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(54) Title: ROSIN ESTERS AND COMPOSITIONS THEREOF

(57) Abstract: Rosin esters are provided. The rosin esters can exhibit improved color (*e.g.*, the rosin ester can have a neat Gardner color of 8.5 or less), improved oxidative stability (*e.g.*, when 1000 ppm or less of an antioxidant is present in combination with the rosin ester, the rosin ester can exhibit an oxidative-induction time at 130°C of at least 75 minutes), improved color stability (*e.g.*, the rosin ester can exhibit less than a 10% change in neat Gardner color when heated to a temperature of 160°C for a period of three hours), or combinations thereof. Also provided polymeric compositions comprising the rosin esters, as well as methods of making the rosin esters.



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ROSIN ESTERS AND COMPOSITIONS THEREOF

TECHNICAL FIELD

This application relates generally to rosin esters, as well as methods of making and using thereof.

BACKGROUND

5 Rosin esters, including rosin esters derived from polyhydric alcohols, have been known for more than 50 years. *See*, for example, U.S. Patent No. 1,820,265 to Bent, *et al.* Rosin esters are typically formed by the reaction of rosin, which is primarily a mixture of isomeric C₂₀ tricyclic mono-carboxylic acids known as rosin acids, with alcohols such as
10 glycerol or pentaerythritol. The resultant rosin esters serve as additives in a variety of applications, including as tackifiers in hot-melt and pressure-sensitive adhesives, modifiers for rubbers and various plastics, emulsifiers for synthetic rubbers, base materials for chewing gum, resins in coating compositions such as traffic paints and inks, and sizing agents for paper making.

15 While suitable for many applications, many existing rosin esters fail to possess suitable properties for particular applications. Notably, many commercially available rosin esters are colored (*e.g.*, yellow or yellowish brown) and exhibit poor oxidative stability. Accordingly, there continues to be a need for rosin esters which exhibit improved color (*e.g.*, are colorless or nearly colorless) and improved oxidative stability.

SUMMARY

20 Provided herein are rosin esters that include at least 70% by weight of an esterified dehydroabietic acid and an esterified dihydroabietic acid. The rosin esters can exhibit improved color. For example, the rosin ester can have a neat Gardner color of 8.5 or less (*e.g.*, 6 or less, or 4 or less). The rosin esters can have improved color stability (*e.g.*, the
25 rosin ester can exhibit less than a 10% change in neat Gardner color when heated to a temperature of 160°C for a period of three hours). The rosin esters can also exhibit improved oxidative stability (*e.g.*, when 1000 ppm or less of an antioxidant is present in combination with the rosin ester, the rosin ester can exhibit an oxidative-induction time at
30 130°C of at least 75 minutes).

In certain cases, the rosin ester has not been hydrogenated following esterification. The weight ratio of esterified dehydroabietic acid to esterified dihydroabietic acid in the rosin ester can range from 1:0.80 to 1:0.25 (*e.g.*, from 1:0.70 to 1:0.35, from 1:0.65 to

1:0.40, or from 1:0.55 to 1:0.40). In other embodiments, the rosin ester is a hydrogenated rosin ester (*e.g.*, the rosin ester is subjected to hydrogenation following the esterification reaction). The weight ratio of the esterified dehydroabietic acid to the esterified dihydroabietic acid in the rosin ester can range from 1.3:1 to 1:2.6 (*e.g.*, from 1.3:1 to 1:2.5, 5 from 1.3:1 to 1:1.6, or from 1.2:1 to 1:1.5).

The rosin esters can be derived from tall oil rosin, gum rosin, wood rosin, or a combination thereof. In some cases, the rosin ester is also derived from a polyhydric alcohol, such as a polyhydric alcohol selected from the group consisting of ethylene glycol, propylene glycol, diethylene glycol, triethylene glycol, tetraethylene glycol, trimethylene 10 glycol, glycerol, trimethylolpropane, trimethylolethane, pentaerythritol, mannitol, and combinations thereof.

Also provided are polymeric compositions comprising a polymer derived from one or more ethylenically-unsaturated monomers, or a blend of two or more such polymers, and a rosin ester. The polymer can be a homopolymer or a copolymer (*e.g.*, a random 15 copolymer or a block copolymer) derived from one or more ethylenically-unsaturated monomers, such as (meth)acrylate monomers, vinyl aromatic monomers (*e.g.*, styrene), vinyl esters of carboxylic acids, (meth)acrylonitriles, vinyl halides, vinyl ethers, (meth)acrylamides and (meth)acrylamide derivatives, ethylenically unsaturated aliphatic monomers (*e.g.*, ethylene, butylene, butadiene), and combinations thereof. In some 20 embodiments, the rosin ester includes more than one type of rosin ester.

In some embodiments, the polymer derived from one or more ethylenically-unsaturated monomers comprises a copolymer of ethylene and n-butyl acrylate. In some embodiments, the polymer derived from one or more ethylenically-unsaturated monomers comprises a copolymer of styrene and one or more of isoprene and butadiene. In certain 25 embodiments, the polymer derived from one or more ethylenically-unsaturated monomers comprises a polymer derived from vinyl acetate. Polymers derived from vinyl acetate include polymers derived, at least in part, from polymerization of vinyl acetate monomers. For example, the polymer derived from vinyl acetate can be a homopolymer of vinyl acetate (*i.e.*, polyvinyl acetate; PVA). The polymer derived from vinyl acetate can also be a 30 copolymer of vinyl acetate and one or more additional ethylenically-unsaturated monomers (*e.g.*, poly(ethylene-co-vinyl acetate), EVA). In certain embodiments, the composition is a hot-melt adhesive, such as an EVA-based hot-melt adhesive.

In some embodiments, the polymer is present in the composition in an amount ranging from 20% to 60% by weight, based on the total weight of the composition (*e.g.*,

from 30% to 40% by weight). In some embodiments, the rosin ester is present in the composition in an amount ranging from 20% to 50% by weight, based on the total weight of the composition (*e.g.*, from 30% to 40% by weight).

5 The polymeric compositions can exhibit improved thermal stability, including improved viscosity stability on aging at elevated temperatures (thermal aging), improved color stability on thermal aging, or combinations thereof. For example, in some embodiments, the composition exhibits a change in viscosity of less than 5% when heated to a temperature of 177°C for a period of 96 hours. In some cases, the composition exhibits a change of 5 or less Gardner color units when heated to a temperature of 177°C for a period
10 of 96 hours.

Also provided are methods of making rosin esters. Methods of making rosin esters can comprise esterifying a rosin with an alcohol to form the rosin ester. The esterification reaction can comprise contacting the rosin with the alcohol in the presence of activated carbon. In some embodiments, the esterification reaction can comprise contacting the rosin
15 with the alcohol in the presence of activated carbon, and in the absence of an additional esterification catalyst. Methods can further include hydrogenating the rosin ester to form a hydrogenated rosin ester. In some embodiments, both the esterification reaction and hydrogenation reaction are conducted in the presence of activated carbon, with esterification reaction optionally being performed in the absence of an additional esterification catalyst.

20

DETAILED DESCRIPTION

Provided herein are rosin esters. The rosin esters can exhibit improved color (*e.g.*, the rosin ester can have a neat Gardner color of 8.5 or less), improved oxidative stability (*e.g.*, when 1000 ppm or less of an antioxidant is present in combination with the rosin
25 ester, the rosin ester can exhibit an oxidative-induction time at 130°C of at least 75 minutes), improved color stability (*e.g.*, the rosin ester can exhibit less than a 10% change in neat Gardner color when heated to a temperature of 160°C for a period of three hours), or combinations thereof.

Rosin esters can be formed by the esterification of rosin. Rosin, also called
30 colophony or Greek pitch (*Pix græca*), is a solid hydrocarbon secretion of plants, typically of conifers such as pines (*e.g.*, *Pinus palustris* and *Pinus caribaea*). Rosin can include a mixture of rosin acids, with the precise composition of the rosin varying depending in part on the plant species. Rosin acids are C₂₀ fused-ring monocarboxylic acids with a nucleus of three fused six-carbon rings containing double bonds that vary in number and location.

Examples of rosin acids include abietic acid, neoabietic acid, dehydroabietic acid, dihydroabietic acid, pimaric acid, levopimaric acid, sandaracopimaric acid, isopimaric acid, and palustic acid. Natural rosin typically consists of a mixture of seven or eight rosin acids, in combination with minor amounts of other components.

5 Rosin is commercially available, and can be obtained from pine trees by distillation of oleoresin (gum rosin being the residue of distillation), by extraction of pine stumps (wood rosin) or by fractionation of tall oil (tall oil rosin). Any type of rosin can be used to prepare the rosin esters described herein, including tall oil rosin, gum rosin and wood rosin and mixtures thereof. In certain embodiments, the rosin ester is derived from tall oil rosin.
10 Examples of commercially available rosins include tall oil rosins such as SYLVAROS® 90 and SYLVAROS® NCY, commercially available from Arizona Chemical.

As described above, rosin includes a mixture of rosin acids (*e.g.*, abietadienoic acids) which can include conjugated double bonds within their ring systems. These conjugated double bonds can be a source of oxidative instability. Accordingly, in some
15 cases, the rosin, rosin ester, or combinations thereof are processed to decrease the weight percent of components which include conjugated double bonds. For example, the PAN number of rosin or a rosin ester refers to the weight percentage of abietadienoic acids (in particular palustic, abietic and neoabietic acids) present in the rosin or rosin ester, based on the total weight of the rosin or rosin ester. The term "PAN number", as used herein,
20 specifically refers to the sum of the weight percentages of palustic, abietic and neoabietic acid moieties in a rosin or rosin ester, as determined according to method described in ASTM D5974-00 (2010).

The rosin ester can have a low PAN number. In some embodiments, the rosin ester can have a PAN number, as determined according to the method described in ASTM
25 D5974-00 (2010), of 15.0 or less (*e.g.*, 14.5 or less, 14.0 or less, 13.5 or less, 13.0 or less, 12.5 or less, 12.0 or less, 11.5 or less, 11.0 or less, 10.5 or less, 10.0 or less, 9.5 or less, 9.0 or less, 8.5 or less, 8.0 or less, 7.5 or less, 7.0 or less, 6.5 or less, 6.0 or less, 5.5 or less, 5.0 or less, 4.5 or less, 4.0 or less, 3.5 or less, 3.0 or less, 2.5 or less, 2.0 or less, 1.5 or less, or 1.0 or less).

30 The rosin ester can comprise at least 70% by weight of an esterified dehydroabietic acid and an esterified dihydroabietic acid, based on the total weight of the rosin ester (*e.g.*, at least 75% by weight of an esterified dehydroabietic acid and an esterified dihydroabietic acid, at least 80% by weight of an esterified dehydroabietic acid and an esterified dihydroabietic acid, at least 85% by weight of an esterified dehydroabietic acid and an

esterified dihydroabiatic acid, at least 90% by weight of an esterified dehydroabiatic acid and an esterified dihydroabiatic acid, or at least 95% by weight of an esterified dehydroabiatic acid and an esterified dihydroabiatic acid).

