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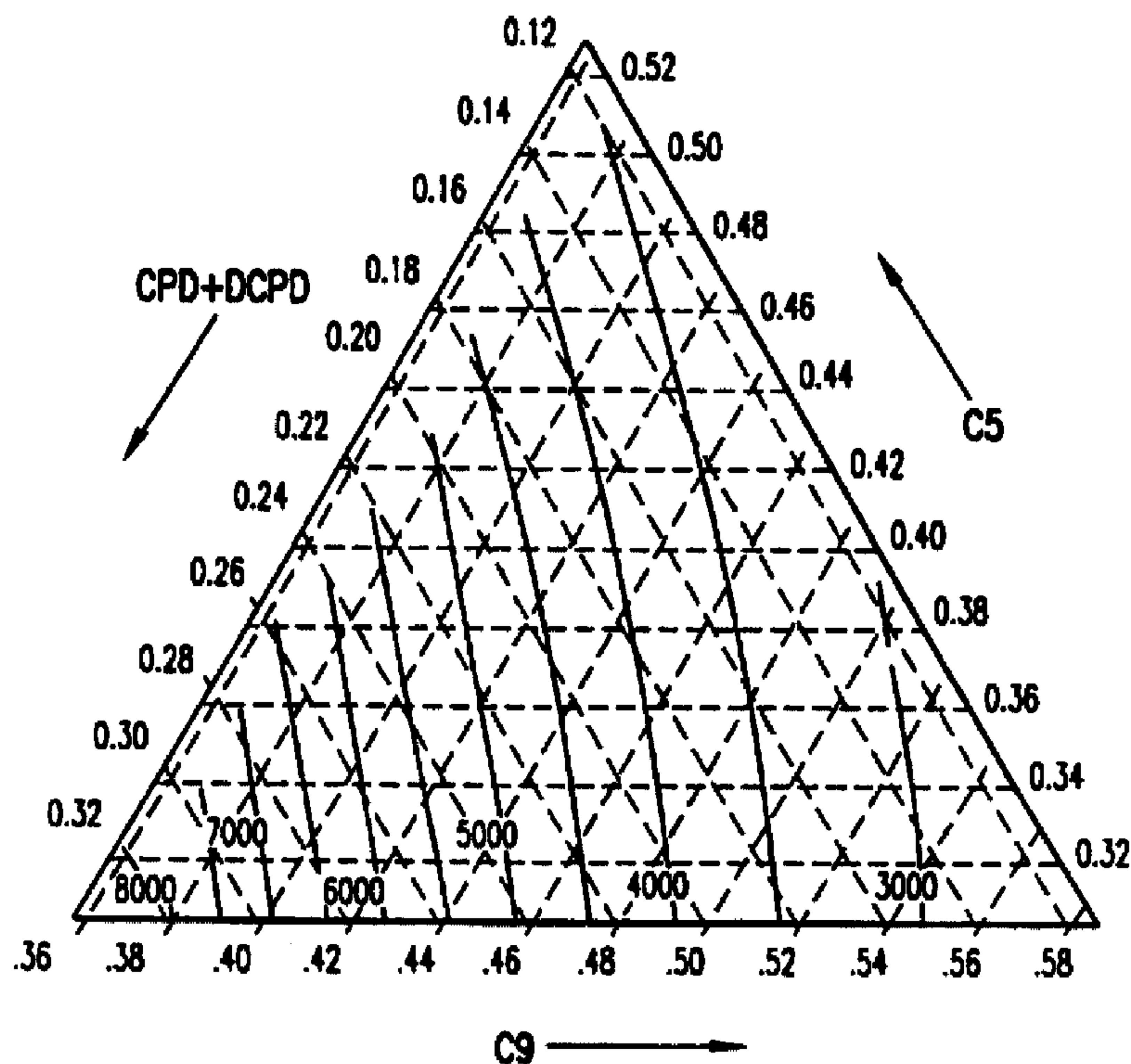
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(54) **RESINES D'HYDROCARBURES AROMATIQUES  
ALIPHATIQUES MODIFIES**

(54) **AROMATIC MODIFIED ALIPHATIC HYDROCARBON RESINS**



(57) L'invention concerne des résines d'hydrocarbures aromatiques aliphatiques modifiés permettant d'obtenir un équilibre excellent entre propriétés de pégiosité et de cisaillement, même à des poids de revêtement limités. Ces résines sont caractérisées par le fait qu'elles possèdent un point de ramollissement de Ring et Ball

(57) The invention relates to aromatic modified aliphatic hydrocarbon resins giving excellent balance between tack and shear properties even at low coating weights. These resins are characterized in that they have a Ring and Ball (R & B) softening point of 94 °C or lower, a weight average molecular weight (Mw) of not more than



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(R & B) égal ou inférieur à 94 °C, un poids moléculaire moyen en poids (Mw) de 2000 daltons maximum, un poids moléculaire moyen en Z (Mz) de 6000 daltons maximum et un point de nuage d'aniline et de méthylcyclohexane mélangés (MMAp) situé entre 25 et 45 °C. On peut préparer ces résines d'hydrocarbures aromatiques aliphatiques modifiés par soumission de charges de polymérisation contenant des charges de pétrole composées (a) d'oléfines et/ou dioléfines C5 et C6, y compris des cyclooléfines, (b) de monomères aromatiques et (c) de (di-)cyclodioléfines à une polymérisation de Friedel-Crafts. Elle concerne également l'utilisation de ces résines en tant qu'agents adhésifs dont la formulation adhésive ne contient qu'une seule résine, ainsi qu'une bande adhésive contenant ces résines.

2000 Dalton, a Z-average molecular weight (Mz) of not more than 6000 Dalton and a mixed methylcyclohexane aniline cloud point (MMAp) between 25 and 45 °C. The aromatic modified aliphatic hydrocarbon resins of the invention may be prepared by subjecting polymerization feeds containing petroleum feeds which comprise (a) C5 and C6 olefins and/or diolefins including cycloolefins, (b) aromatic monomers and (c) (di-)cycloolefins to a Friedel-Crafts polymerization. The invention is also directed to the use of the aromatic modified aliphatic hydrocarbon resins as mono-tackifiers in adhesive formulations as well as to an adhesive tape comprising these resins.

