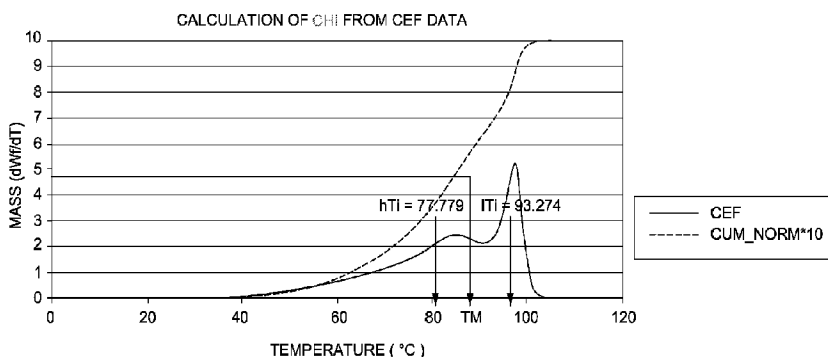




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THEREFROM



(57) **Abrégé/Abstract:**

Methods for making olefin polymerization catalysts and methods for making polymers using the catalysts are provided. The method for making the catalyst can include combining one or more supports with one or more magnesium-containing compounds under reaction conditions to form a first reacted product. One or more chlorinating compounds selected from the group consisting of aluminum alkyl chlorides and chloro substituted silanes can be combined with the first reacted product under reaction conditions to form a second reacted product. One or more titanium-containing compounds selected from the group consisting of titanium alkoxides and titanium halides can be combined with the second reacted product under reaction conditions to form a catalyst.

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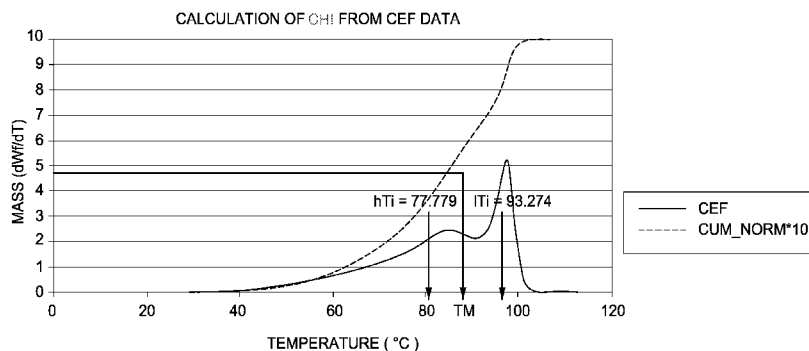
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- (57) Abstract: Methods for making olefin polymerization catalysts and methods for making polymers using the catalysts are provided. The method for making the catalyst can include combining one or more supports with one or more magnesium-containing compounds under reaction conditions to form a first reacted product. One or more chlorinating compounds selected from the group consisting of aluminum alkyl chlorides and chloro substituted silanes can be combined with the first reacted product under reaction conditions to form a second reacted product. One or more titanium-containing compounds selected from the group consisting of titanium alkoxides and titanium halides can be combined with the second reacted product under reaction conditions to form a catalyst.



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**METHODS FOR MAKING CATALYST COMPOSITIONS AND POLYMER  
PRODUCTS PRODUCED THEREFROM**

**BACKGROUND**

[0001] Ziegler-Natta catalysts are widely used to produce polyethylene and copolymers thereof. There are many varieties and methods for making Ziegler-Natta catalysts, such as depositing a titanium complex on a solid support such as magnesium chloride and/or silica. Ziegler-Natta catalysts are fairly inexpensive to produce and usually generate polymer products at high levels of productivity.

[0002] Typical Ziegler-Natta products have a molecular weight distribution (MWD) greater than about 2.0, more commonly greater than about 3.0, and a melt flow ratio (MFR) defined as  $I_{21}/I_2$  ranging from about 24 to about 28. Polyethylene films produced from Ziegler-Natta catalyzed resins are known for excellent toughness and tear properties. To increase production rates when making these polyethylene films it is common to add high pressure low density polyethylene (LDPE) to the Ziegler-Natta catalyzed resins prior to extrusion by dry blending, which reduces the motor load and extruder pressure and can also improve bubble stability for blown films and reduce draw resonance for cast films. LDPE can also be added to linear and substantially linear polyethylene (including polyethylene copolymers) to increase melt strength and suppress draw resonance. Increased melt strength is particularly important in production of thick gauge blown film, especially when a large diameter bubble is required, for example in the production of agricultural films. The suppression of draw resonance is particularly important in cast processes and extrusion coating where, in both cases, the rate of production is often limited by the onset of draw resonance.

[0003] The use of high pressure low density polyethylene, however, is detrimental to most physical properties of Ziegler-Natta catalyst resins. For example, the high pressure low density polyethylene in amounts as low as 4 wt% can cause an ethylene-hexene copolymer to assume the properties of an ethylene-butene copolymer. This undesirable consequence can be offset to a certain extent by increasing the gauge of the film and/or lowering the melt index of the Ziegler-Natta catalyzed resin, but both of these approaches counteract the process benefits of adding the high pressure low density polyethylene.

[0004] There is a need, therefore, for improved catalysts to produce polyethylene copolymers having a significantly increased molecular weight distribution as expressed by MFR. For example, there is a need for polymer products that have an MFR of greater than about 28, or greater than about 35, that can be used in film compositions without the need for blending in high pressure low density polyethylene.

### SUMMARY

[0005] Disclosed herein are methods for making olefin polymerization catalysts and methods for making polymers using those catalysts. The method for making the catalyst can include combining one or more supports with one or more magnesium-containing compounds under reaction conditions to form a first reacted product. One or more chlorinating compounds selected from aluminum alkyl chlorides and chloro substituted silanes can be combined with the first reacted product under reaction conditions to form a second reacted product. One or more titanium-containing compounds selected from titanium alkoxides and titanium halides can be combined with the second reacted product under reaction conditions to form a catalyst.

[0006] The method for making a polyethylene can include combining ethylene with a Ziegler-Natta catalyst in a polymerization reactor at conditions sufficient to produce a polyethylene. The polyethylene can have a molecular weight distribution (MWD) of about 4.5 to about 6.8, a slope of strain hardening greater than about 0.75, as measured by extensional viscosity fixture (EVF), a melt flow ratio (MFR) greater than or equal to  $8.33 + (4.17 \times \text{MWD})$ .

[0006A] The present specification discloses and claims a method for making an olefin polymerization catalyst, consisting of: combining one or more supports with one or more magnesium-containing compounds under reaction conditions to form a first reacted product; combining one or more chlorinating compounds selected from the group consisting of one or more chloro substituted silanes comprising dimethyldichlorosilane, chlorotrimethylsilane, methyltrichlorosilane, diethyldichlorosilane, t-butyl dimethylsilyl chloride, n-butyltrichlorosilane, and a combination thereof with the first reacted product under reaction conditions to form a second reacted product; and combining one or more titanium-containing compounds selected from the group consisting of one or more titanium alkoxides, one or more titanium halides, and a combination thereof with the second reacted product under reaction conditions to form a catalyst, wherein the catalyst is essentially free of electron donor compounds.

[0006B] The present specification also discloses and claims a method for making a polyethylene, comprising: making an olefin polymerization catalyst according to a method as claimed herein; and combining ethylene with the olefin polymerization catalyst in a polymerization reactor at conditions sufficient to produce a polyethylene.

[0006C] The present specification also discloses and claims a polyethylene as prepared by a method as claimed herein, the polyethylene comprising: a molecular weight distribution (MWD) of 4.5 to 6.8; a slope of strain hardening greater than about 0.75, as measured by extensional viscosity fixture (EVF); a melt flow ratio ( $I_{21}/I_2$ ) ranging from 30 to 45, and a melt flow ratio ( $I_{21}/I_2$ ) greater than or equal to  $8.33 + (4.17 \times \text{MWD})$ .

#### **BRIEF DESCRIPTION OF THE DRAWINGS**

[0007] Figure 1 depicts a graphical representation of the Crystallization Elution Fractionation (CEF) data used to calculate the comonomer heterogeneity index (CHI) for Example 19.

[0008] Figures 2 and 3 depict graphical representations that compare the CEF data of Example 18 to comparative example C12 and the CEF data of Example 19 to comparative example C13, respectively.

[0009] Figure 4 depicts the graphical representations of the strain hardening rate ( $0.1 \text{ s}^{-1}$ ) of Examples 18 and 19 and comparative examples C12, C13, and C3.

[0010] Figure 5 depicts a graphical representation of the melt strength for Example 1 and comparative examples C3 and C15.

#### **DETAILED DESCRIPTION**

[0011] Described herein are methods for making an olefin polymerization catalyst. The method may comprise combining one or more supports with one or more magnesium-containing compounds under reaction conditions to form a first reacted product. The first reacted product may then be combined with one or more chlorinating compounds selected from one or more aluminum alkyl chlorides, one or more chloro substituted silanes, and combinations thereof to form a second reacted product. The second reacted product may then be combined with one or more titanium-containing compounds selected from one or more titanium alkoxides, one or more titanium halides, and combinations thereof under reaction conditions to form the polymerization catalyst.

[0012] In some embodiments, the method may comprise combining one or more supports with one or more magnesium-containing compounds under reaction conditions to form a first reacted product; combining one or more aluminum alkyl chlorides with the first reacted product under reaction conditions to form a second reacted product; and combining one or more titanium alkoxides with the second reacted product under reaction conditions to form the polymerization catalyst.

[0013] In some embodiments, the method may comprise combining one or more supports with one or more magnesium-containing compounds under reaction conditions to form a first reacted product; combining one or more chloro substituted silanes with the first reacted product under reaction conditions to form a second reacted product; and combining one or more titanium halides with the second reacted product under reaction conditions to form a catalyst.

[0014] In the above described methods, the one or more supports and the one or more magnesium-containing compounds may be combined with one another in the presence of one or more diluents. For example, the magnesium-containing compound and the support may be combined with one another in the presence of one or more aromatic hydrocarbons, one or more cycloalkanes, or any combination thereof.

[0015] In the above described methods, the first reacted product and the one or more chlorinating compounds may be combined with one another in the presence of one or more diluents.

[0016] Additionally, the second reacted product and the one or more titanium-containing compounds may be combined with one another in the presence of one or more diluents. For example the second reacted product and the one or more titanium-containing compounds may be combined with one another in the presence of one or more diluents to provide the catalyst mixed with the one or more diluents. In such an embodiment, the method for making the polymerization catalyst, may then further comprise removing the one or more diluents from the catalyst to provide a dried catalyst in powder form.

[0017] The catalysts formed by the methods described herein may be essentially free of donor compounds. For example, the catalyst may be essentially free of donor compounds selected from the group consisting of alcohols, thiols, amines, phosphines, ethers, ketones, and esters.

[0018] In some embodiments, the one or more supports and the one or more magnesium-containing compounds may be combined with one another at a temperature of about 20°C to about 120°C and mixed for a time ranging from about 30 minutes to about 24 hours to form the first reacted product. The one or more chlorinating compounds and the first reacted product may then be combined with one another at a temperature of about 20°C to about 120°C and mixed for

a time ranging from about 30 minutes to about 24 hours to form the second reacted product. The one or more titanium-containing compounds and the second reacted product may then be combined with one another at a temperature of about 20°C to about 120°C and mixed for a time ranging from about 30 minutes to about 24 hours to form the polymerization catalyst.

[0019] The above described polymerization catalysts may be combined with ethylene in a polymerization reactor at conditions sufficient to produce polyethylene having improved properties. The polyethylene may be a homopolymer, or may be a copolymer derived from ethylene and one or more C<sub>3</sub> to C<sub>20</sub> alpha-olefin comonomers, or may be a copolymer derived from ethylene and one or more C<sub>3</sub> to C<sub>6</sub> alpha-olefin comonomer

[0020] The polyethylene may have a molecular weight distribution (MWD) of about 4.5 to about 6.8; a slope of strain hardening greater than about 0.75, as measured by extensional viscosity fixture (EVF); and a melt flow ratio ( $I_{21}/I_2$ ) greater than or equal to  $8.33 + (4.17 \times \text{MWD})$ . The polyethylene may also have a long chain branching (LCB) greater than about 0.01 per 1,000 carbon atoms and less than about 0.05 per 1,000 carbon atoms. In preferred embodiments, the long chain branches are composed of more than 6 carbon atoms. The polyethylene may also have a comonomer homogeneity index (CHI) of less than about 0.5.

[0021] The polyethylene may have a density greater than or equal to 0.945 g/cm<sup>3</sup> and a melt strength greater than or equal to  $a \times (3.7463 \times \exp(-1.485 \times \log(\text{MI})))$ , wherein a is equal to 1.5, or 1.75, or 1.9.

[0022] The polyethylene may have a density less than or equal to 0.945 g/cm<sup>3</sup> and a melt strength greater than or equal to  $a \times (3.7463 \times \exp(-1.485 \times \log(\text{MI})))$ , wherein a is equal to 1.2, or 1.5, or 1.9.

#### Support

[0023] As used herein, the terms "support" and "carrier" are used interchangeably and refer to any support material or combination of support materials. The support can be or include one or more porous materials, such as talc, inorganic oxides, and inorganic chlorides. Other supports can be or include resinous materials such as polystyrene, functionalized or crosslinked organic polymers such as polystyrene divinyl benzene polyolefins or other polymeric compounds, or any other organic or inorganic support material, or mixtures thereof. The support can be an amorphous material, crystalline material, or a mixture of amorphous and crystalline material. Illustrative inorganic oxides can include one or more metal oxides of Group 2, 3, 4, 5, 12, 13, or 14 elements. For example, the inorganic oxide can include, but is not limited to, alumina, silica, titania, zirconia, boria, zinc oxide, magnesia, or any combination thereof. Illustrative

combinations of inorganic oxides can include, but are not limited to, alumina-silica, silica-titania, alumina-silica-titania, alumina-zirconia, alumina-titania, and the like. In at least one example, the support can be or include alumina, silica, or a combination thereof. As used herein, all reference to the Periodic Table of the Elements and groups thereof is to the New Notation published in "Hawley's Condensed Chemical Dictionary," Thirteenth Edition, John Wiley & Sons, Inc., (1997) (reproduced there with permission from IUPAC), unless reference is made to the Previous IUPAC form noted with Roman numerals (also appearing in the same), or unless otherwise noted.

[0024] The support can include one or more hydroxyl groups, *e.g.*, a support containing silica can include silanol (Si-OH) groups, in and/or on the support. The hydroxyl groups can be present in an amount ranging from a low of about 0.1 millimoles (mmol), about 0.2 mmol, about 0.3 mmol, about 0.4 mmol, or about 0.5 mmol to a high of about 1 mmol, about 2 mmol, about 3 mmol, about 4 mmol, or about 5 mmol per gram of the support. For example, the hydroxyl groups can be present in an amount of about 0.3 mmol to about 5 mmol, about 0.5 mmol to about 2 mmol, about 0.5 mmol to about 0.9 mmol, or about 0.6 mmol to about 1 mmol per gram of the support. If the number of hydroxyl groups present on the support is greater than a desired amount, the excess hydroxyl groups can be removed by heating the carrier for a sufficient time at a sufficient temperature. For example, a relatively small number of hydroxyl groups can be removed by heating the support to a temperature of about 150°C to about 250°C, whereas a relatively large number of hydroxyl groups may be removed by heating at a temperature of about 500°C to about 800°C, or about 550°C to 650°C. The support can be heated for a time ranging from about 1 hour to about 20 hours, or about 4 hours to about 16 hours, for example. The surface hydroxyl concentration in silica can be determined according to J.B. Peri, and A.L. Hensley, Jr., *J. Phys. Chem.*, vol. 72, No. 8, p. 2926 (1968). An alternative to heating the support to remove at least a portion of any hydroxyl groups can include chemical means. For example, a desired fraction of hydroxyl groups can be reacted with a chemical agent such as a hydroxyl-reactive organoaluminum compound, *e.g.*, triethylaluminum.

[0025] Supports that include two or more inorganic oxides can have any ratio or amount of each inorganic oxide, relative to one another. For example, an alumina-silica catalyst support can include from about 1 wt% alumina to about 99 wt% alumina, based on the total amount of alumina and silica. In another example, an alumina-silica catalyst support can have an alumina concentration ranging from a low of about 2 wt%, about 5 wt%, about 15 wt%, or about 25 wt% to a high of about 50 wt%, about 60 wt%, about 70 wt%, or about 90 wt%, based on the total amount of alumina and silica. A mixed inorganic oxide support can be prepared using any

suitable method. For example, a silica support can be mixed, blended, contacted, or otherwise combined with one or more aluminum compounds to produce a silica support and aluminum compound(s) mixture. In another example, the silica support can be mixed with the one or more aluminum compounds in a water and/or alcohol solution and dried to produce the silica support and aluminum compound(s) mixture. Suitable alcohols can include, but are not limited to, alcohols having from 1 to 5 carbon atoms, and mixtures or combinations thereof. For example, the alcohol can be or include methanol, ethanol, propan-1-ol, propan-2-ol, and the like. Suitable aluminum compounds can include, but are not limited to, aluminum monoacetate ((HO)<sub>2</sub>AlC<sub>2</sub>H<sub>3</sub>O<sub>2</sub>), aluminum diacetate (HOAl(C<sub>2</sub>H<sub>3</sub>O<sub>2</sub>)<sub>2</sub>), and aluminum triacetate (Al(C<sub>2</sub>H<sub>3</sub>O<sub>2</sub>)<sub>3</sub>), aluminum hydroxide (Al(OH)<sub>3</sub>), aluminum diacetate hydroxide (Al(OAc)<sub>2</sub>OH), aluminum tri-acetylacetonate, aluminum fluoride (AlF<sub>3</sub>), sodium hexafluoroaluminate (Na<sub>3</sub>AlF<sub>6</sub>), or any combination thereof.

[0026] The silica support and aluminum compound(s) mixture can be heated (calcined) in the presence of one or more inert gases, oxidants, reducing gases, or in any order/comboination thereof to produce an alumina-silica catalyst support. As used herein, the term "oxidant" can include, but is not limited to, air, oxygen, ultra-zero air, oxygen/inert gas mixtures, or any combination thereof. Inert gases can include, but are not limited to, nitrogen, helium, argon, or combinations thereof. Reducing gases can include, but are not limited to, hydrogen, carbon monoxide, or combinations thereof.

[0027] The silica support and aluminum compound(s) mixture can be heated to a first temperature under nitrogen gas or other inert gas. After heating to the first temperature the nitrogen gas can be stopped, one or more oxidants can be introduced, and the temperature can be increased to a second temperature. For example, the silica support and aluminum compound(s) mixture can be heated under an inert atmosphere to a temperature of about 200°C, the oxidant can be introduced, and the mixture can then be heated to a temperature of from about 450°C to about 1,500°C to produce an alumina-silica catalyst support. The second temperature can range from a low of about 250°C, about 300°C, about 400°C, or about 500°C to a high of about 600°C, about 650°C, about 700°C, about 800°C, or about 900°C. For example, the second temperature can range from about 400°C to about 850°C, about 800°C to about 900°C, about 600°C to about 850°C, or about 810°C to about 890°C. The silica support and aluminum compound(s) mixture can be heated and held at the second temperature for a period of time ranging from about 1 minute to about 100 hours. For example, the silica support and alumina compound(s) mixture can be heated and held at the second temperature for a time ranging from a low of about 30 minutes, about 1 hour, or about 3 hours to a high of about 10 hours, about 20

hours, or about 50 hours. In one or more embodiments, the silica support and alumina compound(s) mixture can be heated from ambient temperature to the second or upper temperature without heating to an intermediate or first temperature. The silica support and alumina compound(s) mixture can be heated under a nitrogen or other inert atmosphere initially, which can be modified to include the one or more oxidants or the atmosphere can be or include the one or more oxidants at the initial heating from ambient temperature.

[0028] The support can be mixed, blended, contacted, or otherwise combined with one or more sources of halide ions, sulfate ions, or a combination of anions to produce an inorganic oxide catalyst support and anion mixture, which can be heated or calcined to produce a suitable support. The support can be contacted with bromine, fluorine, chlorine, compounds containing bromine, fluorine, and/or chlorine, or any combination thereof. Suitable supports can include, but are not limited to, brominated silica, brominated silica-titania, fluorinated silica, fluorinated silica-alumina, fluorinated silica-zirconia, fluorinated-chlorinated silica, fluorinated silica-titania, chlorinated silica, sulfated silica, or any combination thereof. The support can also be treated with one or more metal ions in addition to or in lieu of the one or more halide ion sources and/or sulfate ion sources. Illustrative metal ions can include, but are not limited to, copper, gallium, molybdenum, silver, tin, tungsten, vanadium, zinc, or any combination thereof. Suitable activated supports can include those discussed and described in PCT Publication No. WO 2011/103402.

[0029] The support can have an average particle size ranging from a low of about 0.1  $\mu\text{m}$ , about 0.3  $\mu\text{m}$ , about 0.5  $\mu\text{m}$ , about 1  $\mu\text{m}$ , about 5  $\mu\text{m}$ , about 10  $\mu\text{m}$ , or about 20  $\mu\text{m}$  to a high of about 50  $\mu\text{m}$ , about 100  $\mu\text{m}$ , about 200  $\mu\text{m}$ , or about 500  $\mu\text{m}$ . The support can have an average pore size ranging from about 10  $\text{\AA}$  to about 1,000  $\text{\AA}$ , preferably from about 50  $\text{\AA}$  to about 500  $\text{\AA}$ , and more preferably from about 75  $\text{\AA}$  to about 350  $\text{\AA}$ . The support can have a pore volume ranging from a low of about 0.01  $\text{cm}^3/\text{g}$ , about 0.1  $\text{cm}^3/\text{g}$ , about 0.8  $\text{cm}^3/\text{g}$ , or about 1  $\text{cm}^3/\text{g}$  to a high of about 2  $\text{cm}^3/\text{g}$ , about 2.5  $\text{cm}^3/\text{g}$ , about 3  $\text{cm}^3/\text{g}$ , or about 4  $\text{cm}^3/\text{g}$ . Internal porosity of the support can be determined by a technique termed BET-technique, described by S. Brunauer, P. Emmett and E. Teller in *Journal of the American Chemical Society*, 60, pp. 209-319 (1938). The support can have a surface area ranging from a low of about 1  $\text{m}^2/\text{g}$ , about 50  $\text{m}^2/\text{g}$ , or about 100  $\text{m}^2/\text{g}$  to a high of about 400  $\text{m}^2/\text{g}$ , about 500  $\text{m}^2/\text{g}$ , or about 800  $\text{m}^2/\text{g}$ . The surface area of the support can be measured in accordance with the above-mentioned BET-technique, with use of the standardized method as described in British Standards BS 4359, Volume 1, (1969).