In certain cases, the rosin ester has not been hydrogenated following esterification.

5 In some embodiments, the weight ratio of esterified dehydroabiatic acid to esterified dihydroabiatic acid in the rosin ester is 1:0.25 or less (*e.g.*, 1:0.30 or less, 1:0.35 or less, 1:0.40 or less, 1:0.45 or less, 1:0.50 or less, 1:0.55 or less, 1:0.60 or less, 1:0.65 or less, 1:0.70 or less, or 1:0.75 or less). In some embodiments, the weight ratio of esterified dehydroabiatic acid to esterified dihydroabiatic acid in the rosin ester is at least 1:0.80 (*e.g.*,
10 at least 1:0.75, at least 1:0.70, at least 1:0.65, at least 1:0.60, at least 1:0.55, at least 1:0.50, at least 1:0.45, at least 1:0.40, at least 1:0.35, or at least 1:0.30). The weight ratio of esterified dehydroabiatic acid to esterified dihydroabiatic acid in the rosin ester can range from any of the minimum values described above to any of the maximum values described above. For example, the weight ratio of esterified dehydroabiatic acid to esterified
15 dihydroabiatic acid in the rosin ester can range from 1:0.80 to 1:0.25 (*e.g.*, from 1:0.70 to 1:0.35, from 1:0.65 to 1:0.40, or from 1:0.55 to 1:0.40).

In certain cases, the rosin ester is a hydrogenated rosin ester. In some embodiments, the weight ratio of esterified dehydroabiatic acid to esterified dihydroabiatic acid in the rosin ester is 1.3:1 or less (*e.g.*, 1.25:1 or less, 1.2:1 or less, 1.15:1 or less, 1.1:1 or less,
20 1.05:1 or less, 1:1 or less, 1:1.05 or less, 1:1.1 or less, 1:1.15 or less, 1:1.2 or less, 1:1.25 or less, 1:1.3 or less, 1:1.35 or less, 1:1.4 or less, 1:1.45 or less, 1:1.5 or less, 1:1.55 or less, 1:1.6 or less, 1:1.65 or less, 1:1.7 or less, 1:1.75 or less, 1:1.8 or less, 1:1.85 or less, 1:1.9 or less, 1:1.95 or less, 1:2 or less, 1:2.05 or less, 1:2.1 or less, 1:2.15 or less, 1:2.2 or less, 1:2.25 or less, 1:2.3 or less, 1:2.35 or less, 1:2.4 or less, 1:2.45 or less, 1:2.5 or less, or
25 1:2.55 or less). In some embodiments, the weight ratio of esterified dehydroabiatic acid to esterified dihydroabiatic acid in the rosin ester is at least 1:2.6 (*e.g.*, at least 1:2.55, at least 1:2.5, at least 1:2.45, at least 1:2.4, at least 1:2.35, at least 1:2.3, at least 1:2.25, at least 1:2.2, at least 1:2.15, at least 1:2.1, at least 1:2.05, at least 1:2, at least 1:1.95, at least 1:1.9, at least 1:1.85, at least 1:1.8, at least 1:1.75, at least 1:1.7, at least 1:1.65, at least 1:1.6, at
30 least 1:1.55, at least 1:1.5, at least 1:1.45, at least 1:1.4, at least 1:1.35, at least 1:1.3, at least 1:1.25, at least 1:1.2, at least 1:1.15, at least 1:1.1, at least 1:1.05, at least 1:1, at least 1.05:1, at least 1.1:1, at least 1.15:1, at least 1.2:1, or at least 1.25:1). The weight ratio of esterified dehydroabiatic acid to esterified dihydroabiatic acid in the rosin ester can range from any of the minimum values described above to any of the maximum values described above. For

example, the weight ratio of esterified dehydroabiatic acid to esterified dihydroabiatic acid in the rosin ester can range from 1.3:1 to 1:2.6 (*e.g.*, from 1.3:1 to 1:2.5, from 1.3:1 to 1:1.6, or from 1.2:1 to 1:1.5).

The rosin ester can be derived from any suitable alcohol, include monoalcohols,
5 diols, and other polyols. Examples of suitable alcohols include glycerol, pentaerythritol, dipentaerythritol, ethylene glycol, diethylene glycol, triethylene glycol, sorbitol, neopentylglycol, trimethylolpropane, methanol, ethanol, propanol, butanol, amyl alcohol, 2-ethyl hexanol, diglycerol, tripentaerythritol, C₈-C₁₁ branched or unbranched alkyl alcohols, and C₇-C₁₆ branched or unbranched arylalkylalcohols. In certain embodiments, the rosin
10 ester is derived from a polyhydric alcohol. For example, the polyhydric alcohol can be selected from the group consisting of ethylene glycol, propylene glycol, diethylene glycol, triethylene glycol, tetraethylene glycol, trimethylene glycol, glycerol, trimethylolpropane, trimethylolethane, pentaerythritol, dipentaerythritol, mannitol, and combinations thereof.

The rosin ester can have a weight average molecular weight, as determined using gel
15 permeation chromatography (GPC) as described in ASTM D5296-05, of at least 800 g/mol (*e.g.*, at least 850 g/mol, at least 900 g/mol, at least 950 g/mol, at least 1000 g/mol, at least 1050 g/mol, at least 1100 g/mol, at least 1150 g/mol, at least 1200 g/mol, at least 1250 g/mol, at least 1300 g/mol, at least 1350 g/mol, at least 1400 g/mol, at least 1450 g/mol, at
20 least 1500 g/mol, at least 1550 g/mol, at least 1600 g/mol, at least 1650 g/mol, at least 1700 g/mol, at least 1750 g/mol, at least 1800 g/mol, at least 1850 g/mol, at least 1900 g/mol, or at least 1950 g/mol). The blend of rosin esters can have a weight average molecular weight of 2000 g/mol or less (*e.g.*, 1950 g/mol or less, 1900 g/mol or less, 1850 g/mol or less, 1800 g/mol or less, 1750 g/mol or less, 1700 g/mol or less, 1650 g/mol or less, 1600 g/mol
25 or less, 1550 g/mol or less, 1500 g/mol or less, 1450 g/mol or less, 1400 g/mol or less, 1350 g/mol or less, 1300 g/mol or less, 1250 g/mol or less, 1200 g/mol or less, 1150 g/mol or less, 1100 g/mol or less, 1050 g/mol or less, 1000 g/mol or less, 950 g/mol or less, 900 g/mol or less, or 850 g/mol or less).

The rosin ester can have a weight average molecular weight ranging from any of the minimum values above to any of the maximum values above. For example, the rosin ester
30 can have a weight average molecular weight of from 800 g/mol to 2000 g/mol (*e.g.*, from 900g/mol to 1600 g/mol, or from 1000 g/mol to 1500 g/mol).

The rosin esters can have an improved Gardner color. In some embodiments, the rosin ester has a neat Gardner color, as determined according to the method described in ASTM D1544-04 (2010), of 8.5 or less (*e.g.*, 8.0 or less, 7.5 or less, 7.0 or less, 6.5 or less,

6.0 or less, 5.5 or less, 5.0 or less, 4.5 or less, 4.0 or less, 3.5 or less, 3.0 or less, 2.5 or less, 2.0 or less, 1.5 or less, 1.0 or less, or 0.5 or less).

The rosin esters can exhibit improved color stability. In some embodiments, the rosin ester can exhibit less than a 10% change in neat Gardner color, as determined according to the method described in ASTM D1544-04 (2010), when heated to a temperature of 160°C for a period of three hours (*e.g.*, less than a 9.5% change in neat Gardner color, less than a 9% change in neat Gardner color, less than a 8.5% change in neat Gardner color, less than a 8% change in neat Gardner color, less than a 7.5% change in neat Gardner color, less than a 7% change in neat Gardner color, less than a 6.5% change in neat Gardner color, less than a 6% change in neat Gardner color, less than a 5.5% change in neat Gardner color, less than a 5% change in neat Gardner color, less than a 4.5% change in neat Gardner color, less than a 4% change in neat Gardner color, less than a 3.5% change in neat Gardner color, less than a 3% change in neat Gardner color, less than a 2.5% change in neat Gardner color, less than a 2% change in neat Gardner color, less than a 1.5% change in neat Gardner color, or less than a 1% change in neat Gardner color. In certain embodiments, the neat Gardner color of the rosin ester, as determined according to the method described in ASTM D1544-04 (2010), remains substantially unchanged (*i.e.*, exhibits less than a 0.5% change in neat Gardner color) when the rosin ester is heated to a temperature of 160°C for a period of three hours.

The rosin esters can also exhibit improved oxidative stability. For example, in some embodiments, when 1000 ppm or less of an antioxidant is present in combination with the rosin ester, the rosin ester can exhibit an oxidative-induction time at 130°C, as measured using the methods specified in ASTM D5483-05(2010), of at least 10 minutes (*e.g.*, at least 15 minutes, at least 20 minutes, at least 25 minutes, at least 30 minutes, at least 35 minutes, at least 40 minutes, at least 45 minutes, at least 50 minutes, at least 55 minutes, at least 60 minutes, at least 65 minutes, at least 70 minutes, at least 75 minutes, at least 80 minutes, at least 85 minutes, at least 90 minutes, at least 95 minutes, at least 100 minutes, at least 105 minutes, at least 110 minutes, at least 115 minutes, at least 120 minutes, at least 125 minutes, at least 130 minutes, at least 135 minutes, at least 140 minutes, at least 145 minutes, at least 150 minutes, at least 155 minutes, at least 160 minutes, at least 165 minutes, at least 170 minutes, at least 175 minutes, at least 180 minutes, at least 185 minutes, at least 190 minutes, or at least 195 minutes). In certain embodiments, the rosin ester is a hydrogenated rosin ester, and when 1000 ppm or less of an antioxidant is present in combination with the hydrogenated rosin ester, the hydrogenated rosin ester exhibits an

oxidative-induction time at 130°C, as measured using the methods specified in ASTM D5483-05(2010), of at least 75 minutes (*e.g.*, at least 80 minutes, at least 85 minutes, at least 90 minutes, at least 95 minutes, at least 100 minutes, at least 105 minutes, at least 110 minutes, at least 115 minutes, at least 120 minutes, at least 125 minutes, at least 130 minutes, at least 135 minutes, at least 140 minutes, at least 145 minutes, at least 150 minutes, at least 155 minutes, at least 160 minutes, at least 165 minutes, at least 170 minutes, at least 175 minutes, at least 180 minutes, at least 185 minutes, at least 190 minutes, or at least 195 minutes). For example, when the rosin ester or the hydrogenated rosin ester includes 1000 ppm of antioxidant, or when the rosin ester or the hydrogenated rosin ester includes less than 1000 ppm of antioxidant (*e.g.*, 800 ppm of antioxidant, 600 ppm of antioxidant, 400 ppm of antioxidant, 200 ppm of antioxidant, 100 ppm of antioxidant, 50 ppm of antioxidant, or 0 ppm of antioxidant), the rosin ester or the hydrogenated rosin ester can exhibit the oxidative-induction times described above at 130°C, as measured using the methods specified in ASTM D5483-05(2010). In certain embodiments, when 1000 ppm or less of an antioxidant is present in combination with the rosin ester or the hydrogenated rosin ester, the rosin ester or the hydrogenated rosin ester can exhibit an oxidative-induction time at 130°C, as measured using the methods specified in ASTM D5483-05(2010), of 250 minutes or less (*e.g.*, 200 minutes or less).