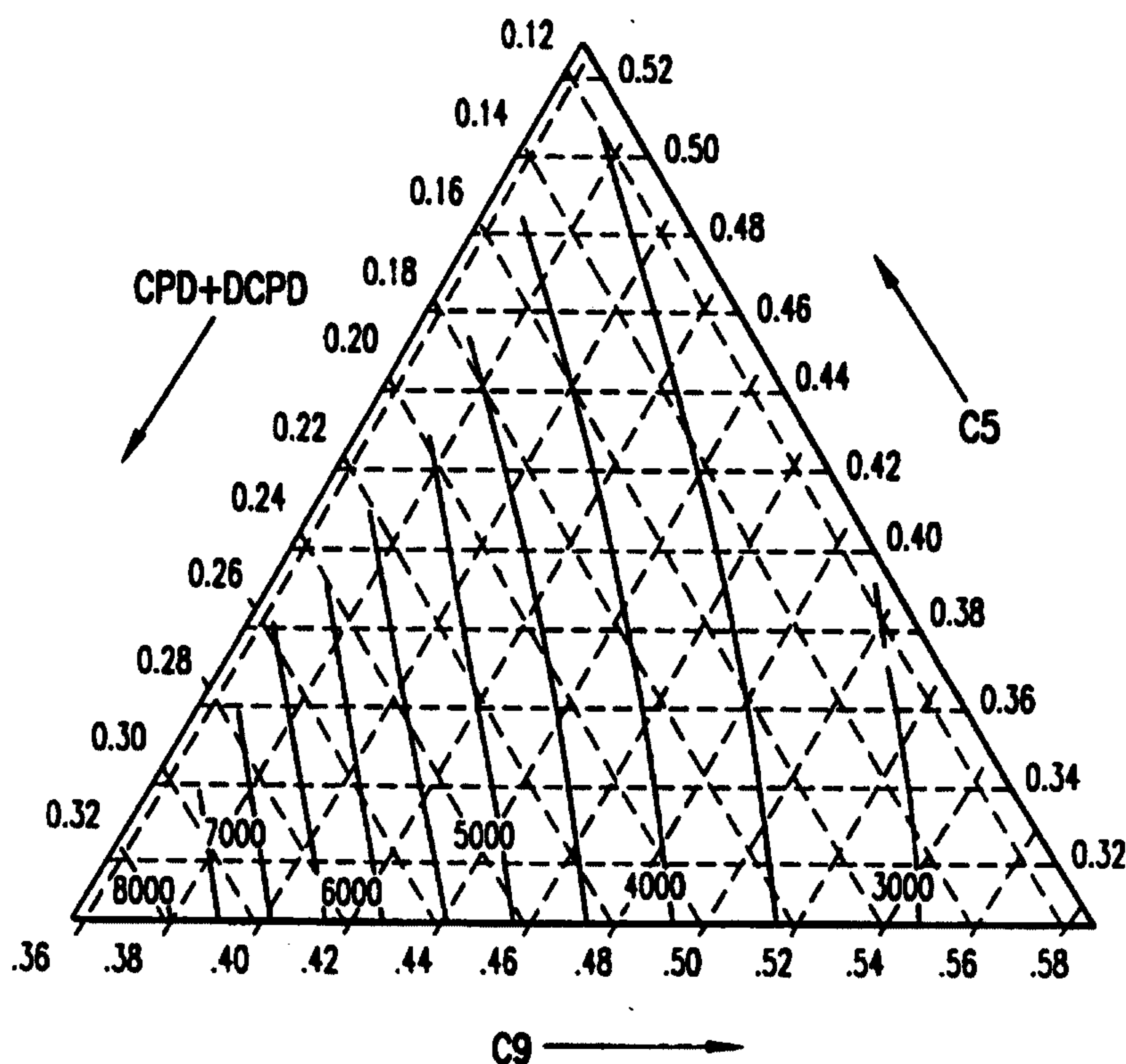
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## INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

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<b>(21) International Application Number:</b> PCT/US99/03157 <b>(22) International Filing Date:</b> 11 February 1999 (11.02.99) <b>(30) Priority Data:</b> 98102423.5      12 February 1998 (12.02.98)      EP <b>(71) Applicant:</b> HERCULES INCORPORATED [US/US]; Intellectual Property Section, 1313 N. Market Street, Wilmington, DE 19894-0001 (US). <b>(72) Inventors:</b> DOMMISSE, Nicolaas, Adriaan; Van Randwijckstraat 21, NL-4401 KL Yerseke (NL). DONKER, Chretien, Pieter, Louie, Charles; Plattendijk 10, NL-4451 RA Heinkenszand (NL). THEELEN, Michael, Hendrikus; Zuidstraat 18 C, NL-4361 AC Westkapelle (NL). Van RIJN, Jacobus; Pinakel 15, NL-4336 JG Middelburg (NL). VERRIJZER, Gerard, Arie; Burgemeester Lewestraat 28, NL-4456 AH Lewedorp (NL). <b>(74) Agent:</b> O'FLYNN O'BRIEN, Robert, P.; Hercules Incorporated, Intellectual Property Section, 1313 N. Market Street, Wilmington, DE 19894-0001 (US).		<b>(81) Designated States:</b> BR, CA, JP, KR, MX.  <b>Published</b> <i>With international search report.</i> <i>Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i>

**(54) Title:** AROMATIC MODIFIED ALIPHATIC HYDROCARBON RESINS**(57) Abstract**

The invention relates to aromatic modified aliphatic hydrocarbon resins giving excellent balance between tack and shear properties even at low coating weights. These resins are characterized in that they have a Ring and Ball (R & B) softening point of 94 °C or lower, a weight average molecular weight (Mw) of not more than 2000 Dalton, a Z-average molecular weight (Mz) of not more than 6000 Dalton and a mixed methylcyclohexane aniline cloud point (MMAp) between 25 and 45 °C. The aromatic modified aliphatic hydrocarbon resins of the invention may be prepared by subjecting polymerization feeds containing petroleum feeds which comprise (a) C5 and C6 olefins and/or diolefins including cycloolefins, (b) aromatic monomers and (c) (di-)cycloolefins to a Friedel-Crafts polymerization. The invention is also directed to the use of the aromatic modified aliphatic hydrocarbon resins as mono-tackifiers in adhesive formulations as well as to an adhesive tape comprising these resins.





**AROMATIC MODIFIED ALIPHATIC HYDROCARBON RESINS**

5

**Description**

10 This invention relates to the field of aromatic modified aliphatic hydrocarbon resins. More specifically, this invention relates to aromatic modified aliphatic hydrocarbon resins giving excellent balance between tack and shear properties even at low coating weights.

**Background**

15

Aromatic modified aliphatic hydrocarbon resins have been used in solvent based tape formulations (US 4250272, US 5177163, WO 91/07472). However, the tape industry has begun lowering coating weights so that new and optimized systems are required to comply with this trend. Lower coating weights decrease the tack properties of the adhesive, and the hydrocarbon resins must therefore be modified to maintain the desired adhesion strength.

25

US 3846352 (Goodyear) discloses the use of cyclic diolefins in combination with 2-methyl-2-butene in the polymerization feed for the production of aliphatic hydrocarbon resins. Further, alpha-methylstyrene was used for aromatic modifications. However, the resin properties were not related to the adhesive behavior, so that no optimization according to the requirements at lower coating weights were carried out.

30

US 4104327 and US 4636555 disclose the use of alpha-methylstyrene and para-methylstyrene in the aromatic part of the feed for the production of aromatic modified aliphatic hydrocarbon resins, respectively.

35

In view of the above, the present invention aims to provide novel aromatic modified aliphatic hydrocarbon resins with excellent tack and shear properties even at low coating weights. It is also an object of the invention to provide a method for the preparation of such aromatic modified aliphatic hydrocarbon resins. A further object of the invention is the use of the aromatic modified aliphatic hydrocarbon resins as mono-tackifiers in solvent based tape formulations. The invention further aims to provide an adhesive tape comprising the aromatic modified aliphatic hydrocarbon resin of the invention.

#### Summary of the Invention

It was surprisingly found that the first object, which is the provision of an aromatic modified aliphatic hydrocarbon resin with excellent tack and shear properties even at low coating weights, can be attained by aromatic modified aliphatic hydrocarbon resins, characterized in that the resin has a Ring and Ball (R&B) softening point of 94°C or lower, a weight-average molecular weight (Mw) of not more than 2000 Dalton, a Z-average molecular weight (Mz) of not more than 6000 Dalton and a mixed methylcyclohexane aniline cloud point (MMAP) between 25 and 45°C.