[0030] Suitable commercially available silica supports can include, but are not limited to, ES757, ES70, and ES70W available from PQ Corporation. Suitable commercially available

silica-alumina supports can include, but are not limited to, SIRAL<sup>®</sup> 1, SIRAL<sup>®</sup> 5, SIRAL<sup>®</sup> 10, SIRAL<sup>®</sup> 20, SIRAL<sup>®</sup> 28M, SIRAL<sup>®</sup> 30, and SIRAL<sup>®</sup> 40, available from SASOL<sup>®</sup> and Davison 948, Davison 952, and Davison 955, available from W.R. Grace & Co.

[0031] Suitable supports can be as described in U.S. Patent Nos.: 4,173,547; 4,701,432; 4,808,561; 4,912,075; 4,925,821; 4,937,217; 5,008,228; 5,238,892; 5,240,894; 5,332,706; 5,346,925; 5,422,325; 5,466,649; 5,466,766; 5,468,702; 5,529,965; 5,554,704; 5,629,253; 5,639,835; 5,625,015; 5,643,847; 5,665,665; 5,698,487; 5,714,424; 5,723,400; 5,723,402; 5,731,261; 5,759,940; 5,767,032; and 5,770,664; and WO 95/32995; WO 95/14044; WO 96/06187; and WO 97/02297.

#### Magnesium-Containing Compound

[0032] The one or more magnesium-containing compounds can be represented by the formula  $R^1-Mg-R^2$ , where  $R^1$  and  $R^2$  are independently selected from the group consisting of hydrocarbyl groups, and halogen atoms. Suitable hydrocarbyl groups can include, but are not limited to, alkyl groups, aryl groups, and alkoxy groups. The alkyl groups, and/or alkoxy groups can include from 1 to 12 carbon atoms, or from 1 to 10 carbon atoms, or from 1 to 8 carbon atoms, or from 1 to 6 carbon atoms, or from 1 to 4 carbon atoms. The aryl groups can include from 6 to 12 carbon atoms, or from 6 to 10 carbon atoms, or from 6 to 8 carbon atoms. Suitable halogens can include fluoride, chloride, and bromide.

[0033] Illustrative magnesium-containing compounds can include, but are not limited to, dialkylmagnesiums, dicycloalkylmagnesiums, diarylmagnesiums, alkylmagnesium halides, or any combination thereof. Illustrative dialkylmagnesiums can include, but are not limited to, diethylmagnesium, dipropylmagnesium, di-isopropylmagnesium, di-n-butylmagnesium, di-isobutylmagnesium, diamylmagnesium, di-n-octylmagnesium, di-n-hexylmagnesium, di-n-decylmagnesium, di-n-dodecylmagnesium, or any combination thereof. Illustrative dicycloalkylmagnesiums can include, but are not limited to, dicyclohexylmagnesium, dicyclopentylmagnesium, or any combination thereof. Illustrative diarylmagnesiums can include, but are not limited to, dibenzylmagnesium, ditolylmagnesium, dixylylmagnesium, or any combination thereof. Illustrative magnesium alkyls that include two different alkyl groups can include, but are not limited to, ethyl-n-propylmagnesium, ethyl-n-butylmagnesium, amyl-n-hexylmagnesium, n-butyl-s-butylmagnesium, n-butyl-n-octylmagnesium, or any combination thereof. Illustrative alkylmagnesium halides can include, but are not limited to, methylmagnesium chloride, ethylmagnesium chloride, n-butylmagnesium chloride, t-butylmagnesium chloride, isopropylmagnesium chloride, methylmagnesium bromide, ethylmagnesium bromide, n-butylmagnesium bromide, or any combination thereof.

[0034] It should be noted that magnesium alkyls may contain a mixture of molecules. For example, ethylmagnesium chloride may contain a mixture of molecules other than ethylmagnesium chloride, per se. For example, if a liquid or solvent is combined with ethylmagnesium chloride, the ethylmagnesium chloride may disproportionate to form a mixture of magnesium dichloride and diethylmagnesium. Such mixtures are encompassed within the general formula  $R^1MgR^2$ . Accordingly, it should be understood that compositions of the formula  $R^1-Mg-R^2$  and compositions representative thereof are intended to represent the overall empirical formula of these compositions rather than to set forth the molecular formula of these compositions.

#### First Reacted Product

[0035] The support and the magnesium-containing compound can be combined with one another to provide or form a first mixture or first reacted product. The support and the magnesium-containing compound can at least partially react with one another during mixing thereof. Said another way, the support and the magnesium-containing compound can be combined with one another under reaction conditions such that the support and the magnesium-containing compound at least partially react with one another to form a reacted first mixture or reacted first product. For example, if the support contains one or more hydroxyl groups, the magnesium-containing compound can react with at least some of the hydroxyl groups to produce a reacted first mixture or first reacted product.

[0036] The mixture of the support and the magnesium-containing compound can be heated to a temperature ranging from a low of about 20°C, about 25°C, or about 30°C to a high of about 60°C, about 75°C, or about 120°C, for example, with suitable ranges comprising the combination of any lower temperature and any upper temperature. If the diluent is present, the temperature of the mixture can be maintained below a boiling point of the diluent. The support and the magnesium-containing compound can be mixed, blended, stirred, or otherwise agitated for a time ranging from a low of about 15 minutes, about 30 minutes, about 1 hour, about 2 hours, or about 3 hours to a high of about 5 hours, about 10 hours, about 15 hours, about 20 hours, about 25 hours, or more. The support and the magnesium-containing compound can be combined with one another and mixed under a vacuum, e.g., 50 kPa. The support and the magnesium-containing compound can be combined with one another and mixed at atmospheric pressure. The support and the magnesium-containing compound can be combined with one another and mixed under pressure, e.g., a pressure ranging from about 102 kPa to about 500 kPa. The support and the magnesium-containing compound can be combined with one another under an inert atmosphere. Inert atmospheres can be or include, but are not limited to, nitrogen, argon,

helium, or any combination thereof. In another example, the support and the magnesium-containing compound can be combined with one another in a substantially inert atmosphere. The substantially inert atmosphere can be an atmosphere that contains less than about 5 mol% oxygen, less than about 3 mol% oxygen, less than about 2 mol% oxygen, less than about 1 mol% oxygen, less than about 0.5 mol% oxygen, less than about 0.1 mol% oxygen, or less than about 0.05 mol% oxygen.

[0037] The amount of the magnesium-containing compound combined with the support can range from a low of about 0.2 mmol, about 0.5 mmol, about 1 mmol, about 1.5 mmol, or about 2 mmol to a high of about 3 mmol, about 4 mmol, about 6 mmol, about 8 mmol, or about 12 mmol per gram of the support, with suitable ranges comprising the combination of any lower amount and any upper amount. For example, the amount of the magnesium-containing compound combined with the support can range from about 0.3 mmol to about 10 mmol, about 1 mmol to about 7 mmol, about 1.5 mmol to about 5 mmol, about 1.5 mmol to about 4 mmol, or about 2 mmol to about 3 mmol of the magnesium-containing compound per gram of the support.

[0038] If the support is added to the magnesium-containing compound or the magnesium-containing compound is added to the support, the support or the magnesium-containing compound can be added all at once or over a period of time. The magnesium-containing compound can be added over a period of time ranging from a low of about 1 minute, about 5 minutes, about 10 minutes or about 15 minutes to a high of about 45 minutes, about 1 hour, about 2 hours, about 4 hours, about 6 hours or more. For example, the magnesium-containing compound can be added to the support of a time of about 15 minutes to about 45 minutes, about 20 minutes to about 1 hour, or about 30 minutes to about 1.5 hours. The support and the magnesium-containing compound can be continuously or intermittently stirred over during the time the magnesium-containing compound is added to the support.

[0039] The support and the magnesium-containing compound can be combined with one another in the presence of one or more diluents to form a solution or slurry thereof. The diluent, if present, can be any liquid medium or combination of liquid mediums suitable for forming a slurry of the support, the magnesium-containing compound, or the mixture of the support and magnesium-containing compound. Illustrative diluents can include, but are not limited to, one or more alkanes, one or more aromatic hydrocarbons, one or more cycloalkanes, or any combination thereof. Illustrative alkanes can include, but are not limited to, pentane, hexane, heptane, octane, nonane, decane, structural isomers thereof, stereoisomers thereof, enantiomers thereof, or any combination thereof. Illustrative aromatic hydrocarbons can include, but are not limited to, benzene, toluene, xylenes, o-xylene, m-xylene, p-xylene, or any combination thereof.

Illustrative cycloalkanes can include, but are not limited to, cyclohexane, methylcyclohexane, or a combination thereof.

[0040] The amount of the diluent, if present, can be sufficient to produce a slurry of the support and the magnesium-containing compound. The amount of diluent can range from a low of about 0.5 g, about 1 g, about 2 g, or about 2.5 g to a high of about 5 g, about 7 g, about 10 g, or about 25 g per gram of the support, with suitable ranges comprising the combination of any lower amount and any upper amount. For example, the amount of diluent, if present, can range from about 1.5 g to about 25 g, about 2 g to about 20 g, about 1 g to about 15 g, about 2.5 g to about 6 g, about 0.5 g to about 8 g, or about 2.5 g to about 5.5 g per gram of the support.

[0041] The support and the magnesium-containing compound can be combined with one another in any suitable container or vessel. The container can be an open container or a container capable of being closed or sealed. The container can include one or more devices, systems, or combination thereof capable of mixing, blending, or otherwise agitating the mixture of the support and the magnesium-containing compound. For example, the container can include one or more mixing devices such as one or more mechanical/power mixers and/or acoustic mixers such as sonic mixers. The container can include one or more heating jackets, heating coils, internal heating elements, cooling jackets, cooling coils, internal cooling elements, or the like, capable of controlling or adjusting a temperature therein.

#### Second Reacted Product

[0042] After the support and magnesium-containing compound have been mixed and/or at least partially reacted with one another for a desired amount of time, one or more chlorinating compounds can be combined with the first mixture or the first reacted product to produce or form a second mixture or second reacted product. Illustrative chlorinating compounds can be or include, but are not limited to, aluminum alkyl chlorides, halo substituted silanes containing one or more chlorine atoms, fluorine atoms, bromine atoms, or any combination thereof, organic chlorides, or any combination thereof. Illustrative aluminum alkyl chlorides can include, but are not limited to, diethylaluminum chloride, diisobutylaluminum chloride, ethylaluminum dichloride, ethylaluminum sesquichloride, isobutylaluminum dichloride, diethylaluminum bromide, or any combination thereof. Illustrative halo substituted silanes can include, but are not limited to, dimethyldichlorosilane, chlorotrimethylsilane, methyltrichlorosilane, diethyldichlorosilane, t-butyl dimethylsilyl chloride, n-butyltrichlorosilane, triethoxysilylchloride, trimethoxysilylchloride, tetrachlorosilane, tetrabromosilane, dimethyldibromosilane, trimethylbromosilane, or any combination thereof. Illustrative organic chlorides can include, but are not limited to t-butyl chloride, tetrachloromethane, chloroform,

methyl chloride, tribromomethane, tetrabromomethane, or any combination thereof. In one or more embodiments, the one or more chlorinating compounds can be limited to either one or more aluminum alkyl chlorides or one or more halo substituted silanes. In one or more embodiments, the one or more chlorinating compounds can include at least one aluminum alkyl chloride and at least one halo substituted silane.

[0043] The chlorinating compound and the first reacted product can at least partially react with one another to produce a second reacted product. Said another way, the mixture of the first reacted product and the chlorinating compound can be combined with one another under reaction conditions such that the first reacted product and the chlorinating compound at least partially react with one another to form a reacted second mixture or reacted second product. For example, the chlorinating compound can react with the magnesium containing compound in the first reacted product to produce the reacted second mixture or second reacted product.

[0044] The chlorinating compound can be added to the first reacted product or conversely the first reacted product can be added to the chlorinating compound. The chlorinating compound can be combined directly with the first reacted product or the chlorinating compound can be in the form of a solution or slurry. For example, the chlorinating compound can be combined with one or more diluents to form a solution or slurry thereof. The solution or slurry of the chlorinating compound can be combined with the first reacted product to produce the second mixture or second reacted product. Suitable diluents can include, but are not limited to, the one or more alkanes, the one or more aromatic hydrocarbons, the one or more cycloalkanes, or any combination thereof, discussed and described above.

[0045] The chlorinating compound and the first reacted product can be combined with one another in any suitable container or vessel. For example, the chlorinating compound can be combined with the first reacted product within the same vessel the first reacted product was produced in. The chlorinating compound and the first reacted product can be simultaneously combined with one another in the container or vessel. If the chlorinating compound is added to the first reacted product or the first reacted product is added to the chlorinating compound, the chlorinating compound or the first reacted product can be added all at once or over a period of time. For example, the chlorinating compound can be added to the first reacted product all at one time. In another example, the chlorinating compound can be added to the first reacted product over a period of time ranging from a low of about 1 minute, about 5 minutes, about 10 minutes, or about 15 minutes to a high of about 45 minutes, about 1 hour, about 2 hours, about 4 hours, about 6 hours, or more. In another example, the chlorinating compound can be added to the first reacted product over a period of time of about 15 minutes to about 45 minutes, about 20

minutes to about 1 hour, or about 30 minutes to about 1.5 hours. The chlorinating compound and the first reacted product can be continuously or intermittently stirred during the time the chlorinating compound is added to the first reacted product.

[0046] The amount of the chlorinating compound combined with the first reacted product can range from a low of about 0.2 mmol, about 0.5 mmol, about 1 mmol, about 1.5 mmol, or about 2 mmol to a high of about 5 mmol, about 7 mmol, about 10 mmol, about 15 mmol, or about 20 mmol per gram of the support, with suitable ranges comprising the combination of any lower amount and any upper amount. For example, the second reacted product can contain about 0.25 mmol to about 20 mmol, about 1 mmol to about 10 mmol, about 1.5 mmol to about 7 mmol, or about 2 mmol to about 5 mmol of the chlorinating compound per gram of the support.

[0047] The mixture of the first reacted product and the chlorinating compound can be heated to a temperature ranging from a low of about 20°C, about 25°C, or about 30°C to a high of about 60°C, about 75°C, or about 120°C, for example, with suitable ranges comprising the combination of any lower temperature and any upper temperature. If the diluent is present, the temperature of the second mixture can be maintained below a boiling point of the diluent. The chlorinating compound and the first reacted product can be mixed, blended, stirred, or otherwise agitated for a time ranging from a low of about 15 minutes, about 30 minutes, about 1 hour, about 2 hours, or about 3 hours to a high of about 5 hours, about 10 hours, about 15 hours, about 20 hours, about 25 hours, or more. The chlorinating compound and the first reacted product can be combined with one another and mixed under a vacuum, *e.g.*, 50 kPa. The chlorinating compound and the first reacted product can be combined with one another and mixed at atmospheric pressure. The chlorinating compound and the first reacted product can be combined with one another and mixed under pressure, *e.g.*, a pressure ranging from about 102 kPa to about 500 kPa. The support and the first reacted product and the chlorinating compound can be combined with one another under an inert atmosphere.

#### Third Reacted Product

[0048] After the chlorinating compound and the first reacted product have been mixed and/or reacted with one another for a desired amount of time, one or more titanium-containing compounds can be combined with the second mixture or second reacted product to produce or form the catalyst. The titanium-containing compound and the second reacted product can at least partially react with one another during mixing thereof. Said another way, the second reacted product can be combined with the one or more titanium-containing compounds under reaction conditions to produce or form the catalyst. For example, the titanium-containing compound can react with the second reacted product to produce a reacted third mixture or

catalyst. The catalyst can include the reaction product between the titanium-containing compound and the second reacted product.

[0049] Illustrative titanium-containing compounds can include, but are not limited to, one or more titanium halides, one or more titanium alkoxides, one or more titanium amides, or any combination thereof. Illustrative titanium halides can include, but are not limited to, titanium (IV) chloride, titanium (IV) bromide, titanium (IV) fluoride, titanium (IV) iodide, or any combination thereof. Illustrative titanium alkoxides can include, but are not limited to, tetraisopropyltitanate, titanium (IV) ethoxide, titanium (IV) n-butoxide, titanium (IV) t-butoxide, or any combination thereof. Illustrative titanium amides can include, but are not limited to, tetrakis(dimethylamine)titanium(IV).

[0050] The one or more titanium-containing compounds can be added to the second reacted product or conversely the second reacted product can be added to the transition metal compounds. The titanium-containing compound can be combined directly with the second reacted product or the titanium-containing compound can be in the form of a solution or slurry. For example, the titanium-containing compound can be combined with one or more diluents to form a solution or slurry thereof. The solution or slurry of the titanium-containing compound can be combined with the second reacted product to produce the catalyst. Suitable diluents can include, but are not limited to, the one or more alkanes, the one or more aromatic hydrocarbons, the one or more cycloalkanes, or any combination thereof, discussed and described above.

[0051] The titanium-containing compound and the second reacted product can be combined with one another in any suitable container or vessel. For example, the titanium-containing compound can be combined with the second reacted product within the same vessel the second reacted product was produced in. The titanium-containing compound and the second reacted product can be simultaneously combined with one another in the container or vessel. If the titanium-containing compound is added to the second reacted product or the second reacted product is added to the titanium-containing compound, the titanium-containing compound or the second reacted product can be added all at once or over a period of time. For example, the titanium-containing compound can be added to the second reacted product all at one time. In another example, the titanium-containing compound can be added to the second reacted product over a period of time ranging from a low of about 1 minute, about 5 minutes, about 10 minutes or about 15 minutes to a high of about 45 minutes, about 1 hour, about 2 hours, about 4 hours, about 6 hours or more. In another example, the titanium-containing compound can be added to the second reacted product over a time period of about 15 minutes to about 45 minutes, about 20 minutes to about 1 hour, or about 30 minutes to about 1.5 hours. The titanium-containing

compound and the second reacted product can be continuously or intermittently stirred during the time the titanium-containing compound is added to the second reacted product.

[0052] The amount of the titanium-containing compound in the catalyst can range from a low of about 0.05 mmol, about 0.1 mmol, about 0.5 mmol, about 1 mmol, or about 2 mmol to a high of about 3 mmol, about 4 mmol, about 6 mmol, about 8 mmol, or about 12 mmol per gram of the support, with suitable ranges comprising the combination of any lower amount and any upper amount. For example, the catalyst can contain about 0.1 mmol to about 8 mmol, about 0.5 mmol to about 6 mmol, about 1 mmol to about 4 mmol, or about 2 mmol to about 3 mmol of the titanium-containing compound per gram of the support.

[0053] The mixture of the titanium-containing compound and second reacted product can be heated to a temperature ranging from a low of about 20°C, about 25°C, or about 30°C to a high of about 60°C, about 75°C, or about 120°C, for example, with suitable ranges comprising the combination of any lower temperature and any upper temperature. If the diluent is present, the temperature of the second mixture can be maintained below a boiling point of the diluent. The titanium-containing compound and the second reacted product can be mixed, blended, stirred, or otherwise agitated for a time ranging from a low of about 15 minutes, about 30 minutes, about 1 hour, about 2 hours, or about 3 hours to a high of about 5 hours, about 10 hours, about 15 hours, about 20 hours, about 25 hours, or more. The titanium-containing compound and the second reacted product can be combined with one another and mixed under a vacuum, *e.g.*, 50 kPa. The titanium-containing compound and the second reacted product can be combined with one another and mixed at atmospheric pressure. The titanium-containing compound and the second reacted product can be combined with one another and mixed under pressure, *e.g.*, a pressure ranging from about 102 kPa to about 500 kPa. The second reacted product and the titanium-containing compound can be combined with one another in air or under an inert atmosphere. Inert atmospheres can be or include, but are not limited to, nitrogen, argon, or a combination thereof.

[0054] If a diluent is used in preparation of the catalyst, *e.g.*, in the preparation of the first reacted product, the second reacted product, and/or the mixture of the titanium-containing compound and the second reacted product, at least a portion of the diluent can be removed. The diluent can be removed using any suitable process. For example, the diluent can be removed from the catalyst by placing the slurried catalyst under a vacuum, heating the slurry to a temperature sufficient to vaporize the diluent, or a combination thereof to produce a dried, free-flowing catalyst. As such, the catalyst can be in the form of a slurry, *i.e.*, the diluent was used in producing the catalyst, or the catalyst can be in the form of a powder, *i.e.*, either no diluent was

used or, if the diluent was present a sufficient amount of the diluent was removed therefrom to produce the powdered catalyst. In one or more embodiments, the catalyst can have a crystalline phase or structure, an amorphous phase or structure, or a mixture of crystalline and amorphous phases.

[0055] In one or more embodiments, if the catalyst includes one or more aluminum alkyl chlorides as the chlorinating compound, the titanium-containing compound can include the one or more titanium alkoxides, the one or more titanium amides, or the combination thereof. In one or more embodiments, if the catalyst includes one or more substituted silanes as the chlorinating compound, the titanium-containing compound can include one or more titanium halides. Said another way, when the titanium-containing compound is a titanium halide, the chlorinating compound can be one or more substituted silanes. Likewise, when the titanium-containing compound is a titanium alkoxide and/or a titanium amide, the chlorinating compound can be one or more aluminum alkyl chlorides. In at least one specific embodiment, when the chlorinating compound includes one or more aluminum alkyl chlorides, the chlorinating compound can be free of or essentially free of any intentionally added substituted silanes. In at least one other specific embodiment, when the chlorinating compound includes one or more substituted silanes, the chlorinating compound can be free of or essentially free of any intentionally added aluminum alkyl chlorides.

[0056] In one or more embodiments, the catalyst can be free or essentially free from any electron donors or donor compounds. As used herein the terms "essentially free from any electron donors" and "essentially free from any donor compounds" are used interchangeably and mean that the catalyst contains less than about 1 wt% of an electron donor, based on the total weight of the catalyst. For example, catalyst essentially free from any electron donors can contain less than about 1 wt%, less than about 0.7 wt%, less than about 0.5 wt%, less than about 0.3 wt%, less than about 0.1 wt%, or less than about 0.05 wt% of an electron donor, based on the total weight of the catalyst. As used herein, the term "electron donor" refers to compounds that donate one or more electrons used in chemical covalent and/or dative bond and/or adduct formation. Electron donors include alcohols, thiols, amines, phosphines, ethers, ketones, and esters.

[0057] As used herein, the term "alcohol" refers to a chemical compound having the formula ROH, where R is any substituted or unsubstituted hydrocarbyl group. Illustrative alcohols include aliphatic alcohols, cyclic alcohols, and aromatic alcohols. Aliphatic alcohols can have from 1 to about 25 carbon atoms, for example. Illustrative aliphatic alcohols include methanol,

ethanol, propanol, isopropanol, butanol, 2-ethylhexanol, and 1-dodecanol. Illustrative cyclic alcohols include cyclohexanol. Illustrative aromatic alcohols include t-butyl phenol.

