	1830	2730
53	HF	5 wt%	F-22	87%	115°C	844	2040	3060
54	HF	1 wt%	F-20	84%	113°C	845	1178	3782
55	HF	5 wt%	F-20	85%	118°C	882	1861	3950
56	H ₂ SO ₄	1 wt%	F-22	84%	113°C	824	1837	4352
57	H ₂ SO ₄	5 wt%	F-22	89%	114°C	787	1776	4132
58	H ₃ PO ₄	1 wt%	F-22	96%	91°C	611	1533	4473
59	H ₃ PO ₄	5 wt%	F-22	92%	110°C	824	1788	5911

EXAMPLES 60-95

The following examples illustrate a range of resin properties available from the current invention using styrene and alpha-methyl styrene as the monomers and calcined acid-treated clay as the catalyst. When combined, the following examples define a half factorial designed experiment with five variables. The variables in these experiments include reaction temperature, catalyst loading, solvent level, alpha-methyl styrene:styrene ratio, and water level in the monomer feedstocks. Additional points are included to define curvature in each variable as well as replicate points to estimate experimental error. One skilled in the art can use the results from the following examples to generate a model equation for each measured response in terms of the variables studied. The responses studied in these examples include product yield, Ring and Ball softening point, and molecular weight distribution as defined by number average molecular weight (Mn), weight average molecular weight (Mw), Z average molecular weight (Mz), and polydispersity (PD) defined as Mw/Mn (PD).

A 500 milliliter three neck flask was equipped with an overhead stirrer, reflux condenser, gas inlet and outlet ports, thermometer, and a dropping addition funnel. The flask was charged with alpha-methyl styrene (reagent grade, Aldrich, Milwaukee, WI), styrene (reagent grade, Aldrich, Milwaukee, WI), and toluene (reagent grade, Aldrich,

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Milwaukee, WI) as outlined in the Table 11. The monomers and solvent were dried as follows: the monomers were dried by passing through a column of activated alumina (Fischer 8-16 mesh, 0.3 grams alumina to 1 milliliter monomer) immediately prior to use, the toluene was dried over 3 angstrom molecular sieves prior to use. Acid-treated clay, "F-22" (Engelhard Corporation, Iselin, NJ), was treated at 200°C at 2-5 mm Hg for 4-6 hours prior to use. The catalyst was transferred to the dropping addition funnel in a moisture free atmosphere of nitrogen. The reaction solution was cooled to 5 to 10°C below the target reaction temperature prior to catalyst addition and the reaction was allowed to warm to the target reaction temperature as the catalyst was added. The acid-treated clay catalyst was added to the reaction from the dropping addition funnel at a rate to maintain the reaction at the target temperature while externally cooling the reaction flask with a -50°C bath. Catalyst addition time was typically 15 minutes. The reaction solution was stirred at the reaction temperature for a total reaction time of 1 hour.

After catalyst filtration, the solvent was removed from the resin solution at 100°C at 2-5 mm Hg. Also, the flask containing the resin oil was fitted with a distillation head with an adaptor for an inlet tube and a thermometer, and attached to a condenser and receiving flask. The resin oil was heated to 235°C with a nitrogen purge followed by a steam purge at 235-245°C to remove the light oil products. The steam purge was continued until less than 1 ml of resin was collected per 100 ml of steam condensate or until 1000 ml of steam condensate was collected. The steam purge was followed by a nitrogen purge at 235°C to remove water from the remaining resin.

The reaction conditions for each example are outlined in Table 11. The level of each variable was coded as -1, 0, and 1 for low, middle, and high, respectively. Use of coded variable values facilitates generation of the model equations for each response. The coded values are included for each example.

TABLE 11

Ex.	Catalyst Loading (wt%)	Reaction Temp. (°C)	AMS:STY Ratio	Solvent Level (%)	H ₂ O Level (ppm)
60	3.25 (0)	25 (0)	50:50 (0)	50 (0)	90 (0)
61	6 (1)	0 (-1)	30:70 (-1)	70 (1)	150 (1)

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Ex.	Catalyst Loading (wt%)	Reaction Temp. (°C)	AMS:STY Ratio	Solvent Level (%)	H ₂ O Level (ppm)
62	6 (1)	0 (-1)	30:70 (-1)	30 (-1)	30 (-1)
63	6 (1)	50 (1)	70:30 (1)	30 (-1)	30 (-1)
64	6 (1)	50 (1)	30:70 (-1)	70 (1)	30 (-1)
65	3.25 (0)	25 (0)	50:50 (0)	50 (0)	90 (0)
66	6 (1)	50 (1)	30:70 (-1)	30 (-1)	150 (1)
67	6 (1)	0 (-1)	70:30 (1)	70 (1)	30 (-1)
68	0.5 (-1)	0 (-1)	70:30 (1)	30 (-1)	30 (-1)
69	0.5 (-1)	0 (-1)	70:30 (1)	70 (1)	150 (1)
70	3.25 (0)	25 (0)	50:50 (0)	50 (0)	90 (0)
71	0.5 (-1)	0 (-1)	30:70 (-1)	70 (1)	30 (-1)
72	0.5 (-1)	50 (1)	70:30 (1)	30 (-1)	150 (1)
73	0.5 (-1)	50 (1)	70:30 (1)	70 (1)	30 (-1)
74	3.25 (0)	25 (0)	50:50 (0)	50 (0)	90 (0)
75	6 (1)	0 (-1)	70:30 (1)	30 (-1)	150 (1)
76	0.5 (-1)	50 (1)	30:70 (-1)	30 (-1)	30 (-1)
77	6 (1)	50 (1)	70:30 (1)	70 (1)	150 (1)
78	3.25 (0)	25 (0)	50:50 (0)	50 (0)	90 (0)
79	0.5 (-1)	50 (1)	30:70 (-1)	70 (1)	150 (1)
80	0.5 (-1)	0 (-1)	30:70 (-1)	30 (-1)	150 (1)
81	0.5 (-1)	0 (-1)	30:70 (-1)	30 (-1)	150 (1)
82	3.25 (0)	25 (0)	50:50 (0)	50 (0)	90 (0)
83	3.25 (0)	25 (0)	50:50 (0)	50 (0)	150 (1)
84	3.25 (0)	0 (-1)	50:50 (0)	50 (0)	90 (0)
85	3.25 (0)	25 (0)	50:50 (0)	50 (0)	90 (0)
86	3.25 (0)	25 (0)	50:50 (0)	70 (1)	90 (0)
87	6 (1)	25 (0)	50:50 (0)	50 (0)	90 (0)
88	3.25 (0)	50 (1)	50:50 (0)	50 (0)	90 (0)

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Ex.	Catalyst Loading (wt%)	Reaction Temp. (°C)	AMS:STY Ratio	Solvent Level (%)	H ₂ O Level (ppm)
89	0.5 (-1)	25 (0)	50:50 (0)	50 (0)	90 (0)
90	3.25 (0)	25 (0)	50:50 (0)	50 (0)	90 (0)
91	3.25 (0)	25 (0)	50:50 (0)	30 (-1)	90 (0)
92	3.25 (0)	25 (0)	70:30 (1)	50 (0)	90 (0)
93	3.25 (0)	25 (0)	50:50 (0)	50 (0)	30 (-1)
94	3.25 (0)	25 (0)	30:70 (-1)	50 (0)	90 (0)
95	3.25 (0)	25 (0)	50:50 (0)	50 (0)	90 (0)

The resin properties obtained for each example described in the Table 11 are summarized in the Table 12.

TABLE 12

Example	Yield (%)	Softening Point (R&B)	Molecular Weight			
			Mn	Mw	Mz	PD
60	89	99°C	780	1150	1700	1.5
61	87	104°C	970	1580	2620	1.6
62	85	119°C	1320	2900	6100	2.2
63	68	70°C	530	670	860	1.3
64	82	82°C	720	1020	1460	1.4
65	86	96°C	760	1100	1620	1.5
66	89	91°C	790	1260	2170	1.6
67	88	108°C	760	1530	3940	2.0
68	59	140°C	1530	3350	6810	2.2
69	73	120°C	850	1530	3440	1.8
70	87	94°C	750	1130	1810	1.5
71	39	112°C	1010	1740	3680	2.1
72	49	60°C	510	610	1040	1.7

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Example	Yield (%)	Softening Point (R&B)	Molecular Weight			
			Mn	Mw	Mz	PD
73	58	61°C	500	590	700	1.2
74	83	104°C	820	1230	1870	1.5
75	90	143°C	1280	3150	7710	2.5
76	61	95°C	870	1450	3200	1.7
77	69	59°C	470	570	710	1.2
78	91	97°C	770	1180	1830	1.5
79	71	81°C	700	970	1340	1.4
80	13	143°C	1580	2870	5570	1.8
81	21	130°C	1670	3190	5520	1.9
82	89	94°C	740	1120	1690	1.5
83	88	98°C	790	1190	1840	1.5
84	95	117°C	1060	2060	4340	1.9
85	89	98°C	790	1190	1790	1.5
86	85	86°C	690	980	1390	1.4
87	90	97°C	810	1250	1900	1.5
88	83	81°C	650	900	1230	1.4
89	39	100°C	750	1080	1520	1.4
90	90	95°C	760	1150	1720	1.5
91	90	101°C	850	1330	2060	1.6
92	83	86°C	610	830	1200	1.4
93	87	97°C	790	1160	1700	1.5
94	90	102°C	950	1600	2590	1.7
95	87	95°C	760	1120	1650	1.5

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The data from Tables 11 and 12 was analyzed by regression analysis for each of the five responses (steam stripped product yield, Ring and Ball softening point, Mw molecular weight, Mz molecular weight, and polydispersity). The process variables (reaction temperature (TMP), catalyst loading (CAT), solvent level (SOL), AMS:styrene ratio (A:S),

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and water level (H₂O)) were coded to -1, 0, and 1 for the low, mid, and high levels respectively. The following regression models were obtained based on the coded variables.

The proportion of the variation in the response data that is explained by the models ($R^2(\text{adj})$) was 95-97% in all cases. This is considered to be high and an indication of a model with good predictive confidence.

Equation 1

$$\begin{aligned} \text{Resin Yield \%} = & 87.7 + 15.9(\text{CAT}) + 2.63(\text{SOL}) - 6.19(\text{TMP})(\text{CAT}) \\ & - 9.14(\text{TMP})(\text{A:S}) - 4.14(\text{CAT})(\text{SOL}) - \\ & 5.16(\text{CAT})(\text{A:S}) + 4.67(\text{SOL})(\text{H}_2\text{O}) - 20.6(\text{CAT})^2 \end{aligned}$$

Equation 2

$$\begin{aligned} \text{R \& B Softening Point} = & 97.7 - 23.2(\text{TMP}) - 1.84(\text{CAT}) - 7.96(\text{SOL}) - \\ & 4.23(\text{A:S}) + 2.51(\text{TMP})(\text{CAT}) + 3.89(\text{TMP})(\text{SOL}) - \\ & 8.61(\text{TMP})(\text{A:S}) - 3.36(\text{TMP})(\text{H}_2\text{O}) + \\ & 1.76(\text{CAT})(\text{A:S}) \end{aligned}$$

Equation 3

$$\begin{aligned} \text{Mw Molecular Weight} = & 1164 - 714(\text{TMP}) - 403(\text{SOL}) - 152(\text{A:S}) + \\ & 327(\text{TMP})(\text{SOL}) - 159(\text{TMP})(\text{A:S}) + \\ & 94.3(\text{CAT})(\text{H}_2\text{O}) + 443(\text{TMP})^2 \end{aligned}$$

Equation 4

$$\begin{aligned} \text{Mz Molecular Weight} = & 1724 - 1737(\text{TMP}) - 889(\text{SOL}) - 124(\text{A:S}) - \\ & 137(\text{TMP})(\text{CAT}) + 576(\text{TMP})(\text{SOL}) - \\ & 564(\text{TMP})(\text{A:S}) + 152(\text{CAT})(\text{A:S}) + \\ & 252(\text{CAT})(\text{H}_2\text{O}) + 259(\text{A:S})(\text{H}_2\text{O}) + 1173(\text{TMP})^2 + \\ & 283(\text{A:S})^2 \end{aligned}$$

Equation 5

$$\begin{aligned} \text{Polydispersity (Mw/Mn)} = & 1.49 - 0.293(\text{TMP}) - 0.138(\text{SOL}) - 0.0281(\text{H}_2\text{O}) - \\ & 0.0549(\text{TMP})(\text{CAT}) - 0.0924(\text{TMP})(\text{A:S}) + \end{aligned}$$

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$$\begin{aligned}
 &0.0704(\text{TMP})(\text{H}_2\text{O}) - 0.0299(\text{CAT})(\text{SOL}) + \\
 &0.0298(\text{CAT})(\text{H}_2\text{O}) - 0.0424(\text{SOL})(\text{A:S}) - \\
 &0.0625(\text{SOL})(\text{H}_2\text{O}) + 0.106(\text{A:S})(\text{H}_2\text{O}) + 0.173(\text{TMP})^2 + \\
 &0.0733(\text{A:S})^2
 \end{aligned}$$

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The regression equations listed above can be used to predict the properties of all resins which can be obtained for a set of reaction conditions where the control variables lie within the intervals tested. Contour plots can be generated to investigate the factor effects and make comparisons of resin properties predicted to be generated using various reaction conditions. Sample contour plots are shown in Figures 1-5 for each response versus catalyst loading and reaction temperature for a solvent level of 30%, an alpha-methyl styrene to styrene ratio of 70 to 30 by weight, and a water level of 20 ppm in the monomer feed. Contour plots can be generated from the regression equations for any response with respect to any combination of variables studied.

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EXAMPLES 96-100

These examples illustrate the ability to predict pure monomer resin properties for a set of reaction conditions using the regression equations generated from the designed experiment described in Examples 60-95.

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A 500 milliliter three neck flask was equipped with an overhead stirrer, reflux condenser, gas inlet and outlet ports, thermometer, and a dropping addition funnel. The flask was charged with alpha-methyl styrene (reagent grade, Aldrich, Milwaukee, WI), styrene (reagent grade, Aldrich, Milwaukee, WI), and toluene (reagent grade, Aldrich, Milwaukee, WI) as outlined in the Table 13. The monomers and solvent were dried as follows: the monomers were dried by passing through a column of activated alumina (Fischer 8-16 mesh, 0.3 grams alumina to 1 milliliter monomer) immediately prior to use, the toluene was dried over 3 angstrom molecular sieves prior to use. Acid-treated clay, "F-22" (Engelhard Corporation, Iselin, NJ), was treated at 200°C at 2-5 mm Hg for 4-6 hours prior to use. The catalyst was transferred to the dropping addition funnel in a moisture free atmosphere of nitrogen. The reaction solution was cooled to 5 to 10°C below the target reaction temperature prior to catalyst addition and the reaction was allowed to warm to the target reaction temperature as the catalyst was added. The acid-treated clay catalyst was added to the reaction from the dropping addition funnel at a rate to maintain the reaction at

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the target temperature while externally cooling the reaction flask with a -50°C bath. Catalyst addition time was typically 15 minutes. The reaction solution was stirred at the reaction temperature for a total reaction time of 1 hour.

After catalyst filtration, the solvent was removed from the resin solution at 100°C at 2-5 mm Hg. Also, the flask containing the resin oil was fitted with a distillation head with an adaptor for an inlet tube and a thermometer, and attached to a condenser and receiving flask. The resin oil was heated to 235°C with a nitrogen purge followed by a steam purge at 235-245°C to remove light oil products. The steam purge was continued until less than 1 ml of resin was collected per 100 ml of steam condensate or until 1000 ml of steam condensate was collected. The steam purge was followed by a nitrogen purge at 235°C to remove water from the remaining resin.