In some embodiments, the rosin ester includes less than 1000 ppm antioxidant (*e.g.*, less than 950 ppm antioxidant, less than 900 ppm antioxidant, less than 850 ppm antioxidant, less than 800 ppm antioxidant, less than 750 ppm antioxidant, less than 700 ppm antioxidant, less than 650 ppm antioxidant, less than 600 ppm antioxidant, less than 550 ppm antioxidant, less than 500 ppm antioxidant, less than 450 ppm antioxidant, less than 400 ppm antioxidant, less than 350 ppm antioxidant, less than 300 ppm antioxidant, less than 250 ppm antioxidant, less than 200 ppm antioxidant, less than 150 ppm antioxidant, less than 100 ppm antioxidant, less than 50 ppm antioxidant, or less than 10 ppm antioxidant), wherein ppm refers to parts of antioxidant per million parts of rosin ester

Optionally, the rosin esters can have a low hydroxyl number. In some embodiments, the rosin ester has a hydroxyl number, as measured using a modified version of the standard method provided in DIN 53240-2 (different solvent tetrahydrofuran was applied), of 5.0 or less (*e.g.*, 4.5 or less, 4.0 or less, 3.5 or less, 3.0 or less, 2.5 or less, 2.0 or less, 1.5 or less, or 1.0 or less). The hydroxyl number is expressed as mg KOH per gram rosin ester sample.

The rosin ester or blend of rosin esters incorporated in the compositions provided herein can have a low acid number. In some embodiments, the rosin ester or blend of rosin

esters has an acid number, as determined according to the method described in ASTM D465-05 (2010), of 10.0 or less (*e.g.*, 9.5 or less, 9.0 or less, 8.5 or less, 8.0 or less, 7.5 or less, 7.0 or less, 6.5 or less, 6.0 or less, 5.5 or less, 5.0 or less, 4.5 or less, 4.0 or less, 3.5 or less, 3.0 or less, 2.5 or less, 2.0 or less, 1.5 or less, or 1.0 or less). The acid number is expressed as mg KOH per gram rosin ester sample.

The sulfur content of the rosin ester can be measured with an ANTEK® 9000 sulfur analyzer using the standard methods described in ASTM D5453-05. The composition can have a sulfur content of 700 ppm or less (*e.g.*, 650 ppm or less, 600 ppm or less, 550 ppm or less, 500 ppm or less, or 450 ppm or less). The composition can optionally have low sulfur content. In some embodiments, the composition comprises less than 400 ppm sulfur (*e.g.*, less than 350 ppm sulfur, less than 300 ppm sulfur, less than 250 ppm sulfur, or less than 200 ppm sulfur). In some embodiments, the sulfur content of the rosin ester can be reduced by treating the rosin ester with a sorbent, such as activated carbon, to decrease the amount of sulfur in the rosin ester.

Also provided are polymeric compositions comprising a rosin ester described herein and a polymer derived from one or more ethylenically-unsaturated monomers. In this context, a polymer derived from an ethylenically-unsaturated monomer includes polymers derived, at least in part, from polymerization of the ethylenically-unsaturated monomer. For example, a polymer derived from an ethylenically-unsaturated monomers can be obtained by, for example, radical polymerization of a monomer mixture comprising the ethylenically-unsaturated monomer. A polymer derived from an ethylenically-unsaturated monomer can be said to contain monomer units obtained by polymerization (*e.g.*, radical polymerization) of the ethylenically-unsaturated monomer. Polymeric compositions can also comprise a rosin ester described herein and a blend of two or more polymers derived from one or more ethylenically-unsaturated monomers. In these cases, the blend of two or more polymers can be, for example, a blend of two or more polymers having different chemical compositions (*e.g.*, a blend of poly(ethylene-*co*-vinyl acetate) and polyvinyl acetate; or a blend of two poly(ethylene-*co*-vinyl acetates) derived from different weight percents of ethylene and vinyl acetate monomers).

In some embodiments, the rosin ester includes more than one type of rosin ester. For example, the rosin ester can include a mixture of two rosin esters which are derived from the same type of rosin and two different alcohols (*e.g.*, a pentaerythritol ester of tall oil rosin and a glycerol ester of tall oil rosin), a mixture of two rosin esters which are derived from the same alcohol and two different types of rosin (*e.g.*, a pentaerythritol ester of tall oil

rosin and a pentaerythritol ester of gum rosin), or a mixture of two rosin esters which are derived from two different alcohols and two different types of rosin (*e.g.*, a pentaerythritol ester of tall oil rosin and a glycerol ester of gum rosin).

The polymer can be a homopolymer or a copolymer (*e.g.*, a random copolymer or a block copolymer) derived from one or more ethylenically-unsaturated monomers. In other words, the homopolymer or copolymer can include monomer units of one or more ethylenically-unsaturated monomers. The polymer can be a branched polymer or copolymer. For example, polymer can be a graft copolymer having a polymeric backbone and a plurality of polymeric side chains grafted to the polymeric backbone. In some cases, the polymer can be a graft copolymer having a backbone of a first chemical composition and a plurality of polymeric side chains which are structurally distinct from the polymeric backbone (*e.g.*, having a different chemical composition than the polymeric backbone) grafted to the polymeric backbone.

Examples of suitable ethylenically-unsaturated monomers include (meth)acrylate monomers, vinyl aromatic monomers (*e.g.*, styrene), vinyl esters of a carboxylic acids, (meth)acrylonitriles, vinyl halides, vinyl ethers, (meth)acrylamides and (meth)acrylamide derivatives, ethylenically unsaturated aliphatic monomers (*e.g.*, ethylene, butylene, butadiene), and combinations thereof. As used herein, the term “(meth)acrylate monomer” includes acrylate, methacrylate, diacrylate, and dimethacrylate monomers. Similarly, the term “(meth)acrylonitrile” includes acrylonitrile, methacrylonitrile, etc. and the term “(meth)acrylamide” includes acrylamide, methacrylamide, etc.

Suitable (meth)acrylate monomers include esters of α,β -monoethylenically unsaturated monocarboxylic and dicarboxylic acids having 3 to 6 carbon atoms with alkanols having 1 to 20 carbon atoms (*e.g.*, esters of acrylic acid, methacrylic acid, maleic acid, fumaric acid, or itaconic acid, with C₁-C₂₀, C₁-C₁₂, C₁-C₈, or C₁-C₄ alkanols). Exemplary (meth)acrylate monomers include, but are not limited to, methyl acrylate, methyl (meth)acrylate, ethyl acrylate, ethyl (meth)acrylate, butyl acrylate, butyl (meth)acrylate, isobutyl (meth)acrylate, n-hexyl (meth)acrylate, ethylhexyl (meth)acrylate, n-heptyl (meth)acrylate, ethyl (meth)acrylate, 2-methylheptyl (meth)acrylate, octyl (meth)acrylate, isooctyl (meth)acrylate, n-nonyl (meth)acrylate, isononyl (meth)acrylate, n-decyl (meth)acrylate, isodecyl (meth)acrylate, dodecyl (meth)acrylate, lauryl (meth)acrylate, tridecyl (meth)acrylate, stearyl (meth)acrylate, glycidyl (meth)acrylate, alkyl crotonates, vinyl acetate, di-n-butyl maleate, di-octylmaleate, acetoacetoxyethyl (meth)acrylate, acetoacetoxypropyl (meth)acrylate, hydroxyethyl (meth)acrylate, allyl (meth)acrylate,

tetrahydrofurfuryl (meth)acrylate, cyclohexyl (meth)acrylate, 2-ethoxyethyl (meth)acrylate, 2-methoxy (meth)acrylate, 2-(2-ethoxyethoxy)ethyl (meth)acrylate, 2-ethylhexyl (meth)acrylate, 2-propylheptyl (meth)acrylate, 2-phenoxyethyl (meth)acrylate, isobornyl (meth)acrylate, caprolactone (meth)acrylate, polypropyleneglycol mono(meth)acrylate, polyethyleneglycol (meth)acrylate, benzyl (meth)acrylate, 2,3-di(acetoacetoxy)propyl (meth)acrylate, hydroxypropyl (meth)acrylate, methylpolyglycol (meth)acrylate, 3,4-epoxycyclohexylmethyl (meth)acrylate, 1,6 hexanediol di(meth)acrylate, 1,4 butanediol di(meth)acrylate and combinations thereof.

Suitable vinyl aromatic compounds include styrene, α - and p-methylstyrene, α -butylstyrene, 4-n-butylstyrene, 4-n-decylstyrene, vinyltoluene, and combinations thereof. Suitable vinyl esters of carboxylic acids include vinyl esters of carboxylic acids comprising up to 20 carbon atoms, such as vinyl laurate, vinyl stearate, vinyl propionate, versatic acid vinyl esters, and combinations thereof. Suitable vinyl halides can include ethylenically unsaturated compounds substituted by chlorine, fluorine or bromine, such as vinyl chloride and vinylidene chloride. Suitable vinyl ethers can include, for example, vinyl ethers of alcohols comprising 1 to 4 carbon atoms, such as vinyl methyl ether or vinyl isobutyl ether. Aliphatic hydrocarbons having 2 to 8 carbon atoms and one or two double bonds can include, for example, hydrocarbons having 2 to 8 carbon atoms and one olefinic double bond, such as ethylene, as well as hydrocarbons having 4 to 8 carbon atoms and two olefinic double bonds, such as butadiene, isoprene, and chloroprene.

In some embodiments, the polymer derived from one or more ethylenically-unsaturated monomers comprises a copolymer of ethylene and n-butyl acrylate. In some embodiments, the polymer derived from one or more ethylenically-unsaturated monomers comprises a copolymer of styrene and one or more of isoprene and butadiene. In certain embodiments, the polymer derived from one or more ethylenically-unsaturated monomers comprises a metallocene-catalyzed polyolefin. Examples of suitable metallocene-catalyzed polyolefins include metallocene polyethylenes and metallocene polyethylene copolymers, which are commercially available, for example, from Exxon Mobil Corporation (under the trade name EXACT®) and Dow Chemical Company (under the trade name AFFINITY®).