[0058] As used herein the term "ether" refers to a chemical compound having the formula R-O-R', where R and R' are independently selected from substituted and unsubstituted hydrocarbyl groups, or R and R' form a fused ring, where the fused ring is saturated or unsaturated. Illustrative ethers that contain hydrocarbyl groups include diethyl ether, diisopropyl ether, di-n-butyl ether, ethylisopropyl ether, methylbutyl ether, methylallyl ether, and ethylvinyl ether. Illustrative ethers that contain a fused ring include tetrahydrofuran, and 2-methyl tetrahydrofuran.

[0059] As used herein, the term "ketone" refers to a chemical compound having the formula R(C=O)R', where R and R' are independently selected from substituted and unsubstituted hydrocarbyl groups and as otherwise described above with reference to ethers. Illustrative ketones include acetone, methylethyl ketone, cyclohexanone, cyclopentylmethyl ketone, 3-bromo-4-heptanone, and 2-chlorocyclopentanone. Other suitable ketones may include other functional groups such as unsaturations, as in allylmethyl ketone.

[0060] As used herein, the term "ester" refers to a chemical compound having the formula R(C=O)OR', where the carbon atom of the carbonyl group forms one bond to a carbon atom and another bond to an oxygen atom, and where R and R' are independently selected from substituted or unsubstituted hydrocarbyl groups. Illustrative esters can include alkyl esters of aliphatic and aromatic carboxylic acids, cyclic esters, saturated esters, and halogenated esters. Specific examples of esters can include methyl acetate, ethyl acetate, ethyl propionate, methyl propionate, and ethyl benzoate.

[0061] One or more co-catalysts or activators can be combined with the catalyst. Suitable co-catalysts can include, but are not limited to, organometallic compounds such as aluminum alkyl compounds. Illustrative aluminum alkyl compounds can include, but are not limited to, dialkylaluminum halides *e.g.*, dialkylaluminum chlorides, dialkylaluminum hydrides, alkylaluminum halides, *e.g.* alkylaluminum chlorides, and trialkylaluminum compounds. The alkyl group in aluminum alkyl compounds can include from 1 to 18 or from 1 to 12, or from 1 to 10, or from 1 to 8, or from 1 to 6 carbon atoms. For example, the alkyl group in aluminum alkyl compounds can be methyl, ethyl, propyl, butyl, isobutyl, pentyl, hexyl, heptyl, or octyl. Preferably, the co-catalyst can be or include trialkylaluminum compounds, in which the alkyl group includes from 1 to 18 or from 1 to 12, or from 1 to 10, or from 1 to 8, or from 1 to 6 carbon atoms. Illustrative trialkylaluminum compounds can include, but are not limited to, triethylaluminum, triisobutylaluminum, tri-n-butylaluminum, tri-n-hexylaluminum, tri-n-

octylaluminum, trimethylaluminum, or any combination thereof. Other suitable co-catalysts can include those discussed and described in U.S. Patent Nos. 3,787,384; 4,148,754; and 4,481,301.

[0062] The amount of the co-catalyst that can be combined with the catalyst can range from a low of about 0.1 mmol, about 0.5 mmol, about 1 mmol, about 2 mmol, or about 3 mmol to a high of about 10 mmol, about 20 mmol, about 50 mmol, about 100 mmol, or about 500 mmol per mmol of titanium contained in the catalyst. For example, the concentration of the co-catalyst in the catalyst/co-catalyst mixture can range from about 0.5 mmol to about 150 mmol, about 1 mmol to about 100 mmol, about 1 mmol to about 75 mmol, about 1 mmol to about 50 mmol, about 2 mmol to about 30 mmol, about 2 mmol to about 20 mmol, about 3 mmol to about 15 mmol, or about 3 mmol to about 10 mmol per mmol of titanium contained in the catalyst.

[0063] It has been surprising and unexpectedly discovered that polyethylene and polyethylene copolymers produced with one or more of the catalysts discussed and described herein have unique properties. For example, it has been surprisingly and unexpectedly discovered that polyethylenes and copolymers thereof produced with one or more catalysts discussed and described herein can have long chain branching (LCB) and a broad molecular weight distribution (MWD). This combination of properties is believed to be unique among polyethylenes produced with Ziegler-Natta catalysts. The LCB is inherent to the granular polymer produced within the reactor. The LCB and the resulting melt strength and other associated properties are not significantly modified during the pelletization process. The combination of the broad MWD and the LCB results in a polymer with substantially increased extrusion processibility and consequent reduction in pelletization costs with reduced power consumption and/or increased rate of production.

[0064] The term "polyethylene" refers to a polymer having at least 50 wt% ethylene-derived units. For example, a polyethylene can have at least 50 wt% ethylene-derived units, at least 70 wt% ethylene-derived units, at least 80 wt% ethylene-derived units, 90 wt% ethylene-derived units, 95 wt% ethylene-derived units, or 100 wt% ethylene-derived units. The polyethylene can be a homopolymer or a copolymer, including a terpolymer, having one or more other monomeric units. As such, the polyethylene can include, for example, one or more other olefin(s) and/or alpha-olefin comonomer(s). Illustrative alpha-olefin comonomers can include, but are not limited to, those having from 3 to about 20 carbon atoms, such as C<sub>3</sub>-C<sub>20</sub> alpha-olefins, C<sub>3</sub>-C<sub>12</sub> alpha-olefins, C<sub>3</sub>-C<sub>8</sub> alpha-olefins, C<sub>3</sub>-C<sub>6</sub> alpha-olefins, C<sub>3</sub>-C<sub>5</sub> alpha-olefins, C<sub>4</sub>-C<sub>6</sub> alpha-olefins, C<sub>4</sub>-C<sub>5</sub> alpha-olefins, or C<sub>4</sub> alpha-olefins. Suitable alpha-olefin comonomers can be linear or branched or can include two unsaturated carbon-carbon bonds (dienes). Two or more comonomers can be used. Examples of suitable comonomers can include, but are not

limited to, linear C<sub>3</sub>-C<sub>12</sub> alpha-olefins and alpha-olefins having one or more C<sub>1</sub>-C<sub>3</sub> alkyl branches or an aryl group.

[0065] Examples of useful comonomers include propylene; 1-butene; 3-methyl-1-butene; 3,3-dimethyl-1-butene; 1-pentene; 1-pentene with one or more methyl, ethyl, or propyl substituents; 1-hexene; 1-hexene with one or more methyl, ethyl, or propyl substituents; 1-heptene; 1-heptene with one or more methyl, ethyl, or propyl substituents; 1-octene; 1-octene with one or more methyl, ethyl, or propyl substituents; 1-nonene; 1-nonene with one or more methyl, ethyl, or propyl substituents; ethyl, methyl, or dimethyl-substituted 1-decene; 1-dodecene; and styrene; and combinations thereof. Particularly preferred comonomers include 1-butene, 1-hexene, and 1-octene.

[0066] If one or more comonomers are used, the monomer, *i.e.* ethylene, can be polymerized in a proportion of from about 50 wt% to about 99.9 wt% of monomer, preferably from about 70 wt% to about 99 wt% of monomer, and more preferably, from about 80 wt% to about 98 wt% of monomer, with from about 0.1 wt% to about 50 wt% of the one or more comonomers, preferably from about 1 wt% to about 30 wt% of the one or more comonomers, and more preferably from about 2 wt% to about 20 wt% of the one or more comonomers.

[0067] The polyethylene can have a density of about 0.900 g/cm<sup>3</sup> to about 0.970 g/cm<sup>3</sup>. For example, the polyethylene can have a density ranging from a low of about 0.910 g/cm<sup>3</sup>, about 0.915 g/cm<sup>3</sup>, about 0.915 g/cm<sup>3</sup>, about 0.920 g/cm<sup>3</sup>, or about 0.925 g/cm<sup>3</sup> to a high of about 0.940 g/cm<sup>3</sup>, about 0.945 g/cm<sup>3</sup>, about 0.950 g/cm<sup>3</sup>, about 0.955 g/cm<sup>3</sup>, about 0.960 g/cm<sup>3</sup>, about 0.965 g/cm<sup>3</sup>, or about 0.970 g/cm<sup>3</sup>. In another example, the polyethylene can have a density of about 0.915 g/cm<sup>3</sup> to about 0.935 g/cm<sup>3</sup>, or about 0.920 g/cm<sup>3</sup> to about 0.930 g/cm<sup>3</sup>, or about 0.935 g/cm<sup>3</sup> to about 0.960 g/cm<sup>3</sup>, or about 0.945 g/cm<sup>3</sup> to about 0.957 g/cm<sup>3</sup>, or about 0.915 g/cm<sup>3</sup> to about 0.960 g/cm<sup>3</sup>, or about 0.920 g/cm<sup>3</sup> to about 0.955 g/cm<sup>3</sup>. Density can be determined in accordance with ASTM D-792.

[0068] The terms "molecular weight distribution" and "MWD" mean the same thing as polydispersity index (PDI). The molecular weight distribution (MWD) is the ratio of weight-average molecular weight (M<sub>w</sub>) to number-average molecular weight (M<sub>n</sub>), *i.e.*, M<sub>w</sub>/M<sub>n</sub>. The polyethylene can have a molecular weight distribution (M<sub>w</sub>/M<sub>n</sub>) or (MWD) ranging from about 4 to about 7. For example, the polyethylene can have a molecular weight distribution (M<sub>w</sub>/M<sub>n</sub>) ranging from a low of about 4.1, about 4.3, about 4.5, about 4.7, about 4.9, or about 5 to a high of about 5.7, about 5.9, about 6, about 6.1, about 6.3, about 6.5, about 6.8, about 7.0, about 7.3, or about 7.5. In another example, the polyethylene can have a molecular weight distribution

(Mw/Mn) of about 4.5 to about 6.5, about 4.6 to about 6.3, about 4.9 to about 6.3, about 5 to about 6.4, or about 4.5 to about 6.8.

[0069] The polyethylene can have an Mz/Mw value of from about 3.0 to about 5.5. For example, the polyethylene can have an Mz/Mw value ranging from a low of about 3.3, about 3.6, about 3.7, about 3.8, about 3.9, or about 4.0 to a high of about 4.6, about 4.7, about 4.8, about 4.9, about 5.0, or about 5.3. In another example, the Mz/Mw value of the polyethylene can range from about 3.65 to about 4.85, from about 3.55 to about 4.75, from about 3.7 to about 4.7, or from about 3.6 to about 4.5.

[0070] Mw, Mn, and z-average molecular weight (Mz) can be measured using gel permeation chromatography (GPC), also known as size exclusion chromatography (SEC). This technique utilizes an instrument containing columns packed with porous beads, an elution solvent, and detector in order to separate polymer molecules of different sizes. Measurement of molecular weight by SEC is well known in the art and is discussed in more detail in, for example, Slade, P. E. Ed., *Polymer Molecular Weights Part II*, Marcel Dekker, Inc., NY, (1975) 287-368; Rodriguez, F., *Principles of Polymer Systems* 3rd ed., Hemisphere Pub. Corp., NY, (1989) 155-160; U.S. Patent No. 4,540,753; and Verstrate *et al.*, *Macromolecules*, vol. 21, (1988) 3360; T. Sun *et al.*, *Macromolecules*, vol. 34, (2001) 6812-6820.

[0071] The polyethylene can have a melt index (MI) or ( $I_2$ ) ranging from about 0.05 g/10 min to about 100 g/10 min. For example, the polyethylene can have a MI ( $I_2$ ) ranging from a low of about 0.10 g/10 min, about 0.4 g/10 min, about 0.9 g/10 min, about 1.1 g/10 min, or about 1.5 g/10 min to a high of about 60 g/10 min, about 70 g/10 min, about 80 g/10 min, about 90 g/10 min, or about 100 g/10 min. In another example, the polyethylene can have a MI ( $I_2$ ) of about 0.40 g/10 min to about 6 g/10 min, about 0.8 g/10 min to about 3 g/10 min, about 0.3 g/10 min to about 2 g/10 min, or about 0.4 g/10 min to about 3.5 g/10 min. In another example, the polyethylene can have a MI ( $I_2$ ) of about 0.5 g/10 min to about 45 g/10 min, about 5 g/10 min to about 30 g/10 min, about 10 g/10 min to about 80 g/10 min, about 40 g/10 min to about 90 g/10 min, about 1 g/10 min to about 5 g/10 min, or about 0.05 g/10 min to about 10 g/10 min. The MI ( $I_2$ ) can be measured in accordance with ASTM D-1238-E (at 190°C, 2.16 kg weight).

[0072] The polyethylene can have a flow index (FI) or ( $I_{21}$ ) ranging from about 10 g/10 min to about 1,000 g/10 min. For example, the polyethylene can have a FI ( $I_{21}$ ) ranging from a low of about 10 g/10 min, about 15 g/10 min, or about 20 g/10 min to a high of about 100 g/10 min, about 200 g/10 min, about 300 g/10 min, about 400 g/10 min, or about 500 g/10 min. In another example, the polyethylene can have a FI ( $I_{21}$ ) of about 40 g/10 min to about 200 g/10 min, about

50 g/10 min to about 100 g/10 min, or about 100 g/10 min to about 200 g/10 min. The FI ( $I_{21}$ ) can be measured in accordance with ASTM D-1238-F (at 190°C, 21.6 kg weight).

[0073] The terms "melt index ratio," "MIR," "melt flow ratio," "MFR," and " $I_{21}/I_2$ ," are used interchangeably and refer to the ratio of the flow index ( $I_{21}$ ) to melt index ( $I_2$ ), *i.e.*,  $I_{21}/I_2$ . The polyethylene can have a MFR ( $I_{21}/I_2$ ) ranging from about 30 to about 45. For example, the polyethylene can have a MFR ( $I_{21}/I_2$ ) ranging from a low of about 30, about 31, about 32, about 33, or about 34, to a high of about 35, about 36, about 37, about 39, about 40, about 42, about 43, or about 45. In another example, the polyethylene can have a MFR ranging from about 31 to about 42, or about 32 to about 40, or about 33 to about 37, or about 34 to about 44, or about 35 to about 45. The polyethylene can have a melt flow ratio (MFR) greater than or equal to  $8.33 + (4.17 \times \text{MWD})$ .

[0074] The polyethylene can have a melt index ( $I_2$ ) of less than about 100 g/10 min and a flow index ( $I_{21}$ ) greater than about 10 g/10 min. In another example, the polyethylene can have a melt index ( $I_2$ ) less than about 50 g/10 min and a flow index ( $I_{21}$ ) greater than about 25 g/10 min. In another example, the polyethylene can have a melt index ( $I_2$ ) less than about 20 g/10 min and a flow index ( $I_{21}$ ) greater than about 40 g/10 min.

[0075] Various methods are known for determining the presence of long chain branches. For example, long chain branching can be determined by using  $^{13}\text{C}$  nuclear magnetic resonance (NMR) spectroscopy and to a limited extent, *e.g.*, for ethylene homopolymers and for certain copolymers, it can be quantified using the method of Randall, (*Journal of Macromolecular Science: Rev. Macromol. Chem. Phys.*, C29 (2&3), p. 285-297). Although conventional  $^{13}\text{C}$  nuclear magnetic resonance spectroscopy can determine the length of a long chain branch for up to six carbon atoms, when more than about six carbon atoms are present, there are other known techniques useful for quantifying or determining the presence of long chain branches in ethylene polymers, such as ethylene/1-octene interpolymers. For those interpolymers where the  $^{13}\text{C}$  resonances of the comonomer overlap completely with the  $^{13}\text{C}$  resonances of the long-chain branches, either the comonomer or the other monomers (such as ethylene) can be isotopically labeled so that the long chain branching can be distinguished from the comonomer. For example, a copolymer of ethylene and 1-octene can be prepared using  $^{13}\text{C}$ -labeled ethylene. In this case, the long chain branching resonances associated with macromer incorporation will be significantly enhanced in intensity and will show coupling to neighboring  $^{13}\text{C}$  carbons, whereas the octene resonances will be unenhanced. Other methods include the technique disclosed in U.S. Patent No. 4,500,648, which discloses that long chain branching frequency (LCBF) can be represented by the equation  $\text{LCBF} = b/M_w$ , where  $b$  is the weight average number of long chain

branches per molecule and  $M_w$  is the weight average molecular weight. The molecular weight averages and the long chain branching characteristics can be determined by gel permeation chromatography and intrinsic viscosity methods, respectively.

[0076] The polyethylene can have long chain branching (LCB). The level or amount of long chain branching refers to the number of long chain branches per 1,000 carbon atoms. The long chain branches can have a length greater than 6 carbon atoms up to as long as the length of the polymer back-bone. For example, the number of carbon atoms on the long chain branches can range from a low of about 7, about 8, or about 9 to a high of about 10, about 50, about 100, about 1,000, about 10,000 or more, depending, at least in part, on the polymerization conditions. The polyethylene can have long chain branching (LCB) greater than about 0.01 per 1,000 carbon atoms and less than about 0.05 per 1,000 carbon atoms. For example, the polyethylene can have long chain branches ranging from a low of about 0.01, about 0.015, about 0.02, or about 0.025 to a high of about 0.035, about 0.040, about 0.045, or about 0.05 per 1,000 carbon atoms.

[0077] Branches introduced as a result of comonomer incorporation, such as branches 8 carbons long when using n-decene as a comonomer, are not considered "Long Chain Branches" as conventionally understood in the art. In the presence of such comonomer, LCB in the polyethylene can be determined by preparative temperature rising elution fractionation (pTREF), where the homopolymer or crystalline fraction eluting above 95°C is separated from the rest of the polymer. Additional details for the pTREF technique can be as discussed and described in U.S. Patent Application Publication No.: 2012/0028065. Using the NMR techniques described, the amount of LCB in the homopolymer fraction can be determined. The LCB in this fraction can be in the range 0.01 per 1000 carbon atoms to 0.05 branches per 1,000 carbon atoms.

[0078] Two other useful methods for quantifying or determining the presence of long chain branches in ethylene polymers, such as ethylene/1-octene interpolymers, can include gel permeation chromatography coupled with a low angle laser light scattering detector (GPC-LALLS) and gel permeation chromatography coupled with a differential viscometer detector (GPC-DV). The use of these techniques for long chain branch detection and the underlying theories are discussed and described in the literature. *See, e.g.*, G.H. Zimm, and W.H. Stockmayer, *J. Chem. Phys.*, vol. 17, p. 1301 (1949); and A. Rudin, "Modern Methods of Polymer Characterization," John Wiley & Sons, New York (1991) p. 103. Still another method for determining long chain branching can include GPC-FTIR as described by E.J. Markel, *et al. Macromolecules*, vol. 33, p. 8541 (2000).

[0079] Comonomer distribution analysis can be performed with Crystallization Elution Fractionation (CEF) (PolymerChar in Spam) (Monrabal, B. *et al.*, *Macromol. Symp.*, 257, p. 71

(2007)). Ortho-dichlorobenzene (ODCB) with 600 ppm antioxidant butylated hydroxytoluene (BHT) can be used as solvent. Sample preparation can be done with an autosampler at 160°C for about 2 hours under shaking at 4 mg/ml (unless otherwise specified). The injection volume can be about 300 µl. The temperature profile of CEF is: crystallization at 3°C/min from 110°C to 30°C, the thermal equilibrium at 30°C for 5 minutes, elution at 3°C/min from 30°C to 140°C. The flow rate during crystallization can be at 0.052 ml/min. The flow rate during elution can be at 0.50 ml/min. The data can be collected at one data point/second. The glass beads can be acid washed and the CEF column can be packed with glass beads at 125 µm ± 6% (MO-SCI Specialty Products) with 0.125 inch stainless steel tubing. The column volume can be about 2.06 ml. The column temperature calibration can be performed using a mixture of NIST Standard Reference Material Linear polyethylene 1475a (1.0 mg/ml) and Eicosane (2 mg/ml) in ODCB. The temperature can be calibrated by adjusting elution heating rate so that NIST linear polyethylene 1475a has a peak temperature at 101°C, and Eicosane has a peak temperature at 30.0°C. The CEF column resolution can be calculated with a mixture of NIST linear polyethylene 1475a (1.0 mg/ml) and hexacontane (Fluka, purum, >97.0%, 1mg/ml). A baseline separation of hexacontane and NIST polyethylene 1475a can be achieved. The area of hexacontane (from 35.0°C to 67.0°C) to the area of NIST 1475a from 67.0°C to 110.0°C can be 50 to 50, the amount of soluble fraction below 35.0°C can be less than 1.8 wt%. The column resolution can be 6.0. The CEF column resolution can be defined as:

$$\text{Resolution} = \frac{\text{peak temperature of NIST 1475a} - \text{peak temperature of hexacontane}}{\text{half - height width of NIST 1475a} + \text{half - height width of hexacontane}}$$

[0080] The polyethylene can have a heterogeneous distribution of short chain branching (SCB). As used herein, the terms "heterogeneous branching distribution," "heterogeneously branched," and "heterogeneous distribution of short chain branching" are used interchangeably and refer to: (1) molecules of different chain length contain different levels of comonomer and in particular the molecules of lower chain length contain higher amounts of comonomer *i.e.*, a lower ethylene to comonomer ratio, (2) the polymer is characterized by a broad short chain branching distribution where the comonomer heterogeneity index or (CHI) is < 0.5, and (3) the polymer contains a measureable high density (crystalline) fraction shown as a peak at an elution temperature of about 100°C in any of several known fractionation techniques that involve polymer fractional elution as a function of temperature, *e.g.*, temperature rising elution fractionation (TREF) (*see, e.g.*, U.S. Patent No. 5,008,204 and J. Wild *et al.*, *Poly. Sci., Poly. Phy. Ed.*, vol. 20, p. 441 (1982)), crystallization analysis fractionation (CRYSTAF) (*see, e.g.*, D. Beigzadeh, J.B.P. Soares, and T.A. Duever; "Modeling of Fractionation in CRYSTAF Using

Monte Carlo Simulation of Crystallizable Sequence Lengths: Ethylene/1-octene Copolymers Synthesized with Single-Site-Type Catalysts," *J. Applied Polymer Science*, vol. 80, No. 12, p. 2200 (2001); also B. Morabal, J. Blanco, J. Nieto, and J.B.P. Soares, *Polym. Sci Part A: Polym. Chem.*, vol. 37, p. 89 (1999)), and crystallization elution fraction (CEF), which is discussed and described in WO Publication No. WO2011/002868. The polyethylene can have a comonomer heterogeneity index (CHI) of less 0.5, less than about 0.47, less than about 0.45, less than about 0.43, less than about 0.40, less than about 0.37, less than about 0.35, less than about 0.33, less than about 0.3, less than about 0.27, less than about 0.25, less than about 0.23, or less than about 0.20.