The reaction conditions for each example are outlined in Table 13.

TABLE 13

Example	Catalyst Loading (wt%)	Reaction Temperature (°C)	AMS:STY Ratio	Solvent Level (%)	H ₂ O Level (ppm)
96	2.5	45	70:30	30	30
97	2.0	0	70:30	30	30
98	4.0	25	70:30	30	30
99	4.0	0	70:30	50	30
100	2.0	0	50:50	30	30

Each example was run in triplicate. The resin properties obtained for each example described in the Table 13 are summarized in Table 14.

TABLE 14

Example	Yield (%)	Softening Point (R&B)	Molecular Weight		
			Mw	Mz	PD
96 (Model)	78	75°C	760	1020	1.36
96a	76	71°C	700	910	1.28
96b	73	70°C	680	880	1.27

Example	Yield (%)	Softening Point (R&B)	Molecular Weight		
			Mw	Mz	PD
96c	78	77°C	750	990	1.30
97 (Model)	86	135°C	3100	6550	2.20
97a	71	135°C	2580	5430	2.12
97b	88	130°C	2910	8680	2.40
97c	90	135°C	3100	7450	2.40
98 (Model)	92	101°C	1390	2490	1.60
98a	87	101°C	1130	1930	1.54
98b	84	99°C	1070	1830	1.53
98c	83	104°C	1180	2170	1.58
99 (Model)	100	121°C	2300	5110	2.12
99a	91	116°C	2140	6420	2.48
99b	90	129°C	2590	6890	2.46
99c	93	127°C	2380	5880	2.24
100 (Model)	74	131°C	3100	6150	2.10
100a	75	132°C	3110	6310	2.10
100b	77	136°C	3410	7410	2.26
100c	79	136°C	3080	6350	2.10

Values for yield and Ring and Ball softening point for the replicate reactions fall within the interval where 95% of all future runs are predicted to lie. These examples illustrate the utility of the regression equations for predicting available resin properties within the defined range of variables used to generate the model.

EXAMPLE 101

This example compares the results of polymerization of a pure monomer feed by using calcined acid treated clay catalyst and calcined silica-alumina catalyst with the polymerization of a pure monomer feed by using BF_3 , a traditional Lewis acid catalyst.

A 70:30 weight ratio of alpha-methyl styrene and styrene in toluene was reacted with 3 wt% calcined acid treated clay, "F-22" from Engelhard, at 0°C over 3 hours. The solvent

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was removed from the resulting product under vacuum to yield 99% of a resin with a softening point of 130°C and a molecular weight distribution of Mw-3210, Mn-1070, Mz-8010, and a polydispersity (PD) of 3.0. Steam distillation resulted in 87% of a product with a 142°C softening point and a molecular weight distribution of Mw-3380, Mn-1430, Mz-7840, and a polydispersity (PD) of 2.4. A commercial product with a 50:50 weight ratio of alpha-methyl styrene and styrene catalyzed with BF₃ has a softening point of 140°C and a molecular weight distribution of Mw-4800, Mn-1450, Mz-9590, and a polydispersity (PD) of 3.3.

EXAMPLE 102

This example involves polymerization of a pure monomer feed by using silica-alumina catalyst.

A 70:30 weight ratio of alpha-methyl styrene and styrene in toluene was reacted with 3 wt% activated silica-alumina, SAB-30 from UOP, at 0 °C over 3 hours. The solvent was removed from the resulting product under vacuum to yield 99% of a resin with a softening point of 84°C and a molecular weight distribution of Mw-1760, Mn-610, Mz-4590 and a polydispersity (PD) of 2.9. The activity of silica-alumina for the preparation of pure monomer resins is not limited to SAB-30. Other silica-alumina samples with varying ratios of silicon to aluminum would be expected to show activity toward the polymerization of pure monomer relative to their acid strengths and number of acid sites.

EXAMPLES 103-106

These examples show the effect of acid-treated clay catalyst calcination on the activity for polymerization of piperylene concentrate, a C5 feed.

A 500 milliliter three neck flask was equipped with an overhead stirrer, reflux condenser, gas inlet and outlet ports, a thermometer and a dropping addition funnel. The flask was charged with 60 grams toluene (reagent grade, Aldrich, Milwaukee, WI) and an acid-treated clay catalyst, "F-22" (Engelhard Corporation, Iselin, NJ), calcined as described in the Table 15. The catalyst slurry was heated to 50°C. Piperylene concentrate ("Naphtha Petroleum 3 Piperylenes" Lyondell Petrochemical Company, Houston, TX), 140 grams, was added to the nitrogen purged reaction flask via the dropping addition funnel over 15 minutes maintaining a 50°C reaction temperature and stirring at 50°C for a total reaction time of up to one hour. The monomers and solvent were dried over 4 angstrom molecular sieves prior to use.

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After completion of the reaction time, the resin solution was vacuum filtered from the acid-treated clay catalyst at room temperature. The reaction flask and catalyst filter cake were rinsed with approximately 100 milliliters of toluene.

After catalyst filtration, the resin oil flask was fitted with a distillation head with an adaptor for an inlet tube and a thermometer, and attached to a condenser and receiving flask. The resin oil was heated to 235°C with a nitrogen purge followed by a steam purge at 235-245°C to remove light oil products. The steam purge was continued until less than 1 ml of resin was collected per 100 ml of steam condensate or until 1000 ml of steam condensate was collected. The steam purge was followed by a nitrogen purge at 235°C to remove water from the remaining resin.

The resins produced had the properties listed in Table 15. Examples 104-106 are in accordance with the present invention, whereas Comparative Example 103 is for comparison purposes.

TABLE 15

Example	Catalyst Preparation	Yield	Softening Point (R&B)	Molecular Weight		
				Mn	Mw	Mz
103	10 wt%, As Received	36%	oil	980	1290	2220
104	10 wt%, 100°C/1 hr	6%	42°C	1430	2550	5980
105	14 wt%, 250°C/8 hr	18%	-	1340	2130	4300
106	14 wt%, 400°C/8 hr	29%	32°C	1210	1810	3590

These examples demonstrate the effect of the use of different catalyst calcination conditions on the yield as well as on the physical properties of the resultant resins. These examples demonstrate that controlling calcination conditions of the catalyst can be used to tailor the production of desired resin products.

EXAMPLES 107 and 108

These examples illustrate the effect of alternate monomer streams on the polymerization of piperylene, a C5 feed, with acid-treated clay catalysts.

Procedures are essentially the same as those outlined for Examples 103-106, except

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where noted. Example 107 was run using 68 grams of 90% piperylene (Technical grade, Aldrich, Milwaukee, WI) as the monomer feed and 100 grams of toluene solvent. The "F-22" acid-treated clay catalyst (Engelhard Corporation, Iselin, NJ), calcined at 200°C for 4 hours, was used at a 14.6 wt% loading based on monomer. The reaction product was collected by heating to 175°C under a nitrogen purge. Example 108 was run using 68 grams of 90% piperylene (Technical grade, Aldrich, Milwaukee, WI) and 18 grams of 2-methyl-2-butene (99%, Aldrich, Milwaukee, WI) as the monomer feed and 75 grams of toluene solvent. The "F-22" acid-treated clay catalyst (Engelhard Corporation, Iselin, NJ), calcined at 200°C for 4 hours, was used at a 14.6 wt% loading based on monomer. The reaction product was collected using procedures outlined in Examples 103-106.

The resins produced had the properties listed in Table 16.

TABLE 16

Example	Yield	Molecular Weight		
		Mn	Mw	Mz
107	17%	680	1890	8250
108	15%	1430	2070	3600

EXAMPLES 109 and 110

The following examples illustrate the effect of an incremental catalyst addition method and reaction temperature on the polymerization of piperylene concentrate, a C5 feed, with acid-treated clay catalysts.

A 500 milliliter three neck flask was equipped with an overhead stirrer, reflux condenser, gas inlet and outlet ports, a thermometer, dropping addition funnel, and a dropping addition funnel. The flask was charged with 60 grams of toluene (reagent grade, Aldrich, Milwaukee, WI) and an acid-treated clay catalyst "F-13" (Engelhard Corporation, Iselin, NJ) as described in the Table 17. The catalysts were calcined under vacuum (2-5 mm Hg). The catalyst charge was 14 wt% with half of the catalyst charged to the reaction flask prior to monomer addition, one quarter of the total catalyst charge was added after half of the monomer was added, and the remaining catalyst was added at the end of the monomer addition. The catalyst slurry in the reaction flask was heated to 50°C. Piperylene concentrate ("Naphtha Petroleum 3 Piperylenes" Lyondell Petrochemical Company,

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Houston, TX), 140 grams, was added to the nitrogen purged reaction flask via the dropping addition funnel over 15 minutes maintaining the reaction temperature at 50°C and stirring at 50°C for a total reaction time of three hours. Example 110 was heated to reflux during this 3 hour hold period. The monomers and solvent were dried over 4 angstrom molecular sieves prior to use.

After completion of the reaction time, the resin solutions were vacuum filtered from the acid-treated clay catalyst at room temperature. The reaction flask and catalyst filter cake were rinsed with approximately 100 milliliters of toluene.

After catalyst filtration, the resin oil flask was fitted with a distillation head with an adaptor for an inlet tube and a thermometer, and attached to a condenser and receiving flask. The resin oil was heated to 235°C with a nitrogen purge followed by a steam purge at 235-245°C to remove light oil products. The steam purge was continued until less than 1 ml of resin was collected per 100 ml of steam condensate or until 1000 ml of steam condensate was collected. The steam purge was followed by a nitrogen purge at 235°C to remove water from the remaining resin.

The resins produced had the properties listed in Table 17.

TABLE 17

Example	Catalyst	Yield	Softening Point (R&B)	Molecular Weight		
				Mn	Mw	Mz
109	F-13 200°C/2 hr	8%	45°C	1670	2610	4390
110	F-13 200°C/4 hr	10%	44°C	1540	2480	4360

EXAMPLE 111

This example illustrates the effect of reverse addition of catalyst to monomer on the polymerization of piperylene concentrate, a C5 feed, with acid-treated clays.

A 500 milliliter three neck flask was equipped with an overhead stirrer, reflux condenser, gas inlet and outlet ports, thermometer, and a dropping addition funnel. The nitrogen purged flask was charged with 60 grams of toluene (reagent grade, Aldrich, Milwaukee, WI) and 140 grams of piperylene concentrate ("Naphtha Petroleum 3 Piperylenes" Lyondell Petrochemical Company, Houston, TX) via syringe. The monomers and solvent were dried over 4 angstrom molecular sieves prior to use. The catalyst, "F-13"

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acid-treated clay (Engelhard Corporation, Iselin, NJ) was calcined at 200°C under vacuum (2-5 mm Hg) for 4 hours and added under an atmosphere of nitrogen to a dropping addition funnel and connected to the reaction flask. The catalyst was added to the monomer solution at 50°C over 20 minutes and the reaction held at 50°C for an additional 3 hours.

5 After completion of the reaction time, the resin solution was vacuum filtered from the acid-treated clay catalyst at room temperature. The reaction flask and catalyst filter cake were rinsed with approximately 100 milliliters of toluene.

10 After catalyst filtration, the resin oil flask was fitted with a distillation head with an adaptor for an inlet tube and a thermometer, and attached to a condenser and receiving flask. The resin oil was heated to 235°C with a nitrogen purge followed by a steam purge at 235-245°C to remove light oil products. The steam purge was continued until less than 1 ml of resin was collected per 100 ml of steam condensate or until 1000 ml of steam condensate was collected. The steam purge was followed by a nitrogen purge at 235°C to remove water from the remaining resin.

15 The resin produced had the following properties.

Yield	7%
Softening Point(R&B)	41°C
Molecular Weight	
Mn	1890
Mw	3310
Mz	7240

20

EXAMPLE 112

25 This example illustrates the effect of two stage catalysis with acid-treated clay followed by aluminum trichloride for the polymerization of piperylene concentrate, a C5 feed.

30 A 500 milliliter three neck flask was equipped with an overhead stirrer, reflux condenser, gas inlet and outlet ports, a thermometer and a dropping addition funnel. The flask was charged with 60 grams of toluene (reagent grade, Aldrich, Milwaukee, WI) and 7 wt% of the acid-treated clay catalyst "F-22" (Engelhard Corporation, Iselin, NJ) which had been calcined at 200°C under vacuum (2-5 mm Hg) for 6 hours. The catalyst slurry was heated to 50°C. Piperylene concentrate ("Naphtha Petroleum 3 Piperylenes" Lyondell

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Petrochemical Company, Houston, TX), 140 grams, was added to the nitrogen purged reaction flask via the dropping addition funnel over 15 minutes maintaining the 50°C reaction temperature and stirring at 50°C for one hour. The monomers and solvent were dried over 4 angstrom molecular sieves prior to use.

5 After completion of the reaction time, the resin solution was filtered from the acid-treated clay catalyst under an atmosphere of nitrogen and recharged over 15 minutes to a reaction flask containing 60 grams of toluene and 1.1 wt% aluminum chloride based on total monomer feed maintaining a 50°C reaction temperature. The reaction solution was stirred at 50°C for an additional 45 minutes. The reaction solution was quenched using 4 milliliters
10 of 28% ammonium hydroxide in 100 milliliters water. The resin solution was vacuum filtered from the salts. The reaction flask and catalyst filter cake were rinsed with approximately 100 milliliters of toluene.

 After catalyst filtration, the resin oil flask was fitted with a distillation head with an adaptor for an inlet tube and a thermometer, and attached to a condenser and receiving flask.
15 The resin oil was heated to 235°C with a nitrogen purge followed by a steam purge at 235-245°C to remove light oil products. The steam purge was continued until less than 1 ml of resin was collected per 100 ml of steam condensate or until 1000 ml of steam condensate was collected. The steam purge was followed by a nitrogen purge at 235°C to remove water from the remaining resin.

20 The resin produced had the following properties.

	Yield	57%
	Softening Point(R&B)	56°C
	Molecular Weight	
	Mn	1300
25	Mw	2040
	Mz	3590

EXAMPLES 113-121

 These examples illustrate the effect of catalyst loading, reaction temperature, solvent,
30 and solvent level on the acid-treated clay catalyzed polymerization of piperylene concentrate, a C5 feed.

 A 500 milliliter three neck flask was equipped with an overhead stirrer, reflux

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condenser, gas inlet and outlet ports, a thermometer and a dropping addition funnel. The flask was charged with 60 grams of solvent, either toluene ("tol") or methylcyclohexane ("mch") (both reagent grade, Aldrich, Milwaukee, WI) and an acid-treated clay catalyst, "F-22" (Engelhard Corporation, Iselin, NJ), calcined at 200°C under vacuum (2-5 mm Hg) for 4 hours. The catalyst slurry was heated to the desired reaction temperature. Piperylene concentrate ("Naphtha Petroleum 3 Piperylenes" Lyondell Petrochemical Company, Houston, TX), 140 grams, was added to the nitrogen purged reaction flask via the dropping addition funnel over 15 minutes maintaining the desired reaction temperature with cooling or heating as needed. The reaction solution was stirred at temperature for one hour after monomer addition was complete. The monomers and solvent were dried over 4 angstrom molecular sieves prior to use.

After completion of the reaction time, the resin solution was vacuum filtered from the acid-treated clay catalyst at room temperature. The reaction flask and catalyst filter cake were rinsed with approximately 100 milliliters of toluene.