In certain embodiments, the polymer derived from one or more ethylenically-unsaturated monomers comprises a polymer derived from vinyl acetate. Polymers derived from vinyl acetate include polymers derived, at least in part, from polymerization of vinyl acetate monomers. For example, the polymer derived from vinyl acetate can be a homopolymer of vinyl acetate (*i.e.*, polyvinyl acetate; PVA). The polymer derived from

vinyl acetate can also be a copolymer of vinyl acetate and one or more additional ethylenically-unsaturated monomers (*e.g.*, poly(ethylene-co-vinyl acetate), EVA). In these embodiments, the polymer derived from vinyl acetate can be derived from varying amounts of vinyl acetate, so as to provide a polymer having the chemical and physical properties suitable for a particular application.

In some embodiments, the polymer derived from vinyl acetate is derived from at least 5% by weight vinyl acetate, based on the total weight of all of the monomers polymerized to form the polymer (*e.g.*, at least 7.5% by weight, at least 9% by weight, at least 10% by weight, at least 11% by weight, at least 12% by weight, at least 13% by weight, at least 14% by weight, at least 15% by weight, at least 16% by weight, at least 17% by weight, at least 18% by weight, at least 19% by weight, at least 20% by weight, at least 21% by weight, at least 22% by weight, at least 23% by weight, at least 24% by weight, at least 25% by weight, at least 26% by weight, at least 27% by weight, at least 28% by weight, at least 29% by weight, at least 30% by weight, at least 31% by weight, at least 32% by weight, at least 33% by weight, at least 34% by weight, at least 35% by weight, at least 37.5% by weight, at least 40% by weight, at least 45% by weight, at least 50% by weight, at least 55% by weight, at least 60% by weight, at least 65% by weight, at least 70% by weight, at least 75% by weight, at least 80% by weight, at least 85% by weight, or at least 90% by weight). In some embodiments, the polymer derived from vinyl acetate is derived from 95% by weight or less vinyl acetate, based on the total weight of all of the monomers polymerized to form the polymer (*e.g.*, 90% by weight or less, 85% by weight or less, 80% by weight or less, 75% by weight or less, 70% by weight or less, 65% by weight or less, 60% by weight or less, 55% by weight or less, 50% by weight or less, 45% by weight or less, 40% by weight or less, 37.5% by weight or less, 35% by weight or less, 34% by weight or less, 33% by weight or less, 32% by weight or less, 31% by weight or less, 30% by weight or less, 29% by weight or less, 28% by weight or less, 27% by weight or less, 26% by weight or less, 25% by weight or less, 24% by weight or less, 23% by weight or less, 22% by weight or less, 21% by weight or less, 20% by weight or less, 19% by weight or less, 18% by weight or less, 17% by weight or less, 16% by weight or less, 15% by weight or less, 14% by weight or less, 13% by weight or less, 12% by weight or less, 11% by weight or less, 10% by weight or less, 9% by weight or less, or 7.5% by weight or less).

The polymer derived from vinyl acetate can be a copolymer derived from an amount of vinyl acetate ranging from any of the minimum values above to any of the maximum values above. For example, the polymer derived from vinyl acetate can be a copolymer

derived from 5% by weight to less than 100% by weight vinyl acetate, based on the total weight of all of the monomers polymerized to form the polymer (*e.g.*, from 5% by weight to 75% by weight vinyl acetate, from 10% by weight to 40% by weight vinyl acetate, or from 17% by weight to 34% by weight vinyl acetate).

5 In the case of copolymers derived from vinyl acetate and one or more ethylenically-unsaturated monomers, any suitable ethylenically-unsaturated monomers can be incorporated in the copolymer, so as to provide a copolymer having the chemical and physical properties desired for a particular application. By way of example, suitable ethylenically-unsaturated monomers which can be incorporated into the copolymers include
10 those described above, including (meth)acrylate monomers, vinyl aromatic monomers (*e.g.*, styrene), vinyl esters of a carboxylic acids, (meth)acrylonitriles, vinyl halides, vinyl ethers, (meth)acrylamides and (meth)acrylamide derivatives, ethylenically unsaturated aliphatic monomers (*e.g.*, ethylene, butylene, butadiene), and combinations thereof.

 In certain embodiments, the polymer is poly(ethylene-*co*-vinyl acetate) (EVA).
15 EVA is a copolymer derived from ethylene and vinyl acetate. EVA is widely used in a variety of applications, including as a copolymer in hot-melt adhesives, in road marking and pavement marking applications, in biomedical applications (*e.g.*, as a matrix for controlled drug delivery), as an additive in plastic films, and as a foam in a variety of consumer products. Optionally, the EVA copolymer can be grafted with suitable olefinic monomers,
20 such as butadiene, to obtain copolymers having the particular chemical and physical properties required for a particular application. *See*, for example, U.S. Patent Nos. 3,959,410 to DiRossi and 5,036,129 to Atwell, *et al.*

 In certain embodiments, the polymer is EVA derived from 9% by weight to less than 45% by weight vinyl acetate, based on the total weight of all of the monomers polymerized
25 to form the polymer (*e.g.*, from 17% by weight to 40% by weight vinyl acetate, from 17% by weight to 34% by weight vinyl acetate, or from 25% by weight to 30% by weight vinyl acetate) and from greater than 55% by weight to 91% by weight ethylene (*e.g.*, from 60% by weight to 83% by weight vinyl acetate, from 66% by weight to 83% by weight vinyl acetate, or from 70% by weight to 75% by weight vinyl acetate). In one embodiment, the
30 polymer derived from vinyl acetate is EVA derived from 26% by weight to 28% by weight vinyl acetate and from 72% by weight to 74% by weight ethylene, based on the total weight of all of the monomers polymerized to form the polymer.

 In some embodiments, the polymer has a melting temperature, as measured by differential scanning calorimetry (DSC) using the standard method described in ISO 11357-

3:2011, of greater than 25°C (*e.g.*, greater than 30°C, greater than 35°C, greater than 40°C, greater than 45°C, greater than 50°C, greater than 55°C, greater than 60°C, greater than 65°C, greater than 70°C, greater than 75°C, greater than 80°C, or greater than 85°C, greater than 90°C, or greater than 95°C). The polymer derived from vinyl acetate can have a
5 melting temperature of less than 100°C (*e.g.*, less than 95°C, less than 90°C, less than 85°C, less than 80°C, less than 75°C, less than 70°C, less than 65°C, less than 60°C, less than 55°C, less than 50°C, less than 45°C, less than 40°C, less than 35°C, or less than 30°C).

The polymer can have a melting temperature ranging from any of the minimum values above to any of the maximum values above. For example, the polymer can have a
10 melting temperature, as measured by differential scanning calorimetry (DSC) using the standard method described in ISO 11357-3:2011, of from 25°C to 100°C (*e.g.*, from 25°C to 90°C, from 35°C to 85°C, or 50°C to 80°C).

The rosin ester can be present in the polymeric compositions in varying amounts, depending upon the desired properties of the composition. In some embodiments, the rosin
15 ester comprises at least 5% by weight of the composition (*e.g.*, at least 10% by weight of the composition, at least 15% by weight of the composition, at least 20% by weight of the composition, at least 25% by weight of the composition, at least 30% by weight of the composition, at least 35% by weight of the composition, at least 40% by weight of the composition, or at least 45% by weight of the composition). In some embodiments, the
20 rosin ester comprises 50% or less of the composition by weight (*e.g.*, 45% or less by weight, 40% or less by weight, 35% or less by weight, 30% or less by weight, 25% or less by weight, 20% or less by weight, 15% or less by weight, or 10% or less by weight). The rosin ester can be present in the composition in an amount ranging from any of the minimum values above to any of the maximum values above. In some embodiments, rosin ester is
25 present in the composition in an amount ranging from 20% to 50% by weight, based on the total weight of the composition (*e.g.*, from 30% to 40% by weight).

Similarly, the polymer derived from one or more ethylenically-unsaturated monomers can be present in the polymeric compositions in varying amounts, depending upon the desired properties of the composition. In some embodiments, the polymer derived
30 from one or more ethylenically-unsaturated monomers comprises at least 20% by weight of the composition (*e.g.*, at least 25% by weight of the composition, at least 30% by weight of the composition, at least 35% by weight of the composition, at least 40% by weight of the composition, at least 45% by weight of the composition, at least 50% by weight of the composition, at least 55% by weight of the composition, at least 60% by weight of the

composition, at least 65% by weight of the composition, at least 70% by weight of the composition, at least 75% by weight of the composition, at least 80% by weight of the composition, at least 85% by weight of the composition, or at least 90% by weight of the composition). In some embodiments, the polymer derived from one or more ethylenically-unsaturated monomers comprises 95% or less of the composition by weight (*e.g.*, 90% or less by weight, 85% or less by weight, 80% or less by weight, 75% or less by weight, 70% or less by weight, 65% or less by weight, 60% or less by weight, 55% or less by weight, 50% or less by weight, 45% or less by weight, 40% or less by weight, 35% or less by weight, 30% or less by weight, 25% or less by weight, 20% or less by weight, 15% or less by weight, or 10% or less by weight). The rosin ester can be present in the composition in an amount ranging from any of the minimum values above to any of the maximum values above. In some embodiments, the polymer derived from one or more ethylenically-unsaturated monomers is present in the composition in an amount ranging from 20% to 60% by weight, based on the total weight of the composition (*e.g.*, from 30% to 40% by weight).

In certain embodiments, the weight ratio of the polymer derived from one or more ethylenically-unsaturated monomers to the total amount of esterified dehydroabiatic acid and esterified dihydroabiatic acid in the composition is at least 1:2.2 (*e.g.*, at least 1:2.1, at least 1:2.0, at least 1:1.9, at least 1:1.8, at least 1:1.7, at least 1:1.6, at least 1:1.5, at least 1:1.4, at least 1:1.3, at least 1:1.2, at least 1:1.1, at least 1:1, at least 1.1:1, at least 1.2:1, at least 1.3:1, at least 1.4:1, at least 1.5:1, at least 1.6:1, at least 1.7:1, at least 1.8:1, at least 1.9:1, at least 2:1, at least 2.1:1, at least 2.2:1, at least 2.3:1, at least 2.4:1, at least 2.5:1, at least 2.6:1, at least 2.7:1, at least 2.8:1, at least 2.9:1, at least 3:1, at least 3.1:1, at least 3.2:1, at least 3.3:1, at least 3.4:1, at least 3.5:1, at least 3.6:1, at least 3.7:1, at least 3.8:1, at least 3.9:1, at least 4:1, at least 4.1:1, or at least 4.2:1). In certain embodiments, the weight ratio of the polymer derived from one or more ethylenically-unsaturated monomers to the total amount of esterified dehydroabiatic acid and esterified dihydroabiatic acid in the composition is 4.3:1 or less (*e.g.*, 4.2:1 or less, 4.1:1 or less, 4:1 or less, 3.9:1 or less, 3.8:1 or less, 3.7:1 or less, 3.6:1 or less, 3.5:1 or less, 3.4:1 or less, 3.3:1 or less, 3.2:1 or less, 3.1:1 or less, 3:1 or less, 2.9:1 or less, 2.8:1 or less, 2.7:1 or less, 2.6:1 or less, 2.5:1 or less, 2.4:1 or less, 2.3:1 or less, 2.2:1 or less, 2.1:1 or less, 2:1 or less, 1.9:1 or less, 1.8:1 or less, 1.7:1 or less, 1.6:1 or less, 1.5:1 or less, 1.4:1 or less, 1.3:1 or less, 1.2:1 or less, 1.1:1 or less, 1:1 or less, 1:1.1 or less, 1:1.2 or less, 1:1.3 or less, 1:1.4 or less, 1:1.5 or less, 1:1.6 or less, 1:1.7 or less, 1:1.8 or less, 1:1.9 or less, 1:2 or less, or 1:2.1 or less). The weight ratio of the polymer derived from one or more ethylenically-unsaturated monomers to the total

amount of esterified dehydroabiatic acid and esterified dihydroabiatic acid in the composition can range from any of the minimum values above to any of the maximum values above. For example, in some embodiments, the weight ratio of the polymer derived from one or more ethylenically-unsaturated monomers to the total amount of esterified dehydroabiatic acid and esterified dihydroabiatic acid in the composition is from 1:2.2 to 4.3:1 (e.g., from 1:1.1 to 2:1).