[0081] The compounds were measured for melt strength by Rheotens at 190°C and by dynamic EVF using an ARES Melt rheometer. The terms "melt strength" and "MS" are used interchangeably and refer to the maximum tensile force measured on a molten filament of a polymer melt extruded from a capillary rheometer die at a constant shear rate of 33 reciprocal seconds ( $\text{sec}^{-1}$ ) while the filament is being stretched by a pair of nip rollers that are accelerating the filament at a rate of about 0.24 centimeters per second per second ( $\text{cm}/\text{sec}^2$ ) from an initial speed of about 1 cm/sec. The maximum force can be determined from the Force versus take off velocity data as follows: in the absence of draw resonance, the melt strength value is the maximum value immediately before break; in the presence of draw resonance before break, the melt strength is the average value of twenty data points before the onset of draw resonance, where draw resonance is defined as a oscillation that has an amplitude greater than 10% of the mean value of the oscillation. The molten filament is preferably generated by heating about 10 g of a polymer that is packed into a barrel of an Instron capillary rheometer, equilibrating the polymer at 190°C for five minutes, and then extruding the polymer at a piston speed of about 2.54 cm/minute ( $\text{cm}/\text{min}$ ) through a capillary die with a diameter of about 0.21 cm and a length of about 4.19 cm. The tensile force is preferably measured with a Goettfert Rheotens that is located so that the nip rollers are about 10 cm directly below a point at which the filament exits the capillary die.

[0082] The melt strength of the polyethylene can also be represented in the form of an equation. More particularly, the melt strength of the polyethylene can be represented by the equation: melt strength  $\approx 7.6938 \times \exp(-1.56 \times \log(\text{MI}))$ , where the logarithm is base 10. In one or more embodiments, the polyethylene can have a density greater than or equal to  $0.945 \text{ g}/\text{cm}^3$  and a melt strength greater than or equal to  $a \times (3.7463 \times \exp(-1.485 \times \log(\text{MI})))$ , where a is equal to 1.5, 1.55, 1.6, 1.65, 1.7, 1.75, 1.8, 1.85, or 1.9. For example, a heterogeneous polyethylene can have a density greater than or equal to  $0.945 \text{ g}/\text{cm}^3$  and a melt strength greater than or equal to a

$\times (3.7463 \times \exp(-1.485 \times \log(MI)))$ , where  $a$  is equal to 1.5, 1.75, or 1.9. In one or more embodiments, the polyethylene can have a density less than  $0.945 \text{ g/cm}^3$  and a melt strength greater than or equal to  $a \times (3.7463 \times \exp(-1.485 \times \log(MI)))$ , where  $a$  is equal to 1.2, 1.25, 1.3, 1.35, 1.4, 1.45, 1.5, 1.55, 1.6, 1.65, 1.7, 1.75, 1.8, 1.85, or 1.9. For example, a heterogeneous polyethylene can have a density less than  $0.945 \text{ g/cm}^3$  and a melt strength greater than or equal to  $a \times (3.7463 \times \exp(-1.485 \times \log(MI)))$ , where  $a$  is equal to 1.2, 1.5, or 1.9.

[0083] The polyethylene can have a melt strength ranging from a low of about 2 centi-Newtons (cN), about 3 cN, about 3.5 cN, about 4 cN, or about 4.5 cN to a high of about 6 cN, about 8 cN, about 10 cN, about 12 cN, about 14 cN, about 16 cN, about 18 cN, or about 20 cN. For example, the polyethylene can have a melt strength of about 2 cN to about 7 cN, about 2.5 cN to about 6 cN, about 3.3 cN to about 7.3 cN, about 3.6 cN to about 7 cN, or about 2.2 cN to about 6.8 cN. In another example, the polyethylene can have a melt strength of about 3.3 cN to about 16 cN, about 5 cN to about 18 cN, about 6 cN to about 14 cN, about 8 cN to about 20 cN, or about 8.5 cN to about 17 cN. In another example, the polyethylene can have a melt strength of at least 2 cN, at least 3 cN, at least 4 cN, at least 5 cN, at least 6 cN, at least 7 cN, at least 8 cN, at least 9 cN, at least 10 cN, at least 11 cN, at least 12 cN, at least 13 cN, at least 14 cN, at least 15 cN, or at least 16 cN. In another example, the polyethylene can have a melt strength of at least 2.5 cN, at least 3.5 cN, at least 4.5 cN, at least 5.5 cN, at least 6.5 cN, at least 7.5 cN, at least 8.5 cN, at least 9.5 cN, at least 10.5 cN, at least 11.5 cN, at least 12.5 cN, at least 13.5 cN, at least 14.5 cN, at least 15.5 cN, or at least 16.5 cN.

[0084] The polyethylene can have a slope of strain hardening (SSH) greater than about 0.75, greater than about 0.80, greater than about 0.85, greater than about 0.90, greater than about 0.95, or greater than about 1.00, as measured by extensional viscosity fixture (EVF). For example, the polyethylene can have a SSH ranging from a low of about 0.76, about 0.78, about 0.80, about 0.83, about 0.85, or about 0.87 to a high of about 0.90, about 0.95, about 1.00, about 1.10, about 1.20, about 1.30, or about 1.40, as measured by EVF. For example, the polyethylene can have a slope of strain hardening greater than about 0.75 to about 1.35, about 0.80 to about 1.30, about 0.90 to about 1.29, about 0.95 to about 1.35, about 1.00 to about 1.35, or about 1.05 to about 1.30, as measured by EVF.

[0085] The extensional viscosity can be measured by an extensional viscosity fixture (EVF) of TA Instruments (New Castle, DE) attached onto an ARES rheometer of TA Instruments at Hencky strain rates of  $10 \text{ s}^{-1}$ ,  $1 \text{ s}^{-1}$ , and  $0.1 \text{ s}^{-1}$  at  $150^\circ\text{C}$ . A sample plaque can be prepared on a programmable Tetrahedron bench top press. The program can hold the melt at  $177^\circ\text{C}$  at a pressure of 1,500 psi ( $10^7 \text{ Pa}$ ) for 5 minutes. The chase is then removed to the bench top to cool.

The test samples can be die-cut from the sample plaque using a punch press and a handheld die with the dimensions of about 10 mm x 18 mm (Width x Length). The specimen thickness can range from about 0.7 mm to about 1.1 mm.

[0086] The TA instruments Extensional Velocity Fixture (EVF) can be used with a conventional Aries rheometer. The rheometer oven that encloses the EVF fixture can be set to a test temperature of about 150°C for at least 60 minutes prior to zeroing fixtures. The width and thickness of each sample film can be measured at three different locations of the plaque sample and the average values can be entered into the test program (TA Orchestrator version 7.2). Densities of the sample at room temperature and at the test temperature ( $0.78 \text{ g/cm}^3$ ) can also be entered into the test program to allow for the program to calculate the actual dimensions of the sample film at the test temperature. The density of the sample at room temperature varies from sample to sample and the density measured according to ASTM D-792 can be used. The film specimen can be attached onto each of the two drums of the fixture by a pin. The oven can be closed to let the temperature equilibrate before starting the test. The test was divided into three zones. The first zone is the pre-stretch zone that stretches the film at a strain rate of about  $0.005 \text{ s}^{-1}$  for 11 seconds. Pre-stretching the film can reduce the film buckling introduced when the film is loaded. This is followed by a relaxation zone of about 60 seconds to minimize or reduce the stress introduced in the pre-stretch step. The third zone is the measurement zone where the film is stretched at the pre-set Hencky strain rate. The data collected in the third zone is that used for analysis.

[0087] The extensional viscosity can be measured at about 150°C. Data for the calculation of slope of strain hardening can be collected at a strain rate of about  $0.1 \text{ s}^{-1}$ . The slope of strain hardening SSH can be calculated as follows: (a) data is recorded as viscosity ( $\text{Pa}\cdot\text{s}$ ) vs. elapsed time (seconds), (b) viscosity increases with elapsed time; data in the range of elapsed time  $> 1$  sec is considered for the purposes of this calculation, (c) the point immediately before breakage, or a decrease in viscosity, or an obvious slippage of the sample signified by a sudden rise or fall in force is noted: value  $F_{\text{max}}$  and time  $t_{\text{max}}$ ; the log of  $t_{\text{max}}$  is calculated =  $Lt_{\text{max}}$ , (d) with time expressed as  $\log_{10}(\text{time})$ , the range of data to be used for the calculation is between  $0.9 \times Lt_{\text{max}}$  and  $0.75 \times Lt_{\text{max}}$  (the point adjacent and less than  $0.9 \times Lt_{\text{max}}$  and the point adjacent to and greater than  $0.75 \times Lt_{\text{max}}$  define the upper and lower limits of the range), (e) using the range of step (d), the data are plotted as  $\log(\text{viscosity})$  vs.  $\log(\text{time})$ , (f) using conventional linear regression techniques known in the art, a line of the form  $y = m \times x + c$  is fitted to the data (the linear line fit offered in Microsoft Corporation's EXCEL® program is suitable), (g) the slope of strain hardening is equal to  $m$ . Since the slope is measured in log space, the slope of strain

hardening value (SSH) is a dimensionless number. Additional information with regard to extensional viscosity can be found in *J. Chem. Educ.*, vol. 74, No. 8, p. 899 (1997); and *J. Chem. Educ.*, vol. 72, No. 10, p. 954 (1995).

[0088] The catalyst can be used to polymerize one or more olefins to provide one or more polymer products therefrom. Any polymerization process including, but not limited to, high pressure, solution, slurry, and/or gas phase processes can be used. Preferably, a continuous gas phase process utilizing a fluidized bed reactor is used to polymerize ethylene or ethylene and one or more comonomers to provide a polyethylene or a polyethylene copolymer, respectively. The comonomers can be as discussed and described above.

[0089] An illustrative fluidized bed reactor can include a reaction zone and a so-called velocity reduction zone. The reaction zone can include a bed of growing polymer particles, formed polymer particles and a minor amount of catalyst particles fluidized by the continuous flow of the gaseous monomer and diluent to remove heat of polymerization through the reaction zone. Optionally, some of the re-circulated gases may be cooled and compressed to form liquids that increase the heat removal capacity of the circulating gas stream when readmitted to the reaction zone. A suitable rate of gas flow may be readily determined by simple experiment. Make up of gaseous monomer to the circulating gas stream can be at a rate equal to the rate at which particulate polymer product and monomer associated therewith can be withdrawn from the reactor and the composition of the gas passing through the reactor can be adjusted to maintain an essentially steady state gaseous composition within the reaction zone. The gas leaving the reaction zone can be passed to the velocity reduction zone where entrained particles are removed. Finer entrained particles and dust may be removed in a cyclone and/or fine filter. The gas can be passed through a heat exchanger where the heat of polymerization can be removed, compressed in a compressor, and then returned to the reaction zone. Additional reactor details and means for operating the reactor are described in, for example, U.S. Patent Nos. 3,709,853; 4,003,712; 4,011,382; 4,302,566; 4,543,399; 4,882,400; 5,352,749; and 5,541,270; EP 0802202; and Belgian Patent No. 839,380.

[0090] The reactor temperature of the fluid bed process can range from 30°C or 40°C or 50°C to 90°C or 100°C or 110°C or 120°C or 150°C. In general, the reactor temperature can be operated at the highest temperature that can be feasible taking into account the sintering temperature of the polyethylene within the reactor. Regardless of the process used to make the polyethylene, the polymerization temperature or reaction temperature should be below the melting or "sintering" temperature of the polyethylene to be formed. Thus, the upper temperature limit in one embodiment is the melting temperature of the polyethylene produced in the reactor.

[0091] Hydrogen gas can be used in olefin polymerization to control the final properties of the polyolefin, such as described in "Polypropylene Handbook," at pages 76-78 (Hanser Publishers, 1996). Increasing concentrations (partial pressures) of hydrogen can increase the melt flow rate (MFR) (also referred to herein as melt index (MI)) of the polyethylene generated. The MFR or MI can thus be influenced by the hydrogen concentration. The amount of hydrogen in the polymerization reactor can be expressed as a mole ratio relative to the total polymerizable monomer, for example, ethylene, or a blend of ethylene and hexene. The amount of hydrogen used in the polymerization process can be an amount sufficient to achieve the desired MFR or MI of the final polyolefin resin. In one embodiment, the mole ratio of hydrogen to total monomer ( $H_2$ :monomer) can be in a range from greater than 0.0001 in one embodiment, and from greater than 0.0005 in another embodiment, and from greater than 0.001 in yet another embodiment, and less than 10 in yet another embodiment, and less than 5 in yet another embodiment, and less than 3 in yet another embodiment, and less than 0.10 in yet another embodiment, wherein a desirable range can include any combination of any upper mole ratio limit with any lower mole ratio limit described herein. Expressed another way, the amount of hydrogen in the reactor at any time may range to up to 5,000 ppm, and up to 4,000 ppm in another embodiment, and up to 3,000 ppm in yet another embodiment, and between 50 ppm and 5,000 ppm in yet another embodiment, and between 500 ppm and 2,000 ppm in another embodiment.

[0092] The one or more reactor pressures in a gas phase process (either single stage or two or more stages) may vary from 690 kPa to 3,448 kPa, and in the range from 1,379 kPa to 2,759 kPa in another embodiment, and in the range from 1,724 kPa to 2,414 kPa in yet another embodiment.

[0093] The gas phase reactor can be capable of producing from 227 kg of polymer per hour (kg/hr) to 90,900 kg/hr, and greater than 455 kg/hr in another embodiment, and greater than 4,540 kg/hr in yet another embodiment, and greater than 11,300 kg/hr in yet another embodiment, and greater than 15,900 kg/hr in yet another embodiment, and greater than 22,700 kg/hr in yet another embodiment, and from 29,000 kg/hr to 45,500 kg/hr in yet another embodiment.

[0094] In one or more embodiments, a staged reactor employing two or more reactors in series, where one reactor may produce, for example, a high molecular weight component and another reactor may produce a low molecular weight component can be used. In one or more embodiments, the polyolefin can be produced using a staged gas phase reactor. Such commercial polymerization systems are described in, for example, "Volume 2, Metallocene-

Based Polyolefins," at pages 366-378 (John Scheirs & W. Kaminsky, eds. John Wiley & Sons, Ltd. 2000); U.S. Patent Nos. 5,665,818; 5,677,375; and 6,472,484; and EP 0 517 868 and EP 0 794 200.

[0095] A slurry polymerization process can also be used. A slurry polymerization process generally uses pressures in the range of from about 101 kPa to about 5,070 kPa and even greater and temperatures in the range of from about 0°C to about 120°C, and more particularly from about 30°C to about 100°C. In a slurry polymerization, a suspension of solid, particulate polymer can be formed in a liquid polymerization diluent medium to which ethylene and comonomers and often hydrogen along with catalyst are added. The suspension including diluent can be intermittently or continuously removed from the reactor where the volatile components are separated from the polymer and recycled, optionally after a distillation, to the reactor. The liquid diluent employed in the polymerization medium can be an alkane having from 3 to 7 carbon atoms, such as, for example, a branched alkane. The medium employed should be liquid under the conditions of polymerization and relatively inert. When a propane medium can be used the process must be operated above the reaction diluent critical temperature and pressure. In one embodiment, a hexane, isopentane, or isobutane medium can be employed.

[0096] One or more co-catalysts, if used, can be combined with the catalyst outside of the polymerization reactor, within the polymerization reactor, or a combination thereof. For example, the catalyst and the co-catalyst can be separately introduced to the polymerization reactor and combined therein. In another example, the catalyst and the co-catalyst can be combined with one another outside or external to the polymerization reactor and introduced as a mixture to the polymerization reactor. In another example, a first portion of the co-catalyst can be combined with the catalyst external the polymerization reactor and a second portion of the co-catalyst can be combined with the mixture of the first portion of the co-catalyst and the catalyst within the polymerization reactor. The co-catalyst can be used in high pressure, solution, slurry, and/or gas phase polymerization processes.

[0097] It has been surprisingly and unexpectedly discovered that the inventive catalyst compositions discussed and described herein may produce polyethylene and polyethylene copolymers with increased efficiency and melt flow ratios ( $I_{21}/I_2$ ) when lesser amounts of co-catalyst are employed. Said another way, decreasing the co-catalyst to catalyst ratio may allow for increased catalyst productivity (typically described as pounds of resin produced per pound of catalyst) as well as increased melt flow ratios of the polyethylene or polyethylene copolymers produced. As such in preferred embodiments the concentration of co-catalyst in the co-catalyst/catalyst mixture may be less than about 20 mmol co-catalyst per mmol titanium

contained in the catalyst, or less than about 10 mmol co-catalyst per mmol titanium contained in the catalyst, or less than about 5 mmol co-catalyst per mmol titanium contained in the catalyst.

[0098] In polymerization processes disclosed herein, it may also be desired to additionally use one or more static control agents to aid in regulating static levels in the reactor. As used herein, a static control agent is a chemical composition which, when introduced into a fluidized bed reactor, may influence or drive the static charge (negatively, positively, or to zero) in the fluidized bed. The specific static control agent used may depend upon the nature of the static charge, and the choice of static control agent may vary dependent upon the polymer being produced and the catalyst compound(s) being used. For example, the use of static control agents is disclosed in European Patent No. 0229368 and U.S. Patent Nos. 4,803,251; 4,555,370; and 5,283,278, and references cited therein.

[0099] Control agents such as aluminum stearate may also be employed. The static control agent used may be selected for its ability to receive the static charge in the fluidized bed without adversely affecting productivity. Other suitable static control agents may also include aluminum distearate, ethoxlated amines, and anti-static compositions such as those provided by Innospec Inc. under the trade name OCTASTAT. For example, OCTASTAT™ 2000 is a mixture of a polysulfone copolymer, a polymeric polyamine, and oil-soluble sulfonic acid.

[00100] Any of the aforementioned control agents, as well as those described in, for example, WO 01/44322, listed under the heading Carboxylate Metal Salt and including those chemicals and compositions listed as antistatic agents may be employed either alone or in combination as a control agent. For example, the carboxylate metal salt may be combined with an amine containing control agent (e.g., a carboxylate metal salt with any family member belonging to the KEMAMINE™ (available from Crompton Corporation) or ATMER™ (available from ICI Americas Inc.) family of products).

[00101] Other useful continuity additives include, ethyleneimine additives useful in embodiments disclosed herein may include polyethyleneimines having the following general formula:



where n can be from about 10 to about 10,000. The polyethyleneimines may be linear, branched, or hyperbranched (i.e., forming dendritic or arborescent polymer structures). They can be a homopolymer or copolymer of ethyleneimine or mixtures thereof (referred to as polyethyleneimine(s) hereafter). Although linear polymers represented by the chemical formula --[CH<sub>2</sub> CH<sub>2</sub> NH]-- may be used as the polyethyleneimine, materials having primary, secondary, and tertiary branches can also be used. Commercial polyethyleneimine can be a compound

having branches of the ethyleneimine polymer. Suitable polyethyleneimines are commercially available from BASF Corporation under the trade name Lupasol. These compounds can be prepared as a wide range of molecular weights and product activities. Examples of commercial polyethyleneimines sold by BASF suitable for use in the present invention include, but are not limited to, Lupasol™ FG and Lupasol™ WF. Another useful continuity additive can include a mixture of aluminum distearate and an ethoxylated amine type compound, *e.g.*, IRGASTAT™ AS-990, available from Huntsman (formerly Ciba Specialty Chemicals). The mixture of aluminum distearate and ethoxylated amine type compound can be slurried in mineral oil *e.g.*, Hydrobrite 380. For example, the mixture of aluminum distearate and an ethoxylated amine type compound can be slurried in mineral oil to have total slurry concentration ranging from about 5 wt% to about 50 wt% or about 10 wt% to about 40 wt%, or about 15 wt% to about 30 wt%. Other useful static control agents and additives are disclosed in U.S. Patent Application Publication No. 2008/0045663.

[00102] The continuity additive(s) or static control agent(s) may be added to the reactor in an amount ranging from 0.05 to 200 ppm, based on the weight of all feeds to the reactor, excluding recycle, more preferably in an amount ranging from 2 to 100 ppm; more preferably from 4 to 50 ppm in yet other embodiments.

[00103] As discussed above, conventional polyethylenes produced from Ziegler-Natta catalyzed polyethylenes may be, and often are, blended with high pressure low density polyethylenes (LDPE) in an attempt to combine the processibility of the low density polyethylene and the physical attributes of the Ziegler-Natta catalyzed polyethylene. It has been surprisingly and unexpectedly discovered that the Ziegler-Natta catalyzed polyethylenes discussed and described herein can avoid the need or substantially reduce the need for blending LDPE and/or other polymers therewith in order to obtain acceptable processibility. In other words, the polyethylenes discussed and described herein can be used alone or can be blended with one or more additional polymers if so desired. Other suitable polymers that can be blended with the polyethylenes discussed and described herein can include, but are not limited to, high pressure low density polyethylene (LDPE), ethylene vinyl acetate, ethylene ethylacrylate, ethylene acrylic acid, ethylene-styrene interpolymers, polyethylene homopolymers, ethylene/alpha-olefin copolymers made with conventional catalysts and processes known in the art, and the like, or any combination thereof.

[00104] A polymer blend containing the polyethylene and one or more other polymers, *e.g.*, LDPE, can be formed using conventional equipment and methods, such as by dry blending the individual components and subsequently melt mixing in a mixer or by mixing the

components together directly in a mixer, such as, for example, a Banbury mixer, a Haake mixer, a Brabender internal mixer, or a single or twin-screw extruder, which can include a compounding extruder and a side-arm extruder used directly downstream of a polymerization process. In another example, the polymer blend can be produced in situ using a multistage polymerization reactor arrangement and process. In a multistage reactor arrangement two or more reactors can be connected in series where a mixture of a first polymer, *e.g.*, the polyethylene and catalyst precursor can be transferred from a first reactor to a second reactor where a second polymer, *e.g.*, a metallocene catalyzed polyethylene, can be produced and blended in situ with the first polymer.

[00105] A polymer blend that includes the polyethylene can include at least 0.1 percent by weight (wt%) and up to 99.9 wt% of the polyethylene and at least 0.1 wt% and up to 99.9 wt% of the one or more other polymers, based on the combined weight of the polyethylene and the one or more other polymers. For example, the amount of the polyethylene in the polymer blend can range from a low of about 55 wt%, about 60 wt%, about 65 wt%, about 70 wt%, or about 75 wt% to a high of about 80 wt%, about 85 wt%, about 90 wt%, about 95 wt%, or about 99 wt%, based on the combined weight of the polyethylene and the one or more other polymers. In another example, the amount of the polyethylene in the polymer blend can range from about 60 wt% to about 85 wt%, about 75 wt% to about 95 wt%, about 80 wt% to about 95 wt%, about 80 wt% to about 90 wt%, about 85 wt% to about 95 wt%, or about 90 wt% to about 95 wt%, based on the combined weight of the polyethylene and the one or more other polymers.