After catalyst filtration, volatile components and solvents were removed on a rotary evaporator at 50°C, 5 mm Hg. Also, if sufficient product remained, the resin oil flask was fitted with a distillation head with an adaptor for an inlet tube and a thermometer, and attached to a condenser and receiving flask. The resin oil was heated to 235°C with a nitrogen purge followed by a steam purge at 235-245°C to remove light oil products. The steam purge was continued until less than 1 ml of resin was collected per 100 ml of steam condensate or until 1000 ml of steam condensate was collected. The steam purge was followed by a nitrogen purge at 235°C to remove water from the remaining resin.

The resins produced had the properties listed in Table 18.

TABLE 18

Ex.	Catalyst Loading	Reaction Temp.	Solvent Level - tol:mch	Yield	Softening Point (R&B)	Molecular Weight		
						Mn	Mw	Mz
113	12.5 wt%	30°C	50%-50:50	11%	43°C	1640	2910	6210
114	5 wt%	10°C	30%-0:100	2% ¹	-	210	2510	9130
115	5 wt%	50°C	70%-0:100	3% ¹	-	570	1820	6600
116	5 wt%	50°C	30%-100:0	2%	-	1630	2610	5280
117	5 wt%	10°C	70%-100:0	10% ¹	-	650	1660	3750
118	20 wt%	10°C	70%-0:100	6% ¹	-	780	2650	7910
119	20 wt%	50°C	30%-0:100	6%	52°C	1680	3140	7380
120	20 wt%	50°C	70%-100:0	32%	39°C	1050	1510	2560
121	20 wt%	10°C	30%-100:0	26%	40°C	1560	2620	4750

1. Samples were not steam stripped.

EXAMPLES 122-127

These examples illustrate the addition of monomer to a slurry of the catalyst in solvent and the effect of catalyst loading on the resulting softening point and molecular weight of C9 hydrocarbon resins prepared with acid-treated clay catalysts. Resin properties can be controlled through the use of alternate reaction conditions.

A 500 milliliter three neck flask was equipped with an overhead stirrer, reflux condenser, gas inlet and outlet ports, thermometer, and a dropping addition funnel. The flask was charged with 50 grams of toluene (reagent grade, Aldrich, Milwaukee, WI) and the desired level of acid-treated clay catalyst, "F-22" (Engelhard Corporation, Iselin, NJ). The clay was treated at 200°C at 2-5 mm Hg for 4-6 hours prior to use. The C9 monomer feed, 100 grams of either "LRO-90" (Lyondell Petrochemicals, Houston, TX) or a 1:1 mixture of "DSM C9 Resinfeed Classic" (DSM Geleen, The Netherlands) and "Dow Resin Oil 60-L" (Dow Chemical Company Terneuzen, The Netherlands), was added to the dropping addition funnel. The monomers and solvent were dried as follows: the C9 monomer feed was dried by storing a solution over activated alumina (Fischer 8-16 mesh) for several hours prior to use to reduce the water content to approximately 190 ppm, the

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toluene was dried over 3 angstrom molecular sieves. The reaction solution was heated to a 50°C reaction temperature. The monomer solution was added to the reaction flask from the dropping addition funnel at a rate to maintain the desired reaction temperature with external cooling. Monomer addition time was approximately 15 minutes. The reaction solution was stirred at the desired reaction temperature for a total reaction time of 2 hours.

After completion of the reaction time, the resin solution was vacuum filtered from the acid-treated clay catalyst at room temperature. The reaction flask and catalyst filter cake were rinsed with approximately 100 milliliters of toluene. The solvent was removed from the resin solution at 100°C at 2-5 mm Hg.

After catalyst filtration, the resin oil flask was fitted with a distillation head with an adaptor for an inlet tube and a thermometer, and attached to a condenser with a receiving flask. The resin oil was heated to 235°C with a nitrogen purge followed by a steam purge at 235-245°C to remove light oil products. The steam purge was continued until less than 1 ml of resin was collected per 100 ml of steam condensate or until 1000 ml of steam condensate was collected. The steam purge was followed by a nitrogen purge at 235°C to remove water from the remaining resin.

The resins produced had the properties in Table 19.

TABLE 19

Ex.	Monomer	Catalyst Loading	Yield	Softening Point (R&B)	Molecular Weight			
					Mn	Mw	Mz	PD
122	LRO-90	10 wt%	31%	132°C	760	1060	1540	1.40
123	LRO-90	15 wt%	39%	122°C	670	930	1300	1.38
124	LRO-90	20 wt%	41%	115°C	610	810	1110	1.33
125	DSM/RO60	10 wt%	28%	129°C	750	1040	1500	1.40
126	DSM/RO60	15 wt%	42%	123°C	650	910	1310	1.40
127	DSM/RO60	20 wt%	44%	121°C	650	880	1240	1.37

EXAMPLES 128-133

These examples illustrate the addition of the monomer to a slurry of the catalyst in solvent and the effect of catalyst loading on the resulting softening point and molecular weight of C9 hydrocarbon resins prepared with an amorphous silica-alumina catalyst. Resin

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properties can be controlled through the use of alternate reaction conditions.

A 500 milliliter three neck flask was equipped with an overhead stirrer, reflux condenser, gas inlet and outlet ports, thermometer, and a dropping addition funnel. The flask was charged with 50 grams of toluene (reagent grade, Aldrich, Milwaukee, WI) and the desired level of ground amorphous silica-alumina catalyst, "SAB-30" (UOP, DesPlaines, IL). The silica-alumina was treated at 400°C at 2-5 mm Hg for 4-6 hours prior to use. The C9 monomer feed, 100 grams of either "LRO-90" (Lyondell Petrochemicals, Houston, TX) or a 1:1 mixture of "DSM C9 Resinfeed Classic" (DSM Geleen, The Netherlands) and "Dow Resin Oil 60-L" (Dow Chemical Company Terneuzen, The Netherlands), was added to the dropping addition funnel. The monomers and solvent were dried as follows: the C9 monomer feed was dried by storing a solution over activated alumina (Fischer 8-16 mesh) for several hours prior to use to reduce the water content to approximately 190 ppm, the toluene was dried over 3 angstrom molecular sieves prior to use. The reaction solution was heated to a 50°C reaction temperature. The monomer solution was added to the reaction flask from the dropping addition funnel at a rate to maintain the desired reaction temperature with external cooling. Monomer addition time was approximately 15 minutes. The reaction solution was stirred at the desired reaction temperature for a total reaction time of 2 hours.

After completion of the reaction time, the resin solution was vacuum filtered from the acid-treated clay catalyst at room temperature. The reaction flask and catalyst filter cake were rinsed with approximately 100 milliliters of toluene.

After catalyst filtration, the solvent was removed from the resin solution at 100°C at 2-5 mm Hg. Light oils were removed from the resin products by steam distillation as follows: a single neck flask containing the resin was fitted with a distillation head with an adaptor for an inlet tube and a thermometer and attached to a condenser with a receiving flask. The resin oil was heated to 235°C with a nitrogen purge followed by a steam purge at 235-245°C to remove light oil products. The steam purge was continued until less than 1 ml of resin was collected per 100 ml of steam condensate or until 1000 ml of steam condensate was collected. The steam purge was followed by a nitrogen purge at 235°C to remove water from the remaining resin.

The resins produced had the properties listed in Table 20.

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TABLE 20

Ex.	Monomer	Catalyst Loading	Yield	Softening Point (R&B)	Molecular Weight			
					Mn	Mw	Mz	PD
128	LRO-90	10 wt%	33%	126°C	700	1000	1500	1.42
129	LRO-90	15 wt%	38%	124°C	680	950	1360	1.40
130	LRO-90	20 wt%	31%	121°C	640	880	1220	1.36
131	DSM/RO60	10 wt%	40%	128°C	710	1020	1500	1.43
132	DSM/RO60	15 wt%	44%	122°C	660	970	1430	1.46
133	DSM/RO60	20 wt%	41%	121°C	650	900	1280	1.40

EXAMPLES 134-137

These examples illustrate the reuse of solid acid catalysts for the polymerization of C9 monomer feed streams to prepare hydrocarbon resins.

Catalysts used in Examples 124, 127, 130, and 133 were recovered at the end of each reaction. The catalysts were placed in a soxlet extraction unit and residual resin was extracted from the solid catalysts with toluene for approximately 7 hours. Toluene was allowed to evaporate from the solid catalysts which were then dried under vacuum for 24 hours. The catalysts were then calcined at 120°C for approximately 7 hours prior to use.

Fifteen weight percent of each recovered and regenerated solid acid catalyst was used as the catalyst charge for the reuse experiments. The C9 monomer feed was "LRO-90" (Lyondell Petrochemicals, Houston, TX) or a 1:1 mixture of "DSM C9 Resinfeed Classic" (DSM, Geleen, The Netherlands) and Dow "Resin Oil 60-L" (Dow, Terneuzen, The Netherlands). The reaction apparatus and procedures were essentially the same as those outlined in Examples 122-133, except where noted.

The resins produced from the regenerated catalysts have the properties listed in Table 21.

TABLE 21

Ex.	Monomer	Catalyst	Yield	Softening Point (R&B)	Molecular Weight			
					Mn	Mw	Mz	PD
134	LRO-90	F-22	36%	132°C	750	1100	1700	1.5
135	LRO-90	SAB-30	30%	118°C	650	900	1310	1.4
136	DSM/RO60	F-22	43%	125°C	670	990	1480	1.5
137	DSM/RO60	SAB-30	33%	127°C	700	970	1390	1.4

COMPARATIVE EXAMPLES 138 and 139

These comparative examples illustrate the effect of using acid-treated clay or amorphous silica-alumina without calcination as a solid acid catalyst for the preparation of hydrocarbon resins from C9 unsaturated aromatic hydrocarbon feed stocks.

Fifteen weight percent of catalyst, either "F-22" (Engelhard Corporation, Iselin, NJ) or "SAB-30" (UOP, DesPlaines, IL), was used. Both catalysts were used as received with no treatment to reduce freely-associated water prior to the reaction. The C9 monomer feed used was "LRO-90" from Lyondell Petrochemicals, Houston, TX. The reaction apparatus and procedures were essentially the same as those outlined in Examples 122-133, except where noted.

The resins prepared using these catalysts are summarized in Table 22.

TABLE 22

Comparative Example	Catalyst	Yield	Softening Point (R&B)	Molecular Weight			
				Mn	Mw	Mz	PD
138	F-22	33%	128°C	760	1010	1390	1.3
139	SAB-30	4%	Oil	130	450	3900	3.4

EXAMPLES 140-147

These examples illustrate the use of a variety of acid-treated clays as solid acid catalysts for the preparation of hydrocarbon resins from C9 unsaturated aromatic hydrocarbon feed stocks.

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A 500 milliliter three neck flask was equipped with an overhead stirrer, reflux condenser, gas inlet and outlet ports, thermometer, and a dropping addition funnel. The flask was charged with 50 grams of toluene (reagent grade, Aldrich, Milwaukee, WI) and 12.5 wt% of clay catalyst, "F-22", "F-105", and "F-20X" (Engelhard Corporation, Iselin, NJ) or "K10", "KSF", "KS", "KO", or "KSF/O" (Sud Chemie/United Catalyst Inc., Louisville, KY). The clay was treated at 200°C at 2-5 mm Hg for 4-6 hours prior to use. The C9 monomer feed, 100 grams of "LRO-90" (from Lyondell Petrochemicals, Houston, TX) was added to the dropping additional funnel. The monomers and solvent were dried as follows: the C9 monomer feed was dried by passing through a column of activated alumina (Fischer 8-16 mesh, 0.3 grams of alumina to 1 milliliter of monomer) immediately prior to use, the toluene was dried over 3 angstrom molecular sieves prior to use. The reaction solution was heated to a 60°C reaction temperature. The monomer solution was added to the reaction flask from the dropping addition funnel at a rate to maintain the desired reaction temperature with external cooling. Monomer addition time was approximately 15 minutes. The reaction solution was stirred at the desired reaction temperature for a total reaction time of 2 hours.

After completion of the reaction time, the resin solution was vacuum filtered from the acid-treated clay catalyst at room temperature. The reaction flask and catalyst filter cake were rinsed with approximately 100 milliliters of toluene.

After catalyst filtration, the solvent was removed from the resin solution at 100°C at 2-5 mm Hg. Light oils were removed from the resin products by steam distillation as follows: a single neck flask containing the resin was fitted with a distillation head with an adaptor for an inlet tube and a thermometer and attached to a condenser with a receiving flask. The resin oil was heated to 235°C with a nitrogen purge followed by a steam purge at 235-245°C to remove light oil products. The steam purge was continued until less than 1 ml of resin was collected per 100 ml of steam condensate or until 1000 ml of steam condensate was collected. The steam purge was followed by a nitrogen purge at 235°C to remove water from the remaining resin.

The resins produced had the properties listed in Table 23.

TABLE 23

Example	Catalyst	Yield	Softening Point (R&B)	Molecular Weight			
				Mn	Mw	Mz	PD
140	F-22	33%	123°C	690	940	1340	1.4
141	K 10	15%	117°C	650	920	1390	1.4
142	KSF	none	-	-	-	-	-
143	KS	28%	120°C	670	920	1340	1.4
144	KO	23%	112°C	680	1100	4210	1.6
145	KSF/O	9%	121°C	670	890	1280	1.3
146	F-105	27%	129°C	760	1130	1750	1.5
147	F-20X	44%	116°C	630	1170	2740	1.8

EXAMPLES 148-161

The following examples illustrate a range of resin properties available from the current invention using a C9 unsaturated aromatic hydrocarbon feed stock as the monomer and dried amorphous silica-alumina or acid-treated clay as the catalyst. When combined, the following examples define a 3 x 3 factorial designed experiment for a reaction where monomer is added to a catalyst slurry in solvent. The variables in these experiments include reaction temperature and catalyst loading with the amorphous silica-alumina catalyst. Additional center points have been included using the acid-treated clay catalyst for comparison. Replicate center points were run to estimate experimental error. One skilled in the art can use the results from the following examples to generate a model equation for each measured response in terms of the variables studied. The responses studied in these examples include product yield, Ring and Ball softening point, and molecular weight distribution as defined by weight average molecular weight (Mw), Z average molecular weight (Mz), and polydispersity defined as Mw/Mn (PD).

A 500 milliliter three neck flask was equipped with an overhead stirrer, reflux condenser, gas inlet and outlet ports, thermometer, and a dropping addition funnel. The flask was charged with 50 grams of toluene (reagent grade, Aldrich, Milwaukee, WI) and the desired level of amorphous silica-alumina catalyst "SAB-30" (UOP, DesPlaines, IL) which was ground and passed through a 100 mesh sieve, or acid-treated clay catalyst, "F-22"

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(Engelhard Corporation, Iselin, NJ). The silica-alumina was treated at 400°C at 2-5 mm Hg for 4-6 hours prior to use. The clay was treated at 200°C at 2-5 mm Hg for 4-6 hours prior to use. The C9 monomer feed, 100 grams of "LRO-90" (Lyondell Petrochemicals, Houston, TX) was added to the dropping addition funnel. The monomers and solvent were dried as follows: the C9 monomer feed was dried by passing through a column of activated alumina (Fischer 8-16 mesh, 0.3 grams of alumina to 1 milliliter of monomer) immediately prior to use, the toluene was dried over 3 angstrom molecular sieves prior to use. The reaction solution was heated to the desired reaction temperature. The monomer solution was added to the reaction flask from the dropping addition funnel at a rate to maintain the desired reaction temperature with external cooling. Monomer addition time was approximately 15 minutes. The reaction solution was stirred at the desired reaction temperature for a total reaction time of 2 hours.

After completion of the reaction time, the resin solution was vacuum filtered from the solid catalyst at room temperature. The reaction flask and catalyst filter cake were rinsed with approximately 100 milliliters of toluene.