The aromatic modified aliphatic hydrocarbon resins showing the above parameters can be obtained by a method wherein polymerization feeds containing petroleum feeds comprising (a) C5 and C6 olefins and/or diolefins including cycloolefins, (b) aromatic monomers and (c) (di)cyclo-diolefins are subjected to Friedel-Crafts-polymerization, and wherein

said C5 and C6 olefins and/or diolefins including cycloolefins and the aromatic monomers are used in an amount so that the resin has an MMAP between 25 and 45°C;



and said (di-) cyclodiolefins are used in an amount so that the resin has an Mw of not more than 2000 Dalton and an Mz of not more than 6000.

## 5 Brief description of the drawings

Figure 1 is a contour plot showing the influence of the composition of the feed on the MMAP cloud point.

10 Figure 2 is a contour plot showing the influence of the composition of the feed on the Z-average molecular weight.

## Detailed Description

15 It was surprisingly found by the inventors that excellent tack and shear properties of aromatic modified aliphatic hydrocarbon resins can be obtained by individually controlling the R&B softening point, the weight-average molecular weight (Mw), the Z-average molecular weight (Mz)  
20 and the mixed methylcyclohexane aniline cloud point (MMAP) of the resin. Aromatic modified aliphatic hydrocarbon resins having the following values exhibit satisfactory tack and shear properties:

- 25 - a Ring and Ball (R&B) softening point of 94°C or lower, preferably from 75 to 94°C;
- a weight-average molecular weight (Mw) of not more than 2000 Dalton, preferably from 1000 to 2000 Dalton, most preferably from 1200 to 2000 Dalton;
- 30 - a Z-average molecular weight (Mz) of not more than 6000 Dalton, preferably from 2500 to 6000 Dalton, more preferably from 3000 to 5000 Dalton, and most preferably from 3000 to 4000 Dalton; and
- a mixed methylcyclohexane aniline cloud point (MMAP)  
35 between 25 and 45°C, preferably from 30 to 40°C.

It was found that the softening point had a great effect on the adhesion properties. Adhesion was improved by lowering the R&B softening point. The improved adhesion was observed by a lower rolling ball tack value. Especially at lower  
5 coating weights (about 15 g/cm<sup>2</sup>) it was found that softening points of 94°C or lower resulted in very desirable rolling ball tack values (< 5 cm). Generally, the rolling ball tack values increased when the coating weight of the resin was lowered.

10

It was also found that an increase of the Mz and Mw molecular weights increased the cohesion of the adhesive system, as was observed from a better shear to steel at 40°C.

15 The R&B softening point in combination with the desired molecular weight ranges resulted in an optimal balance between adhesion and cohesion properties. Cardboard properties appeared to be effected by both R&B softening point and the molecular weights. In the desired R&B softening  
20 point and molecular weight ranges for rolling ball tack and shear to steel at 40°C, the adhesives also showed sufficient cardboard properties (shear and flaptest).

25 The balance between non-aromatic components and the aromatic monomers in the aromatic modified aliphatic hydrocarbon resins mainly determines the MMAP cloud point. A method for measuring the MMAP cloud point is described further below.

30 The aromatic modified aliphatic hydrocarbon resins of the present invention are obtainable by subjecting polymerization feeds to Friedel-Crafts-polymerization. Said polymerization feeds usually include a mixed petroleum feed and a diluent. The petroleum feed preferably comprises (a) C5 and C6 olefins and/or diolefins including cycloolefins, preferably in an  
35 amount of 45 wt% +/- 25 wt%, (b) aromatic monomers, preferably in an amount of 40 wt% +/- 20 wt%, and (c)



(di-)cyclodiolefins, preferably in an amount of 20 wt% +/- 10 wt%.

5 In a particularly preferred embodiment of the invention, (a) is an isoprene or an isoprene-rich piperylene stream, (b) a methyldiene-rich stream and (c) a (di-)cyclodiolefin.

10 The aromatic modified aliphatic hydrocarbon resin of the present invention may be preferably produced by a polymerization process, wherein the C5 and C6 olefins and/or diolefins including cycloolefins (a) and the aromatic monomers (b) are used in an amount so that the resin has an MMAP between 25 and 45°C, and the (di-)cyclodiolefins are used in an amount so that the resin has an Mw of not more  
15 than 2000 Dalton and an Mz of not more than 6000 Dalton.

In a particularly preferred embodiment, chain transfer agents are added to the (di-)cyclodiolefins in an amount so that the resin has an Mw of not more than 2000 Dalton and an Mz of not  
20 more than 6000 Dalton.

25 Additionally, further lower molecular weight oligomers may be added to the resin so that the resin has an R&B softening point of 94°C or less.

30 The polymerization feeds of this invention preferably contain about 20 to 60 wt%, more preferably 30 to 50 wt%, of the mixed petroleum feed streams, 0 to 20 wt% chain transfer agent and 40 to 80 wt% of a diluent, preferably an aromatic diluent, most preferably toluene or plant recycled diluent, mainly consisting of trimethylbenzenes and their isomers. A suitable polymerization feed preferably contains between 30 and 50 wt% and more preferably between 35 and 45 wt% of polymerisable monomers so that the ultimate resin yield on  
35 total feed will be between 30 and 50 wt%.



More particularly, the petroleum feeds are preferably built up from mainly three kinds of components.

(a) One part of the feed streams essentially consists of  
5 unsaturated hydrocarbons like C5 and C6 olefins and/or  
diolefins, including cycloolefins, boiling in the range from  
20 to 100°C, preferably from 30 to 70°C. Examples of  
aliphatic C5 and C6 diolefins are : 1-pentene, trans- and  
cis-2-pentene, trans- and cis-piperylene, 1,4-pentadiene,  
10 isoprene, 1,3-hexadiene and 1,4-hexadiene, and cycloolefins  
like cyclopentene and cyclohexene.

Most preferably used feed streams for these monomers are  
commercially available piperylene feed streams. Their main  
components are trans- and cis-piperylene. Isoprene streams  
15 and crude piperylene streams can also be used.

(b) The aromatic part of the feeds comprises styrene, alpha-  
methylstyrene, vinyltoluenes, para-methylstyrene,  
divinylbenzene, (t-)butylstyrene, indene, methylindenes, and  
20 mixtures of these.

Most preferably used feed streams for the aromatic monomers  
are commercially available resin oils mainly consisting of  
vinyltoluenes and indene as monomers. High boiling range  
resin oils can also be used. They contain mainly indene and  
25 methylindenes. Pure monomer streams can also be used and  
mixed to the desired composition.

(c) The feeds further contain cyclodiolefins and  
dicyclodiolefins. Examples of these components are  
30 cyclopentadiene, dicyclopentadiene, methyl and ethyl  
substituted homologues of both components, codimers of  
cyclopentadiene and the diolefins.

These monomers can originate from (crude) piperylene and  
isoprene streams, but these streams are generally heated at  
35 temperatures between 100 and 160°C followed by distillation  
to remove cyclopentadiene and dicyclopentadiene.

Commercially available dicyclopentadiene streams can be used for the desired amount of cyclodiolefines in the feed.

A particularly preferred representative feed stream generally  
5 consists of about 35 to 45 wt% active components (=monomers) with the following composition:

C5 and C6 olefins and diolefins : 45 wt% +/- 25 wt%  
aromatic monomers : 40 wt% +/- 20 wt%  
10 (di)-cyclodiolefins : 20 wt% +/- 10 wt%  
chain transfer agents: 0 to 20 wt%

The exact amounts can be adjusted in the following way to reach the desired resin properties, which determine the  
15 adhesive properties of the tape based adhesive formulations.

The balance between the C5 and C6 olefins and/or diolefins and the aromatic monomers may be used to adapt the MMAP cloud point. The feed compositions are mixed in such a way that the  
20 MMAP cloud point of the resins is between 25 and 45°C, preferably between 30 and 40°C. The MMAP cloud point is an indication for the compatibility to aromatic solvents.