[00106] The polyethylene and/or a polymer blend containing the polyethylene can be used for a wide variety of applications. For example, the polyethylene and/or a polymer blend that includes the polyethylene can be particularly useful in extrusion coating, cast film processes, blown film processes, thermoforming processes, injection molding processes, and lamination processes. Exemplary end uses can include, but are not limited to, coatings, films, film-based products, diaper backsheets, housewrap, wire and cable coatings, articles formed by molding techniques, *e.g.*, injection or blow molding, foaming, casting, and combinations thereof. End uses can also include products made from films, *e.g.*, bags, packaging, and personal care films, pouches, medical products, such as for example, medical films and intravenous (IV) bags. In end uses that include films, either or both of the surfaces of the films produced from the polymer blend can be modified by known and conventional post-forming techniques such as corona discharge, chemical treatment, flame treatment, and the like.

[00107] In one example, monolayer films can be prepared from the polyethylene and/or a polymer blend containing the polyethylene. In another example, multilayer films can be

prepared from the polyethylene and/or blends thereof. Multilayer films can include one or more layers of film made from polymers other than the polyethylene and/or blends thereof.

[00108] To facilitate discussion of different multilayer film structures, the following notation is used herein. Each layer of a film is denoted "A" or "B", where "A" indicates a film layer not containing the polyethylene and "B" indicates a film layer having the polyethylene. Where a film includes more than one A layer or more than one B layer, one or more prime symbols (' , ' , ' , etc.) are appended to the A or B symbol to indicate layers of the same type that can be the same or can differ in one or more properties, such as chemical composition, density, melt index, thickness, etc. Finally, the symbols for adjacent layers are separated by a slash (/). Using this notation, a three-layer film having an inner or core layer of the polyethylene disposed between two outer, conventional film layers, *i.e.* not containing the polyethylene, would be denoted A/B/A'. Similarly, a five-layer film of alternating conventional/polymer blend layers would be denoted A/B/A'/B'/A". Unless otherwise indicated, the left-to-right or right-to-left order of layers does not matter, nor does the order of prime symbols. For example, an A/B film is equivalent to a B/A film, and an A/A'/B/A" film is equivalent to an A/B/A'/A" film, for purposes described herein.

[00109] The relative thickness of each film layer is similarly denoted, with the thickness of each layer relative to a total film thickness of 100 (dimensionless) indicated numerically and separated by slashes; *e.g.*, the relative thickness of an A/B/A' film having A and A' layers of 10  $\mu\text{m}$  each and a B layer of 30  $\mu\text{m}$  is denoted as 20/60/20. Exemplary conventional films can be as discussed and described in, for example, U.S. Patent Nos. 6,423,420; 6,255,426; 6,265,055; 6,093,480; 6,083,611; 5,922,441; 5,907,943; 5,907,942; 5,902,684; 5,814,399; 5,752,362; 5,749,202; 7,235,607; 7,601,409; RE 38,658; RE 38,429; U.S. Patent Application Publication No. 2007/0260016; and WO Publication No. WO2005/065945.

[00110] For the various films described herein, the "A" layer can be formed of any material known in the art for use in multilayer films or in film-coated products. Thus, for example, the A layer can be formed of a second polyethylene (homopolymer or copolymer), *i.e.*, a polyethylene that differs in at least one property from the polyethylenes discussed and described herein, and the second polyethylene can be, for example, a VLDPE, LDPE, LLDPE, MDPE, HDPE, as well as other polyethylenes known in the art. In another example, the A layer can be formed of a polyethylene (homopolymer or copolymer), a non-polyethylene polymer, *e.g.* a polypropylene, or a blend of a polyethylene and a non-polyethylene polymer.

[00111] Illustrative additional polymers (non-polyethylenes) that can be used as or in the A layer can include, but are not limited to, other polyolefins, polyamides, polyesters,

polycarbonates, polysulfones, polyacetals, polylactones, acrylonitrile-butadiene-styrene resins, polyphenylene oxide, polyphenylene sulfide, styrene-acrylonitrile resins, styrene maleic anhydride, polyimides, aromatic polyketones, or mixtures of two or more of the above. Suitable polyolefins can include, but are not limited to, polymers comprising one or more linear, branched or cyclic C<sub>2</sub> to C<sub>40</sub> olefins, preferably polymers comprising propylene copolymerized with one or more C<sub>3</sub> to C<sub>40</sub> olefins, preferably a C<sub>3</sub> to C<sub>20</sub> alpha olefin, more preferably C<sub>3</sub> to C<sub>10</sub> alpha-olefins.

[00112] In multilayer structures, one or more A layers can also be an adhesion-promoting tie layer, such as PRIMACOR™ ethylene-acrylic acid copolymers available from Dow Chemical Co. and/or ethylene-vinyl acetate copolymers. Other materials for A layers can be, for example, foil, nylon, ethylene-vinyl alcohol copolymers, polyvinylidene chloride, polyethylene terephthalate, oriented polypropylene, ethylene-vinyl acetate copolymers, ethylene-acrylic acid copolymers, ethylene-methacrylic acid copolymers, graft modified polymers, and paper.

[00113] One or more A layers can be replaced with a substrate layer, such as glass, plastic, paper, metal, etc., or the entire film can be coated or laminated onto a substrate. Thus, although the discussion herein focuses on multilayer films, the films that include the polyethylene can also be used as coatings; *e.g.*, films (monolayer and multilayer) can be coated onto a substrate such as paper, metal, glass, plastic and other materials capable of accepting a coating.

[00114] The polymer film can be a multilayer film with any of the following exemplary structures: (a) two-layer films, such as A/B and B/B'; (b) three-layer films, such as A/B/A', A/A'/B, B/A/B' and B/B'/B"; (c) four-layer films, such as A/A'/A"/B, A/A'/B/A", A/A'/B/B', A/B/A'/B', A/B/B'/A', B/A/A'/B', A/B/B'/B", B/A/B'/B" and B/B'/B"/B""; (d) five-layer films, such as A/A'/A"/A'''/B, A/A'/A"/B/A"', A/A'/B/A"/A"', A/A'/A"/B/B', A/A'/B/A"/B', A/A'/B/B'/A", A/B/A'/B'/A", A/B/A'/A"/B, B/A/A'/A"/B', A/A'/B/B'/B", A/B/A'/B'/B", A/B/B'/B"/A', B/A/A'/B'/B", B/A/B'/A'/B", B/A/B'/B"/A', A/B/B'/B"/B"', B/A/B'/B"/B"', B/B'/A/B"/B"', and B/B'/B"/B'''/B''"; and similar structures for films having six, seven, eight, nine, twenty-four, forty-eight, sixty-four, one hundred, or any other number of layers. It should be appreciated that films having still more layers can be formed using polymer blends, and such films are within the scope of the invention.

[00115] The polyethylene and/or a blend thereof can be formed into monolayer and/or multilayer films by any means known including any blown film process known in the art, including bubble and double-bubble processes, cast processes, *e.g.*, cast film and extrusion coating, injection molding, blow-molding, sheet extrusion, and the like. For example, the polyethylene can be extruded in a molten state through a flat die and then cooled to form a film.

In another example, the polyethylene can be used as a sealant which can be extrusion coated onto a substrate either in the form of a monolayer or a coextruded extrudate.

[00116] In one example, in a typical extrusion coating process, the polyethylene and/or the polyethylene and one or more other polymers, *e.g.*, the polyethylene and a linear polyethylene, can be fed to an extruder where the polyethylene or the polyethylene and one or more other polymers is/are melted, mixed, and extruded through the slit die at a temperature typically in the range of about 275°C to about 340°C. A mixing screw with barrier elements can be utilized. The extrudate can contact a chill roll which may be high gloss, matt, or embossed. A typical chill roll temperature can range from about 25°C to 35°C. As is known in the art, a multi-layer co-extrusion can be performed with two or more layers with at least one of the layers including the polyethylene or a polymer blend including the polyethylene. The die width, die gap, extrusion rate, and substrate are chosen to provide the desired extrudate width, thickness, and production rate. Both the substrate and the coated surface can be surface treated with such techniques as are known in the art such as corona or plasma treatment. The extruded surface may be further treated with techniques such as embossing, silane treatment for the preparation of release papers, and other techniques and methods as are known in the art.

[00117] In another example, cast films can be prepared using a cast film line machine as follows. Pellets of the polyethylene, alone or mixed with one or more other polymers, can be melted at a temperature typically ranging from about 275°C to about 325°C for cast polymers (depending upon the particular polymer(s) used), with the specific melt temperature being chosen to match the melt viscosity of the particular polymer(s). In the case of a multilayer cast film, the two or more different melts can be conveyed to a coextrusion adapter that combines the two or more melt flows into a multilayer, coextruded structure. This layered flow can be distributed through a single manifold film extrusion die to the desired width. The die gap opening is typically about 600  $\mu\text{m}$  (0.025 inches). The material can then be drawn down to the final gauge. The material draw down ratio is typically about 21:1 for 20  $\mu\text{m}$  (0.8 mils) films. A vacuum box, edge pinners, air knife, or any combination thereof, can be used to pin the melt exiting the die opening to a primary chill roll maintained at about 32°C (80°F). The resulting film can be collected on a winder. The film thickness can be monitored by a gauge monitor, and the film can be edge trimmed by a trimmer. A typical cast line rate is from about 76.2 m to about 610 m (250 ft to about 2,000 feet) per minute. One skilled in the art will appreciate that higher rates may be used for similar processes such as extrusion coating. One or more optional treaters can be used to surface treat the film, if desired. Such chill roll casting processes and apparatus can be as discussed and described in, for example, The Wiley-Encyclopedia of

Packaging Technology, Second Edition, A. L. Brody and K. S. Marsh, Ed., John Wiley and Sons, Inc., New York (1997). Although chill roll casting is one example, other forms of casting may be employed, such as extrusion coating.

[00118] The total thickness of the resulting monolayer and/or multilayer films can vary based, at least in part, on the particular end use application. A total film thickness of about 5  $\mu\text{m}$  to about 100  $\mu\text{m}$ , more typically about 10  $\mu\text{m}$  to about 50  $\mu\text{m}$ , can be suitable for most applications. Those skilled in the art will appreciate that the thickness of individual layers for multilayer films can be adjusted based on desired end use performance, end use product, equipment capability, and other factors.

[00119] Films made from the polyethylene or a polymer blend of the polyethylene and one or more other polymers as discussed and described herein and/or the process of making the films can have improved properties. For example, films that include the polyethylene can be produced with reduced motor load and/or increased draw-down rates during extrusion of the film as compared to traditional polymer blends. The reduction in motor load depends on the particular equipment used for extrusion. It has been surprisingly and unexpectedly discovered that the polyethylene and/or a polymer blend of the polyethylene and LDPE discussed and described herein can substantially reduce the motor load required to extrude the polyethylene and/or the polymer blend by about 10% or more, about 12% or more, about 14% or more, about 16% or more, about 18% or more, about 20% or more, about 22%, about 24 % or more, about 26% or more, about 28% or more, or about 30% or more or more as compared to a comparative polyethylene and/or a comparative polymer blend containing the same LDPE and a traditional polyethylene when both the polyethylene and the comparative polyethylene have a melt index ( $I_2$ ) of about 1 g/10 min and the LDPE has a melt index ( $I_2$ ) of about 1.9 g/10 min.

[00120] A variety of additives can be employed in the polyethylene compositions and/or polymer blends containing the polyethylene discussed and described herein depending upon the performance characteristics required by a particular application. The additives can be included in the polyethylene and/or in a product formed from the polyethylene, such as an extruded film, as desired. In one example, the polyethylene discussed and described herein can include from about 0.1 wt% to about 40 wt% additives, based on the total weight of the polyethylene. In another example, the polyethylene can include from about 5 wt% to about 25 wt% additives, based on the total weight of the polyethylene.

[00121] Examples of such additives include, but are not limited to, tackifiers, waxes, functionalized polymers such as acid modified polyolefins and/or anhydride modified polyolefins, antioxidants (e.g., hindered phenolics such as IRGANOX® 1010 or IRGANOX®

1076 available from Ciba-Geigy), (e.g., IRGAFOS® 168 available from Ciba-Geigy), oils, compatibilizers, fillers, adjuvants, adhesion promoters, plasticizers, low molecular weight polymers, blocking agents, antiblocking agents, anti-static agents, release agents, anti-cling additives, colorants, dyes, pigments, processing aids, UV stabilizers, heat stabilizers, neutralizers, lubricants, surfactants, nucleating agents, flexibilizers, rubbers, optical brighteners, colorants, diluents, viscosity modifiers, oxidized polyolefins, and any combination thereof. Additives can be combined with one or both of the first or linear polyethylene and/or may be combined with the blend of the first and linear polyethylene as further individual components, in masterbatches, or in any combination thereof.

### Examples

[00122] To provide a better understanding of the foregoing discussion, the following non-limiting examples are provided. All parts, proportions and percentages are by weight unless otherwise indicated.

[00123] The catalyst used to produce the polymers of Examples 1-19 and comparative examples C1-C17 were Ziegler-Natta type catalysts. The catalyst used to produce the polymers of Examples 1-9 was prepared according to the following procedure. About 613 g of Davison 955 silica purchased from W. R. Grace & Co. that had been previously calcined at 600 °C was charged to a 6 liter mix tank under an inert nitrogen atmosphere. About 2.3 kg of dry, degassed hexane was added to the mix tank and the slurry was heated to a temperature of about 60°C with mixing. About 865 g of a 1.2 M *n*-butylethylmagnesium (BEM) solution in heptane (19.6 wt% BEM) was added to the silica/hexane slurry over the course of about 1 hour and was mixed for an additional hour at 60°C to produce a first reacted product. About 198 g of dimethyldichlorosilane (DMDCS) was added to the first reacted product over the course of about 1 hour and was mixed for an additional hour at 60°C to produce a second reacted product. About 290 g of titanium (IV) chloride was diluted with about 100 g of hexane before being added to the second reacted product over the course of about 1 hour and was held at a temperature of about 60°C and further mixed for about 1 hour and then the volatiles were removed therefrom under reduced pressure to produce the catalyst. The catalyst was in the form of a free-flowing powder. A second batch of the same catalyst used to produce the polymers of Examples 1-9 was prepared and was used to produce the polymers of Examples 16-19. The second batch of catalyst was prepared according to the same procedure as the first batch. Both catalysts were analyzed for Ti, Mg, Cl<sup>-</sup> and hexane content, the results of which are shown in Table 1 below.

Table 1					
Catalyst	Cl <sup>-</sup> (mmol/g)	Mg (mmol/g)	Ti (mmol/g)	Mg/Ti	Residual Hexane (wt%)
Used to Produce the Polymers of Examples 1-9	4.82	1.58	0.86	1.84	0.04
Used to Produce the Polymers of Examples 16-19	4.24	1.72	0.70	2.46	<0.01

[00124] The catalyst used to prepare the polymers of Examples 10, 11, and 13-15 was prepared according to the following procedure. About 415 g of Davison 955 silica purchased from W. R. Grace & Co. that had been previously calcined at 600°C was added to a 6 liter mix tank under an inert nitrogen atmosphere. About 1.4 kg of dry, degassed hexane was added to the mix tank and the slurry was heated to a temperature of about 30°C with mixing. About 524 g of a 1.3 M *n*-butylethylmagnesium (BEM) solution in heptane (19.9 wt% BEM) was added to the silica/hexane slurry over the course of about 30 minutes and was mixed for an additional 19 hours at 30°C to produce a first reacted product. About 1,210 g of a 1.0 M ethylaluminum dichloride (EADC) solution in hexane (17.4 wt%) was added over a 30 minute period to the first reacted product and was mixed for an additional 4 hours at 30°C to produce a second reacted product. About 21.6 g of tetraisopropyltitanate (TIPT) was added to the second reacted product and mixed for an additional 16 hours at 30°C and then the volatiles were removed under reduced pressure to form the catalyst. The catalyst was a free-flowing powder.

[00125] The catalyst used to prepare the polymer of Example 12 was prepared according to the following procedure. About 465 g of Davison 955 silica purchased from W. R. Grace & Co. that had been previously calcined at about 600°C was added to a 6 liter mix tank under an inert atmosphere of nitrogen. About 1.5 kg of dry, degassed hexane was added to the mix tank and the slurry was heated to a temperature of about 30°C with mixing. About 1,200 g of a 1.2 M *n*-butylethylmagnesium (BEM) solution in heptane (19.6 wt% BEM) was added to the silica/hexane slurry over the course of about 30 minutes with mixing to produce a first mixture. The first mixture was mixed for an additional 19 hours at 30°C, after which the solids were filtered off. The solids were then suspended in about 1.6 liters of hexane and mixed for about five minutes and then filtered off. This wash/filter cycle was repeated two additional times for a total of three wash/filter cycles. About 1.4 liters of hexane was added to the solids and the slurry was heated to about 30°C with mixing. About 1,630 g of a 1.0 M ethylaluminum dichloride (EADC) solution in hexane (17.4 wt%) was added over a 30 minute period to produce a second mixture. The second mixture was mixed for an additional 4 hours at a temperature of

about 30°C. About 24.2 g of tetraisopropyltitanate (TIPT) was added to the second mixture to produce the catalyst or catalyst composition. The catalyst composition was mixed for an additional 16 hours at 30°C, after which the solids were filtered off. The solids were then suspended in about 1.6 liters of hexane and mixed for about five minutes before being filtered off. This wash/filter cycle was repeated two additional times for a total of three wash/filter cycles. Next, the volatiles of the catalyst composition were removed under reduced pressure. A catalyst in the form of a free-flowing powder was recovered.

[00126] It should be noted that the catalysts used to produce the polymers of Examples 1-19 were prepared without the addition of any electron donors as discussed and described above. As such, the catalyst can be referred to as a "donor free catalyst." The catalysts used to prepare the polymers of Examples 10-15 were analyzed for Ti, Mg, Al, and Cl content, the results of which are shown in Table 2 below.

<b>Table 2</b>					
Catalyst	Cl (mmol/g)	Mg (mmol/g)	Ti (mmol/g)	Al (mmol/g)	Mg/Ti
Used to Produce the Polymers of Examples 10, 11, and 12-15	4.41	1.20	0.12	2.22	10.30
Used to Produce the Polymer of Example 12	4.45	1.91	0.12	0.95	15.90

[00127] A gas phase fluidized bed polymerization reactor of the UNIPOL™ PE Process design having a nominal diameter of about 35.6 cm (about 14 inches) was used for the continuous production of both linear low density polyethylene (LLDPE) and high density polyethylene (HDPE). In these cases, the cycle gas blower was situated upstream of the cycle gas heat exchanger in the gas recirculation loop but the two could have been reversed to reduce the gas temperature where it entered the heat exchanger. The cycle pipe was about 5.1 cm (about 2 inches) in diameter and its flow rate was manipulated by a ball valve in the cycle line to control the superficial gas velocity in the fluid bed at the desired rate. Monomers and gaseous components were added upstream of the cooler before the blower, at the blower impeller or after the blower. The catalyst system was continuously added in discrete small aliquots via an about 0.317 cm (about 0.125 inch) tube directly to the fluidized bed at a height about 0.1 m to 2 m above the distributor plate and most preferably at about the 0.2 m to about 1.2 m range using a nitrogen carrier gas flow at a location about 15% to about 50% of the reactor diameter. Triethylaluminum (TEAL) was utilized as a cocatalyst and added to the reactor as a solution in hexane. Where a continuity additive was used, a 50/50 mixture of a hydroxyethyl stearyl amine

and aluminum distearate continuity additive slurry was metered to the reactor from an agitated slurry feeding vessel to maintain the desired concentration in the bed based on polymer production rate using an inert hydrocarbon, such as isopentane, as a carrier medium. Polymer product was withdrawn periodically from the reactor through a discharge isolation tank in aliquots of about 0.2 kg to 5 kg to maintain a desired approximate average fluidized bed level or weight.

[00128] The polymerization conditions and results for the production of the polymers of Examples 1-19 is shown in Tables 3A-C below.