After catalyst filtration, the solvent was removed from the resin solution at 100°C at 2-5 mm Hg. Light oils were removed from the resin products by steam distillation as follows: a single neck flask containing the resin was fitted with a distillation head with an adaptor for an inlet tube and a thermometer, and attached to a condenser with a receiving flask. The resin oil was heated to 235°C with a nitrogen purge followed by a steam purge at 235-245°C to remove light oil products. The steam purge was continued until less than 1 ml of resin was collected per 100 ml of steam condensate or until 1000 ml of steam condensate was collected. The steam purge was followed by a nitrogen purge at 235°C to remove water from the remaining resin.

The reaction conditions for each example are outlined in Table 24. The level of each variable was coded as -1, 0, and 1 for low, middle, and high, respectively. Use of coded variable values facilitates generation of the model equations for each response. The coded values are included for each example.

TABLE 24

Example	Catalyst	Catalyst Loading (wt%)	Reaction Temperature (°C)
148	SAB-30	12.5 (0)	60 (0)
149	F-22	12.5 (0)	60 (0)
150	SAB-30	5 (-1)	100 (1)
151	SAB-30	20 (1)	60 (0)
152	SAB-30	5 (-1)	20 (-1)
153	SAB-30	12.5 (0)	100 (1)
154	SAB-30	12.5 (0)	60 (0)
155	F-22	12.5 (0)	60 (0)
156	SAB-30	20 (1)	100 (1)
157	SAB-30	12.5 (0)	20 (-1)
158	SAB-30	5 (-1)	60 (0)
159	SAB-30	20 (1)	20 (-1)
160	SAB-30	12.5 (0)	60 (1)
161	F-22	12.5 (0)	60 (1)

The resin properties obtained for each example described in the Table 24 are summarized in Table 25.

TABLE 25

Example	Yield (%)	Softening Point (R&B)	Molecular Weight			
			Mn	Mw	Mz	PD
148	34	119°C	640	890	1290	1.4
149	38	104°C	680	950	1480	1.4
150	24	123°C	530	720	1400	1.4
151	31	100°C	540	720	1060	1.3
152	16	148°C	960	1530	2650	1.6
153	22	99°C	490	600	750	1.2
154	33	115°C	610	830	1180	1.4

Example	Yield (%)	Softening Point (R&B)	Molecular Weight			
			Mn	Mw	Mz	PD
155	32	116°C	620	870	1340	1.4
156	23	86°C	430	530	930	1.2
157	33	139°C	840	1250	2020	1.5
158	11	129°C	750	1030	1730	1.4
159	42	130°C	750	1070	1600	1.4
160	32	116°C	610	840	1270	1.4
161	34	122°C	670	940	1450	1.4

The data from Tables 24 and 25 was analyzed by regression analysis for each of the five responses (steam stripped product yield, Ring and Ball softening point, Mw molecular weight, Mz molecular weight, and polydispersity (Mw/Mn)). The process variables (reaction temperature (TMP) and catalyst loading (CAT)) were coded to -1, 0, and 1 for the low, mid, and high levels respectively. The following regression models were obtained based on the coded variables.

Equation 6

$$\text{Resin Yield \%} = 29.7 + 7.88(\text{CAT}) - 3.5(\text{TMP}) - 5.54(\text{CAT})^2 - 6.52(\text{CAT})(\text{TMP})$$

$$s = 4.24 \quad R^2(\text{adj}) = 76\%$$

Equation 7

$$\text{R \& B Softening Point} = 119 - 13.1(\text{CAT}) - 18.2(\text{TMP}) - 4.75(\text{CAT})(\text{TMP})$$

$$s = 4.145 \quad R^2(\text{adj}) = 94.4\%$$

Equation 8

$$\text{Mw Molecular Weight} = 853 - 156(\text{CAT}) - 333(\text{TMP}) + 36.3(\text{CAT})^2 + 73(\text{TMP})^2 + 67.5(\text{CAT})(\text{TMP})$$

$$s = 24.39 \quad R^2(\text{adj}) = 99.3\%$$

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Equation 9

$$\text{Mz Molecular Weight} = 1207 - 363(\text{CAT}) - 532(\text{TMP}) + 212(\text{CAT})^2 + 209(\text{TMP})^2 + 145(\text{CAT})(\text{TMP})$$

$$s = 88.15 \quad R^2(\text{adj}) = 97\%$$

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Equation 10

$$\text{Polydispersity (Mw/Mn)} = 1.38 - 0.0523(\text{CAT}) - 0.117(\text{TMP})$$

$$s = 0.362 \quad R^2(\text{adj}) = 87.2\%$$

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The regression equations listed above can be used to predict the properties of all resins which can be obtained for a set of reaction conditions where the control variables lie within the intervals tested. Contour plots can be generated to investigate the factor effects and make comparisons of resin properties predicted to be generated using various reaction conditions. Sample contour plots are shown in Figures 6-10 for each response versus catalyst loading and reaction temperature.

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EXAMPLES 162-164

These examples illustrate the ability to predict C9 resin properties for a set of reaction conditions using the regression equations generated from the designed experiment described in Examples 148-161. Reaction procedures were essentially the same as those described for Examples 148-161, except where noted, with specific conditions for each example outlined in Table 26. All reactions were performed using the amorphous silica-alumina "SAB-30" as the catalyst.

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TABLE 26

Example	Catalyst Loading (wt%)	Reaction Temp. (°C)
162	20 wt%	40°C
163	20 wt%	70°C
164	12 wt%	20°C

25

Each example was run in triplicate. The resin properties obtained for each example described in the Table 26 are summarized in Table 27.

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TABLE 27

Example	Yield (%)	Softening Point (R&B)	Molecular Weight		
			Mw	Mz	PD
162 (Model)	37	117°C	880	1300	1.4
162a	35	131°C	1100	1660	1.5
162b	33	128°C	1090	1910	1.5
162c	32	129°C	1070	1590	1.4
163 (Model)	30	100°C	670	970	1.3
163a	28	106°C	750	1060	1.4
163b	26	109°C	790	1410	1.4
163c	28	123°C	800	1100	1.3
164 (Model)	32	138°C	1270	1980	1.5
164a	18	149°C	1580	2770	1.6
164b	19	154°C	1650	2750	1.6
164c	24	150°C	1550	2590	1.7

Values for yield and Ring and Ball softening point for the replicate reactions fall within the interval where 95% of all future runs are predicted to lie. These examples illustrate the utility of the regression equations for predicting available resin properties within the defined range of variables used to generate the model.

EXAMPLES 165-178

The following examples illustrate a range of resin properties available from the current invention using a C9 unsaturated aromatic hydrocarbon feed stock as the monomer and dried amorphous silica-alumina or acid-treated clay as the catalysts. When combined, the following examples serve to define a 3 x 3 factorial designed experiment for a reaction where the catalyst is added as a powder to the monomer in solvent. The variables in these experiments include reaction temperature and catalyst loading with the amorphous silica-alumina catalyst. Additional center points have been included using the acid-treated clay catalyst for comparison. Replicate center points were run to estimate experimental error. One skilled in the art can use the results from the following examples to generate a model equation for each measured response in terms of the variables studied. The responses

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studied in these examples include product yield, Ring and Ball softening point, and molecular weight distribution as defined by weight average molecular weight (M_w), Z average molecular weight (M_z), and polydispersity defined as M_w/M_n (PD).

A 500 milliliter three neck flask was equipped with an overhead stirrer, reflux condenser, gas inlet and outlet ports, thermometer, and a dropping addition funnel. The flask was charged with 100 grams of C9 monomer feed, "LRO-90" (Lyondell Petrochemicals, Houston, TX) and 50 grams of toluene (reagent grade, Aldrich, Milwaukee, WI). The monomers and solvent were dried as follows: the C9 based monomers were dried by passing through a column of activated alumina (Fischer 8-16 mesh, 0.3 grams of alumina to 1 milliliter of monomer) immediately prior to use, the toluene was dried over 3 angstrom molecular sieves prior to use. Amorphous silica-alumina ("SAB-30", UOP, DesPlaines, IL) ground and passed through a 100 mesh sieve was treated at 400°C at 2-5 mm Hg for 4-6 hours prior to use. Acid-treated clay, "F-22" (Engelhard Corporation, Iselin, NJ), was treated at 200°C at 2-5 mm Hg for 4-6 hours prior to use. The catalyst was transferred to the solid addition funnel in a moisture free atmosphere of nitrogen. The reaction solution was cooled to 5 to 10°C below the target reaction temperature prior to catalyst addition and the reaction was allowed to warm to the target reaction temperature as the catalyst was added. The powdered catalysts were added to the reaction from the dropping addition funnel at a rate to maintain the reaction at the target temperature while externally cooling the reaction flask with a -50°C bath. Catalyst addition time was typically 15 minutes. The reaction solution was stirred at the reaction temperature for a total reaction time of 2 hours.

After catalyst filtration, the solvent was removed from the resin solution at 100°C at 2-5 mm Hg. The flask containing the resin oil was fitted with a distillation head with an adaptor for an inlet tube and a thermometer, and attached to a condenser with a receiving flask. The resin oil was heated to 235°C with a nitrogen purge followed by a steam purge at 235-245°C to remove light oil products. The steam purge was continued until less than 1 ml of resin was collected per 100 ml of steam condensate or until 1000 ml of steam condensate was collected. The steam purge was followed by a nitrogen purge at 235°C to remove water from the remaining resin.

The reaction conditions for each example are outlined in Table 28. The level of each variable was coded as -1, 0, and 1 for low, middle, and high, respectively. Use of coded variable values facilitates generation of the model equations for each response. The coded

values are included for each example.

TABLE 28

Example	Catalyst	Catalyst Loading (wt%)	Reaction Temperature (°C)
165	SAB-30	12.5 (0)	60 (0)
166	F-22	12.5 (0)	60 (0)
167	SAB-30	5 (-1)	100 (1)
168	SAB-30	20 (1)	60 (0)
169	SAB-30	5 (-1)	20 (-1)
170	SAB-30	12.5 (0)	100 (1)
171	SAB-30	12.5 (0)	60 (0)
172	F-22	12.5 (0)	60 (0)
173	SAB-30	20 (1)	100 (1)
174	SAB-30	12.5 (0)	20 (-1)
175	SAB-30	5 (-1)	60 (0)
176	SAB-30	20 (1)	20 (-1)
177	SAB-30	12.5 (0)	60 (1)
178	F-22	12.5 (0)	60 (1)

The resin properties obtained for each example described in the Table 28 are summarized in Table 29.

TABLE 29

Example	Yield (%)	Softening Point (R&B)	Molecular Weight			
			Mn	Mw	Mz	PD
165	34	125°C	700	1020	1560	1.5
166	42	129°C	750	1120	1760	1.5
167	24	110°C	580	860	1990	1.5
168	37	121°C	670	970	1480	1.4
169	9	139°C	910	1600	3360	1.8
170	30	105°C	550	780	1490	1.4

Example	Yield (%)	Softening Point (R&B)	Molecular Weight			
			Mn	Mw	Mz	PD
171	35	124°C	700	1020	1870	1.5
172	43	130°C	750	1130	1860	1.5
173	33	110°C	570	780	1260	1.4
174	28	144°C	950	1520	2630	1.6
175	14	135°C	800	1140	2050	1.4
176	42	140°C	880	1380	2270	1.6
177	34	123°C	690	1010	1610	1.5
178	42	131°C	770	1140	1800	1.5

The data from Table 28 and 29 was analyzed by regression analysis for each of the five responses (steam stripped product yield, Ring and Ball softening point, Mw molecular weight, Mz molecular weight, and polydispersity ($PD = Mw/Mn$)). The process variables (reaction temperature (TMP) and catalyst loading (CAT)) were coded to -1, 0, and 1 for the low, mid, and high levels respectively. The following regression models were obtained based on the coded variables.

Equation 11

$$\text{Resin Yield \%} = 32.1 + 11.2(\text{CAT}) - 5.73(\text{CAT})^2 - 6.44(\text{CAT})(\text{TMP})$$

$$s = 2.655 \quad R^2(\text{adj}) = 95\%$$

Equation 12

$$\text{R \& B Softening Point} = 125 - 16.3(\text{TMP})$$

$$s = 4.113 \quad R^2(\text{adj}) = 90\%$$

Equation 13

$$\text{Logarithm(Mw)} = 6.94 - 0.0678(\text{CAT}) - 0.31(\text{TMP}) + 0.0638(\text{TMP})^2$$

$$s = 0.02534 \quad R^2(\text{adj}) = 99\%$$

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Equation 14

$$\text{Logarithm(Mz)} = 7.44 - 0.196(\text{CAT}) - 0.28(\text{TMP}) + 0.188(\text{TMP})^2$$

$$s = 0.06434 \quad R^2(\text{adj}) = 95\%$$

Equation 15

$$\text{Polydispersity (Mw/Mn)} = 1.45 - 0.0517(\text{CAT}) - 0.102(\text{TMP}) + 0.0817(\text{TMP})^2$$

$$s = 0.04512 \quad R^2(\text{adj}) = 81.6\%$$

The regression equations listed above can be used to predict the properties of all resins which can be obtained for a set of reaction conditions where the control variables lie within the intervals tested. Contour plots can be generated to investigate the factor effects and make comparisons of resin properties predicted to be generated using various reaction conditions. Sample contour plots are shown in Figures 11-15 for each response versus catalyst loading and reaction temperature.

EXAMPLES 179-181

These examples illustrate the ability to predict resin properties for a set of reaction conditions using the regression equations generated from the designed experiment described in Examples 165-178. Reaction procedures are essentially the same as those described for Examples 165-178, except where noted, with specific conditions for each example outlined in Table 30. All reactions were performed using "SAB-30", an amorphous silica-alumina, as the catalyst.

TABLE 30

Example	Catalyst Loading (wt%)	Reaction Temp. (°C)
179	17 wt%	70°C
180	17 wt%	100°C
181	19 wt%	20°C

Each example was run in triplicate. The resin properties obtained for each example described in Table 30 are summarized in Table 31.

TABLE 31

Example	Yield (%)	Softening Point (R&B)	Molecular Weight		
			Mw	Mz	PD
179 (Model)	36	121°C	920	1430	1.4
179a	32	119°C	970	1490	1.5
179b	35	121°C	980	1540	1.4
179c	29	121°C	980	1460	1.4
180 (Model)	33	109°C	770	1380	1.4
180a	30	107°C	770	1060	1.3
180b	30	102°C	740	1210	1.4
180c	29	112°C	800	1120	1.4
181 (Model)	43	141°C	1410	2290	1.6
181a	29	145°C	1610	5860	1.7
181b	34	147°C	1590	2670	1.6
181c	36	142°C	1510	2570	1.7

Values for yield and Ring and Ball softening point for the replicate reactions fall within the interval where 95% of all future runs are predicted to lie. These examples illustrate the utility of the regression equations for predicting available resin properties within the defined range of variables used to generate the model.

EXAMPLE 182

This example involves polymerization of a pure monomer hydrocarbon resin followed by hydrogenation of the resin.

POLYMERIZATION OF THE RESIN

In a jacketed one gallon reactor, 38 grams of an acid-treated clay and 1000 grams of toluene were added. The clay was an Engelhard, "F-22", which had been calcined in a tube furnace at 200°C for 2 hours. Dry nitrogen was flowed over the clay bed during the calcination process. The clay/toluene mixture was cooled at 0°C. A mixture of 866 grams of alpha-methyl styrene and 366 grams of styrene were pumped into the 1 gallon reactor at a rate such that the temperature was controlled to 0°C ± 5°C. The time for pumping in the

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monomer was 100 minutes. The reactor was held at 0°C for an additional 3 hours. After filtering the catalyst from the reaction mixture, an aliquot of the mixture was rotary evaporated, with an end condition of 3 mm Hg and 190°C to produce a resin product. The yield of resin was 94% based on the added monomers. The softening point was 97.9°C and molecular weight was 701, Mn; 1060, Mw; and 1580, Mz, with a PD of 1.51.