In some cases, the polymeric composition can be an adhesive formulation (e.g., hot-melt adhesive formulation), an ink formulation, a coating formulation, a rubber formulation, a sealant formulation, an asphalt formulation, or a pavement marking formulation (e.g., a thermoplastic road marking formulation).

In certain embodiments, the composition is a hot-melt adhesive. In these embodiments, the rosin ester can function as all or a portion of the tackifier component in a traditional hot-melt adhesive formulation. The polymer derived from one or more ethylenically-unsaturated monomers (e.g., a polymer derived from vinyl acetate such as EVA), the rosin ester, and one or more additional components, can be present in amounts effective to provide a hot-melt adhesive having the characteristics required for a particular application. For example, the polymer derived from one or more ethylenically-unsaturated monomers (e.g., a polymer derived from vinyl acetate such as EVA), can be from 10% by weight to 60% by weight of the hot-melt adhesive composition (e.g., from 20% by weight to 60% by weight of the hot-melt adhesive composition, from 25% by weight to 50% by weight of the hot-melt adhesive composition, or from 30% by weight to 40% by weight of the hot-melt adhesive composition). The rosin ester can be from 20% by weight to 50% by weight of the hot-melt adhesive composition (e.g., from 25% by weight to 45% by weight of the hot-melt adhesive composition, or from 30% by weight to 40% by weight of the hot-melt adhesive composition).

The hot-melt adhesive can further include one or more additional components, including additional tackifiers, waxes, stabilizers (e.g., antioxidants and UV stabilizers), plasticizers (e.g., benzoates and phthalates), paraffin oils, nucleating agents, optical brighteners, pigments dyes, glitter, biocides, flame retardants, anti-static agents, anti-slip agents, anti-blocking agents, lubricants, and fillers. In some embodiments, the hot-melt adhesive further comprises a wax. Suitable waxes include paraffin-based waxes and synthetic Fischer-Tropsch waxes. The waxes can be from 10% by weight to 40% by weight of the hot-melt adhesive composition, based on the total weight of the composition (e.g., from 20% by weight to 30% by weight of the hot-melt adhesive composition).

In certain embodiments, the composition is a hot-melt adhesive and the polymer derived from one or more ethylenically-unsaturated monomers is EVA. In certain embodiments, the EVA can be derived from 10% by weight to 40% by weight vinyl acetate, based on the total weight of all of the monomers polymerized to form the EVA (*e.g.*, from 17% by weight to 34% by weight vinyl acetate).

In certain embodiments, the composition is a thermoplastic road marking formulation. The thermoplastic road marking formulation can include from 5% by weight to 25% by weight of a rosin ester, based on the total weight of the thermoplastic road marking formulation (*e.g.*, from 10% by weight to 20% by weight of the thermoplastic road marking formulation). The thermoplastic road marking formulation can further include a polymer derived from one or more ethylenically-unsaturated monomers (*e.g.*, a polymer derived from vinyl acetate such as EVA) which can be, for example, from 0.1% by weight to 1.5% by weight of the thermoplastic road marking formulation. The thermoplastic road marking formulation can further include a pigment (*e.g.*, from 1% by weight to 10% by weight titanium dioxide), and glass beads (*e.g.*, from 30% by weight to 40% by weight), and a filler (*e.g.*, calcium carbonate which can make up the balance of the composition up to 100% by weight). The thermoplastic road marking formulation can further include an oil (*e.g.*, from 1% by weight to 5% by weight percent mineral oil), a wax (*e.g.*, from 1% by weight to 5% by weight percent paraffin-based wax or synthetic Fischer-Tropsch wax), a stabilizer (*e.g.*, from 0.1% by weight to 0.5% by weight stearic acid), and, optionally, additional polymers and/or binders other than the rosin ester described herein.

In some embodiments, by incorporating a rosin ester described herein into the polymeric composition, the polymeric composition can exhibit improved thermal stability, including improved viscosity stability on aging at elevated temperatures (thermal aging), improved color stability on thermal aging, or combinations thereof.

In some embodiments, the polymeric compositions provided herein exhibit less than a 10% change in viscosity upon incubation at 177°C for 96 hours, when analyzed using the modified ASTM D4499-07 method described below (*e.g.*, less than a 9% change in viscosity, less than an 8% change in viscosity, less than a 7.5% change in viscosity, less than a 7% change in viscosity, less than a 6% change in viscosity, less than a 5% change in viscosity, less than a 4% change in viscosity, less than a 3% change in viscosity, less than a 2.5% change in viscosity, less than a 2% change in viscosity, or less than a 1% change in viscosity). In some embodiments, the composition exhibits substantially no change in viscosity (*i.e.*, less than a 0.5% change in viscosity) upon incubation at 177°C for 96 hours.

In some embodiments, the polymeric compositions provided herein exhibit color stability upon thermal aging. In certain cases, the polymeric compositions provided herein exhibit a change of 5 or less Gardner color units when heated to a temperature of 177°C for a period of 96 hours (*e.g.*, 4.5 or less, 4.0 or less, 3.5 or less, 3.0 or less, 2.5 or less, 2.0 or less, 1.5 or less, 1.0 or less, or 0.5 or less).

The polymeric compositions provided herein can be used in a variety of applications, including as adhesives (*e.g.*, hot-melt adhesives), inks, coatings, rubbers, sealants, asphalt, and thermoplastic road markings and pavement markings. In some embodiments, the compositions are hot-melt adhesives used, for example, in conjunction with papers and packaging (*e.g.*, to adhere surfaces of corrugated fiberboard boxes and paperboard cartons during assembly and/or packaging, to prepare self-adhesive labels, to apply labels to packaging, or in other applications such as bookbinding), in conjunction with non-woven materials (*e.g.*, to adhere nonwoven material with a backsheet during the construction of disposable diapers), in adhesive tapes, in apparel (*e.g.*, in the assembly of footwear, or in the assembly of multi-wall and specialty handbags), in electrical and electronic bonding (*e.g.*, to affix parts or wires in electronic devices), in general wood assembly (*e.g.*, in furniture assembly, or in the assembly of doors and mill work), and in other industrial assembly (*e.g.*, in the assembly of appliances). The rosin esters described herein can also be used in a variety of additional applications, including as a softener and plasticizer in chewing gum bases, as a weighting and clouding agent in beverages (*e.g.*, citrus flavored beverages), as a surfactant, surface activity modulator, or dispersing agent, as an additive in waxes and wax-based polishes, as a modifier in cosmetic formulations (*e.g.*, mascara), and as a curing agent in concrete.

Also provided are compositions comprising a rosin ester described herein and an oil. Exemplary compositions can include 25% by weight to 55% by weight (*e.g.*, 30% by weight to 50% by weight) of a rosin ester described herein and 45% by weight to 75% by weight (*e.g.*, 50% by weight to 70% by weight) of an oil, such as mineral oil or polybutene oil.

Also provided are methods of making the rosin esters described herein. Methods of making rosin esters can comprise esterifying a rosin with an alcohol to form the rosin ester. The esterification reaction can comprise contacting the rosin with the alcohol in the presence of activated carbon. In some embodiments, the esterification reaction can comprise contacting the rosin with the alcohol in the presence of activated carbon, and in the absence of an additional esterification catalyst. As described in more detail below,

methods can further include hydrogenating the rosin ester to form a hydrogenated rosin ester.

Esterification can comprise contacting a rosin with a suitable alcohol and activated carbon, and allowing the rosin and the alcohol to react for a period of time and under
5 suitable conditions to form a rosin ester. Suitable reaction conditions for esterifying rosin are known in the art. *See*, for example, U.S. Patent No. 5,504,152 to Douglas *et al.*, which is hereby incorporated by reference in its entirety. Suitable reaction conditions can be selected in view of a number of factors, including the nature of the reactants (*e.g.*, the chemical and physical properties of the rosin, the identity of the alcohol, etc.) and the
10 desired chemical and physical properties of the resultant rosin ester. For example, rosin can be esterified by a thermal reaction of the rosin with an alcohol. Esterification can comprise contacting the rosin with the alcohol at an elevated temperature (*e.g.*, at a temperature from greater than greater than 30°C to 250°C). In some embodiments, the esterification reaction involves contacting molten rosin with an alcohol and activated carbon in the absence of an
15 additional esterification catalyst for a period of time suitable to form the rosin ester. In some cases, the esterification reaction involves contacting the rosin with an alcohol and activated carbon in the absence of an additional esterification for a period of time effective to provide a rosin ester having an acid number of 15 or less.

Any suitable rosin can be used in the esterification reaction. The rosin can be a tall
20 oil rosin, a gum rosin, a wood rosin, or a combinations thereof. In certain embodiments, the rosin comprises tall oil rosin. Rosins can be used as a feedstock for the formation of rosin esters as obtained from a commercial or natural source. Examples of commercially available rosins include tall oil rosins such as SYLVAROS® 90 and SYLVAROS® NCY, commercially available from Arizona Chemical. Alternatively, rosin can be subjected to
25 one or more purification steps (*e.g.*, distillation under reduced pressure, extraction, and/or crystallization) prior to its use as a feedstock for the formation of rosin esters.

Any suitable alcohol, include monoalcohols, diols, and other polyols, can be used in esterification reaction. Examples of suitable alcohols include glycerol, pentaerythritol, dipentaerythritol, ethylene glycol, diethylene glycol, triethylene glycol, sorbitol,
30 neopentylglycol, trimethylolpropane, methanol, ethanol, propanol, butanol, amyl alcohol, 2-ethyl hexanol, diglycerol, tripentaerythritol, C₈-C₁₁ branched or unbranched alkyl alcohols, and C₇-C₁₆ branched or unbranched arylalkylalcohols. In certain embodiments, the alcohol is a polyhydric alcohol selected from the group consisting of ethylene glycol, propylene glycol, diethylene glycol, triethylene glycol, tetraethylene glycol, trimethylene glycol,

glycerol, trimethylolpropane, trimethylolethane, pentaerythritol, mannitol, and combinations thereof. In some embodiments, more than one alcohol is used in esterification reaction. In certain embodiments, pentaerythritol and one or more additional alcohols selected from the group consisting of glycerol, dipentaerythritol, ethylene glycol, diethylene glycol, triethylene glycol, trimethylolpropane, and combinations thereof are used in esterification reaction.