<b>Table 3A</b>							
<b>Examples</b>	<b>Ex. 1</b>	<b>Ex. 2</b>	<b>Ex. 3</b>	<b>Ex. 4</b>	<b>Ex. 5</b>	<b>Ex. 6</b>	<b>Ex. 7</b>
Polymer Type	HDPE	HDPE	HDPE	HDPE	HDPE	HDPE	HDPE
Catalyst Ti Content (wt%)	4.11	4.11	4.11	4.11	4.11	4.11	4.11
Catalyst Al Content (wt%)	0.11	0.11	0.11	0.11	0.11	0.11	0.11
Catalyst Mg Content (wt%)	3.84	3.84	3.84	3.84	3.84	3.84	3.84
Prod Rate (lbs/hr)	34.1	38	33.8	37	38.2	39.5	36
Residence Time (hrs)	3.2	2.9	3.3	3	3	2.8	3
C <sub>2</sub> Partial Pressure (psia)	120	120	101	120	120	120	120
H <sub>2</sub> /C <sub>2</sub> (m/m)	0.135	0.18	0.182	0.182	0.282	0.218	0.169
C <sub>4</sub> /C <sub>2</sub> Conc. Ratio (m/m)	0.0113	0.0178	0.0126	0.0171	0.0089	0.0205	0.0224
C <sub>6</sub> /C <sub>2</sub> Conc. Ratio (m/m)	-	-	-	-	-	-	-
Isopentane (mole%)	0.19	0.17	0.3	0.16	0.28	0.3	0.3
RX Pressure (psig)	346	346	346	346	346	346	346
RX Temperature (°C)	102	102	102	102	102	102	102
Gas Velocity (ft/sec)	1.9	1.91	1.66	1.93	1.97	1.96	1.96
Bed Weight (lbs)	110	110	111	110	115	110	110
Fluid Bulk Density (lb/ft <sup>3</sup> )	13.9	13.3	12.6	13.2	15	12.5	12.2
Cocatalyst ID	TEAL	TEAL	TEAL	TEAL	TEAL	TEAL	TEAL
Cocatalyst Conc. (wt%)	1	1	1	1	1	1	1
Cocatalyst Feed, (cc/hr)	75.1	75	135.3	74.8	151.5	150.5	150.3
Reactor Cocatalyst Conc. - Prod. Rate Basis (ppmw)	30	27	55	28	54	52	57
Cont. Additive	None	None	None	None	None	None	None
Continuity Additive Conc. (wt%)	-	-	-	-	-	-	-
Continuity Additive Feed (cc/hr)	-	-	-	-	-	-	-
Reactor Cont. Additive Conc. - Prod Rate Basis (ppmw)	-	-	-	-	-	-	-
Cat. Prod. - Ti ICPEs Basis (g PE/g Catalyst)	9,536	10,883	-	-	-	-	-
Material Balance Cat. Prod. (g PE/g Catalyst)	13,008	15,077	13,967	14,680	10,464	14,070	15,220

<b>Table 3B</b>						
<b>Examples</b>	<b>Ex. 8</b>	<b>Ex. 9</b>	<b>Ex. 10</b>	<b>Ex. 11</b>	<b>Ex. 12</b>	<b>Ex. 13</b>
Polymer Type	HDPE	HDPE	HDPE	HDPE	HDPE	HDPE
Catalyst Ti Content (wt%)	4.11	4.11	0.59	0.59	0.56	0.59
Catalyst Al Content (wt%)	0.11	0.11	2.57	2.57	5.99	2.57
Catalyst Mg Content (wt%)	3.84	3.84	4.65	4.65	2.92	4.65
Prod Rate (lbs/hr)	36.4	33.5	33.7	29.8	23.9	32.2
Residence Time (hrs)	3	3.3	3.4	3.9	4.8	3.6
C <sub>2</sub> Partial Pressure (psia)	120	120	120	120	120	120
H <sub>2</sub> /C <sub>2</sub> (m/m)	0.155	0.162	0.245	0.153	0.258	0.16
C <sub>4</sub> /C <sub>2</sub> Conc. Ratio (m/m)	0.0182	0.0141	0.0096	0.0094	0.008	0.009
C <sub>6</sub> /C <sub>2</sub> Conc. Ratio (m/m)	-	-	-	-	-	-
Isopentane (mole%)	0.31	0.3	0.16	0.18	0.75	0.17
RX Pressure (psig)	346	346	347	347	347	347
RX Temperature (°C)	102	102	102	102	102	102
Gas Velocity (ft/sec)	1.95	1.95	1.8	1.8	1.8	1.81
Bed Weight (lbs)	109	109	115	115	115	115
Fluid Bulk Density (lb/ft <sup>3</sup> )	12.3	12.6	17.9	17.8	16.8	17.7
Cocatalyst ID	TEAL	TEAL	TEAL	TEAL	TEAL	TEAL
Cocatalyst Conc. (wt%)	1	1	1	1	1	1
Cocatalyst Feed (cc/hr)	149.9	149.9	74.8	74.9	373.9	74.8
Reactor Cocatalyst Conc. - Prod. Rate Basis (ppmw)	56	61	30	34	214	32
Cont. Additive	None	None	None	None	None	None
Continuity Additive Conc. (wt%)	-	-	-	-	-	-
Continuity Additive Feed (cc/hr)	-	-	-	-	-	-
Reactor Cont. Additive Conc. - Prod Rate Basis (ppmw)	-	-	-	-	-	-
Cat. Prod. - Ti ICPES Basis (g PE/g Catalyst)	-	9,222	-	-	1,422	3,758
Material Balance Cat. Prod. (g PE/g Catalyst)	14,460	12,184	4,629	3,801	1,705	4,106

<b>Examples</b>	<b>Ex. 14</b>	<b>Ex. 15</b>	<b>Ex. 16</b>	<b>Ex. 17</b>	<b>Ex. 18</b>	<b>Ex. 19</b>
Polymer Type	HDPE	HDPE	HDPE	HDPE	LLDPE	LLDPE
Catalyst Ti Content (wt%)	0.59	0.59	3.34	3.34	3.34	3.34
Catalyst Al Content (wt%)	2.57	2.57	4.18	4.18	4.18	4.18
Catalyst Mg Content (wt%)	4.65	4.65	0.167	0.167	0.167	0.167
Prod Rate (lbs/hr)	31.3	33	35.1	30.4	36.1	32.1
Residence Time (hrs)	3.6	3.4	2.81	3.05	2.89	2.9
C <sub>2</sub> Partial Pressure (psia)	120	120	120.2	120.1	80	80
H <sub>2</sub> /C <sub>2</sub> (m/m)	0.119	0.121	0.1583	0.1796	0.1248	0.1102
C <sub>4</sub> /C <sub>2</sub> Conc. Ratio (m/m)	0.0052	0.0048	0.0178	0.0175	-	0.376
C <sub>6</sub> /C <sub>2</sub> Conc. Ratio (m/m)	-	-	-	-	0.139	-
Isopentane (mole%)	0.18	0.18	0.19	0.23	1.74	1.28
RX Pressure (psig)	347	347	346.4	346.6	346.6	346
RX Temperature (°C)	102	102	102	102	88	88
Gas Velocity (ft/sec)	1.82	1.85	1.81	1.73	1.93	1.8
Bed Weight (lbs)	114	113	99	93	104	93
Fluid Bulk Density (lb/ft <sup>3</sup> )	17.5	18.2	10.3	11.7	13.4	10.8
Cocatalyst ID	TEAL	TEAL	TEAL	TEAL	TEAL	TEAL
Cocatalyst Conc. (wt%)	1	1	1	1	1	1
Cocatalyst Feed (cc/hr)	75.3	39.9	135.6	135.6	129.2	135.5
Reactor Cocatalyst Conc. - Prod. Rate Basis (ppmw)	33	17	53	61	49	58
Cont. Additive	None	None	None	None	Yes	Yes
Continuity Additive Conc. (wt%)	-	-	-	-	15	15
Continuity Additive Feed (cc/hr)	-	-	-	-	1.5	0.5
Reactor Cont. Additive Conc. - Prod Rate Basis (ppmw)	-	-	-	-	15.6	5.8
Cat. Prod. - Ti ICPES Basis (g PE/g Catalyst)	4,014	4,538	-	10,050	9,386	8,743
Material Balance Cat. Prod. (g PE/g Catalyst)	3,992	4,205	13,181	14,495	10,300	11,438

[00129] The UCAT® A2020 (available from Univation Technologies LLC) was used to produce the polymers of comparative examples C1 and C2. The SYLOPOL® 5006 catalyst, acquired from Grace Davison, was used to produce the polymers of comparative examples C3-C11. The polymerization results for comparative examples C1-C11 are shown in Tables 4A-B below.

<b>Table 4A</b>						
<b>Examples</b>	<b>C1</b>	<b>C2</b>	<b>C3</b>	<b>C4</b>	<b>C5</b>	<b>C6</b>
Polymer Type	HDPE	HDPE	HDPE	HDPE	HDPE	HDPE
Catalyst Ti Content (wt%)	1.06	1.06	1.31	1.31	1.31	1.31
Catalyst Al Content (wt%)	2.93	2.93	5.10	5.10	5.10	5.10
Catalyst Mg Content (wt%)	1.66	1.66	3.17	3.17	3.17	3.17
Prod Rate (lbs/hr)	34.2	38.7	38.3	35.2	33.3	38.7
Residence Time (hrs)	3.2	2.9	3.0	3.3	3.5	3.0
C <sub>2</sub> Partial Pressure (psia)	100	120	120	120	120	120
H <sub>2</sub> /C <sub>2</sub> (m/m)	0.418	0.180	0.257	0.268	0.360	0.346
C <sub>4</sub> /C <sub>2</sub> Conc. Ratio (m/m)	0.0109	0.0078	0.0062	0.0056	0.0078	0.0102
C <sub>6</sub> /C <sub>2</sub> Conc. Ratio (m/m)	-	-	-	-	-	-
Isopentane (mole%)	3.55	4.11	0.38	0.29	0.28	0.29
RX Pressure (psig)	347	347	347	347	347	347
RX Temperature (°C)	102	102	102	102	102	102
Gas Velocity (ft/sec)	2.00	1.98	2.00	1.99	1.97	1.97
Bed Weight (lbs)	111	112	115	115	116	115
Fluid Bulk Density (lb/ft <sup>3</sup> )	15.2	15.3	17.6	17.5	17.6	17.4
Cocatalyst ID	TEAL	TEAL	TEAL	TEAL	TEAL	TEAL
Cocatalyst Conc. (wt%)	2.5	2.5	1.0	1.0	1.0	1.0
Cocatalyst Feed (cc/hr)	299.0	300.1	150.6	149.6	150.5	150.3
Reactor Cocatalyst Conc. - Prod Rate Basis (ppmw)	299	265	54	58	62	53
Cont. Additive	None	None	None	None	None	None
Continuity Additive Conc. (wt%)	-	-	-	-	-	-
Continuity Additive Feed (cc/hr)	-	-	-	-	-	-
Reactor Cont. Additive Conc. - Prod Rate Basis (ppmw)	-	-	-	-	-	-
Cat. Prod. - Ti ICPES Basis (g PE/g Catalyst)	-	3,464	-	5,928	-	-
Material Balance Cat. Prod. (g PE/g Catalyst)	6,734	5,518	13,421	11,861	10,809	12,538

<b>Table 4B</b>					
<b>Examples</b>	<b>C7</b>	<b>C8</b>	<b>C9</b>	<b>C10</b>	<b>C11</b>
Polymer Type	HDPE	HDPE	HDPE	HDPE	HDPE
Catalyst Ti Content (wt%)	1.31	1.31	1.31	1.31	1.31
Catalyst Al Content (wt%)	5.10	5.10	5.10	5.10	5.10
Catalyst Mg Content (wt%)	3.17	3.17	3.17	3.17	3.17
Prod Rate (lbs/hr)	37.3	36.7	39.1	42.8	17.9
Residence Time (hrs)	3.1	3.2	3.0	2.7	6.4
C <sub>2</sub> Partial Pressure (psia)	120	120	120	120	100
H <sub>2</sub> /C <sub>2</sub> (m/m)	0.340	0.334	0.338	0.404	0.344
C <sub>4</sub> /C <sub>2</sub> Conc. Ratio (m/m)	0.0096	0.0092	0.0096	0.0015	0.0164
C <sub>6</sub> /C <sub>2</sub> Conc. Ratio (m/m)	-	-	-	-	-
Isopentane (mole%)	0.14	0.28	0.53	0.26	0.33
RX Pressure (psig)	347	347	347	347	347
RX Temperature (°C)	102	102	102	102	100
Gas Velocity (ft/sec)	1.97	1.97	1.97	1.97	1.97
Bed Weight (lbs)	116	116	117	118	115
Fluid Bulk Density (lb/ft <sup>3</sup> )	16.2	17.3	17.8	18.2	17.3
Cocatalyst ID	TEAL	TEAL	TEAL	TEAL	TEAL
Cocatalyst Conc. (wt%)	1.0	1.0	1.0	1.0	1.0
Cocatalyst Feed (cc/hr)	74.8	149.7	300.4	149.5	150.0
Reactor Cocatalyst Conc. - Prod Rate Basis (ppmw)	27	56	105	48	114
Cont. Additive	None	None	None	None	None
Continuity Additive Conc. (wt%)	-	-	-	-	-
Continuity Additive Feed (cc/hr)	-	-	-	-	-
Reactor Cont. Additive Conc. - Prod Rate Basis (ppmw)	-	-	-	-	-
Cat. Prod. - Ti ICPEs Basis (g PE/g Catalyst)	8,037	6,121	4,651	-	-
Material Balance Cat. Prod. (g PE/g Catalyst)	14,653	11,890	8,715	9,699	10,182

[00130] The polymer of comparative example C12 was TUFLIN® HS-7098 NT 7 (a copolymer of ethylene and hexene) and was acquired from Dow Chemical Company. The polymer of comparative example C13 was DFDA 7047 NT 7 (a copolymer of ethylene and butene) and was acquired from Dow Chemical Company. The polymer of comparative example C14 was produced with LDPE 501i polyethylene and was acquired from Dow Chemical Company. The polymer of comparative example C16 was AFFINITY™ PL 1880G (a copolymer of ethylene and octene) and was acquired from Dow Chemical Company. The

polymer of comparative example C17 was EXCEED® 1018CA (a copolymer of ethylene and hexene) and was acquired from ExxonMobil Chemical.

[00131] Comparative example C15 was produced using a 2 liter autoclave gas phase reactor. The following procedure was used to produce the polymer of comparative example C15. The sealed reactor was cycled several times through a heat and nitrogen purge step to ensure that the reactor was clean and under an inert nitrogen atmosphere. About 1L of liquid isobutane was added to the sealed reactor at ambient temperature. A charge of about 1.3 ml of 1M triethyl aluminum was added to the reactor from a shot cylinder using nitrogen pressure. The reactor agitator was turned on at set to 800 rpm. Hydrogen (3.83 L) and 20 ml of 1-hexene were added to the reactor. The reactor was heated to a temperature of about 85°C and ethylene was added to achieve a 125 psi differential pressure. A nominal 35 mg charge of UCAT® A2020 (available from Univation Technologies LLC) was added to the reactor from a shot cylinder using nitrogen pressure. The ethylene feed pressure was increased to match the reactor pressure. The polymerization proceeded at about 85°C and ethylene was added continuously to maintain the reactor at constant pressure. After one hour, the reactor was cooled to ambient temperature, vented, opened, and the polymer product was recovered.

[00132] Selected properties for the polymers of Examples 1-19 and comparative examples C1-C17 are shown in Table 5 below.

<b>Ex.</b>	<b>Comonomer</b>	<b>MI (I<sub>2</sub>)</b>	<b>Density (g/cm<sub>3</sub>)</b>	<b>Mw</b>	<b>Mz</b>	<b>MWD</b>	<b>MFR (I<sub>21</sub>/I<sub>2</sub>)</b>	<b>MS (cN)</b>	<b>EVF Slope (SSH)</b>	<b>CHI</b>
Ex. 1	Butene	0.40	0.9548	143760	615200	5.99	40.0	14.0	0.928	-
Ex. 2	Butene	1.01	0.9549	121260	570400	6.26	37.8	8.5	-	-
Ex. 3	Butene	1.02	0.9555	120310	520500	5.84	36.4	7.3	-	-
Ex. 4	Butene	1.03	0.9544	122190	575100	6.27	38.8	8.5	-	-
Ex. 5	Butene	3.24	0.9597	94390	404600	5.88	33.8	3.3	-	-
Ex. 6	Butene	2.12	0.9562	98230	382100	5.50	33.8	4.8	-	-
Ex. 7	Butene	1.13	0.9532	109100	389300	4.97	35.4	6.7	-	-
Ex. 8	Butene	0.86	0.9544	118900	436600	5.48	37.7	8.3	-	-
Ex. 9	Butene	0.84	0.9553	120400	439100	5.03	37.3	8.0	1.284	-
Ex. 10	Butene	0.40	0.9531	165200	629200	6.08	33.0	6.8	0.452	-
Ex. 11	Butene	0.43	0.9541	162830	617600	6.14	32.8	6.5	-	-
Ex. 12	Butene	0.94	0.9531	135950	524700	5.94	30.6	3.7	-	-
Ex. 13	Butene	0.96	0.9541	134060	551900	6.08	30.5	3.7	-	-
Ex. 14	Butene	1.00	0.9550	134250	566700	6.27	31.0	3.8	0.631	-
Ex. 15	Butene	2.48	0.9576	113320	649900	6.83	32.8	2.2	-	-
Ex. 16	Butene	0.72	0.9525	132210	529500	5.58	40.7	8.2	1.030	0.459
Ex. 17	Butene	0.94	0.9538	128910	581900	6.11	37.5	8.2	-	0.093
Ex. 18	Hexene	0.99	0.9216	119000	483900	6.40	42.0	6.5	1.085	0.227
Ex. 19	Butene	1.00	0.9180	116055	443400	5.55	37.3	5.8	1.174	0.391
C1	Butene	0.94	0.9529	120400	330700	3.95	24.4	3.3	-	-
C2	Butene	1.03	0.9545	118600	329400	4.26	23.6	2.9	-	-
C3	Butene	0.41	0.9532	159300	631900	5.52	35.0	6.7	0.665	-
C4	Butene	0.43	0.9537	154100	636400	5.96	35.8	6.4	-	-
C5	Butene	1.05	0.9544	123300	465700	5.33	32.5	3.7	-	-
C6	Butene	1.04	0.9538	127000	524700	5.62	33.4	3.6	-	-
C7	Butene	0.91	0.9531	125800	446500	5.20	33.4	4.0	-	-
C8	Butene	0.78	0.9535	133000	545600	5.71	34.4	4.5	-	-
C9	Butene	1.03	0.9539	123500	447000	5.30	32.3	3.6	0.371	-
C10	Butene	1.03	0.9290	118100	417800	5.50	37.8	4.0	-	-
C11	Butene	1.04	0.9507	124400	496200	5.65	31.9	3.6	-	-
C12	Hexene	1.00	0.9220	123300	387280	4.22	26.5	3.7	0.062	0.228
C13	Butene	1.00	0.9180	125000	371660	3.97	24.5	3.7	0.086	0.395
C14	N/A (LDPE)	1.85	0.9202	76700	304400	4.58	53.7	6.1	0.706	0.833
C15	None	0.41	0.9498	157140	510900	4.69	23.0	7.2	0.157	-
C16	Octene	0.98	0.9019	105141	189379	2.28	30.1	3.72	0.447	0.947
C17	Hexene	1.00	0.9180	84951	152680	2.13	15.9	2.54	0.060	0.730

[00133] As shown in Table 5 above, the molecular weight distribution (MWD), slope of strain hardening (SSH), and melt flow ratio (MFR) for selected examples, namely, Examples 1, 9, 10, 14, 16, 18, and 19 and comparative examples C3, C9, and C12-C15, were measured. As shown, Examples 1, 9, 16, 18, and 19 all had a MWD ranging from about 5.03 to about 6.4, a SSH greater than 0.75, and a MFR greater than or equal to  $8.33 + (4.17 \times \text{MWD})$ . In contrast, not one of the comparative examples C3, C9, and C12-C15 includes all three properties in combination with one another. Indeed, it is believed that polyethylenes having the unique

combination of MWD, SSH, MFR, and heterogeneous short chain branching distribution associated with Ziegler-Natta polymers are unique to the inventive Ziegler-Natta catalyst polyethylenes.

[00134] Another property measured for selected examples, namely, Examples 16-19 and comparative examples C12, C13, and C16 was the comonomer heterogeneity index (CHI). The CHI was determined according to following procedure. The data used and shown in Table 6 for the following CHI measurement procedure was the data acquired for Ex. 19. For clarity and ease of description some data is omitted from Table 6. However, the full range of experimental data for the data shown in Table 6 is shown in the graph depicted in Figure 1, which shows the Calculation of CHI from the CEF Data.

Table 6							
	Temp. (°C)	Response		Area			Calculated
		Measured	Zeroed	Trapezoid	Cumulative (S <sub>i</sub> )	Cum_Norm x 10	Comonomer
	T <sub>i</sub>		H <sub>i</sub>		S <sub>i</sub>	nS <sub>i</sub>	C <sub>i</sub>
	34.855	0	0	0	0	0	0.112792905
	34.902	-0.001	0	0	0	0	0.112701549
	34.948	0.001	0	0.001	0.001	0	0.112612785
	34.998	-0.001	0	0	0.001	0	0.112514719
	<b>35.048</b>	<b>-0.002</b>	<b>0</b>	<b>0</b>	<b>0.001</b>	<b>0</b>	<b>0.1124192</b>
	35.1	0	0	0	0.001	0	0.112317822
	35.148	0	0	0	0.001	0	0.112224333
	35.197	-0.001	0	0	0.001	0	0.1121294
	35.244	-0.003	0	0	0.001	0	0.112038638
Data omitted for clarity							
	77.64	1.797	1.797	0.073	27.468	3.075	0.036890771
	77.681	1.801	1.801	0.093	27.561	3.085	0.036824825
	77.732	1.807	1.807	0.086	27.647	3.095	0.036741541
<b>hT<sub>i</sub></b>	<b>77.779</b>	<b>1.816</b>	<b>1.816</b>	<b>0.104</b>	<b>27.751</b>	<b>3.106</b>	<b>0.0366649</b>
	77.836	1.821	1.821	0.076	27.827	3.115	0.036572069
Data omitted for clarity							
	85.257	2.481	2.481	0.152	44.306	4.959	0.024718997
	85.318	2.481	2.481	0.124	44.431	4.973	0.024622744
	85.368	2.48	2.48	0.095	44.525	4.984	0.024543881
<b>T<sub>m</sub></b>	<b>85.406</b>	<b>2.478</b>	<b>2.478</b>	<b>0.121</b>	<b>44.646</b>	<b>4.997</b>	<b>0.0244839</b>
	85.455	2.478	2.478	0.127	44.773	5.011	0.024407127
	85.506	2.48	2.48	0.119	44.892	5.025	0.024326748
	85.554	2.479	2.479	0.123	45.015	5.039	0.024251338
	85.604	2.476	2.476	0.119	45.134	5.052	0.024173364
Data omitted for clarity							
	93.123	2.397	2.397	0.138	62.302	6.973	0.012529889
	93.18	2.41	2.41	0.119	62.421	6.987	0.012442021
	93.229	2.425	2.425	0.109	62.53	6.999	0.012366879
<b>IT<sub>i</sub></b>	<b>93.274</b>	<b>2.441</b>	<b>2.441</b>	<b>0.089</b>	<b>62.619</b>	<b>7.009</b>	<b>0.0122987</b>
	93.311	2.455	2.455	0.107	62.726	7.021	0.012242985
	93.354	2.47	2.47	0.146	62.872	7.037	0.012176941
	93.413	2.487	2.487	0.129	63.001	7.052	0.012087362

Data omitted for clarity								
	104.879	0.005	0.005	0	89.341	10	0	
	104.915	0.005	0.005	0	89.341	10	0	
	<b>104.95</b>	<b>0.004</b>	<b>0.004</b>	<b>0</b>	<b>89.341</b>	<b>10</b>	<b>0</b>	<b>n=N</b>
	105.002	0.003	0.003					
	<b>Calculated parameters</b>							
	<b>C 0.5 (lC<sub>i</sub>)</b>	<b>0.01224</b>		<b>In this example, N = 1441</b>				
	<b>CHI</b>	<b>0.391</b>						
	<b>C1.5 (hC<sub>i</sub>)</b>	<b>0.03673</b>						
	<b>M50</b>	<b>34.973</b>						
	<b>Total Wt</b>	<b>89.341</b>						

[00135] The Crystallization Elution Fractionation (CEF) data was tabulated from a temperature of 35°C to 105°C as Temperature (T) vs. Response Height (H). Response data points less than 0 were set to zero for purposes of the calculation. The data was collected at a frequency of a temperature interval of 0.5°C or less (e.g., an interval of 0.2°C). The cumulative curve was calculated according to the following steps: (1)  $S_i = (T_{i+1} - T_i) \times (H_i + H_{i+1})/2 + \sum(S_1..S_{i-1})$ , where H is the response (mass = dWf/dT), (2)  $i = 1 \dots N-1$ , (3) N = the total number of points that range from the point closest to and greater than  $T = 35.0^\circ\text{C}$  to the point closest to and less than  $T = 105.0^\circ\text{C}$  inclusive, and (4)  $S_i$  was normalized according to:  $nS_i = 10 \times S_i/S_N$ . The median temperature  $T_m$  was the point where  $nS_i$  is closest to 5.0. The comonomer content at  $T_m$  was  $C_m$  and was calculated according to the following steps: (1)  $C_m = 1 - \exp(0.5533 - (207.0/(273.12 + T_m)))$ , and (2)  $C_i$  was calculated for each measured  $T_i$ :  $C_i = 1 - \exp(0.5533 - (207.0/(273.12 + T_i)))$ . The mass fraction ( $M_{50}$ ) within the region  $0.5 \times C_i$  to  $1.5 \times C_i$  was calculated according to the following steps: (1)  $lC_i = 0.5 \times C_i$ ; (2)  $hC_i = 1.5 \times C_i$ ; (3) Limits of the range used was set by determining the  $C_i$  values calculated closest to  $lC_i$  and  $hC_i$ : (a)  $alC_i = C_i$  closest to and greater than  $lC_i$ ; and (b)  $ahC_i = C_i$  closest to and less than  $hC_i$ ; (4) The  $T_i$  values equivalent to  $alC_i$  and  $ahC_i$  were identified: (a)  $lT_i \equiv alC_i$ , and (b)  $hT_i \equiv ahC_i$ ; (5) The mass fraction in this region was calculated as in step 4 but within the range  $lT_i$  and  $hT_i$  inclusive (a)  $M50 = \sum(T_{i+1} - T_i) \times (H_i + H_{i+1})/2$  where i represents the data points in the range  $lT_i$  to  $hT_{i-1}$  inclusive  $CHI = M50/S_N$ .