Figure 1 shows a contour plot that was obtained from a  
25 ternary mixture design of the feed components C5 (diolefines and olefines, component (a)), C9 (aromatic monomers, component (b)), and CPD+DCPD (cyclodiolefines, component (c)) as fractions of the total monomer content. It illustrates the effect of the three main types of components on the MMAP  
30 cloud point. A 10% addition of the amount of C5, while holding the relative ratio amounts of the other fractions constant, gives an increase of the MMAP of 7.4°C. A similar increase in the amount of cyclodiolefines induces a smaller increase (2.6°C), while increasing the C9 content in the same  
35 way results in a strong decrease (-8.7°C).



The amount of dicyclodiolefins and cyclodiolefins has an impact on the molecular weight parameters of the resin. Higher molecular weight parameters produce better cohesion strength, and in turn, higher and better shear values on steel at 40°C. It was found that Mz's in the range of not more than 6000 Dalton are required for a sufficient cohesion strength. An Mz of not more than 4000 Dalton assures an optimum adhesion behaviour.

- 10 The contour plot of Figure 2 was obtained from the same design as the previous one. This plot illustrates the effects of the three main types of components on the Mz molecular weight parameter of the resins. The (di-)cyclodiolefin fraction has a large increasing effect, while the C9 fraction has a small decreasing effect. The C5 fraction has no significant effect. The (di-)cyclodiolefin content is the main parameter controlling the Mz value, especially upwards, for this feed combination, where no chain transfer agent was used, which can be used to control the Mz value downwards.
- 15
- 20 The weight-average molecular weight (Mw) shows the same trend as z-average molecular weight (Mz).

- Furthermore, chain transfer agents can be used to obtain resins with a lower and narrower molecular weight distribution. Examples of the chain transfer agents include 1-pentene, trans- and cis-2-pentene, trans- and cis-piperylene, 1,4-pentadiene, isoprene, 1,3-hexadiene and 1,4-hexadiene, cycloolefins like cyclopentene and cyclohexene, isobutylene, 2-methyl-1-butene, 2-methyl-2-butene, or dimers and oligomers thereof. Especially when the amount of cyclodiolefins and dicyclodiolefins in the piperylene or isoprene streams are high, the molecular weight parameters can be decreased by adding the chain transfer agents. The components can be applied in pure or diluted form to a solvent like toluene or unreactive C4 to C6 hydrocarbons.
- 25
- 30
- 35

A diluent is desirable because the polymerization reaction is very fast and highly exothermic. The diluent is however not necessary when the reaction can be controlled by adequate stirring and cooling. The diluent used for the  
5 polymerizations are built up of inert or less active components. They may be paraffinic in nature, like pentane, hexane, heptane, cyclopentane, olefinic in nature like cyclopentene, 2-pentenenes, or aromatic in nature, like toluene, trimethylbenzenes, or be a mixture of paraffinic,  
10 olefinic and aromatic components. Unreacted hydrocarbons from the reactions can also be used after they are recycled.

The catalyst for the polymerization is preferably used in an amount from 1.0 to 8.0 wt% based on the amount of  
15 polymerizable components in the polymerization feed. The exact amount of catalyst used depends on the desired resin. The catalyst can be chosen from any suitable Friedel-Crafts catalyst, such as aluminum trichloride, aluminum bromide, titanium tri- and tetrachloride, tin tetrachloride, boron  
20 trifluoride, or solutions, slurries or complexes thereof. The catalyst may also be used on solids or as supported catalyst. The most preferred catalyst is a liquefied  $AlCl_3$  complex containing about 50 wt.%  $AlCl_3$ , and added at a level of 1.5 wt.%  $AlCl_3$  to monomers.

25

Polymerization temperatures are usually between 0 and 120°C, preferably in the range from 20 to 80°C and most preferably in the range of from 40 to 60 °C.

30 The polymerization can be carried out in a continuous or semi-continuous process or in a batch mode. The reaction time may take place within a few seconds or up to 24 hours. More typical reaction times are from 1 to 4 hours.

35 After the polymerization and a possible quenching step the residues of the catalyst and the quenching agent can be



removed by, for example, addition of and extraction with water.

The polymer-solvent mixtures obtained in this manner are usually stripped to remove unreacted hydrocarbons, diluent and at least part of the low molecular weight oligomers. The stripping process can be carried out selectively in such a way that a part of the lower molecular weight oligomers remains in the resin. Low molecular weight oligomers can also be added afterwards to soften the resin. The potential softening point (the softening point of the resin after all oligomers have been stripped off) is preferably higher than 94°C. By the presence or addition of lower molecular weight oligomers, the desired actual R&B softening point can then be adjusted to a value of 94°C or less.

It was also found that the composition of the aromatic part of the polymerization feed influences the potential R&B softening point, and is therefore preferably adjusted depending on the piperylene or isoprene stream used. It was found that the use of isoprene, or isoprene rich piperylene streams lowers the potential softening point. Adjusting the composition, the aromatic part compensated for the decreased R&B softening point. It was found that especially an aromatic part rich in methylenes resulted in higher potential softening points. A preferred embodiment of the method of the present invention therefore uses feeds which comprise isoprene or isoprene-rich piperylene stream as component (a), a methylenes-rich stream as component (b) and a (di)cyclodiolefin as component (c).

The present invention further provides for the use of the aromatic modified aliphatic hydrocarbon resins of the present invention as mono-tackifiers in adhesive formulations. The term "mono-tackifier" means that only one resin is used in the adhesive formulation. The adhesive formulation is

preferably a solvent based adhesive formulation, a hot-melt or a water-based dispersion.

Possible applications of aromatic modified aliphatic hydrocarbon resins also include water-based tapes, labels and ethylene-vinylacetate copolymer (EVA) based hotmelts.

Further, the present invention provides an adhesive tape comprising the aromatic modified aliphatic hydrocarbon resins of the present invention.

A particularly preferred tackifier (Resin 1) for the use as mono-tackifier in solvent-based tape formulations has the following typical properties :

15	R&B Softening point (°C)	93.0
	MMAp (°C)	37
	Mn (Dalton)	806
	Mw (Dalton)	1595
20	Mz (Dalton)	3333

The resin was prepared by softening a resin which had been stripped to the potential softening point with 5 wt% of its oligomers (see example 1).

The adhesive performance of this resin was evaluated by mixing the resin with a natural rubber (0.9 : 1 parts by weight) and a toluene/hexane blend, so that the solid content of the mixture was approximately 25%.

Tapes were prepared by applying dissolved di-isocyanate to an E-PVC substrate as a primer and an intermediate layer to give better anchorage. Then, the resins were crosslinked with the di-isocyanate to the substrate, as is usually done in the industry, at a coating weight of approximately 20 and 15 g/cm<sup>2</sup>.



The test results are given below.

	20 g/cm <sup>2</sup>	15 g/cm <sup>2</sup>
Rolling ball tack (cm)	2.8	5.0
Shear to steel at 40°C (2.5 kg, minutes)	569	3146
Shear to cardboard at 40°C (1.0 kg, minutes)	315	296
Flaptest to cardboard at 23°C (1.0 kg, minutes)	472	782

5

## EXAMPLES :

### Experimental section:

#### 10 Method for the preparation of the resins :

All resins mentioned in the examples were prepared in a continuous way, but batch-wise or semi-continuous preparation would also be possible. The resin feed was dried over calcium chloride and molecular sieves and was added together with the chain transfer agent at a rate of 1500 ml/h to a tank reactor of 5 liter and stirred continuously. The catalyst was simultaneously added, and the mixture was circulated from the bottom of the reactor to the catalyst inlet point. The level in the reactor was kept at 3 liter by continuously removing polymerizate, so the overall average reaction time for all experiments was 2 hours. The mixture was deactivated using water and washed in three steps with water before it was stripped under vacuum and with steam to remove the solvent and low molecular weight material.