The amount of alcohol employed in esterification reaction relative to the amount of rosin can be varied, depending on the nature of the alcohol and the desired chemical and physical properties of the resultant rosin ester. In some embodiments, the rosin is provided in excess so as to produce a resultant rosin ester having a low hydroxyl number. For example, the alcohol can be provided in an amount such that less than a molar equivalent of hydroxy groups is present in the reaction relative to the amount of rosin present. In other embodiments, the alcohol is provided in excess so as to produce a resultant rosin ester having a low acid number.

Any suitable activated carbon can be used as a catalyst in the esterification reaction. The activated carbon can accelerate the rate of rosin esterification relative to alternative esterification catalysts. The oxidative stability of rosin esters formed using activated carbon can also be higher than rosin esters obtained using alternative esterification catalysts. Activated carbon is a micro-crystalline, non-graphitic form of carbon which has been processed to develop a large internal surface area and pore volume. These characteristics, along with other variables including surface area and functional groups which render the surface chemically reactive, can be selected, as required, to influence the activated carbon's catalytic activity.

Suitable activated carbons can be produced from various carbonaceous raw materials using methods known in the art, each of which impart particular qualities to the resultant activated carbon. For example, activated carbons can be prepared from lignite, coal, bones, wood, peat, paper mill waste (lignin), and other carbonaceous materials such as nutshells. Activated carbons can be formed from carbonaceous raw materials using a variety of methods known in the art, including physical activation (*e.g.*, carbonization of the carbonaceous raw material followed by oxidation) and chemical activation. Suitable activated carbons are also commercially available, for example, under the trade name NORIT® from Cabot Norit Americas, Inc. A variety of forms of activated carbon can be used, including powdered activated carbon (PAC; a particulate form of activated carbon containing powders or fine granules of activated carbon less than 1.0 mm in size), granular

activated carbon (GAC), extruded activated carbon (EAC; powdered activated carbon fused with a binder and extruded into a variety of shapes), bead activated carbon (BAC), and activated carbon fibers. Suitable forms of activated carbon can be selected in view of their desired level of catalytic activity as well as process considerations (*e.g.*, ease of separation).

5 If desired, the activated carbon may be processed prior to being used as a catalyst (*e.g.*, washed with an acid

Activated carbon can be classified on the basis of its activity level, which can be expressed as total surface area per unit weight, in square meters per gram. In some embodiments, the activated carbon has a surface area of greater than 500 m²/g (*e.g.*, greater than 600 m²/g, greater than 700 m²/g, greater than 800 m²/g, greater than 900 m²/g, greater than 1000 m²/g, greater than 1100 m²/g, greater than 1200 m²/g, greater than 1300 m²/g, greater than 1400 m²/g, greater than 1500 m²/g, greater than 1600 m²/g, greater than 1700 m²/g, greater than 1800 m²/g, or greater than 1900 m²/g). In some embodiments, the activated carbon has a surface area of 2000 m²/g or less (*e.g.*, 1900 m²/g or less, 1850 m²/g or less, 1800 m²/g or less, 1750 m²/g or less, 1700 m²/g or less, 1650 m²/g or less, 1600 m²/g or less, 1550 m²/g or less, 1500 m²/g or less, 1450 m²/g or less, 1400 m²/g or less, 1350 m²/g or less, 1300 m²/g or less, 1250 m²/g or less, 1200 m²/g or less, 1150 m²/g or less, 1100 m²/g or less, 1050 m²/g or less, 1000 m²/g or less, 950 m²/g or less, 900 m²/g or less, 850 m²/g or less, 800 m²/g or less, 750 m²/g or less, 700 m²/g or less, 650 m²/g or less, 600 m²/g or less, or 550 m²/g or less).

The activated carbon can have a surface area ranging from any of the minimum values described above to any of the maximum values described above. For example, the activated carbon can have a surface area ranging from 500 m²/g to 2000 m²/g (*e.g.*, from 750 m²/g to 2000 m²/g, from 1000 m²/g to 2000 m²/g, from 1000 m²/g to 1750 m²/g, or from 1000 m²/g to 1500 m²/g).

Activated carbon can have varying porosity. The activated carbon can include micropores (pores having a diameter < 2 nm), mesopores (pores having a diameter of from 2 to 50 nm), macropores (pores having a diameter of > 50 nm), or combinations thereof. The porosity of activated carbons can be characterized in terms of volume of micropores, mesopores, macropores, or combinations thereof present in the activated carbon.

In some embodiments, the activated carbon comprises at least 0.05 mL/g of micropores (*e.g.*, at least 0.1 mL/g, at least 0.15 mL/g, at least 0.2 mL/g, at least 0.25 mL/g, at least 0.3 mL/g, or at least 0.35 mL/g). In some embodiments, the activated carbon comprises 0.4 mL/g of micropores or less (*e.g.*, 0.35 mL/g or less, 0.3 mL/g or less, 0.25

mL/g or less, 0.2 mL/g or less, 0.15 mL/g or less, or 0.1 mL/g or less). The activated carbon can comprise a volume of micropores ranging from any of the minimum values above to any of the maximum values described above. For example, the activated carbon can comprise a volume of micropores ranging from 0.05 mL/g to 0.4 mL/g (*e.g.*, from 0.1 mL/g to 0.3 mL/g).

In some embodiments, the activated carbon comprises at least 0.1 mL/g of mesopores (*e.g.*, at least 0.15 mL/g, at least 0.2 mL/g, at least 0.25 mL/g, at least 0.3 mL/g, at least 0.35 mL/g, at least 0.4 mL/g, at least 0.45 mL/g, at least 0.5 mL/g, at least 0.55 mL/g, at least 0.6 mL/g, at least 0.65 mL/g, at least 0.7 mL/g, at least 0.75 mL/g, at least 0.8 mL/g, at least 0.85 mL/g, at least 0.9 mL/g, at least 0.95 mL/g, at least 1.0 mL/g, at least 1.05 mL/g, at least 1.10 mL/g, at least 1.15 mL/g, or at least 1.20 mL/g). In some embodiments, the activated carbon comprises 1.25 mL/g of mesopores or less (*e.g.*, 1.20 mL/g or less, 1.15 mL/g or less, 1.10 mL/g or less, 1.05 mL/g or less, 1.0 mL/g or less, 0.95 mL/g or less, 0.9 mL/g or less, 0.85 mL/g or less, 0.8 mL/g or less, 0.75 mL/g or less, 0.7 mL/g or less, 0.65 mL/g or less, 0.6 mL/g or less, 0.55 mL/g or less, 0.5 mL/g or less, 0.45 mL/g or less, 0.4 mL/g or less, 0.35 mL/g or less, 0.3 mL/g or less, 0.25 mL/g or less, 0.2 mL/g or less, or 0.15 mL/g or less). The activated carbon can comprise a volume of mesopores ranging from any of the minimum values above to any of the maximum values described above. For example, the activated carbon can comprise a volume of mesopores ranging from 0.1 mL/g to 1.25 mL/g (*e.g.*, 0.2 mL/g to 1.25 mL/g, 0.75 mL/g to 1.25 mL/g, from 0.1 mL/g to 1.0 mL/g, or from 0.2 mL/g to 0.9 mL/g).

In some embodiments, the activated carbon comprises at least 0.1 mL/g of macropores (*e.g.*, at least 0.15 mL/g, at least 0.2 mL/g, at least 0.25 mL/g, at least 0.3 mL/g, at least 0.35 mL/g, at least 0.4 mL/g, at least 0.45 mL/g, at least 0.5 mL/g, at least 0.55 mL/g, at least 0.6 mL/g, or at least 0.65 mL/g). In some embodiments, the activated carbon comprises 0.7 mL/g of macropores or less (*e.g.*, 0.65 mL/g or less, 0.6 mL/g or less, 0.55 mL/g or less, 0.5 mL/g or less, 0.45 mL/g or less, 0.4 mL/g or less, 0.35 mL/g or less, 0.3 mL/g or less, 0.25 mL/g or less, 0.2 mL/g or less, or 0.15 mL/g or less). The activated carbon can comprise a volume of macropores ranging from any of the minimum values above to any of the maximum values described above. For example, the activated carbon can comprise a volume of macropores ranging from 0.1 mL/g to 0.7 mL/g (*e.g.*, from 0.2 mL/g to 0.6 mL/g, or from 0.25 mL/g to 0.55 mL/g).

In some embodiments, the activated carbon comprises a greater volume of micropores than volume of mesopores or volume of macropores. In other embodiments, the

activated carbon comprises a greater volume of mesopores than volume of micropores or volume of macropores. In other embodiments, the activated carbon comprises a greater volume of macropores than volume of micropores or volume of mesopores.

In some cases, the ratio of the volume of micropores in the activated carbon to the volume of mesopores in the activated carbon ranges from 1:7.5 to 2:1. For example, the ratio of the volume of micropores in the activated carbon to the volume of mesopores in the activated carbon can be 1:5, 1:3.6, 1:2, or 1.5:1. In some cases, the ratio of the volume of mesopores in the activated carbon to the volume of macropores in the activated carbon ranges from 1:2 to 1:0.25. For example, the ratio of the volume of mesopores in the activated carbon to the volume of macropores in the activated carbon can be 1:1.25, 1:0.6, or 1:1. In some cases, the ratio of the volume of micropores in the activated carbon to the volume of macropores in the activated carbon ranges from 1:5 to 1:0.7. For example, the ratio of the volume of micropores in the activated carbon to the volume of mesopores in the activated carbon can be 1:3, 1:2.2, 1:2, or 1:0.83.

The ratio of the volume of micropores in the activated carbon to the volume of mesopores in the activated carbon to the volume of macropores in the activated carbon can be 1.5:1:1.25. In one embodiment, the activated carbon comprises steam activated bituminous coal activated carbon having volume of 0.3 mL/g of micropores, 0.2 mL/g of mesopores, and 0.25 mL/g of macropores.

The ratio of the volume of micropores in the activated carbon to the volume of mesopores in the activated carbon to the volume of macropores in the activated carbon can be 1:5:3. In one embodiment, the activated carbon comprises steam activated lignite coal activated carbon having volume of 0.1 mL/g of micropores, 0.5 mL/g of mesopores, and 0.3 mL/g of macropores.

The ratio of the volume of micropores in the activated carbon to the volume of mesopores in the activated carbon to the volume of macropores in the activated carbon can be 1:2:2. In one embodiment, the activated carbon comprises steam activated peat activated carbon having volume of 0.2 mL/g of micropores, 0.4 mL/g of mesopores, and 0.4 mL/g of macropores.