[00136] The CEF data comparing Ex. 18 to C12 and Ex. 19 to C13 are shown in the graphs depicted in Figures 2 and 3, respectively.

#### Slope of Strain Hardening

[00137] The slope of strain hardening (SSH) as measured by extensional viscosity fixture was determined for Examples 1, 9, 10, 14, 16, 18, and 19 and comparative examples C3, C9, and

C12-C15, the values of which are shown in Table 5. The extensional viscosity fixture (EVF) analysis comparing Examples 18 and 19 to comparative examples C3, C12, and C13 is also graphically shown in Figure 4. As shown in Figure 4, Examples 18 and 19 surprisingly and unexpectedly had a significant increase in the strain hardening rate ( $0.1 \text{ s}^{-1}$ ) at a temperature of  $150^\circ\text{C}$ , measured according to the extensional viscosity fixture test discussed and described above.

#### Melt Strength

[00138] The melt strength for Example 1 was compared to comparative examples C3 and C15 all having a melt index ( $I_2$ ) of about  $0.4 \text{ g}/10 \text{ min}$ . Figure 5 depicts the graphical representation of the melt strength for Ex. 1, C3, and C15. As shown in Figure 5, the melt strength of the polyethylene of Ex. 1 surprisingly and unexpectedly far exceeds the melt strength of comparative examples C3 and C15.

#### Blown Film Experiments

[00139] Mono-layer films were formed from the polyethylenes of Examples 18 and 19 and comparative examples C12 and C13 via a blown film process. Depending on the particular example, a LDPE resin (LDPE 501i manufactured by The Dow Chemical Company) was blended with the examples in various amounts ranging from none or zero up to about 30 wt%, based on the combined weight of the Ex. 18, 19, C12, or C13 polyethylene and the LDPE 501i resin. The LDPE 501i resin had a melt index ( $I_2$ ) of 1.9 MI and was acquired from Dow Chemical. The blown films had a nominal thickness of  $25 \mu\text{m}$  or  $12.5 \mu\text{m}$ . The commercially available comparative resins (C12 and C13) were chosen because those resins have a very close match with the inventive polyethylenes in terms of melt index and density. More particularly, the polyethylenes of Ex. 18 and comparative example C12 were both ethylene/hexene copolymers of melt index 1.0 and density  $0.922\text{g}/\text{cm}^3$ ; and the polyethylenes of Ex. 19 and comparative example C13 were both ethylene/butene copolymers that had a melt index 1.0 and density  $0.918\text{g}/\text{cm}^3$ . As such, Ex. 18 was compared to C12 and Ex. 19 was compared to C13.

[00140] The blend components, *i.e.*, the LDPE and the inventive polyethylene (Ex. 18 or 19) or the LDPE and the comparative polyethylene (C13 or C14) were weighed and tumble-blended in a rotating drum blender. The films were blown on a Colin blown film apparatus capable of three layer co-extrusion that required operation of all three extruders. As such, even though a monolayer film was formed, all three extruders were used and were fed with the same resin or resin blend.

[00141] The Colin blown film apparatus included three extruders, *i.e.*, Extruder A, B, and C. Extruders A and C each had a 25 mm barrel diameter and a 25:1 L/D single flight screw

forwarding screw. Extruder B had a 30 mm barrel diameter and a 25:1 L/D single flight forwarding screw. The combined resin from the three extruders was fed to an annular die which had a die diameter of 60 mm, a die gap of 2 mm, and a maximum take off speed of about 30 m/min. The blow up ratio (BUR) was about 2.5:1. The BUR is equal to the ratio of the Bubble Diameter to Die Diameter. The films were produced at the 25 $\mu$ m or 12.5  $\mu$ m thickness by adjusting the take-off rate. Each extruder A, B, and C was operated at 50% of the maximum take-off rate to allow for variations in motor load and pressure to be accommodated without requiring a change in screw speed. Bubble stability was studied by measuring the minimum air flow rate at which the bubble would be stable for 5 seconds when blowing the 12.5  $\mu$ m thick film samples. The experiments performed, extruder data, and bubble data are shown in Table 7 below.

Table 7: Blown Film Experiment														
	Extruder Data												Film Bubble	
	Melt Temp. (°C) in Each Extruder			Motor Current (Amps) in Each Extruder			Extruder Pressure (psi)			Resin Throughput per Extruder (lb/hr)			Frostline Height (cm)	Layflat (cm)
	A	B	C	A	B	C	A	B	C	A	B	C		
<b>LDPE 501i (wt%)</b>														
<b>C12</b>														
0	185	185	181	3.0	3.1	4.6	174	172	209	1.9	1.9	2.5	-	-
5	186	185	181	2.9	3.0	4.4	171	70	204	1.9	1.9	2.5	4.0	23.0
10	185	186	181	2.8	2.9	4.3	170	168	203	1.9	1.9	2.5	4.0	23.1
15	185	186	181	2.6	2.8	4.1	163	165	196	1.9	1.9	2.4	4.0	23.3
30	184	183	183	2.5	2.5	3.8	175	155	185	1.9	1.8	2.4	3.5	23.0
<b>Ex. 18</b>														
0	205	184	184	2.5	2.5	3.7	137	136	161	2.0	1.9	2.5	-	-
5	-	184	184	2.5	2.4	3.5	136	136	159	2.0	1.9	2.5	-	-
10	-	183	183	2.4	2.3	3.5	134	133	157	1.9	1.9	2.4	-	-
15	184	184	184	2.3	2.3	3.3	129	131	154	2.0	1.9	2.5	4.0	23.5
30	183	184	184	2.2	2.2	3.1	123	123	144	1.9	1.9	2.4	3.0	23.5
<b>C13</b>														
0	186	186	186	3.6	3.7	5.2	192	189	226	2.0	2.1	2.6	-	-
5	186	185	185	3.5	3.6	5.0	187	186	220	2.0	2.0	2.5	4.5	23.5
10	185	186	186	3.3	3.5	4.7	182	180	214	2.0	2.0	2.5	4.5	23.5
15	186	185	185	3.1	3.3	4.5	178	177	210	1.9	2.0	2.5	4.5	23.5
30	185	184	184	3.0	2.9	3.9	170	157	188	1.9	1.9	2.3	4.0	23.3
<b>Ex. 19</b>														
0	184	186	186	2.8	2.8	4.1	146	146	174	2.0	2.0	2.5	-	-
5	183	185	185	2.7	2.8	4.0	144	144	169	2.0	2.0	2.5	-	23.4
10	183	184	184	2.6	2.7	3.8	142	143	167	2.0	2.0	2.5	4.0	23.4
15	183	183	183	2.7	2.8	3.7	142	141	167	2.0	1.9	2.5	4.0	23.5
30	184	184	184	2.6	2.5	3.4	137	137	156	2.0	1.9	2.4	3.5	23.5

[00142] The terms "processibility of a polymer" and "polymer processibility" are used interchangeably and refer to the ability to maximize production rate. As such, a highly processible polymer is capable of being converted at a higher rate than a polymer with less processibility. Extrusion processibility can be limited, for example, by the limit of the drive motor (measured as power consumption in Amps) and the pressure build up within the extruder at various locations including at the entrance to the die. In blown film processes, the maximum production rate can also be limited by the stability of the bubble. It will be understood by those skilled in the art that there are many forms of bubble instability any of which can limit the maximum production rate even if the extruder system is capable of higher throughput with the particular polymer or polymer blend involved. In demonstrating the advantages of the inventive polyethylenes, the minimum air-ring air flow required to maintain a stable bubble for at least five seconds at a take-off rate providing 12.5  $\mu\text{m}$  (0.5 mil) film was measured. A lower minimum air flow is indicative of a more stable bubble. The inventive polyethylenes had improved processibility over the comparative polyethylenes, some of which are shown in Table 8.

<b>Table 8: Blown film experiment</b>			
<b>Blend Composition - LDPE 501i (wt%)</b>	<b>Extruder data</b>		<b>Bubble Stability</b>
	<b>Motor Load (Amps)</b>	<b>Pressure (psi)</b>	<b>Min air flow for stable bubble at 12.5 <math>\mu\text{m}</math> (% of max flow)</b>
<b>C12</b>			
0	10.7	209	43
5	10.3	204	42
10	10.0	203	41
15	9.5	196	41
30	8.8	185	39
<b>Ex. 18</b>			
0	8.7	161	41
5	8.4	159	40
10	8.2	157	39
15	7.9	154	41
30	7.5	144	38
<b>C13</b>			
0	12.5	226	43
5	12.1	220	44
10	11.5	214	44
15	10.9	210	43
30	9.8	188	41

<b>Ex. 19</b>			
0	9.7	174	42
5	9.5	169	42
10	9.1	167	42
15	9.2	167	42
30	8.5	156	41

[00143] For all polymers that included the addition of the LDPE 501i a reduced motor load was expected with respect to the pure polyethylene. Both of Examples 18 and 19 had a lower motor load than the comparative examples C12 and C13, respectively, at all levels of added LDPE 501i when comparing equal blend compositions. Surprisingly and unexpectedly, the pure polyethylenes of Examples 18 and 19, *i.e.*, no LDPE was added, also exhibited less motor load than the comparative examples blended with any level of LDPE 501i up to and including 30 wt% LDPE 501i in spite of the LDPE 501i having a melt index of 1.85g/10min.

[00144] Both of Examples 18 and 19 exhibited a substantially lower extruder pressure than the comparative examples C12 and C13, respectively, at all levels of added LDPE 501i when comparing equal blend compositions. Surprisingly and unexpectedly, the pure polyethylenes of Examples 18 and 19, *i.e.*, no LDPE was added, also exhibited substantially less extruder pressure than the comparative examples blended with any level of LDPE 501i up to and including 30 wt% LDPE 501i in spite of the LDPE 501i having a melt index of 1.85g/10min.

[00145] Both of Examples 18 and 19 exhibited a greater or similar bubble stability than the comparative examples C12 and C13 respectively at all levels of added LDPE 501i when comparing equal blend compositions. Surprisingly and unexpectedly, the pure polyethylenes of Examples 18 and 19, *i.e.*, no LDPE was added, exhibited improved bubble stability compared to the comparative resins blended with up to 15% LDPE 501i.

[00146] Taken individually and together these results demonstrate that the inventive polyethylenes of Examples 18 and 19 have substantially superior processibility compared to conventional Ziegler-Natta resins and allow the converter to maintain or increase throughput without the added cost of obtaining and handling LDPE commonly used to improve the processibility of conventional Ziegler-Natta LLDPE. Although demonstrated here for blown film production, it is expected that these benefits will equally apply to any conversion process involving the extrusion of polymer, including, but limited to, cast processes, *e.g.*, cast film and extrusion coating, injection molding, blow-molding, and sheet extrusion. In particular, the ability to eliminate or reduce the use of LDPE and yet maintain or increase processibility is highly advantageous as it is well known in the art that LDPE added to Ziegler-Natta LLDPE generally reduces the physical properties compared to the pure Ziegler-Natta resin. To

compensate for this, converters will often increase the gauge of the film thus reducing the benefits of the increased production rate obtained through the addition of LDPE.

[00147] Tensile properties of Examples 18 and 19 and comparative examples C12 and C13 and blends with LDPE 501i are shown in Table 9 below. The measured tensile properties were Elmendorf Tear in machine direction (MD) and cross direction (CD) with respect to film take-off direction and puncture. These properties were measured for both the 25  $\mu\text{m}$  and the 12.5  $\mu\text{m}$  films.

Table 9: Physical Properties of Films Tested						
Blend Composition - LDPE 501i (wt%)	Film gauge: 25 $\mu\text{m}$			Film gauge: 12.5 $\mu\text{m}$		
	Puncture	Elmendorf Tear		Puncture	Elmendorf Tear	
		Force (ft·lb/in <sup>3</sup> )	CD (g)		MD (g)	Force (ft·lb/in <sup>3</sup> )
<b>C12</b>						
0	218	541	406	209	277	582
5	171	533	344	177	301	674
10	172	567	270	179	300	672
15	148	578	210	137	311	726
30	128	585	161	111	309	684
<b>Ex. 18</b>						
0	160	467	106	145	364	823
5	150	518	108	138	346	769
10	120	556	66	127	401	913
15	122	516	106	113	424	1025
30	104	561	100	97	379	975
<b>C13</b>						
0	216	305	155	215	253	559
5	188	325	147	168	229	491
10	175	369	103	154	258	568
15	155	380	90	131	266	585
30	108	372	51	106	212	468
<b>Ex. 19</b>						
0	134	338	97	121	244	537
5	121	366	76	112	249	567
10	101	390	58	105	275	607
15	92	362	54	101	277	647
30	86	428		79	292	675

[00148] Puncture is reported as puncture force (foot pounds per cubic inch or ft·lb/in<sup>3</sup>). In all examples, the puncture of the pure polyethylene films of Examples 18 and 19, *i.e.*, no LDPE 501i was added, was less than the pure comparative resins, but the puncture of the pure inventive resins exceeds the blends of comparative resins containing about 20% or more LDPE 501i.

[00149] Some observations between the puncture of the ethylene/hexene copolymer films of Ex. 18 and C12 were as follows. The 25  $\mu\text{m}$  pure polyethylene film of Ex.18 had superior puncture to the 25  $\mu\text{m}$  thick comparative film of C12 that contained 15 wt% LDPE 501i. The Ex. 18 film with 5 wt% LDPE had the same puncture as the C12 film that contained 15% LDPE. The 12.5  $\mu\text{m}$  pure polyethylene film of Ex.18 had superior puncture to the comparative resin C12 containing 15 wt% LDPE 501i. The Ex. 18 film with 5 wt% LDPE had the same puncture as C12 containing 15 wt% LDPE. To achieve equivalent motor load to the pure polyethylene film of Ex. 18, 30 wt% LDPE 501i loading in the comparative example C12 was required. An even greater amount of LDPE 501i would be required to achieve equivalent extruder pressure. Accordingly, through the use of the inventive polyethylene of Ex. 18 it was possible to achieve improved puncture performance while at the same time enjoying the benefits of increased processibility.

[00150] Some observations between the puncture of the ethylene/butene copolymer films of Ex. 19 and C13 were as follows. The 25  $\mu\text{m}$  pure polyethylene film of Ex.19 had superior puncture to the comparative resin C13 that contained 30 wt% LDPE 501i and via interpolation, similar puncture to a 22 wt% blend. The film of Ex. 19 that contained 5 wt% LDPE had superior puncture compared to the film of C13 that contained 30 wt% LDPE. The 12.5  $\mu\text{m}$  pure polyethylene film of Ex.19 had superior puncture to the comparative C13 film that contained 30 wt% LDPE 501i. The film of Ex. 19 that contained 10 wt% LDPE had the same puncture as the film of C13 that contained 30 wt% LDPE. To achieve equivalent motor load to the pure polyethylene film of Ex. 19, 30 wt% LDPE 501i loading in comparative example C13 was required. An even greater amount of LDPE 501i would be required to achieve equivalent extruder pressure. Accordingly, through the use of the inventive polyethylene of Ex. 19 it was possible to achieve improved puncture performance while at the same time enjoying the benefits of increased processibility.

[00151] The effect the addition of the LDPE 501i to the tear properties was very dependent on the gauge of film produced under the conditions of the experiments. At 25  $\mu\text{m}$ , the cross direction tear or CD tear (also referred to as transverse direction or TD tear) increased with increasing LDPE loading whereas the machine direction or MD tear decreased. In contrast, at 12.5  $\mu\text{m}$ , the CD and MD tear both increased with the addition of LDPE up to about 15 wt%. At higher levels the CD and MD tear values tended to decrease slightly. The inventive polyethylenes of Examples 18 and 19 were found to be particularly suitable for thin gage film applications requiring good tear performance.

[00152] Some observations between the tear properties of the ethylene/hexene copolymer films (Ex. 18 vs. C12) were as follows. The CD tear for the 25  $\mu\text{m}$  films of Ex. 18 and C12 were substantially the same at all LDPE loadings, including zero loading. With both Ex. 18 and C12, the CD tear tended to increase with increased LDPE loading. The MD tear for the 25  $\mu\text{m}$  film of Ex. 18 was substantially reduced compared to the pure comparative polyethylene of C12. The MD tear of Ex. 18 was essentially unaffected by the level of LDPE loading maintaining a value of about 100 g whereas the tear of C12 dropped from about 400g with zero LDPE to about 160g with 30 wt% LDPE. The CD tear of the 12.5  $\mu\text{m}$  film of Ex. 18 and all blends of Ex. 18 containing LDPE 501i exceeded the CD tear of the comparative films of C13. The CD tear tended to increase with increasing LDPE composition. The CD tear of Ex. 18 reached a maximum at 15 wt% LDPE loading with a value of about 425 g and the maximum tear reached with the C13 films was also at a loading of 15 wt% LDPE with a value of about 310g. The MD tear for all of the 12.5  $\mu\text{m}$  films of Ex. 18 exceeded the MD tear of the comparative films of C13. For both Ex. 18 and C12, the MD tear tended to increase with increasing LDPE loading. The MD tear of Ex. 18 reached a maximum at 15 wt% LDPE loading with a value of about 1,025 g and the MD tear of C13 also reached a maximum at 15 wt% LDPE with a value of about 725 g. The inventive polyethylene/hexene copolymer of Ex. 19 was particularly advantageous when formed into thin gauge film (12.5  $\mu\text{m}$ ) by the blown film process. Indeed, not only were the CD and MD tear properties of the pure polyethylene of Ex. 18 substantially improved compared to C12 at any LDPE 501i loading, the inventive polyethylene copolymer of Ex. 18, in the absence of LDPE provided superior processibility. The pure polyethylene copolymer of Ex. 18, *i.e.*, no LDPE was added, was less advantageous at the thicker gauge (25  $\mu\text{m}$ ); however, in situations where a converter uses a high loading of LDPE (*e.g.*, 15 wt% or more) then the pure polyethylene copolymer of Ex. 18 would provide similar CD and MD tear properties with superior processibility.

[00153] Some observations between the tear properties of the ethylene/butene copolymer films (Ex. 19 vs. C13) were as follows. The CD tear of the 25  $\mu\text{m}$  films of the inventive polyethylene copolymer Ex. 19 and the comparative copolymer C13 were substantially the same at all LDPE loadings, including zero loading. With both Ex. 19 and C13, the CD tear tended to increase with increased LDPE loading. The MD tear for the 25  $\mu\text{m}$  films for the pure polyethylene copolymer of Ex. 19 was about 100 g, which was lower than the pure comparative resin C13 (about 155g). The MD tear for both Ex. 19 and C13 films reduced in an approximately linear fashion when the LDPE was added. The MD tear of the pure Ex. 19 film was about the same as that of the C13

film that contained 10 wt% LDPE and was superior to the C13 films that contained higher levels of LDPE 501i.

[00154] The CD tear for the 12.5  $\mu\text{m}$  films for all the polyethylene copolymers of Ex. 19 was substantially the same as that of the comparative C13 films up to about 15 wt% LDPE 501i. At 30 wt% LDPE loading the CD tear of the Ex. 19 film was about 290 g, while the CD tear of the corresponding C13 film was about 210 g. For both Ex. 19 and C13, the CD tear tended to increase with increasing LDPE loading. The CD tear of Ex. 19 reached a maximum at 30 wt% LDPE loading with a value of about 290 g, while the CD tear of the C13 film reached a maximum at 15 wt% LDPE loading with a value of about 265 g.

[00155] The MD tear of the Ex. 19 films and the C13 films were about equal at about 540 g and 560 g respectively. The MD tear of the Ex. 19 films increased in approximately a linear fashion, reaching a value of about 675 g at 30 wt% LDPE 501i loading. The MD tear of the C13 films was substantially unaffected by the addition of LDPE 501i up to about 15 wt% LDPE. At 30 wt% LDPE loading, however, the C13 films showed a substantial decrease in MD tear.

[00156] The inventive Ex. 19 polyethylene copolymer films were particularly advantageous when formed into thin gauge films (12.5  $\mu\text{m}$ , for example) by the blown film process. The CD and MD tear properties of the pure polyethylene films of Ex. 19 were generally similar to the comparative polyethylene films of C13 at any LDPE 501i loading, while the inventive polyethylene copolymer of Ex. 19, in the absence of LDPE loading, provided superior processibility. The inventive polyethylene copolymer of Ex. 19 was also advantageous for the production of thicker gauge films (25  $\mu\text{m}$ , for example), especially when compared to the comparative polyethylene copolymer of C13 at greater than about 10 wt% LDPE loading. In situations where a converter currently uses a high loading of LDPE (*e.g.*, 10 wt% or more) then the pure polyethylene copolymer of Ex. 19 would provide similar CD and MD tear properties with superior processibility.

[00157] Optics (clarity and haze) were also measured for the 25  $\mu\text{m}$  films of Examples 18 and 19 and comparative examples C12 and C13. The clarity and haze values are shown in Table 10 below.

<b>Table 10: Optics of 1mil Films Tested</b>		
	<b>Optics testing: B1470 ASTM lab</b>	
	<b>Film gauge: 25 <math>\mu</math>m</b>	
<b>Blend composition - LDPE501i (wt%)</b>	<b>Clarity (%)</b>	<b>Haze (%)</b>
<b>C12</b>		
0	87.5	12.4
5	89.4	10.2
10	90.6	8.7
15	92.3	7.1
30	94.0	5.5
<b>Ex. 18</b>		
0	95.9	6.0
5	95.2	6.7
10	95.5	6.0
15	95.4	5.7
30	94.7	5.4
<b>C13</b>		
0	99.5	4.9
5	99.5	3.7
10	99.3	3.0
15	99.4	2.6
30	98.1	2.5
<b>Ex. 19</b>		
0	98.2	5.2
5	97.4	5.0
10	97.7	4.6
15	97.4	4.5
30	96.2	5.0

[00158] The clarity values shown in Table 10 are reported as the percentage of incident light. The clarity and haze values were measured according to ASTM D1746 and D1003, respectively. The clarity of all inventive polyethylene copolymer Ex. 18 films exceeded the clarity of all corresponding comparative C12 films. The clarity of the C12 films increased from 87.5% to 94.0% as LDPE loading was increased from zero to 30%. The clarity of the Ex. 18 films remained substantially unchanged as the LDPE loading was increased, with a value close to 95.5% in all cases.