HYDROGENATION OF THE RESIN

The hydrogenation was carried out in a 1-liter high pressure reactor outfitted for pressure hydrogenations.

To the reactor was added a solution of 287 grams of the resin and 287 grams of Odorless Mineral Spirits and 6.0 grams of "Ni-5256P", a nickel catalyst produced by the Engelhard Corporation. The solution was saturated with hydrogen before the reaction solution was heated. When a temperature of 190°C was reached, the hydrogenation pressure was increased to 1200 psig. Within the first fifteen minutes the reaction exothermed to 259°C. The reaction was held at 250°C and 1200 psig $\pm$ 50 psig for 3 hours. After cooling, the catalyst was filtered from the product solution. The reaction solution was rotary evaporated, with an end condition of 3 mm Hg and 190°C to produce a resin product. The resultant product has a softening point of 103.7°C and molecular weight was 665, Mn; 925, Mw; and 1271, Mz, with a PD of 1.39.

While the invention has been described in connection with certain preferred embodiments so that aspects thereof may be more fully understood and appreciated, it is not intended to limit the invention to these particular embodiments. On the contrary, it is intended to cover all alternatives, modifications and equivalents as may be included within the scope of the invention as defined by the appended claims.

What is claimed is:

1. A process for making a hydrocarbon resin, comprising polymerizing a feed stream comprising at least one member selected from the group consisting of C5 monomers and C9 monomers in the presence of a solid acid catalyst to produce a hydrocarbon resin, wherein substantially all freely-associated water has been removed from the solid acid catalyst, and wherein the solid acid catalyst comprises at least one member selected from the group consisting of acid activated clay, silica-alumina, amorphous silica-alumina, Brønsted acid on silica, Brønsted acid on silica-alumina, zeolites, mesoporous silica-alumina, Brønsted acid on mesoporous silica, and Brønsted acid on mesoporous silica-alumina.

2. The process of claim 1, wherein water removal from the solid acid catalyst comprises calcining at a temperature up to about 700°C.

3. The process of claim 1, wherein the solid acid catalyst comprises acid activated clay.

4. The process of claim 3, wherein the acid activated clay comprises naturally occurring clay mineral comprising at least one member selected from the group consisting of kaolinite, bentonite, attapulgite, montmorillonite, clarit, Fuller's earth, hectorite, and beidellite.

5. The process of claim 3, wherein the acid activated clay comprises synthetic clay comprising at least one member selected from the group consisting of saponite and hydrotalcite.

6. The process of claim 3, wherein the acid activated clay comprises modified clay comprising at least one member selected from the group consisting of aluminum oxide pillared clay, cerium modified alumina pillared clay, and metal oxide pillared clay.

7. The process of claim 3, wherein the acid activated clay comprises Brønsted acid on clay, and wherein the Brønsted acid comprises at least one member selected from the group consisting of hydrofluoric acid, sulfuric acid, nitric acid, phosphoric acid, and hydrochloric acid.

8. The process of claim 1, wherein the solid acid catalyst comprises amorphous silica-alumina.

9. The process of claim 1, wherein the solid acid catalyst comprises Brønsted acid on silica, and wherein the Brønsted acid comprises at least one member selected from

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the group consisting of hydrofluoric acid, sulfuric acid, nitric acid, phosphoric acid, and hydrochloric acid.

10. The process of claim 1, wherein the solid acid catalyst comprises Brønsted acid on silica-alumina, and wherein the Brønsted acid comprises at least one member selected from the group consisting of hydrofluoric acid, sulfuric acid, nitric acid, phosphoric acid, and hydrochloric acid.

11. The process of claim 1, wherein the solid acid catalyst comprises zeolite comprising at least one member selected from the group consisting of zeolite Y, zeolite β , MFI, MEL, NaX, NaY, faujasite, and mordenite.

12. The process of claim 1, wherein the solid acid catalyst comprises mesoporous silica-alumina.

13. The process of claim 1, wherein the solid acid catalyst comprises Brønsted acid on mesoporous silica, and wherein the Brønsted acid comprises at least one member selected from the group consisting of hydrofluoric acid, sulfuric acid, nitric acid, phosphoric acid, and hydrochloric acid.

14. The process of claim 1, wherein the solid acid catalyst comprises Brønsted acid on mesoporous silica-alumina, and wherein the Brønsted acid comprises at least one member selected from the group consisting of hydrofluoric acid, sulfuric acid, nitric acid, phosphoric acid, and hydrochloric acid.

15. The process of claim 1, wherein the feed stream comprises at least C5 monomers comprising at least one member selected from the group consisting of isobutylene, 2-methyl-2-butene, 1-pentene, 2-methyl-1-pentene, 2-methyl-2-pentene, 2-pentene, cyclopentene, cyclohexene, 1,3-pentadiene, 1,4-pentadiene, isoprene, 1,3-hexadiene, 1,4-hexadiene, cyclopentadiene, and dicyclopentadiene.

16. The process of claim 1, wherein the feed stream comprises at least C9 monomers comprising at least one member selected from the group consisting of styrene, vinyl toluene, indene, dicyclopentadiene, and alkylated derivatives thereof.

17. The process of claim 1, wherein the feed stream is contacted with about 0.5 wt% to 30 wt% of the solid acid catalyst based on monomer weight in a batch reactor.

18. The process of claim 1, wherein the solid acid catalyst is added to the feed stream.

19. The process of claim 1, wherein the feed stream is added to a slurry of the

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solid acid catalyst in solvent.

20. The process of claim 1, wherein the feed stream is polymerized at a reaction temperature between about -50°C and 150°C.

21. The process of claim 1, wherein the feed stream comprises at least C5 monomers, and wherein the hydrocarbon resin has a number average molecular weight (Mn) of about 400 to 2000, a weight average molecular weight (Mw) of about 500 to 3500, a Z average molecular weight (Mz) of about 700 to 15,000, and a polydispersity (PD) as measured by Mw/Mn between about 1.2 and 5, where Mn, Mw, and Mz are determined by size exclusion chromatography (SEC).

22. The process of claim 1, wherein the feed stream comprises at least C9 monomers, and wherein the hydrocarbon resin has a number average molecular weight (Mn) of about 400 to 1200, a weight average molecular weight (Mw) of about 500 to 2000, a Z average molecular weight (Mz) of about 700 to 6000, and a polydispersity (PD) as measured by Mw/Mn between about 1.2 and 3.5, where Mn, Mw, and Mz are determined by size exclusion chromatography (SEC).

23. A process for making a hydrocarbon resin, comprising polymerizing a feed stream comprising pure monomer in the presence of a solid acid catalyst to produce a hydrocarbon resin, wherein substantially all freely-associated water has been removed from the solid acid catalyst, and wherein the solid acid catalyst comprises at least one member selected from the group consisting of modified clays, Brønsted acid on clay, amorphous silica-alumina, Brønsted acid on silica, Brønsted acid on silica-alumina, zeolites, mesoporous silica-alumina, Brønsted acid on mesoporous silica, and Brønsted acid on mesoporous silica-alumina.

24. The process of claim 23, wherein the solid acid catalyst comprises modified clay comprising at least one member selected from the group consisting of aluminum oxide pillared clays, cerium modified alumina pillared clays, and metal oxide pillared clays.

25. The process of claim 23, wherein the solid acid catalyst comprises Brønsted acid on clay, and wherein the Brønsted acid comprises at least one member selected from the group consisting of hydrofluoric acid, sulfuric acid, nitric acid, phosphoric acid, and hydrochloric acid.

26. The process of claim 23, wherein the solid acid catalyst comprises amorphous silica-alumina.

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27. The process of claim 23, wherein water removal from the solid acid catalyst comprises calcining at a temperature up to about 700°C.

28. The process of claim 23, wherein the pure monomer comprises at least one member selected from the group consisting of styrene, alpha-methyl styrene, beta-methyl styrene, 4-methyl styrene, and vinyl toluene fractions.

29. The process of claim 23, wherein the feed stream is contacted with about 0.1 wt% to 15 wt% of the solid acid catalyst based on monomer weight in a batch reactor.

30. The process of claim 23, wherein the solid acid catalyst is added to the feed stream.

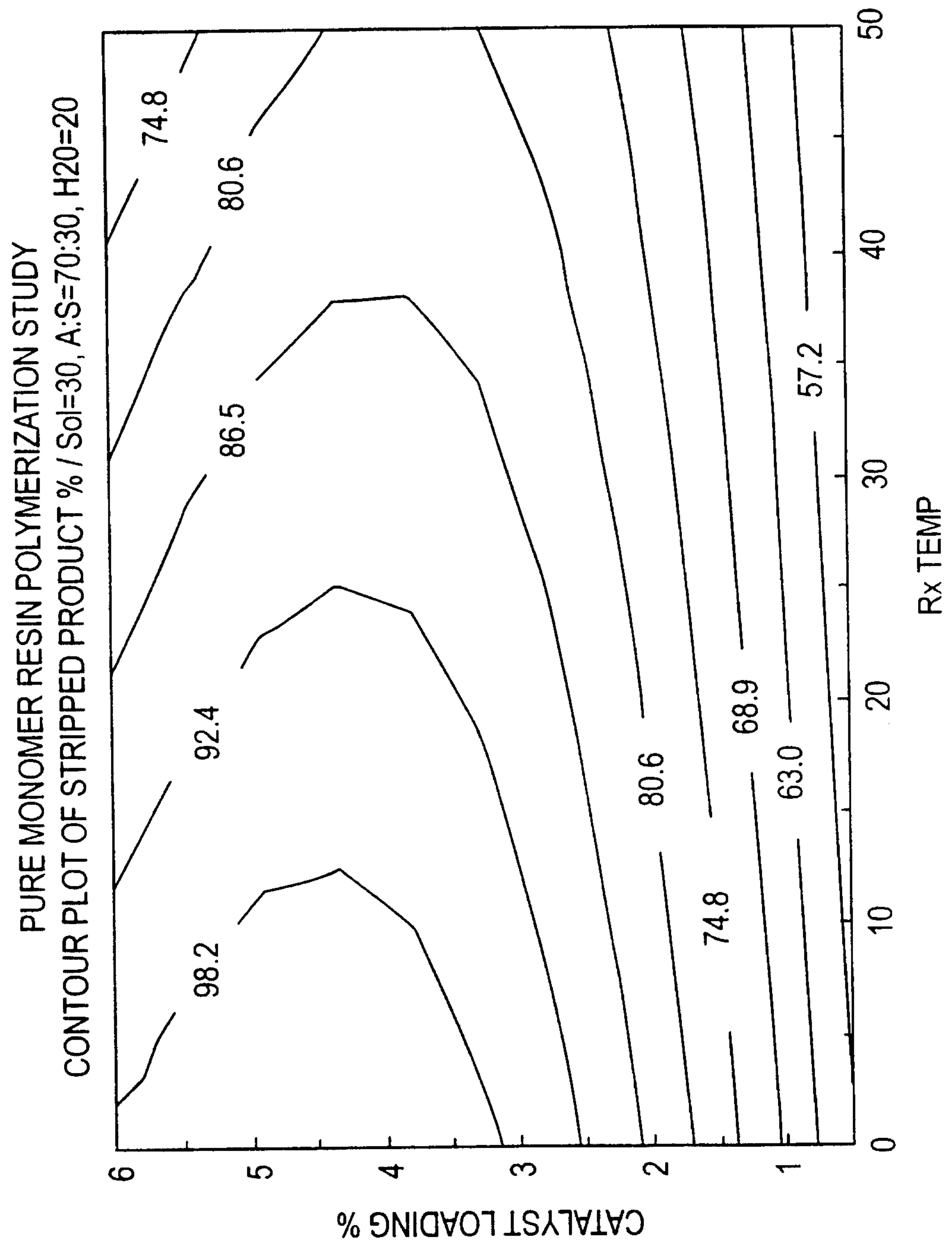
31. The process of claim 23, wherein the feed stream is added to a slurry of the solid acid catalyst in solvent.

32. The process of claim 23, wherein the feed stream is polymerized at a reaction temperature between about -50°C and 100°C.

33. The process of claim 23, wherein the hydrocarbon resin has a number average molecular weight (Mn) ranging from about 400 to 2000, a weight average molecular weight (Mw) ranging from about 500 to 5000, a Z average molecular weight (Mz) ranging from about 500 to 10,000, and a polydispersity (PD) as measured by Mw/Mn between about 1.2 and 3.5, where Mn, Mw, and Mz are determined by size exclusion chromatography (SEC).

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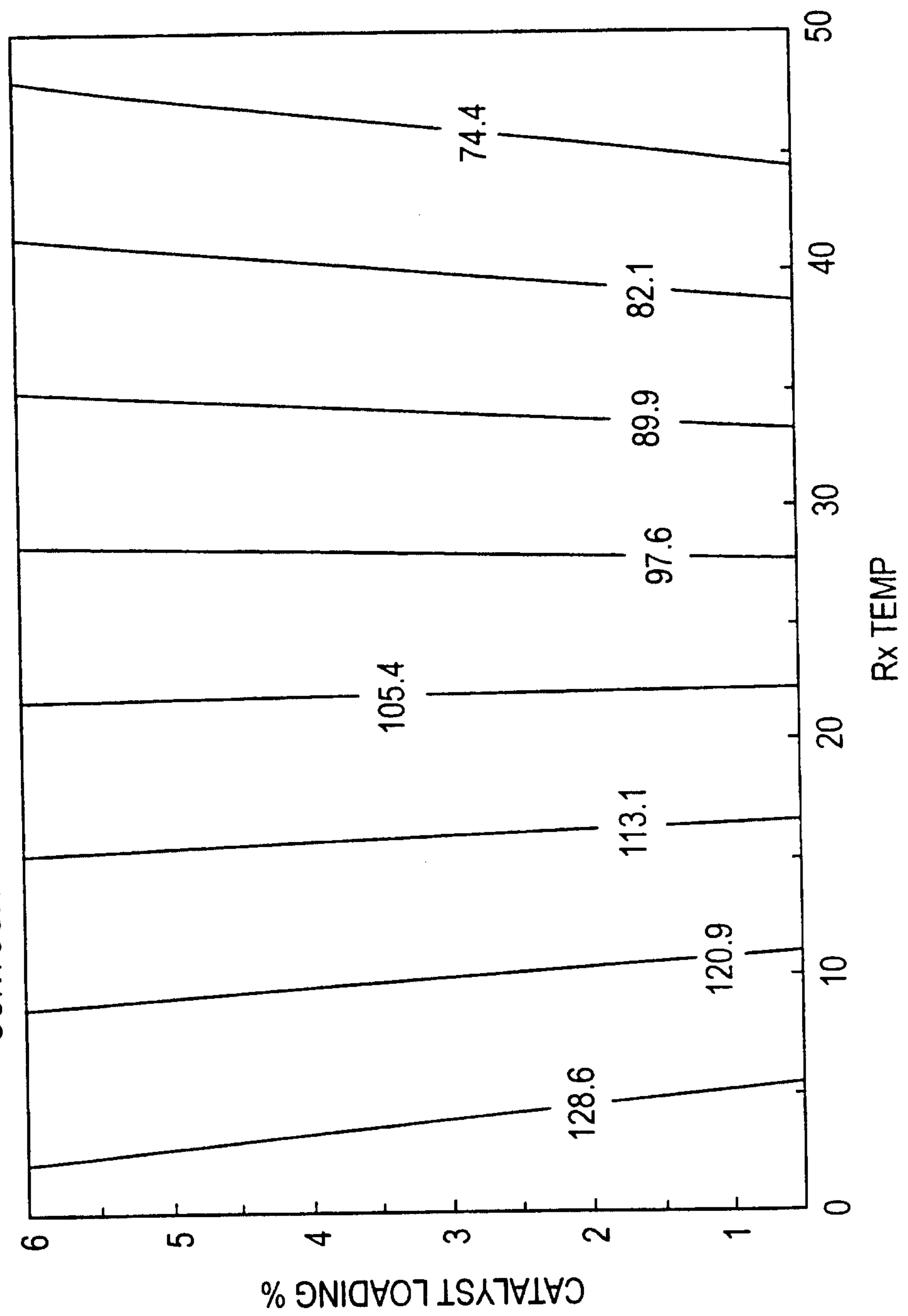
FIG. 1