25

Method for the determination of the R&B softening point:

The R&B softening point was determined according to ASTM D-36-70 with the Walter Herzog R&B apparatus, model MC-735.

5 *Method for the determination of the MMAP:*

10 The MMAP (Mixed Methylcyclohexane Aniline Point) was determined using a modified ASTM D-611-82 procedure. The Methylcyclohexane is substituted for the heptane used in the standard test procedure. The procedure uses resin/aniline/methylcyclohexane in a ratio 1/2/1 (5 g/10 ml/5 ml), and the cloud point is determined by cooling a heated, clear blend of the three components until a complete turbidity just occurs.

15

*Method for the determination of the molecular weights:*

20 The molecular weights  $M_n$ ,  $M_w$ ,  $M_z$  and the polydispersity ( $=M_w/M_n$ ) were determined by size exclusion chromatography using a refractive index detector. Calibration was done using narrow-distributed polystyrene standards.

*Method for the determination of the ball tack:*

25 Ball tack is measured by Pressure Sensitive Tape Council (PSTC)-6 test.

*Method for the determination of the shear strengths:*

30 The shear strengths were measured by PSTC-7 test.

*Method for the determination of the cardboard properties:*

35 The cardboard properties of the tapes are tested by placing the samples on a cardboard strip. A weight is hung on the tape and the time to failure is noted.



## Uses/Definitions:

Materials used in preparing the adhesive compositions as mentioned in the examples are as follows :

5

Regular piperylene 50: a piperylene concentrate available from Shell, Pernis (NL). Composition see below.

10

Crude piperylene : a crude piperylene concentrate available from DOW, Terneuzen (NL). Composition see below.

15

C9 HBR high-boiling resin oil : a resin oil available from DSM, Geleen (NL), consisting mainly of indene and methylindenes. Composition see below.

20

Regular C9 classic resin oil : a resin oil available from DSM, Geleen, consisting mainly of vinyltoluenes and indene. Composition see below.

DCPD 91 concentrate : a dicyclopentadiene concentrate of 91 % purity available from Shell, Pernis (NL).

25

Isoprene 65 : an isoprene stream from Shell, Pernis. Composition see below.

30

Samples of the typical compositions of the various feed streams and plant recycled solvent are given below. The resins of the following examples were prepared from these various feed streams, however, the actual compositions may vary slightly from the value listed below.

Stream	isoprene	crude pip	regular pip	regular C9	HBR C9	Solv.
C4's		0.7				
isopentane	0.1	10.4				
1-pentene	5.1	3.7				
2-methyl-1-butene	10.6	5.1				
n-pentane	16.7	15.6				0.1
isoprene	63.9	17.6	0.5			0.0
trans-2-pentene	2.4	2.5	0.9			0.6
cis-2-pentene	0.4	1.4	1.9			0.5
isoamylene		2.9	5.6			0.1
t-piperylene		6.0	33.2			0.1
c-piperylene		11.8	18.7			0.5
cyclopentene		3.5	13.4			2.4
cyclopentane		3.1	3.8			6.9
cyclopenta-diene		1.2	4.7			0.2
dicyclopenta-diene		8.1	9.4	0.4		1.4
other C5 + C6's	0.7	6.1	4.4	0.2		3.8
toluene				0.1		1.3
C9 light ends*				0.7	0.1	4.2
styrene				2.4	0.4	0.1
alpha-methyl-styrene				3.9	0.4	
vinyltoluenes				21.5	2.8	0.7
indene				27.3	12.0	0.2
methylindenes				5.3	42.6	0.5
trimethyl-benzenes**				28.2	6.0	69.4
tetralines***				8.0	20.9	3.8
naphthalene				1.9	14.7	2.0



Stream	isoprene	crude pip	regular pip	regular C9	HBR C9	Solv.
heavy ends****				0.2	0.2	1.4

\* C9 light ends: all components eluting between toluene and styrene

\*\* trimethylbenzenes: all not-designated components eluting between styrene and indene

5 \*\*\* tetralines: all not-designated components eluting between indene and naphthalene

\*\*\*\* heavy ends: all components eluting after naphthalene

10 All tapes were coated at about 20 g/cm<sup>2</sup> except for the results in example 1.c, where some tapes were coated at about 15 g/cm<sup>2</sup>.

#### 15 EXAMPLE 1 - SOFTENING POINT

Example 1.a. Oligomers added after the resin is stripped to potential R&B, effect of R&B on tack properties.

20 The table below illustrates what happens to the resin properties and the adhesive properties when low molecular weight oligomers are added after the resin has been stripped to the potential softening point. Stripped to potential is defined as being stripped until the water condensate of a  
25 steam strip at 220°C contains 2 wt% or less organic fraction. The oligomers were liquid, having an MMAP of 18°C, an Mn value of 256 Dalton, an Mw of 358 Dalton and an Mz of 832 Dalton.

Experiment	Resin 1	Resin 2	Resin 3
Oligomers (wt% per resin)	0	5	10
R&B (°C)	97.0	93.0	86.5
MMAp (°C)	37	37	36
Color (Gardner)	6.3	7.1	6.9
Mn (Dalton)	867	806	746
Mw (Dalton)	1642	1595	1577
Mz (Dalton)	3342	3333	3586
Rolling ball tack (cm)	5.0	2.8	2.2
Shear to steel at 40°C (2.5 kg, minutes)	791	569	728
Shear to cardboard at 40°C (1.0 kg, minutes)	252	315	210
Flaptest to cardboard at 23°C (1.0 kg, minutes)	883	472	305

The table clearly shows the effect of the oligomer addition on the resin properties. The R&B softening point is decreased by adding oligomers. The effect on the adhesive properties indicates the importance of the softening point on the rolling ball tack value. The lower the softening point, the better the rolling ball tack. This example shows that a resin having a softening point of more than 94°C may be used to provide a resin with a softening point in the desired range of 94°C or less by adding low molecular weight oligomers.



Example 1.b. Several examples of the selective stripping, potential R&B's compared to partially stripped R&B's.

- 5 Oligomers can also be left in the resin during stripping. The table below illustrates the selective stripping with two examples.

Experiment	Resin 4	Resin 4 stripped to pot.	Resin 5	Resin 5 stripped to pot.
R&B (pot:potential; p.s.:partially stripped)	p.s. (approx. 4.5 wt.% oligos)	pot.	p.s. (approx. 6.5 wt.% oligos)	pot.
R&B (°C)	94.0	102.0	88.0	97.0
MMAp (°C)	30	30	31	31
Color (Gardner)	9.9	9.8	9.3	9.4
Mn (Dalton)	607	645	581	624
Mw (Dalton)	1252	1263	1165	1239
Mz (Dalton)	3432	3189	3237	3505
Rolling ball tack (cm)	2.4	6.4	1.8	3.6
Shear to steel at 40°C (2.5 kg, minutes)	908	3472	731	1167
Shear to cardboard at 40°C (1.0 kg, minutes)	702	258	656	156
Flaptest to cardboard at 23°C (1.0 kg, minutes)	260	945	148	1078

The potential softening points are higher than the softening point of partially stripped resins. In the case of partially stripped resins the R&B was kept at or below 94°C.