[00159] The clarity for both inventive and comparative ethylene/butene copolymer films of Ex. 19 and C13 were substantially unchanged at all loadings of LDPE 501i. The clarity of the pure polyethylene copolymer of Ex. 19 was about 98.2% and that of the pure copolymer of C13 was about 99.5%.

[00160] The haze of all inventive polyethylene copolymer films of Ex. 18 was less than the haze of the corresponding comparative films of C12. The haze of the comparative C13 films

decreased from 12.4% to 5.5% as the LDPE loading increased from zero to 30 wt%. The haze of the inventive polyethylene copolymer of Ex. 18 was substantially unchanged by addition of LDPE, with a value of about 6% for pure Ex. 18 and about 5.4% for the 30 wt% LDPE loading. [00161] The haze for the Ex. 19 films remained substantially unchanged at all loadings of LDPE 501i with a value close to about 5%. The haze for the C13 films decreased with increased loading of LDPE 501i from 4.9% to 2.5%.

[00162] The optics of the inventive ethylene/hexene copolymer of Ex. 18 was superior to the optics of the comparative ethylene/hexene copolymer of C13 and in particular was superior to the optics of the comparative copolymer containing up to 30 wt% LDPE 501i. This, in addition to the superior processibility of the inventive resins indicates the inventive copolymer of Ex. 18 would be advantageous in situations where good optics are required.

[00163] All numerical values are "about" or "approximately" the indicated value, and take into account experimental error and variations that would be expected by a person having ordinary skill in the art.

[00164] Various terms have been defined above. To the extent a term used in a claim is not defined above, it should be given the broadest definition persons in the pertinent art have given that term as reflected in at least one printed publication or issued patent.

[00165] While the foregoing is directed to embodiments of the present invention, other and further embodiments of the invention can be devised. The scope of the claims should not be limited by particular embodiments set forth herein, but should be construed in a manner consistent with the specification as a whole.

CLAIMS:

1. A method for making an olefin polymerization catalyst, consisting of:  
combining one or more supports with one or more magnesium-containing compounds under reaction conditions to form a first reacted product;  
combining one or more chlorinating compounds selected from the group consisting of one or more chloro substituted silanes comprising dimethyldichlorosilane, chlorotrimethylsilane, methyltrichlorosilane, diethyldichlorosilane, t-butyldimethylsilyl chloride, n-butyltrichlorosilane, and a combination thereof with the first reacted product under reaction conditions to form a second reacted product; and  
combining one or more titanium-containing compounds selected from the group consisting of one or more titanium alkoxides, one or more titanium halides, and a combination thereof with the second reacted product under reaction conditions to form a catalyst,  
wherein the catalyst is essentially free of electron donor compounds.
2. The method of claim 1, wherein the titanium-containing compound is a titanium halide.
3. The method of claim 1, wherein the one or more magnesium-containing compounds has the formula:  $R^1-Mg-R^2$ , wherein  $R^1$  and  $R^2$  are independently selected from the group consisting of hydrocarbyl groups and halogen atoms.
4. The method of claim 1, wherein the one or more titanium alkoxides comprises tetraisopropyltitanate, titanium (IV) ethoxide, titanium (IV) n-butoxide, titanium (IV) t-butoxide, tetrakis(dimethylamino)titanium (V), or any combination thereof.
5. The method of claim 1, wherein the one or more titanium halides comprises titanium (IV) chloride, titanium (IV) bromide, titanium (IV) fluoride, titanium (IV) iodide, or any combination thereof.

6. The method of claim 1, wherein the catalyst is essentially free of electron donor compounds selected from the group consisting of alcohols, thiols, amines, phosphines, ethers, ketones, and esters.
7. A method for making a polyethylene, comprising:  
making an olefin polymerization catalyst according to the method of any one of claims 1 to 6; and  
combining ethylene with the olefin polymerization catalyst in a polymerization reactor at conditions sufficient to produce a polyethylene.
8. A polyethylene as prepared by the method of claim 7, the polyethylene comprising:  
a molecular weight distribution (MWD) of 4.5 to 6.8;  
a slope of strain hardening greater than 0.75, as measured by extensional viscosity fixture (EVF);  
a melt flow ratio ( $I_{21}/I_2$ ) ranging from 30 to 45, and  
a melt flow ratio ( $I_{21}/I_2$ ) greater than or equal to  $8.33 + (4.17 \times \text{MWD})$ .
9. The polyethylene of claim 8, wherein the polyethylene has a long chain branching (LCB) greater than 0.01 per 1,000 carbon atoms and less than 0.05 per 1,000 carbon atoms.
10. The polyethylene of claim 9, wherein the long chain branching is composed of more than 6 carbon atoms.
11. The polyethylene of claim 8, 9 or 10, wherein the polyethylene has a comonomer homogeneity index (CHI) of less than 0.5.
12. The polyethylene of claim 8, 9 or 10, wherein the polyethylene has a heterogeneous distribution of short chain branching (SCB).

13. The polyethylene of claim 8, 9 or 10, wherein the polyethylene has a melt index ( $I_2$ ) ranging from 0.05 g/10 min to 100 g/10 min, measured according to ASTM D-1238-E (at 190°C, 2.16 kg weight).

14. The polyethylene of claim 8, 9 or 10, wherein the polyethylene has a flow index ( $I_{21}$ ) greater than 10 g/10 min, measured according to ASTM D-1238-F (at 190°C, 21.6 kg weight), and wherein the polyethylene has a melt index ( $I_2$ ) less than 100 g/10 min, measured according to ASTM D-1238-E (at 190°C, 2.16 kg weight).

15. The polyethylene of claim 8, 9 or 10, wherein the polyethylene has a density greater than or equal to 0.945 g/cm<sup>3</sup> and a melt strength greater than or equal to  $a \times (3.7463 \times \exp(-1.485 \times \log(MI)))$ , wherein a is equal to 1.9.

16. The polyethylene of claim 8, 9 or 10, wherein the polyethylene has a density less than or equal to 0.945 g/cm<sup>3</sup> and a melt strength greater than or equal to  $a \times (3.7463 \times \exp(-1.485 \times \log(MI)))$ , wherein a is equal to 1.2.

17. The polyethylene of claim 8, 9 or 10, wherein the polyethylene has a density less than or equal to 0.945 g/cm<sup>3</sup> and a melt strength greater than or equal to  $a \times (3.7463 \times \exp(-1.485 \times \log(MI)))$ , wherein a is equal to 1.9.

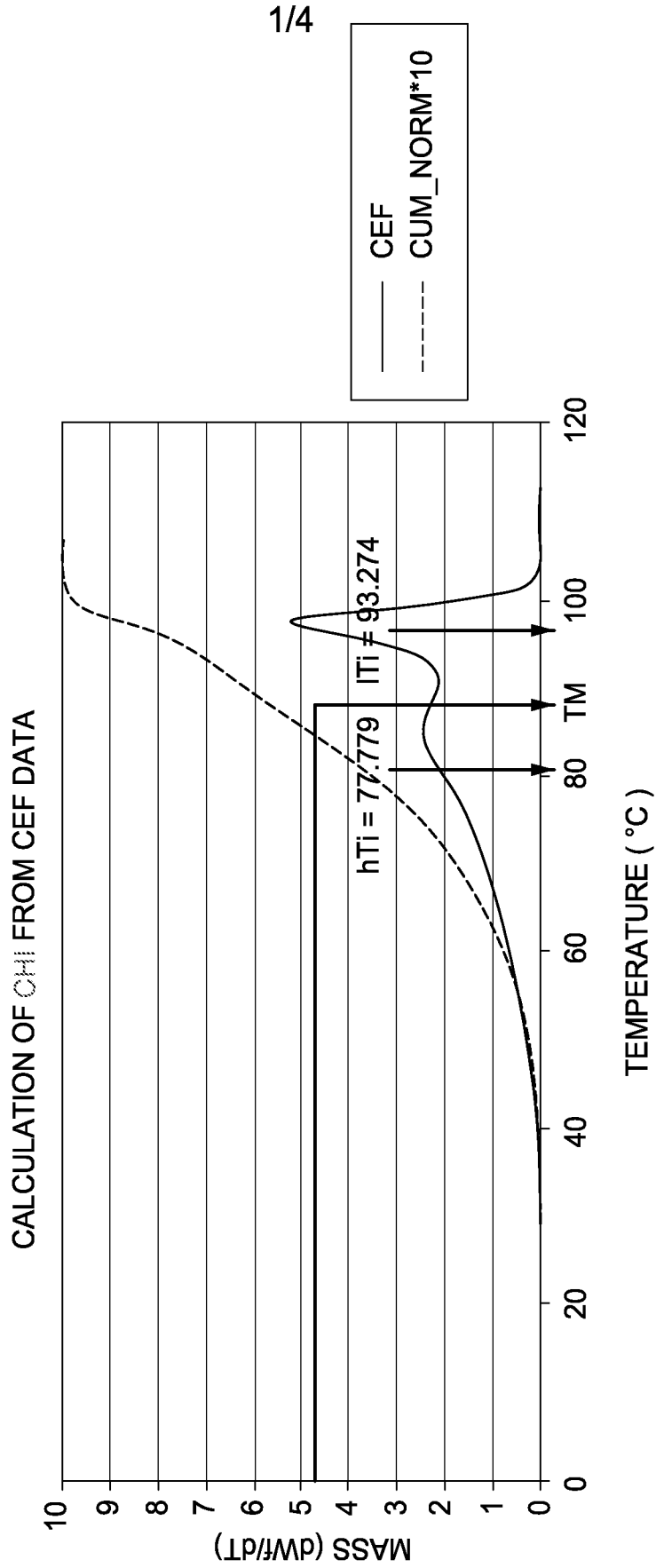
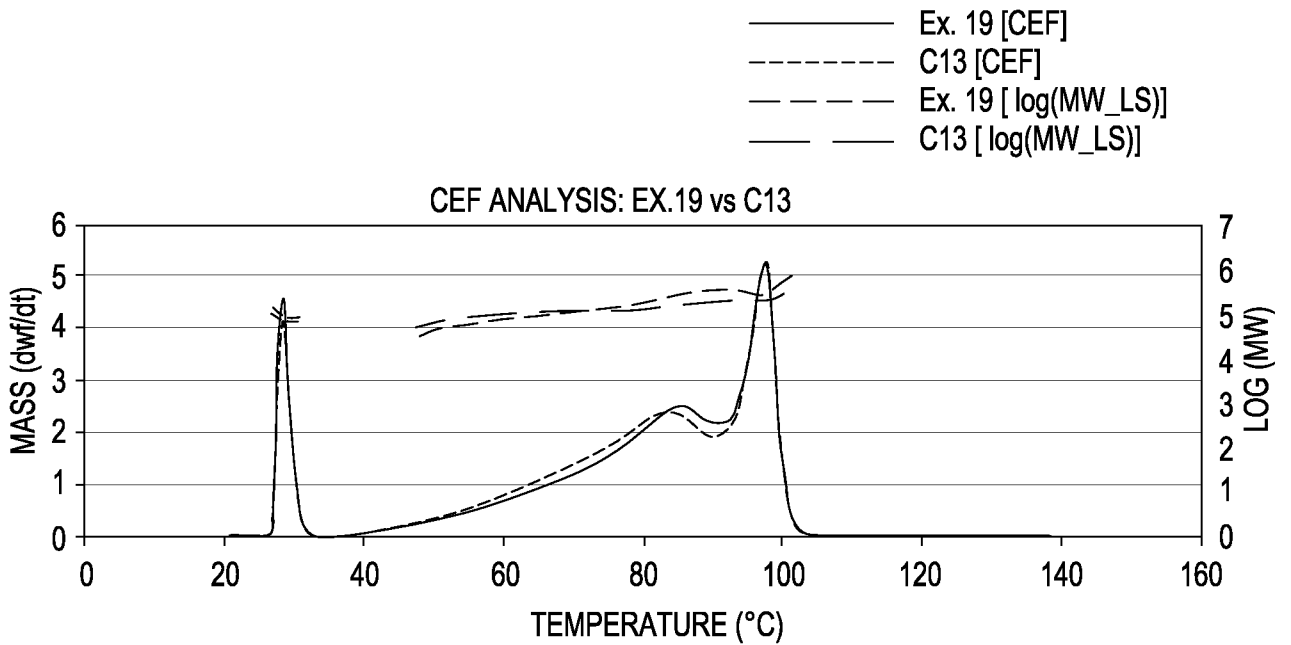
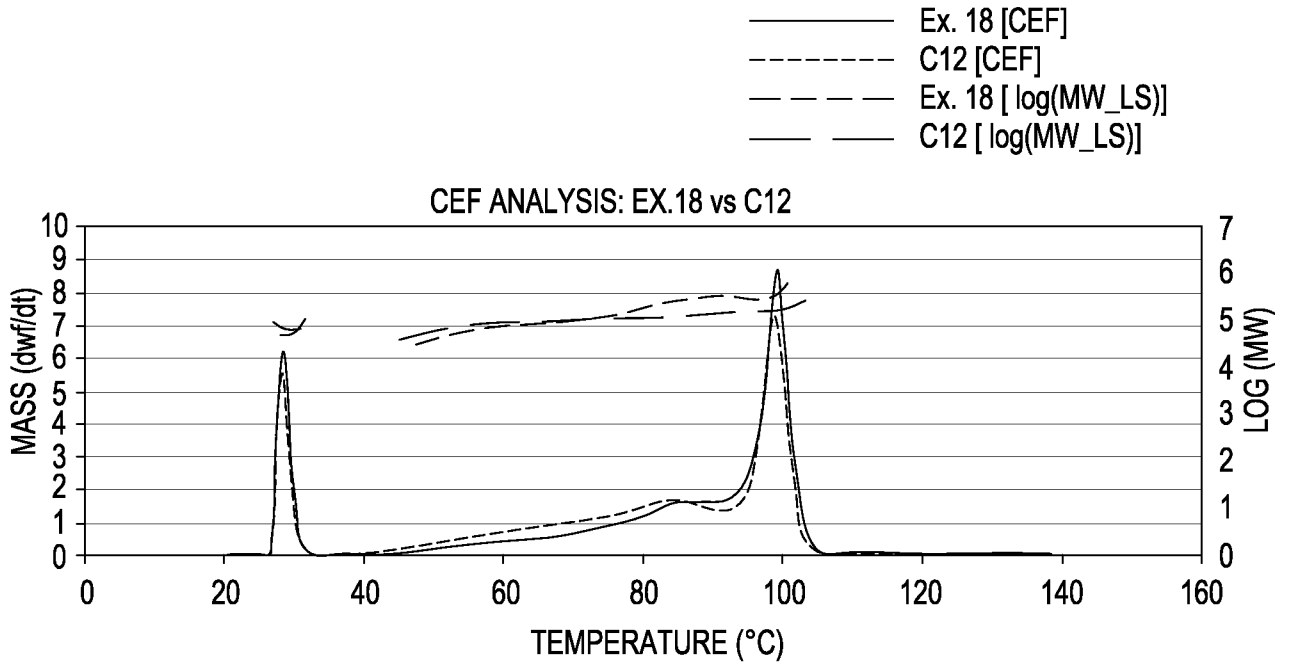


FIG. 1

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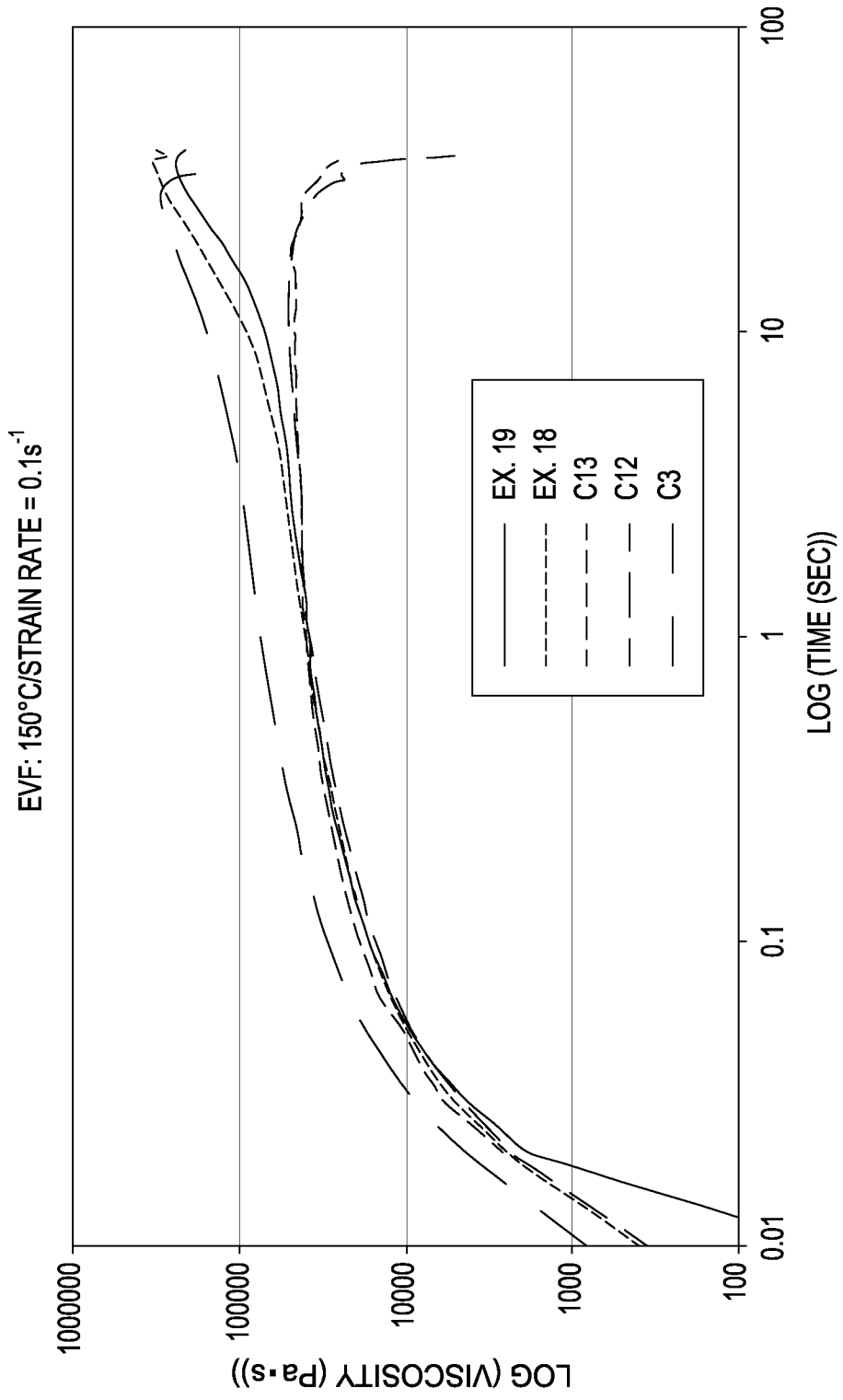


FIG. 4

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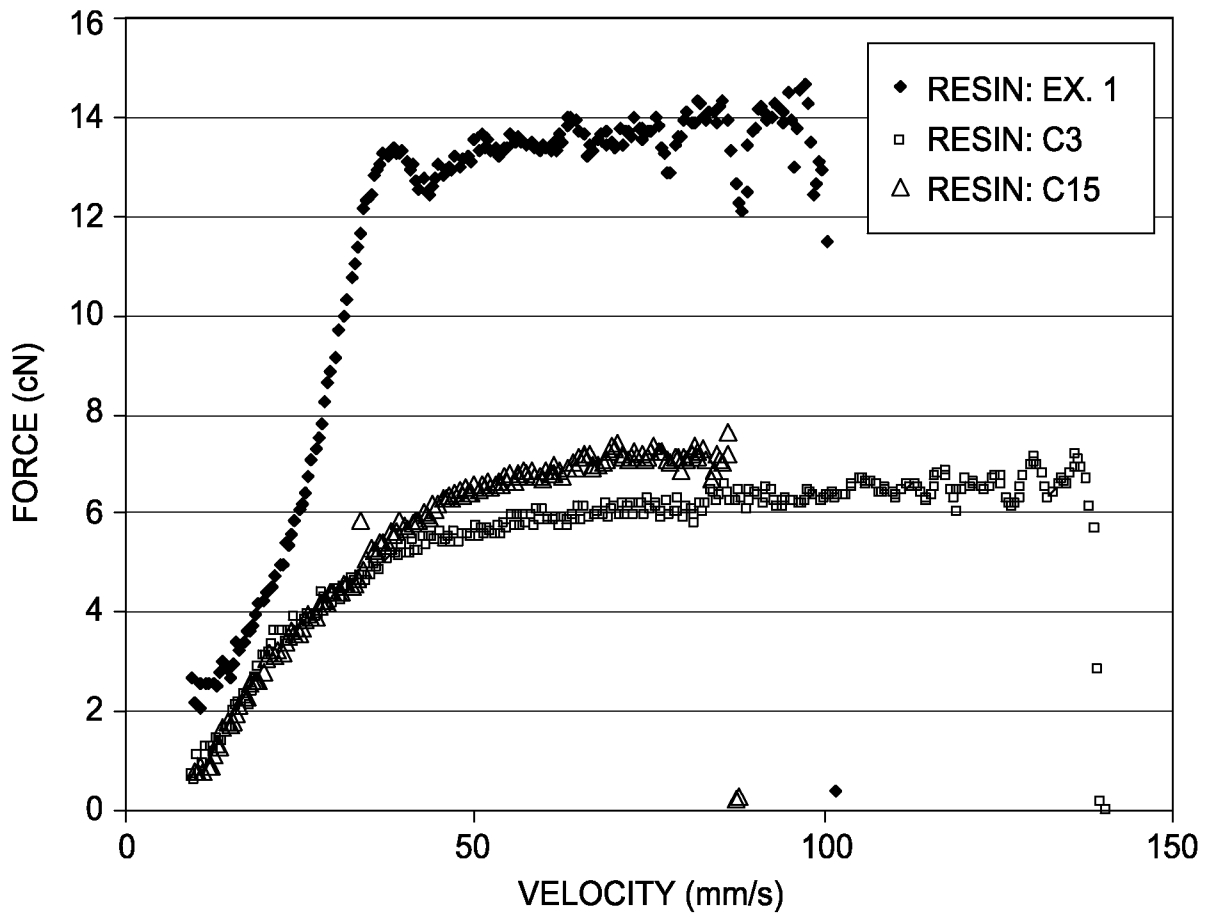


FIG. 5

### CALCULATION OF CHI FROM CEF DATA