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FIG. 2

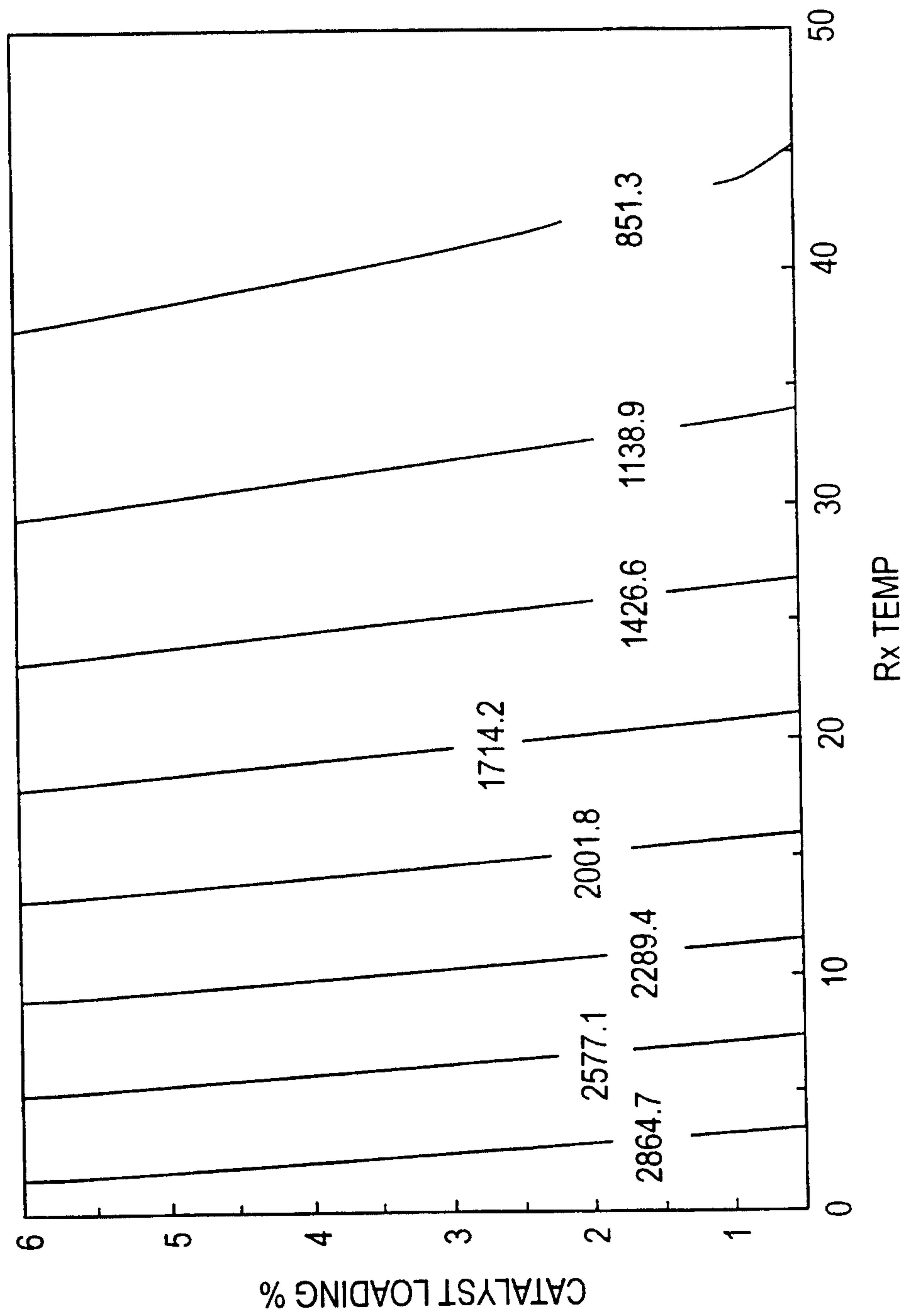
PURE MONOMER RESIN POLYMERIZATION STUDY
CONTOUR PLOT OF R&B SP / Sol=30, A:S=70:30, H2O=20



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FIG. 3

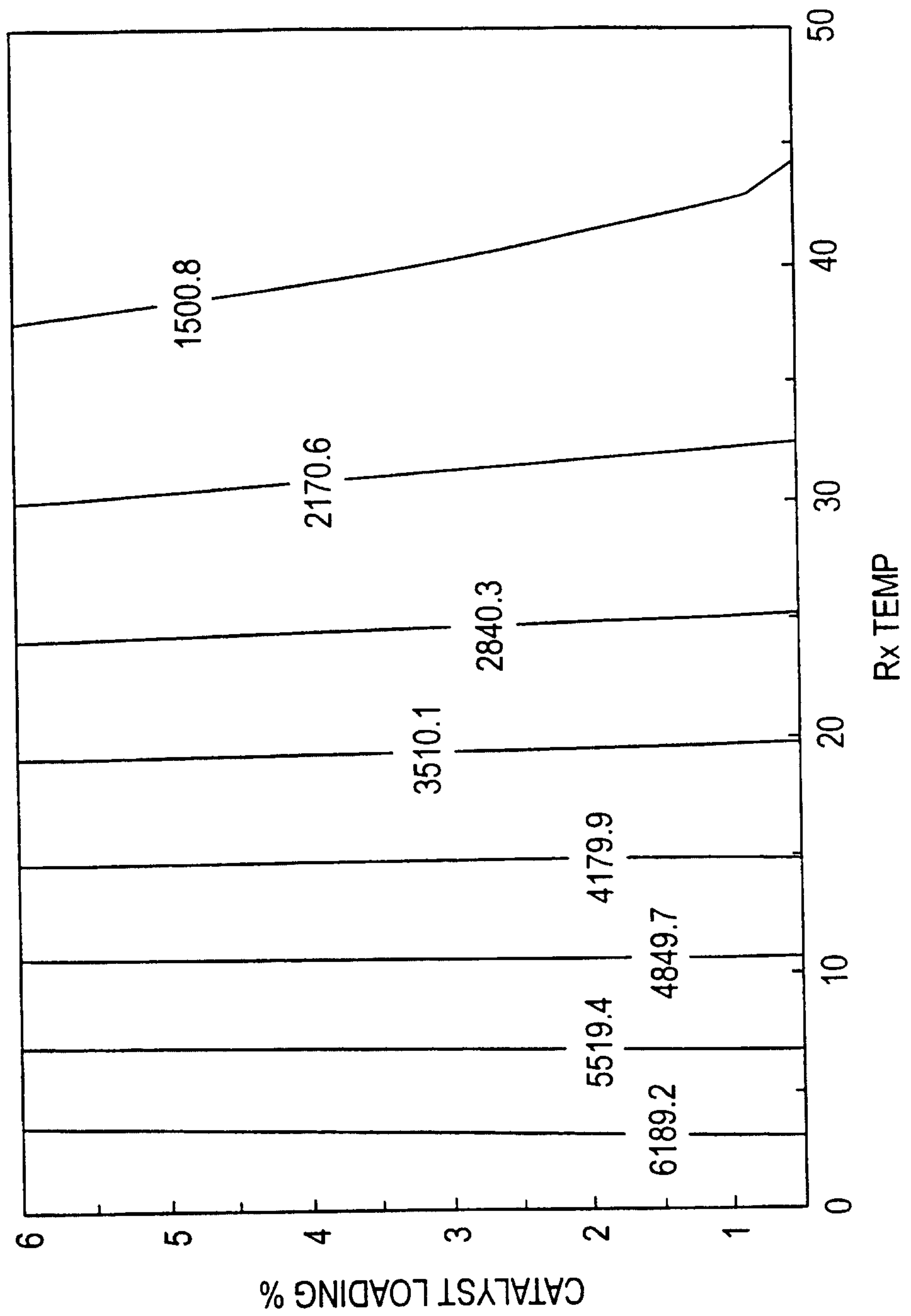
PURE MONOMER RESIN POLYMERIZATION STUDY
CONTOUR PLOT OF Mw / Sol=30, A:S=70:30, H2O=20



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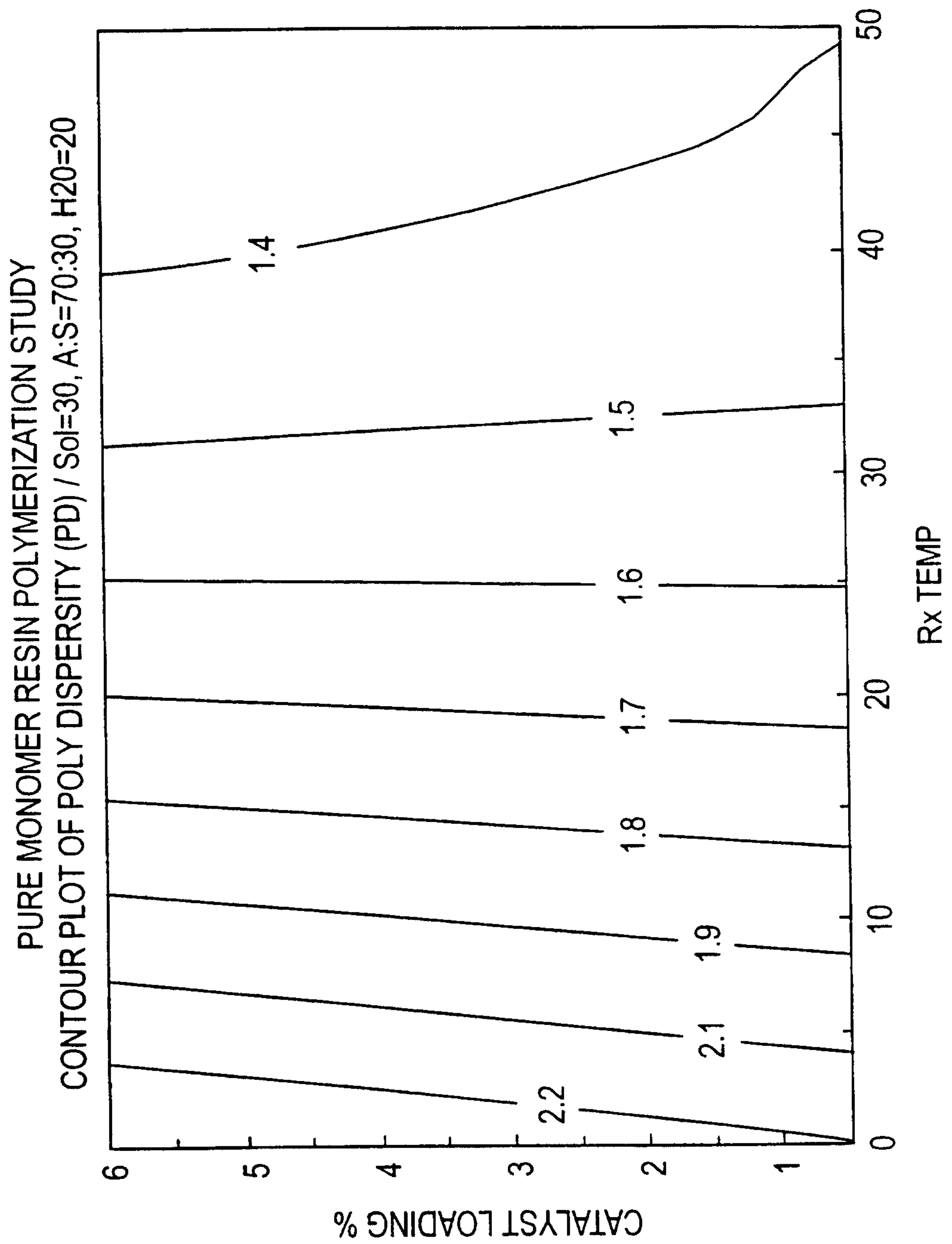
FIG. 4

PURE MONOMER RESIN POLYMERIZATION STUDY
CONTOUR PLOT OF Mz / Sol=30, A:S=70:30, H2O=20



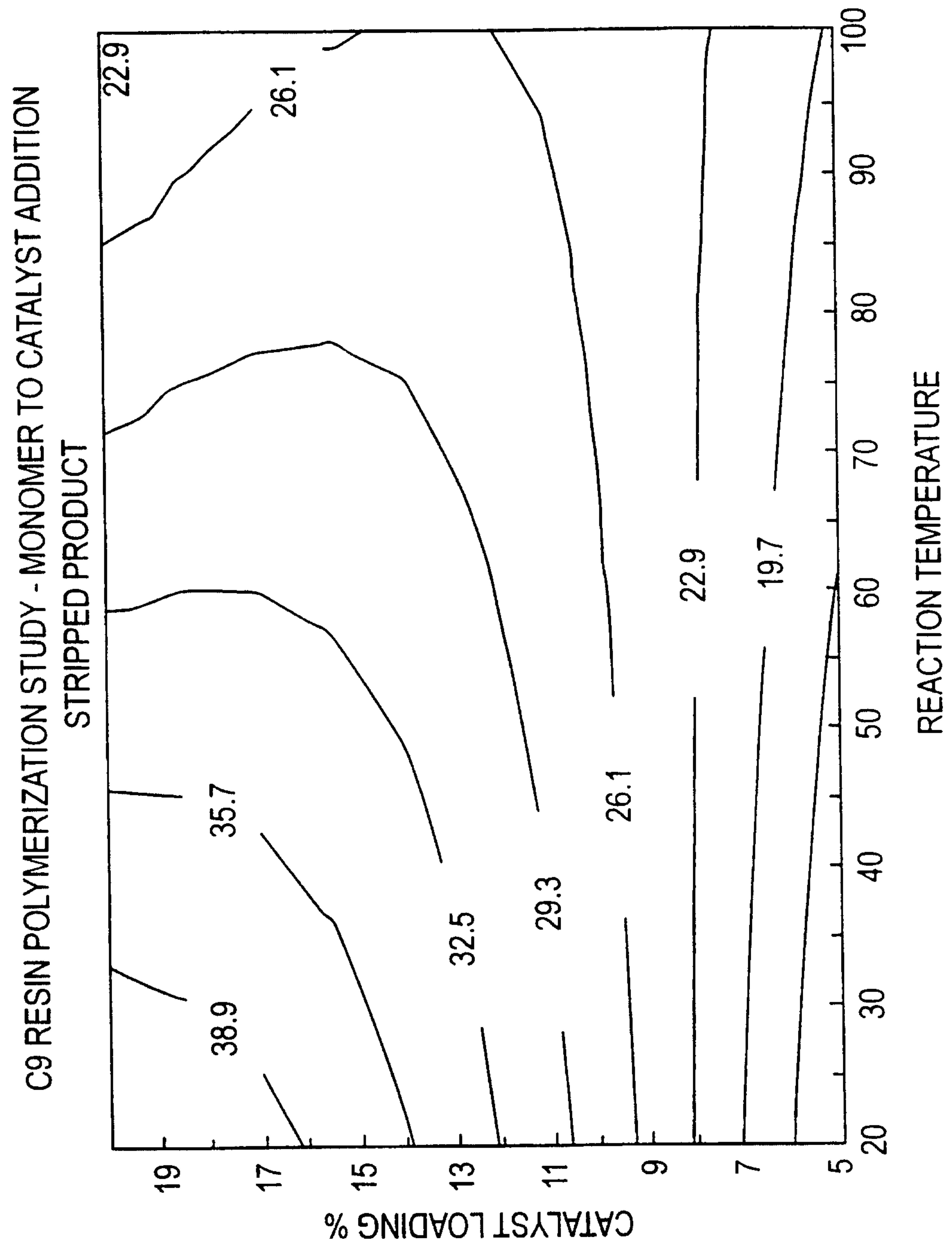
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FIG. 5