5 The adhesive performance indicates similar effects as seen in example 1.a. Rolling ball tack improved at lower softening points. Shear to steel at 40°C also showed a decrease, but the two lower softening point samples still resulted in sufficient values.

10 Example 1.c. Several examples of different coating weights.

Several samples were coated at about 20 g/cm<sup>2</sup> and at about 15 g/cm<sup>2</sup>. The results were compared in the next table.

Experiment	Resin 1				Resin 2	
R&B (°C)		97.0			93.0	
MMA P (°C)		37			37	
Color (Gardner)		6.3			7.1	
Mn (Dalton)		867			806	
Mw (Dalton)		1642			1595	
Mz (Dalton)		3342			3333	
	Resin 1				Resin 2	
Coating weight (g/cm <sup>2</sup> )	20	15			20	15
Rolling ball tack (cm)	5.0	6.4			2.8	5.0
Shear to steel at 40°C (2.5 kg, minutes)	791	3079			569	3146



Experiment	Resin 1			Resin 2	
Shear to cardboard at 40°C (1.0 kg, minutes)	252	517		315	296
Flaptest to cardboard at 23° (1.0 kg, minutes)	883	959		472	782

5 The results clearly show that lowering the coating weight resulted in an increase (worse) in the rolling ball tack value. In this example, an R&B softening point of about 93°C or lower resulted in a rolling ball tack value of below the 5 cm. Other properties were not negatively effected.

#### 10 EXAMPLE 2 - MOLECULAR WEIGHT DISTRIBUTION.

##### Example 2.a. Effect of molecular weights (Mz and Mw) on shear properties.

15 The table below illustrates the effect of the molecular weight parameters on the cohesive strength, thus the shear properties of the resin. Two samples were selected with a similar and comparable R&B softening point.

Experiment	Resin 2		Resin 6
R&B (°C)	93.0		92.4
MMAP (°C)	37		37

Experiment	Resin 2		Resin 6
Color (Gardner)	7.1		8.0
Mn (Dalton)	806		629
Mw (Dalton)	1595		1035
Mz (Dalton)	3333		1947
Rolling ball tack (cm)	2.8		2.2
Shear to steel at 40°C (2.5 kg, minutes)	569		208
Shear to cardboard at 40°C (1.0 kg, minutes)	315		226
Flaptest to cardboard at 23°C (1.0 kg, minutes)	472		189

As can be seen in the table, the rolling ball tack values were within the desired range due to their R&B softening points. The rolling ball tack value was hardly affected by the molecular weight parameters of the resin in this example. The shear to steel at 40°C, to cardboard at 40°C and the flaptest tended to increase together with increasing molecular weights. The molecular weight parameters seem to be important for advantageous cohesion strengths.

Example 2.b. Several examples of (D)CPD on MWD parameters.

Like the contour plot in Figure 2, the table below illustrates how the molecular weight parameters can be controlled and increased by the cyclodiolefins and dicyclodiolefins. In the table below and further the C5 and C6 olefins and diolefins including the cycloolefins fraction on total monomers are given as the aliphatics. The amount of aromatic monomers on total monomers are given by aromatics, and the amount of dicyclodiolefins and cyclodiolefins on



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total monomers are given by the fraction cyclic diolefins. The softening points which are given are the potential softening points.

5

Experiment	Resin 7	Resin 8	Resin 9
aliphatics	0.50	0.46	0.43
aromatics	0.41	0.39	0.37
cyclic diolefins	0.09	0.15	0.20
R&B (°C)	86.0	91.7	97.0
MMAP (°C)	34	32	35
Color (Gardner)	7.9	8.0	8.0
Mn (Dalton)	628	626	680
Mw (Dalton)	1127	1145	1299
Mz (Dalton)	2395	2613	3099
Rolling ball tack (cm)	2.2	2.6	4.0
Shear to steel at 40°C (2.5 kg, minutes)	96	139	364
Shear to cardboard at 40°C (1.0 kg, minutes)	94	282	161
Flaptest to cardboard at 23°C (1.0 kg, minutes)	87	170	273

Here, more cyclic diolefins in the feed resulted in higher potential R&B softening points and molecular weight parameters (Mw and Mz). The effect of the R&B softening point on the rolling ball tack was observed and found to be the same as in example 1. The effect of the molecular weight parameters on the shear to steel at 40°C was observed to increase shears as seen in example 2.a. Flaptest and shear to cardboard also increased. Resin 8 and Resin 9 showed however reasonable cohesion strength and showed increasing shears and

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flaptests with increasing molecular weights. Only the shear to cardboard at 40°C for Resin 9 showed a deviation.

### EXAMPLE 3 - EFFECTS OF THE DIFFERENT FEED STREAMS

5

Example 3.a. Use of crude C5/isoprene compared to regular pip.

10 The table below shows the effects of using an isoprene stream and an isoprene rich piperylene stream (crude piperylene) compared to the use of a regular piperylene stream, together with a regular resin oil for the aromatic part of the polymerization feed. The given R&B softening points are all potential softening points.

15

Experiment	Resin 10	Resin 11	Resin 12
regular piperylene	26.7		
crude piperylene		32.4	
isoprene 65			24.1
regular C9 resin oil	30.0	30.0	34.8
diluent	43.3	37.6	41.1
R&B (°C)	92.2	89.4	86.0
MMAp (°C)	30	30	30
Color (Gardner)	6.7	6.9	6.5
Mn (Dalton)	638	646	661
Mw (Dalton)	1183	1393	1325
Mz (Dalton)	3286	4605	4451

20 It is shown that the R&B softening point decreased and the molecular weight parameters increased when a more isoprene rich feed was used.

Using the combination of regular C9 resin oil and isoprene or isoprene-rich piperylene, it was not possible in this example



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to obtain resins with potential R&B softening points of more than 94°C which is preferred according to the present invention. Potential R&B softening points of more than 94°C allow to control the R&B softening points by selective stripping or oiling down with oligomers afterwards.

Example 3.b. Use of C9 HBR together with regular piperylene.

The next table illustrates the softening point increasing effect of a methylindenes rich resin oil (C9 HBR) using regular piperylene.

The given R&B softening points are potential softening points.

Experiment	Resin 10	Resin 13
regular piperylene	26.7	25.8
regular C9 resin oil	30.0	
HBR C9 resin oil		28.1
diluent	43.3	46.1
R&B (°C)	92.2	107.0
MMAp (°C)	30	35
Color (Gardner)	6.7	8.2
Mn (Dalton)	638	729
Mw (Dalton)	1183	1505
Mz (Dalton)	3286	3813

15

The table clearly shows that the C9 HBR resin oil results in a considerable higher potential R&B softening point, while the molecular weight parameters are comparable. It is much easier to control the R&B softening point for Resin 13 by selective stripping or oiling down with oligomers afterwards.

20

Example 3.c. Use of C9 HBR together with crude C5

5 The table below illustrates the effect of the methylindenes rich C9 HBR resin oil when using it together with a crude piperylene stream which is rich in isoprene (see composition of the feed streams). The R&B softening points were all stripped to potential.