The ratio of the volume of micropores in the activated carbon to the volume of mesopores in the activated carbon to the volume of macropores in the activated carbon can be 1:3.6:2.2. In one embodiment, the activated carbon comprises steam activated wood activated carbon having volume of 0.25 mL/g of micropores, 0.9 mL/g of mesopores, and 0.55 mL/g of macropores.

The ability of activated carbons to adsorb small and medium sized molecules can be quantitatively evaluated by measuring the methylene blue adsorption level of the activated carbon. In some embodiments, the activated carbon has a methylene blue absorption, measured in g/100 g, of at least 20 g/100 g (*e.g.*, at least 21 g/100 g, at least 22 g/100 g, at least 23 g/100 g, at least 24 g/100 g, at least 25 g/100 g, at least 26 g/100 g, or at least 27 g/100 g). In some embodiments, the activated carbon has a methylene blue absorption of 28 g/100 g or less (*e.g.*, 27 g/100 g or less, 26 g/100 g or less, 25 g/100 g or less, 24 g/100 g or less, 23 g/100 g or less, 22 g/100 g or less, or 21 g/100 g or less).

The activated carbon can have a methylene blue absorption ranging from any of the minimum values described above to any of the maximum values described above. For example, the activated carbon can have a methylene blue absorption ranging from 20 g/100 g to 28 g/100 g (*e.g.*, from 20 g/100 g to 25 g/100 g).

Activated carbons can exhibit varying surface chemistries. As a result of the manufacturing processes used to activate them, activated carbons can be alkaline, neutral, or acidic. In some embodiments, the activated carbon used as a catalyst in the esterification reaction is an acidic (*i.e.*, the pH of a water extract of the activated carbon, as measured using the method described in ASTM D3838-05, is less than 7). In some embodiments, pH of a water extract of the activated carbon used as a catalyst in the esterification reaction, as measured using the method described in ASTM D3838-05, is 8.0 or less (*e.g.*, 7.5 or less, 7.0 or less, 6.5 or less, 6.0 or less, 5.5 or less, 5.0 or less, 4.5 or less, 4.0 or less, 3.5 or less, 3.0 or less, 2.5 or less, or 2.0 or less). In some embodiments, pH of a water extract of the activated carbon used as a catalyst in the esterification reaction, as measured using the method described in ASTM D3838-05, is at least 1.5 (*e.g.*, at least 2.0, at least 2.5, at least 3.0, at least 3.5, at least 4.0, at least 4.5, at least 5.0, at least 5.5, at least 6.0, at least 6.5, at least 7.0, or at least 7.5).

The activated carbon catalyst can be incorporated in the esterification reaction in varying amounts, with the amount of activated carbon being selected in view of a number of factors, including the nature of the reactants (*e.g.*, the chemical and physical properties of the rosin, the identity of the alcohol, etc.), the reaction conditions, and the desired chemical and physical properties of the resultant rosin ester. In some embodiments, the activated carbon is present in the esterification reaction in an amount ranging from 0.01% to 15% by weight, based on the weight of the rosin (*e.g.*, from 1% to 15% by weight, or from 5% to 15% by weight).

As is known in the art, catalysts, solvents, bleaching agents, stabilizers, and/or antioxidants can be added in esterification reaction. Suitable catalysts, solvents, bleaching agents, stabilizers, and antioxidants are known in the art, and described, for example, in U.S. Patent Nos. 2,729,660, 3,310,575, 3,423,389, 3,780,013, 4,172,070, 4,548,746,
5 4,690,783, 4,693,847, 4,725,384, 4,744,925, 4,788,009, 5,021,548, and 5,049,652. In order to drive the esterification reaction to completion, water can be removed from the reactor using standard methods, such as distillation and/or application of a vacuum.

In some embodiments, the esterification reaction involves contacting the rosin with the alcohol in the presence of activated carbon and an additional esterification catalyst.
10 Suitable esterification catalysts are known in the art, and include Lewis and Brønsted–Lowry acids. Examples of suitable esterification catalysts include acidic catalysts such as acetic acid, *p*-toluenesulfonic acid, and sulfuric acid; alkaline metal hydroxides such as calcium hydroxide; metal oxides, such as calcium oxide, magnesium oxide, and aluminum oxide; and other metal salts, such as iron chloride, calcium formate, and calcium
15 phosphonates (*e.g.*, calcium bis-monoethyl(3,5-di-*tert*-butyl-4-hydroxybenzyl) phosphonate, Irganox® 1425). In certain embodiments, the esterification reaction can comprise contacting the rosin with the alcohol in the presence of activated carbon in the absence of an additional esterification catalyst.

In some embodiments, the rosin ester is a hydrogenated rosin ester. Methods of
20 making hydrogenated rosin esters can comprise (a) esterifying a rosin with an alcohol to provide a rosin ester, and (b) hydrogenating the rosin ester to form hydrogenated rosin ester. The esterification reaction can comprise contacting the rosin with the alcohol in the presence of activated carbon, as described above. In some embodiments, the esterification reaction can comprise contacting the rosin with the alcohol in the presence of activated
25 carbon, and in the absence of an additional esterification catalyst. In certain embodiments, both the esterifying step (a) and hydrogenating step (b) are conducted in the presence of activated carbon, with esterifying step (a) optionally being performed in the absence of an additional esterification catalyst.

The hydrogenation reaction can comprise contacting the rosin ester with a
30 hydrogenation catalyst for a period of time and under suitable conditions to form a hydrogenated rosin ester. Methods of hydrogenating rosin esters are known in the art. Hydrogenation reactions can be carried out using a hydrogenation catalyst, such as a heterogeneous hydrogenation catalyst (*e.g.*, a palladium catalyst, such as Pd supported on carbon (Pd/C), a platinum catalyst, such as PtO₂, a nickel catalyst, such as Raney Nickel

(Ra-Ni), a rhodium catalyst, or a ruthenium catalyst). In some cases, the hydrogenation catalyst can be present in an amount ranging from 0.25% to 5% by weight, based on the total weight of the crude rosin ester. The hydrogen source for the hydrogenation can be hydrogen (H₂) or a compound which can generate hydrogen under reaction conditions, such as formic acid, isopropanol, cyclohexene, cyclohexadiene, a diimide, or hydrazine.

The hydrogenation reaction can be performed at an elevated temperature, an elevated pressure, or combinations thereof. For example, the hydrogenation reaction can be performed at a temperature ranging from 150°C to 300°C (*e.g.*, from 180°C to 280°C, from 180°C to 240°C, from 200°C to 280°C, or from 220°C to 260°C). The hydrogenation reaction can be performed at a pressure ranging from 250 to 2000 psi (*e.g.*, from 250 to 1450 psi, from 250 to 650 psi, or from 350 to 550 psi).

Optionally a solvent can be present in the esterification reaction, in the hydrogenation reaction, or combinations thereof. In certain embodiments, the rosin esterified in the esterification reaction and/or the rosin ester hydrogenated in the hydrogenation reaction comprise less than 25% by weight solvent. In some embodiments, the concentration of esterified rosin acids in the rosin ester hydrogenated in the hydrogenation reaction is 75% or more by weight, based on the total weight of the rosin ester. In some embodiments, the rosin ester hydrogenated in the hydrogenation reaction is substantially free of solvent (*e.g.*, the rosin ester comprises less than 1% by weight solvent, based on the total weight of the rosin ester). In certain embodiments, the rosin ester hydrogenated in the hydrogenation reaction has a viscosity of 1,000 cP or less at 25°C.

In some embodiments, the rosin ester obtained from the esterification reaction is hydrogenated in the hydrogenation reaction without an intervening distillation step. In certain embodiments, the rosin ester obtained from the esterification reaction is hydrogenated in the hydrogenation reaction without any intervening purification step. For example, the rosin ester obtained from the esterification reaction can be directly hydrogenated.

In some cases, methods of making the rosin esters described herein include a single hydrogenation step. In some embodiments, methods of making the rosin esters described herein consist essentially of an esterification reaction and a hydrogenation reaction. In such cases, the methods involve no additional processing steps which influence the weight ratio of esterified dehydroabiatic acid to esterified dihydroabiatic acid in the rosin ester, such as dehydrogenation, hydrogenation of the rosin prior to esterification, disproportionation and distillation of the rosin prior to esterification, or combinations thereof. In certain

embodiments, methods of making the rosin esters described herein consist of an esterification reaction and a hydrogenation reaction performed consecutively.

To obtain a rosin ester having the desired chemical and physical properties for particular applications, methods of making the rosin esters described herein can optionally further include one or more additional processing steps in addition to the esterification reaction and optionally the hydrogenation reaction. In some embodiments, the rosin to be esterified in the esterification reaction, the rosin ester obtained from the esterification reaction, and/or the hydrogenated rosin ester obtained from the hydrogenation reaction can be further processed, for example, to decrease the PAN number of the rosin, the rosin ester, and/or the hydrogenated rosin ester; to influence the weight ratio of various rosin acids and/or rosin acid esters present in the rosin, the rosin ester, and/or the hydrogenated rosin ester; to influence the hydroxyl number of the resultant rosin ester and/or the hydrogenated rosin ester; to influence the acid number of the resultant rosin ester and/or the hydrogenated rosin ester; or combinations thereof. Suitable additional processing steps are known in the art, and can include additional hydrogenation steps, dehydrogenation, disproportionation, dimerization, and fortification. In certain embodiments, rosin is processed using one or more of these methods prior to the esterification reaction to improve the chemical and physical properties of the resultant rosin esters. Where chemically permissible, such methods can also be performed in combination with the esterification reaction, following the esterification reaction but prior to the hydrogenation reaction, following the hydrogenation reaction, or combinations thereof to obtain a rosin ester and/or a hydrogenated rosin ester having the desired chemical and physical properties, as discussed in more detail below.

In certain embodiments, the methods of making rosin esters can further comprise disproportionating the rosin prior to the esterification reaction. Rosin disproportionation converts abietadienoic acid moieties into dehydroabietic acid and dihydroabietic acid moieties. Methods of disproportionation are known in the art, and can involve heating rosin, often in the presence of one or more disproportionation agents. Suitable methods for disproportionating rosin are described in, for example, U.S. Patent Nos. 3,423,389, 4,302,371, and 4,657,703, all of which are incorporated herein by reference.

A variety of suitable disproportionation agents can be used. Examples of suitable disproportionation agents include thiobisnaphthols, including 2,2'-thiobisphenols, 3,3'-thiobisphenols, 4,4'-thiobis(resorcinol) and t,t'-thiobis(pyrogallol), 4,4'-15 thiobis(6-t-butyl-m-cresol) and 4/4'-thiobis(6-t-butyl-o-cresol) thiobisnaphthols, 2,2'-thio-bisphenols, 3,3'-

thio-bis phenols; metals, including palladium, nickel, and platinum; iodine or iodides (*e.g.*, iron iodide); sulfides (*e.g.*, iron sulfide); and combinations thereof. In certain embodiments, the rosin is disproportionate using a phenol sulfide type disproportionation agent. Examples of suitable phenol sulfide type disproportionation agents include poly-*t*-butylphenol disulfide (commercially available under the trade name ROSINOX® from Arkema, Inc.), 4,4'-thiobis(2-*t*-butyl-5-methylphenol (commercially available under the trade name LOWINOX® TBM-6 from Chemtura), nonylphenol disulfide oligomers (such as those commercially available under the trade name ETHANOX® TM323 from Albemarle Corp.), and amylphenol disulfide polymer (such as those commercially available under the trade name VULTAC® 2 from Sovereign Chemical Co.).