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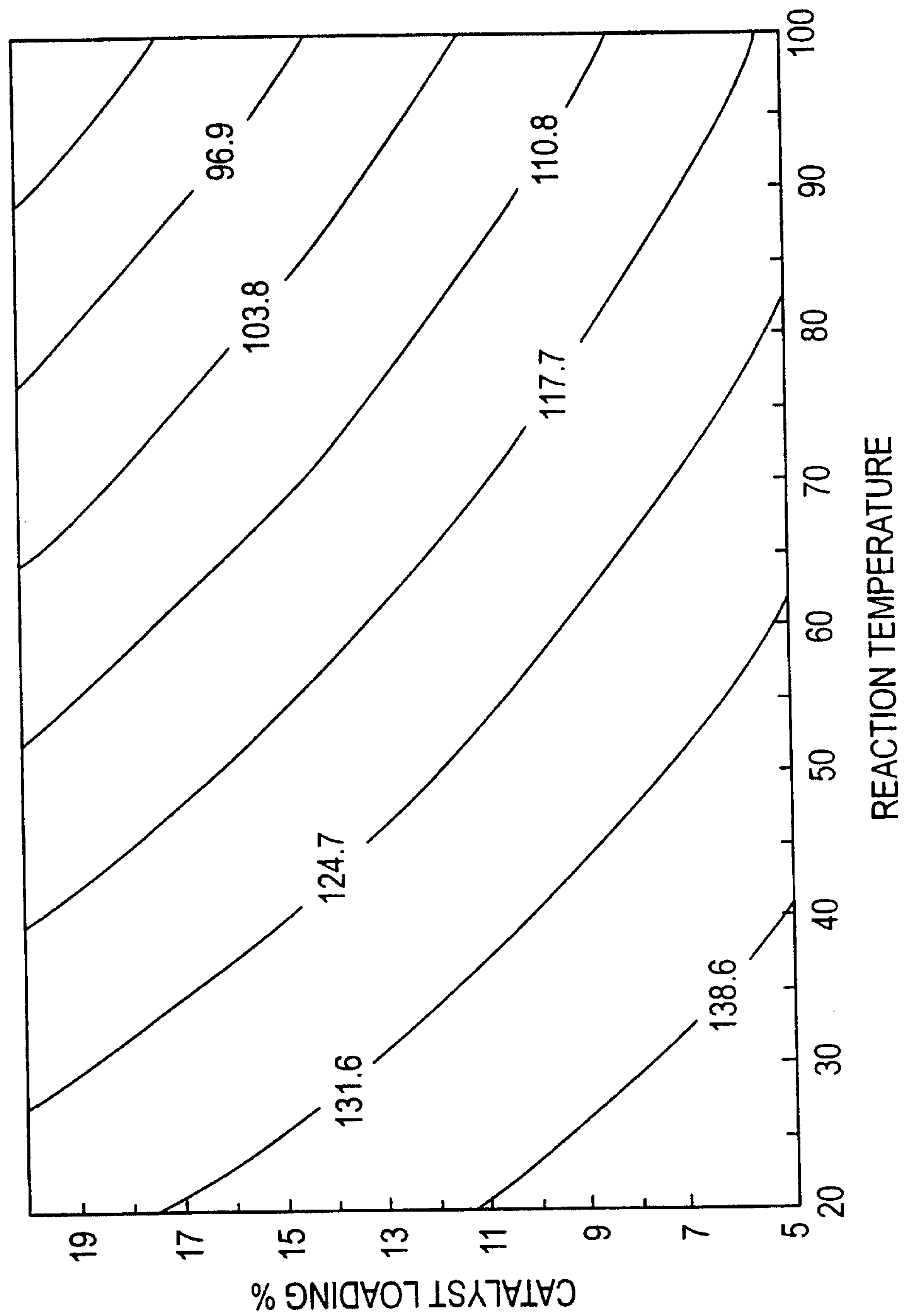
FIG. 6



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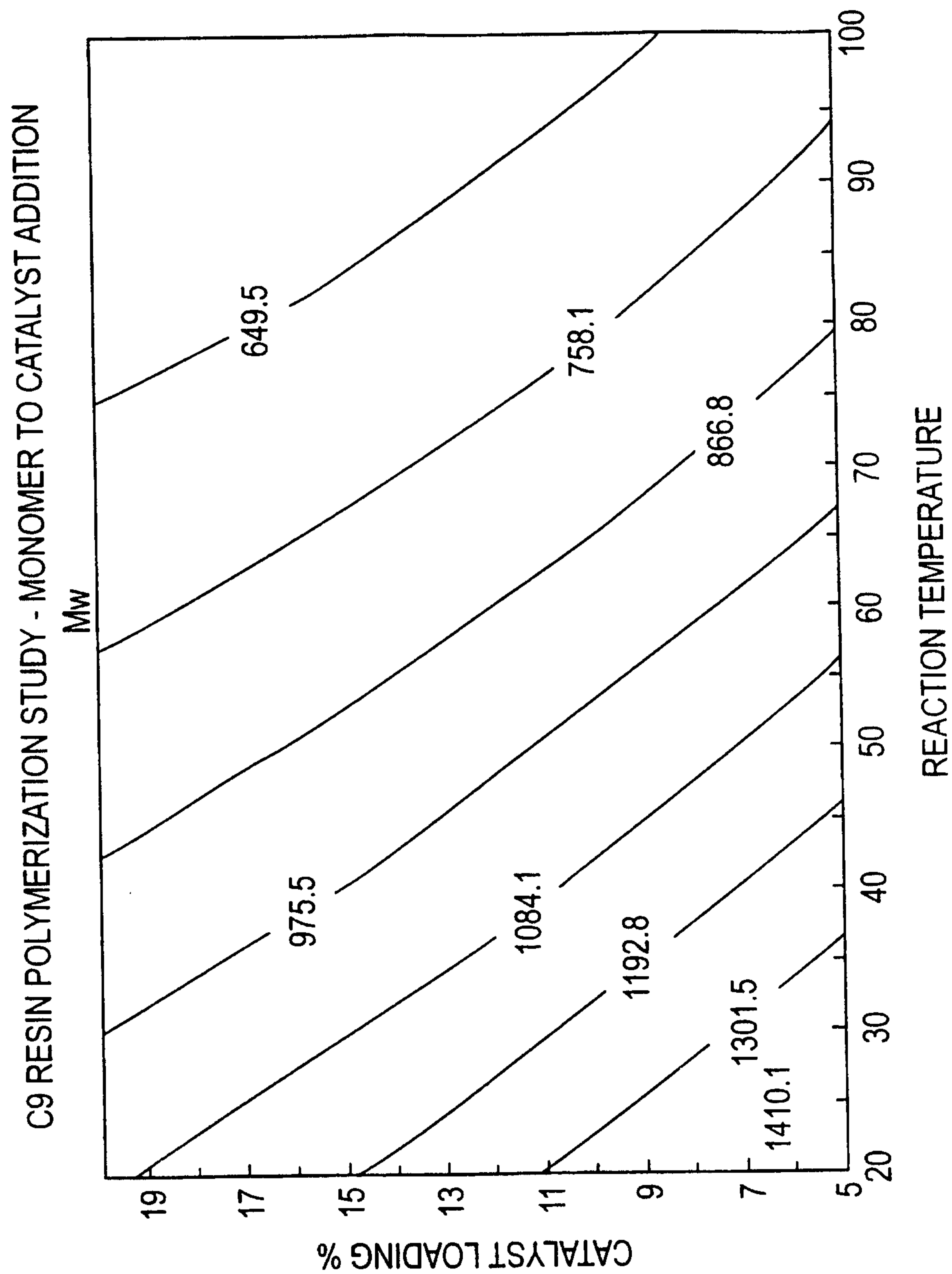
FIG. 7

C9 RESIN POLYMERIZATION STUDY - MONOMER TO CATALYST ADDITION
R&B SOFTENING POINT



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FIG. 8



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FIG. 9

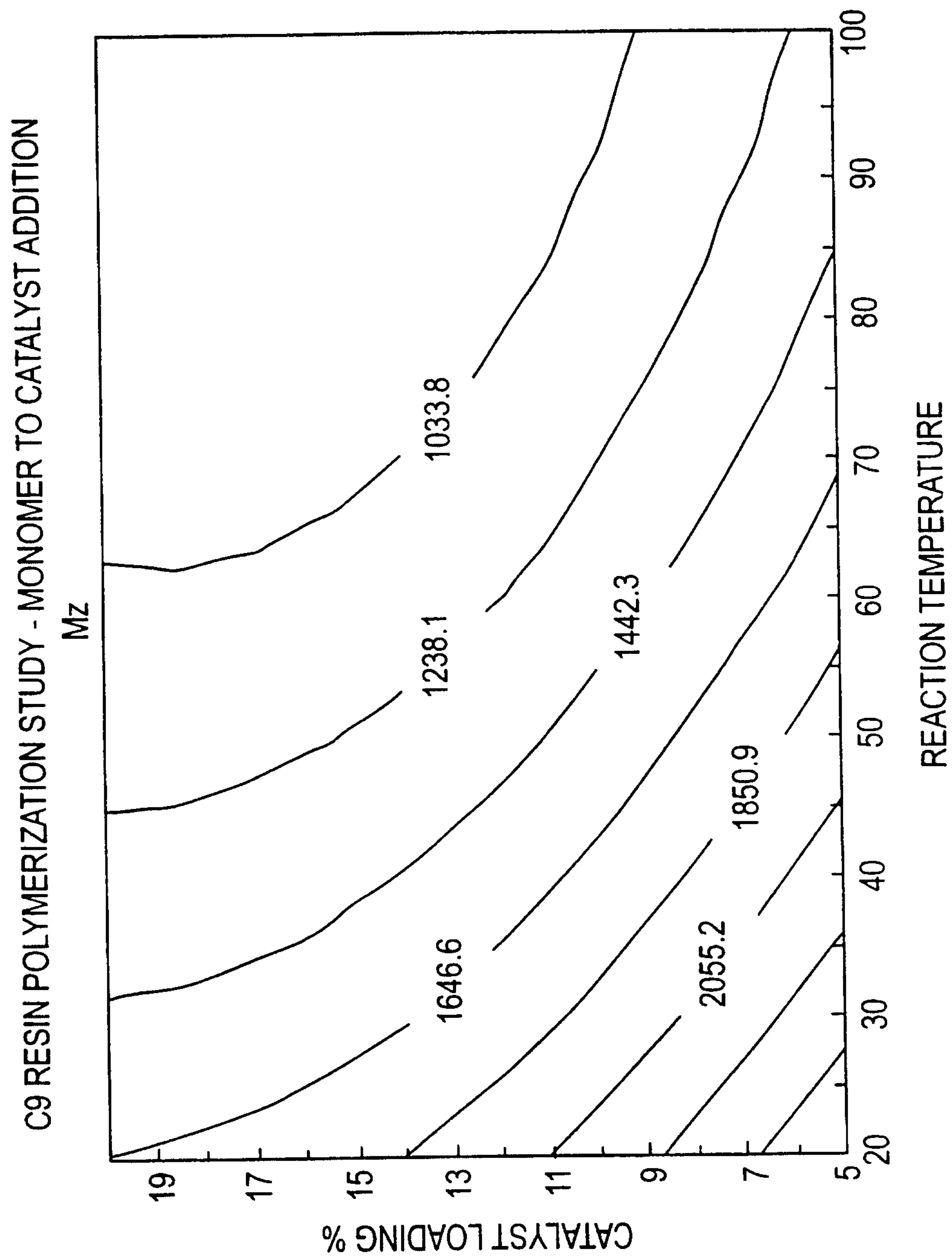
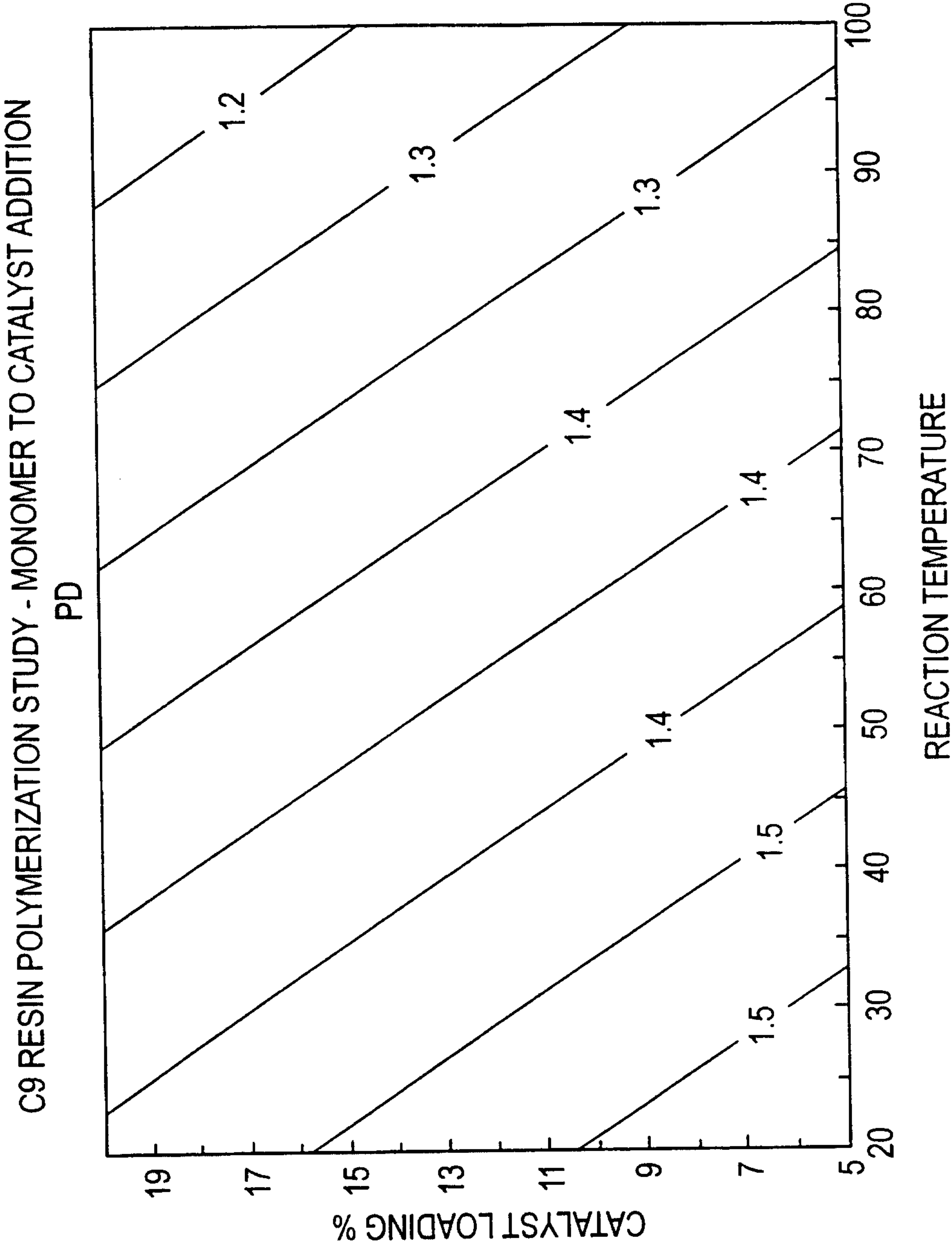
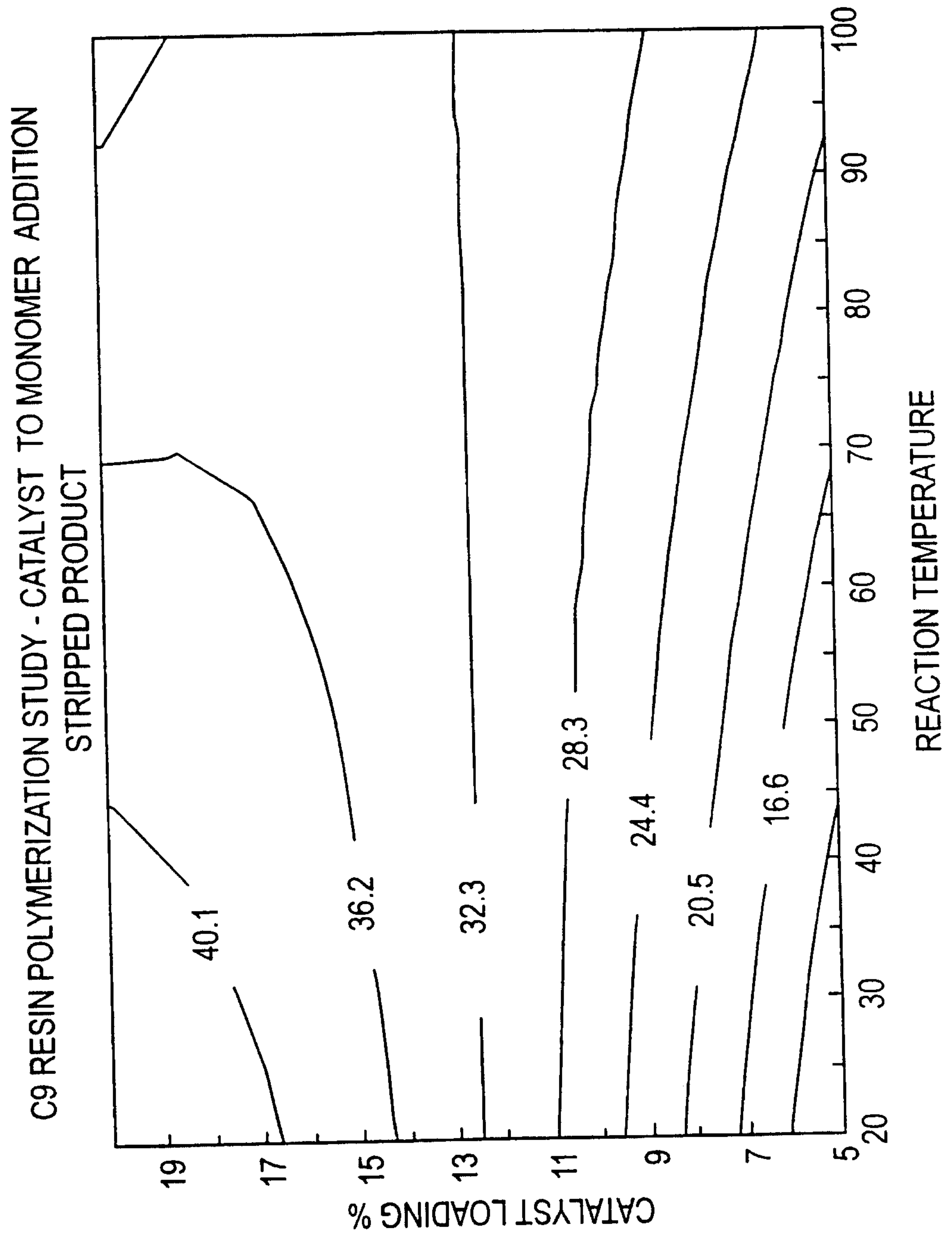