10

Experiment	Resin 11	Resin 14	Resin 15
crude piperylene	32.4	31.0	38.0
regular C9 resin oil	30.0		
HBR C9 resin oil		25.3	24.0
diluent	37.6	43.7	38.0
aliphatics	0.36	0.34	0.32
aromatics	0.44	0.47	0.44
cyclic diolefins	0.20	0.19	0.24
R&B (°C)	89.4	100.4	100.2
MMAp (°C)	30	32	30
Color (Gardner)	6.9	7.6	7.1
Mn (Dalton)	646	712	721
Mw (Dalton)	1393	1605	1348
Mz (Dalton)	4605	5041	3088

15 The results of this example given in the table show that the methylindenes-rich C9 HBR resin oil causes a 10°C higher potential softening point. The control of the softening point by selective stripping or oiling down afterwards becomes much easier. It thus is possible to use isoprene or isoprene-rich piperylene streams for the desired resin properties.



**EXAMPLE 4 - USE OF ADDITIONAL CHAIN TRANSFER AGENT**

- 5 Example 4.a. Use of additional chain transfer agent in case  
the crude piperylene contains too much (di)-cyclodiolefins.

10 In case a crude piperylene stream contains a large amount of  
 dicyclodiolefins and cyclodiolefins, the molecular weight  
 parameters become high and the adhesive formulation becomes  
 harder. A preferred value for Mz which is below 5000 Dalton  
 can be adjusted by using an additional amount of chain  
 transfer agent. The amount of chain transfer agent is given  
 15 in the following table as a fraction of total monomers as  
 C4's. In this case pure isobutylene was used. The given  
 softening points were stripped to potential softening points.

Experiment	Resin 16	Resin 17
crude piperylene	36.4	36.4
HBR C9 resin oil	27.0	27.0
diluent	26.7	26.7
addition isobutylene		3.0*
C4's		0.08
aliphatics	0.36	0.31
aromatics	0.44	0.42
cyclic diolefins	0.20	0.19
R&B (°C)	101.3	99.1
MMAp (°C)	32	35
Color (Gardner)	7.8	7.7
Mn (Dalton)	950	758
Mw (Dalton)	2166	1528
Mz (Dalton)	5848	4035

\* - the amount was calculated on weight percentage of the other ingredients.

Here, the molecular weight parameters decreased using an additional amount of chain transfer agent.

Example 4.b. Use of additional chain transfer agent in case too much (di)-cyclodiolefins are added to the polymerization feed.

10

It is possible that the added amount of dicyclodiolefins and cyclodiolefins is too high. The following table illustrates that the molecular weight parameters can be decreased by using an additional amount of chain transfer agent. The amount of chain transfer agent is given in the following table as a fraction of total monomers as C4's. In this case pure isobutylene was used. For this example experiments were chosen in which the C5 and C6 olefins and diolefins originated from a isoprene stream. The aromatic part originated from a methy lindene-rich C9 HBR resin oil and the dicyclodiolefins and cyclodiolefins originated from a mixture of cyclopentadiene and dicyclopentadiene. The given softening points were stripped to potential softening points.

25

Experiment	Resin 18	Resin 5 (stripped to pot.)
isoprene 65	12.5	12.5
HBR C9 resin oil	23.0	23.0
CPD/DCPD (1:1)	9.0	9.0
diluent	55.0	55.0
addition isobutylene		3.0*
C4's		0.08
aliphatics	0.26	0.22



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Experiment	Resin 18	Resin 5 (stripped to pot.)
aromatics	0.46	0.43
cyclic diolefins	0.28	0.25
R&B (°C)	105.5	97.0
MMAp (°C)	31	31
color (Gardner)	9.2	9.4
Mn (Dalton)	548	624
Mw (Dalton)	1271	1239
Mz (Dalton)	5209	3505

\* - the amount was calculated on weight percentage of the other ingredients.

5

The molecular weight parameters decreased using an additional amount of chain transfer agent to the preferred value below 5000 Dalton.

10

## Claims

1. An aromatic modified aliphatic hydrocarbon resin,  
characterized in that the resin has a Ring and Ball (R&B)  
5 softening point of from 75 to 94°C, an weight-average  
molecular weight (Mw) of from 1200 to 2000 Dalton, a Z-  
average molecular weight (Mz) of from 3000 to 5000 Dalton  
and a mixed methylcyclohexane aniline cloud point (MMAp)  
between 30 to 40°C.
- 10 2. An aromatic modified aliphatic hydrocarbon resin  
according to claim 1, characterized in that the resin is  
obtainable by subjecting a polymerization feed comprising a  
petroleum feed to a Friedel-Crafts-polymerization, wherein  
said petroleum feed comprises (a) C5 and C6 olefins and/or  
15 diolefins including cycloolefins, (b) aromatic monomers and  
(c) (di-)cyclodiolefins.
3. An aromatic modified aliphatic hydrocarbon resin  
according to claim 2, characterized in that the components  
(a), (b), and (c) are contained in the petroleum feeds in an  
20 amount of 45 wt% +/- 25 wt%, 40 wt% +/- 20 wt%, and 20 wt%  
+/- 10 wt%, respectively.
4. An aromatic modified aliphatic hydrocarbon resin  
according to claim 2 or 3, characterized in that (a) is an  
isoprene or an isoprene-rich piperylene stream, (b) a  
25 methyldiene-rich stream and (c) a (di-)cyclodiolefin  
stream.
5. An aromatic modified aliphatic hydrocarbon resin  
according to any of claims 2 to 4, characterized in that the  
petroleum feeds are contained in an amount of 20 to 60 wt.%  
30 in the polymerization feeds, the remainder being a diluent  
and, optionally, a chain transfer agent.



6. A method for preparing an aromatic modified aliphatic hydrocarbon resin according to claim 1, characterized in that polymerization feeds containing petroleum feeds which comprise (a) C5 and C6 olefins and/or diolefins including cycloolefins, (b) aromatic monomers and (c) (di-)cyclodiolefins are subjected to a Friedel-Crafts-polymerization, wherein the C5 and C6 olefins and/or diolefins including cycloolefins and the aromatic monomers are used in an amount so that the resin has an MMAP between 30 to 40°C; and the said (di-) cyclodiolefins are used in an amount so that the resin has an Mw of from 1200 to 2000 Dalton and an Mz of from 3000 to 5000 Dalton.
7. A method according to claim 6, characterized in that chain transfer agents are added to the (di-)cyclodiolefins in an amount so that the resin has an Mw of from 1200 to 2000 Dalton and an Mz of from 3000 to 5000 Dalton.
8. A method according to claim 7, characterized in that further lower molecular weight oligomers are added to the resin to control the R&B softening point of 75 to 94°C.
9. Use of the aromatic modified aliphatic hydrocarbon resin according to any of claims 1 to 5 as mono-tackifiers in adhesive formulations.
10. Use of the aromatic modified aliphatic hydrocarbon resin according to claim 9 characterized in that the adhesive formulation is a solvent based adhesive formulation, a hot-melt or a water-based dispersion.
11. An adhesive tape comprising the aromatic modified aliphatic hydrocarbon resin according to any of claims 1 to 5.

12. A method according to claim 10 or 11, characterized in that further lower molecular weight oligomers are added to the resin to control the R&B softening point of 94°C or less.
- 5 13. Use of the aromatic modified aliphatic hydrocarbon resin according to any of claims 1 to 9 as mono-tackifiers in adhesive formulations.
- 10 14. Use of the aromatic modified aliphatic hydrocarbon resin according to claim 13 characterized in that the adhesive formulation is a solvent based adhesive formulation, a hot-melt or a water-based dispersion.
- 15 15. An adhesive tape comprising the aromatic modified aliphatic hydrocarbon resin according to any of claims 1 to 9.

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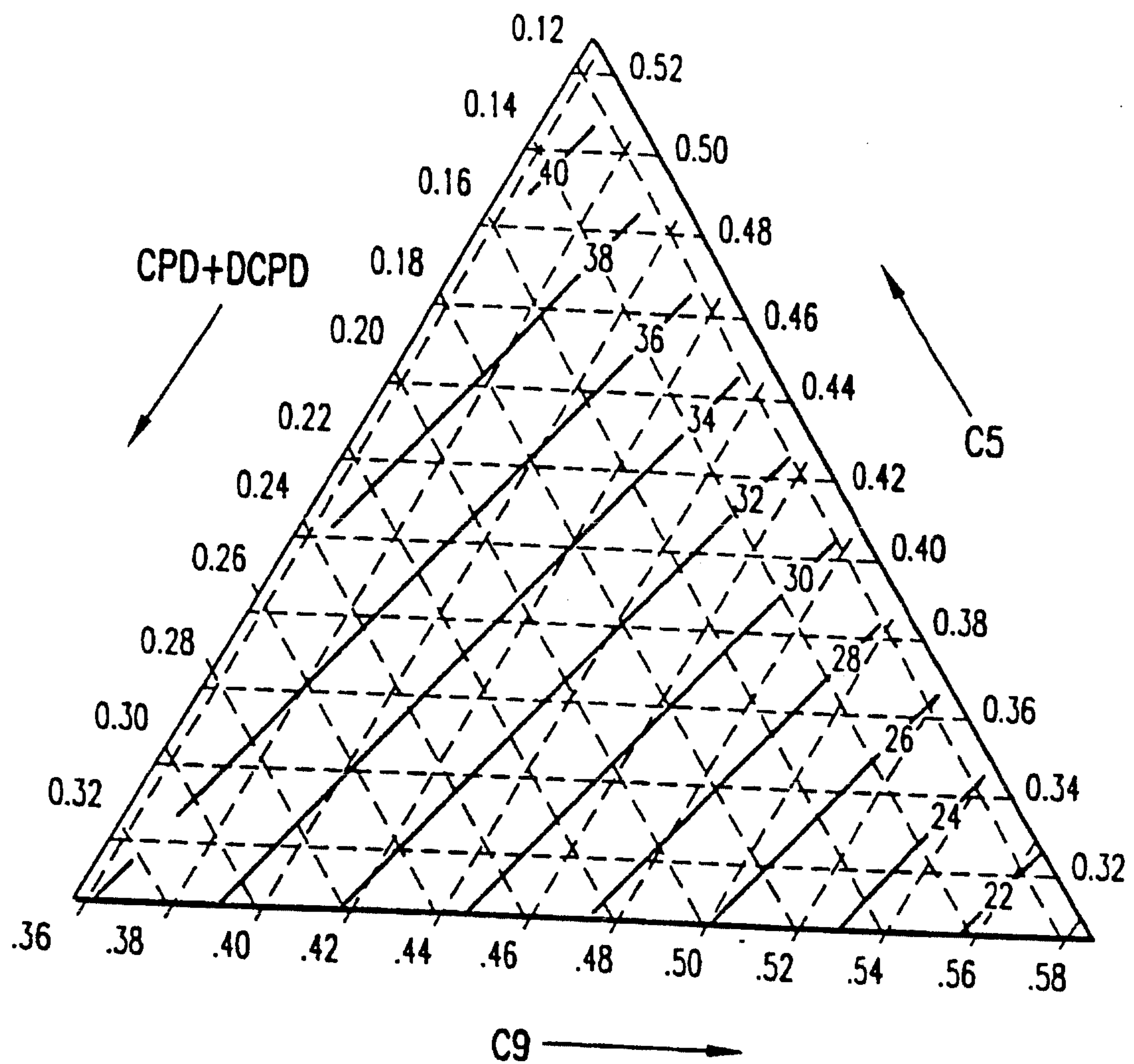


FIG. 1



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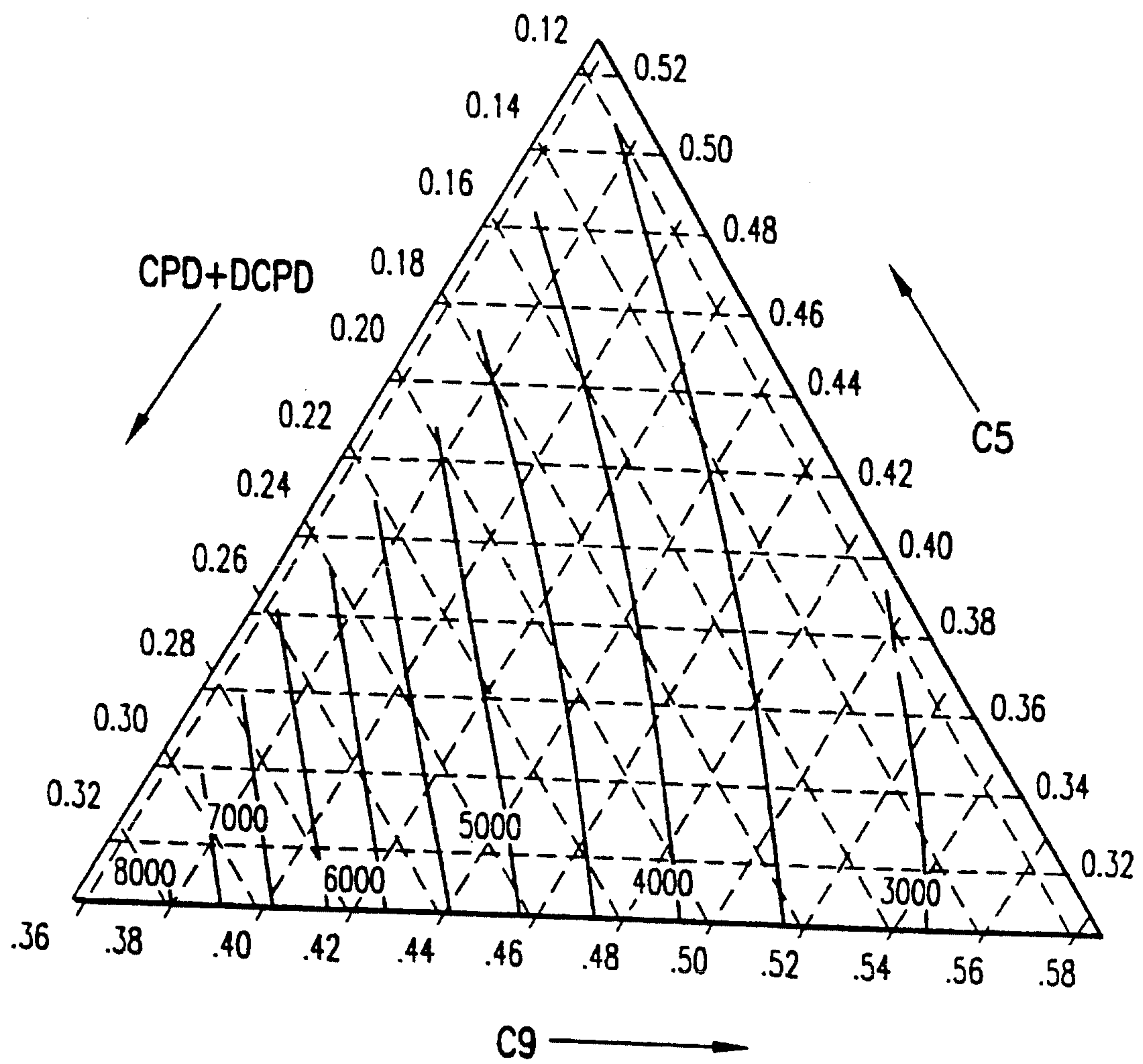


FIG.2