FIG.10



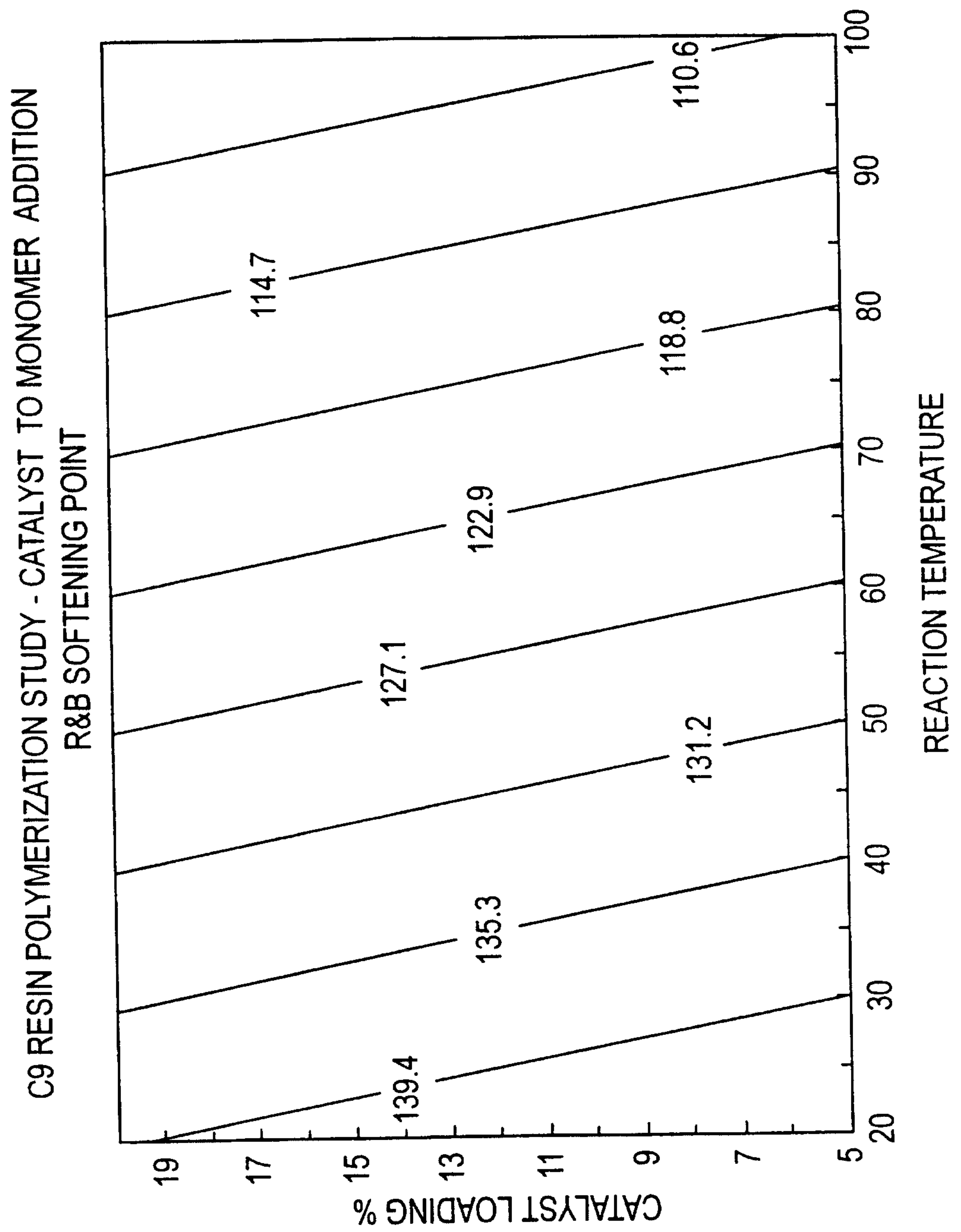
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FIG.11



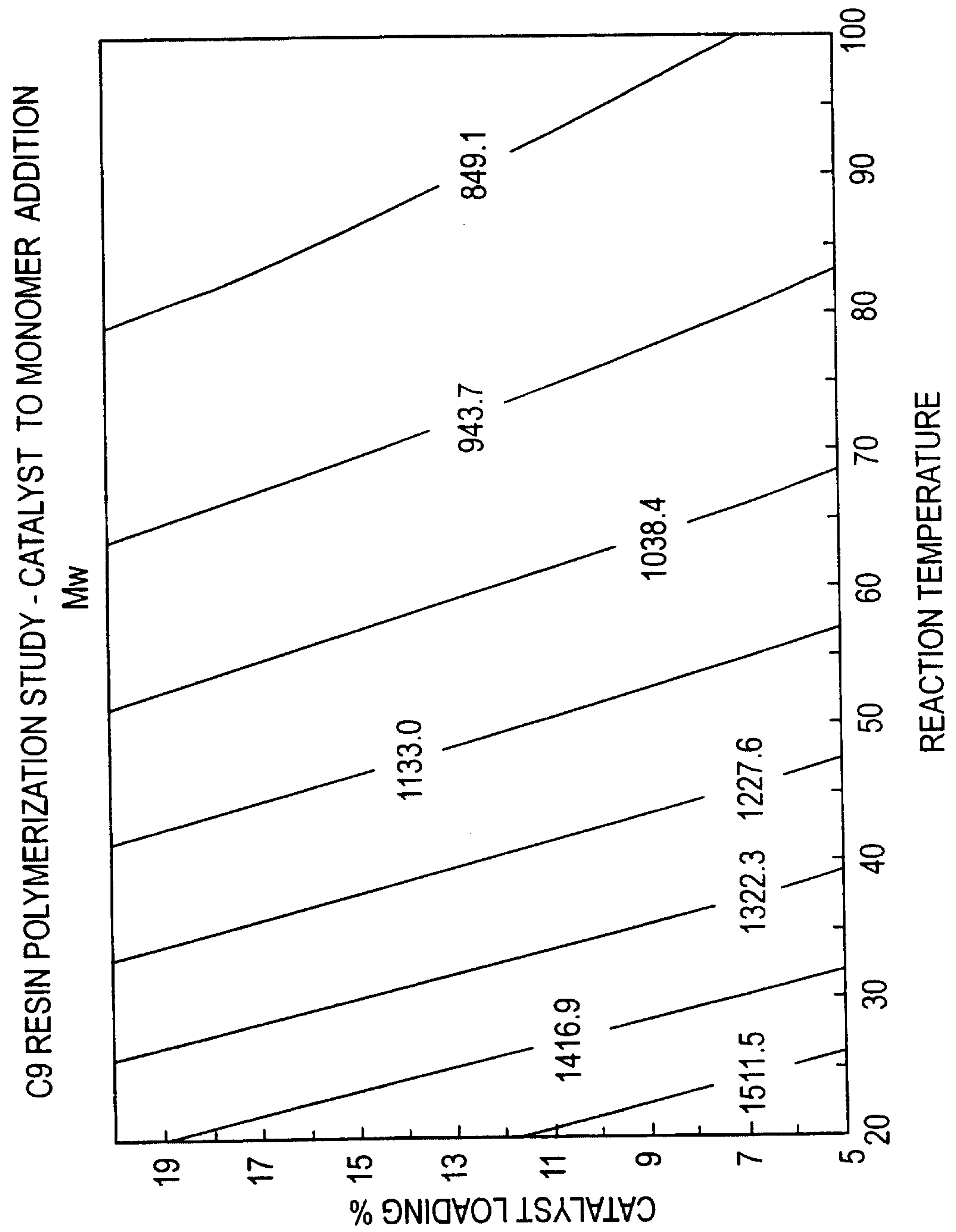
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FIG.12



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FIG.13



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FIG.14

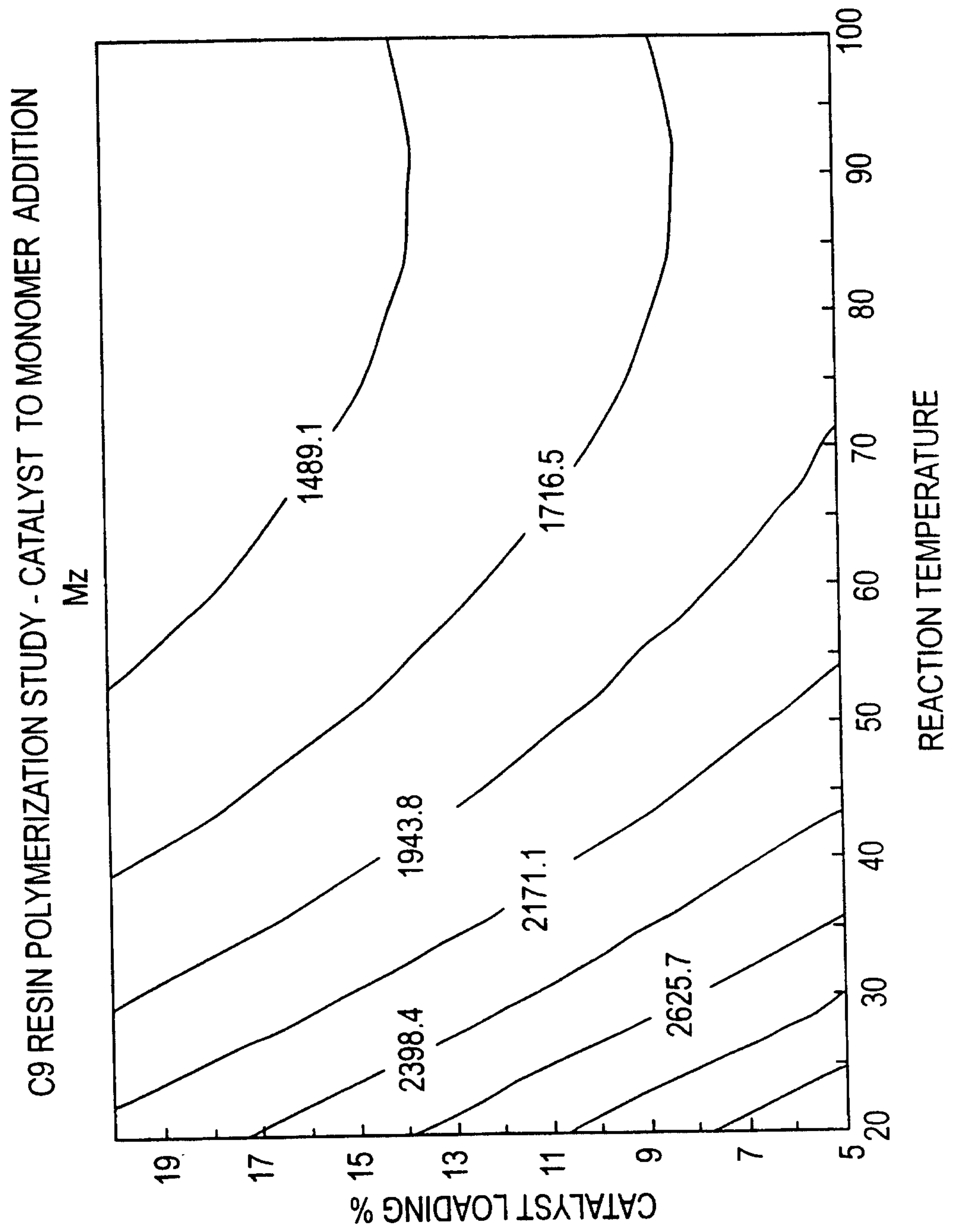


FIG.15