In certain embodiments, the rosin is disproportionated prior to the esterification reaction. In these embodiments, a disproportionated rosin or partly disproportionated rosin can be used as a feedstock for the esterification reaction. In some cases, disproportionation or further disproportionation can be conducted during the esterification reaction. For example, disproportionated or partly disproportionated rosin can be generated *in situ* and esterified thereafter in a one-pot synthesis procedure to a rosin ester.

Optionally, the rosin, rosin ester, and/or hydrogenated rosin ester can be fortified to improve the chemical and physical properties of the resultant rosin esters. In some embodiments, rosin is fortified prior to the esterification reaction to improve the chemical and physical properties of the resultant rosin esters. Fortification of rosin involves the chemical modification of the conjugated double bond system of rosin acids in the rosin, so as to provide a rosin having a lower PAN number and higher molecular weight than the rosin prior to fortification. A number of suitable chemical modifications and related chemical methods are known in the art. For example, rosins can be fortified by means of a Diels-Alder or Ene addition reaction of a rosin acid with a dienophile, such as an α,β -unsaturated organic acid or the anhydride of such an acid. Examples of suitable dienophiles include maleic acid, fumaric acid, acrylic acid, esters derived from these acids, and maleic anhydride.

Optionally, methods can include one or more process steps to influence the hydroxyl number of the resultant rosin ester, to influence the acid number of the resultant rosin ester; or combinations thereof. If desired, rosin esters can be chemically modified following esterification (*e.g.*, following the esterification reaction but prior to any hydrogenation reaction, or following the hydrogenation reaction) to provide a rosin ester having a low hydroxyl number. This process can involve chemical modification of residual hydroxyl

moieties in the rosin ester or hydrogenated rosin ester following esterification using synthetic methods known in the art. For example, the rosin ester or hydrogenated rosin ester can be reacted with an acylating agent (*e.g.*, a carboxylic acid or a derivative thereof, such as an acid anhydride). *See*, for example, U.S. Patent No. 4,380,513 to Ruckel.

5 Residual hydroxyl moieties in the rosin ester or hydrogenated rosin ester can also be reacted with an electrophilic reagent, such as an isocyanate, to produce the corresponding carbamate derivative. *See*, for example, U.S. Patent No. 4,377,510 to Ruckel. Other suitable electrophilic reagents which can be used to react residual hydroxyl moieties include alkylating agents (*e.g.*, methylating agents such as dimethylsulphate). If desired, following
10 esterification (*e.g.*, following the esterification reaction but prior to any hydrogenation reaction, or following the hydrogenation reaction), unreacted rosin as well as other volatile components, can be removed from the rosin ester or hydrogenated rosin ester, for example, by steam sparging, sparging by an inert gas such as nitrogen gas, wiped film evaporation, short path evaporation, and vacuum distillation. By stripping excess rosin (*i.e.*, rosin acids)
15 from the rosin ester or hydrogenated rosin ester, the acid number of the resultant rosin ester can be reduced.

Also provided are methods for preparing polymer compositions, including hot-melt adhesives. Methods for preparing polymer compositions can include mixing a polymer derived from vinyl acetate and a rosin ester as described herein (*e.g.*, a rosin ester
20 comprising at least 70% by weight of an esterified dehydroabiatic acid and an esterified dihydroabiatic acid, wherein when 1000 ppm or less of an antioxidant is present in combination with the rosin ester, the rosin ester exhibits an oxidative-induction time at 130°C of at least 75 minutes, as measured using the methods specified in ASTM D5483-05(2010)). Methods can further include adding one or more additional components to the
25 composition, such as an additional tackifier, a wax, a stabilizer (*e.g.*, an antioxidant UV stabilizer), a plasticizer (*e.g.*, benzoates, phthalates), paraffin oil, a nucleating agent, an optical brightener, a pigment, a dye, glitter, a biocide, a flame retardant, an anti-static agent, an anti-slip agent, an anti-blocking agent, a lubricants, a filler, or a combination thereof. Methods can further include preparing a rosin ester using the methods described herein.

30 An exemplary road marking formulation may be prepared by: (a) charging a standard mixer with 16 parts rosin ester, 2.8 parts oil (*e.g.*, a mineral oil, such as mineral oil; obtained from Statoil), 1 part wax (*e.g.*, polyethylene wax, such as AC6 PE-wax obtained from Honeywell), 1 part of a polymer derived from vinyl acetate (*e.g.*, poly(ethylene-*co*-vinyl acetate) such as Elvax 22W obtained from DuPont), 0.2 parts fatty acid (*e.g.*, stearic

acid), 5.3 parts pigment (*e.g.*, titanium dioxide, such as titanium dioxide obtained from Kronos), 42.4 parts filler (*e.g.*, calcium carbonate), and 37.1 parts reflective filler (*e.g.*, glass beads, such as glass beads obtained from Swarco); and (b) heating (*e.g.*, at 180°C) and blending at low speed to avoid introducing air bubbles into the melt.

5 By way of non-limiting illustration, examples of certain embodiments of the present disclosure are included below.

EXAMPLES

General Methods

10 All materials were characterized using the following methods unless otherwise stated. Hydroxyl numbers were determined according to a modified method (different solvent tetrahydrofuran was applied) of DIN 53240-2 entitled "Determination of Hydroxyl Value – Part 2: Method with Catalyst," which is incorporated herein by reference in its entirety. The rosin ester (dissolved in tetrahydrofuran) was reacted with acetic anhydride in the presence of 4-dimethylaminopyridine (DMAP). Residual acetic anhydride was
15 hydrolyzed and the resulting mixture titrated with an alcoholic solution of potassium hydroxide (0.5 M). The hydroxyl number is expressed as mg KOH per gram rosin ester sample. Acid numbers were determined according to method described in ASTM D465-05 (2010) entitled "Standard Test Methods for Acid Number of Naval Stores Products Including Tall Oil and Other Related Products," which is incorporated herein by reference
20 in its entirety. The acid number is expressed as mg KOH per gram rosin ester sample. Softening points were determined according to method described in ASTM E28-99 (2009) entitled "Standard Test Methods for Softening Point of Resins Derived from Naval Stores by Ring-and-Ball Apparatus," which is incorporated herein by reference in its entirety. The Gardner color of all materials was measured according to the Gardner Color scale as
25 specified in ASTM D1544-04 (2010) entitled "Standard Test Method for Color of Transparent Liquids (Gardner Color Scale)," which is incorporated herein by reference in its entirety. Gardner colors were measured using a Dr Lange LICO® 200 colorimeter. Unless otherwise indicated, all Gardner colors were measured using neat samples. Oxidative-induction time was measured according to the standard methods specified in ASTM D5483-
30 05(2010) entitled "Standard Test Method for Oxidation Induction Time of Lubricating Greases by Pressure Differential Scanning Calorimetry," which is incorporated herein by reference in its entirety. Unless otherwise specified, the oxidative-induction time was measured at 130°C using 550 psi of oxygen. Sulfur content was measured according to the standard methods described in ASTM D5453-05 entitled "Standard Test Method for

Determination of Total Sulfur in Light Hydrocarbons, Motor Fuels and Oils by Ultraviolet Fluorescence,” which is incorporated herein by reference in its entirety. Sulfur content was measured using an ANTEK® 9000 sulfur analyzer.

The isomeric composition of the rosin esters, including the PAN number and the ratio of esterified dehydroabietic acid to esterified dihydroabietic acid, was determined according to the methods described in ASTM D5974-00 (2010) entitled “Standard Test Methods for Fatty and Rosin Acids in Tall Oil Fractionation Products by Capillary Gas Chromatography,” which is incorporated herein by reference in its entirety. Specifically, a rosin ester sample (1.00 g) and 10 mL 2N potassium hydroxide (KOH) in ethanol were added to a high pressure microwave reaction vessel. The reaction vessel was sealed and placed into the rotor of a Perkin Elmer MULTIWAVE® 3000 Microwave System. The sample was saponified in the microwave for 30 minutes at 150°C. Upon completion of the microwave-assisted saponification, the reaction mixture was transferred to a separatory funnel, and dilute hydrochloric acid was added to reduce the pH value to less than 4. This converted the rosin soaps in the reaction mixture to rosin acids. The resulting rosin acids were isolated by way of ethyl ether extraction. Upon removal of the ether solvent, the rosin acids were derivatized and analyzed using a gas chromatograph according to ASTM D5974-00 (2010).

Preparation of Hydrogenated Rosin Esters

1000 g of tall oil rosin (SYLVAROS® NCY, commercially available from Arizona Chemical) with a Gardner color (neat) of 10.1, an acid number of 164, and a softening point of 64.1 was charged into a four-necked flask (2 L) and heated to 200°C under a nitrogen atmosphere. After the rosin was completely melted, the rosin was agitated, and pentaerythritol (115 g), calcium-bis(((3,5-bis(1,1-dimethylethyl)-4-hydroxyphenyl)methyl)-ethylphosphonate) (3.4 g), and NORIT® CA1 (100 g; powdered activated carbon having a pH of 2.0 to 3.5, a surface area of 1400 m²/g, and a methylene blue absorption of at least 25 g/100g; 10 % by weight based on the weight of rosin added to the reaction, commercially available from Cabot Norit Americas, Inc.) were added. The reaction mixture was heated to 275°C (heating rate of 30°C/hour) and left at this temperature for 9 hours. The reaction mixture was then sparged with steam to remove residual rosin acids. The rosin ester was then discharged, and analyzed to have a Gardner color (neat) of 9, an acid number of 13.6, a softening point of 83.1°C, and an oxidative-induction time of 37 minutes.

The rosin ester was then hydrogenated. The rosin ester was then subjected to either full or partial hydrogenation. For full hydrogenation, 300 g of rosin ester was charged into

a flask, and heated to 180°C under a nitrogen atmosphere. 13.6 g of 5% Pd/C (1.5% catalyst on a dry weight basis) was charged to flask, at which point the flask was sparged with nitrogen to remove moisture. The reaction mixture was charged into a Parr reactor, and heated to 245°C under a nitrogen atmosphere. Once at temperature, reactor was pressurized with 450 psi hydrogen gas. Pressure was maintained until hydrogenation was complete. The reaction was considered complete when the addition of hydrogen gas was not necessary to maintain a pressure 450 psi in the Parr reactor. The Parr reactor was then cooled to 190°C, and the rosin ester was discharged. Partial hydrogenation was performed using the procedure described above for full hydrogenation; however, the reaction time was reduced to approximately half of the reaction time determined necessary for full hydrogenation.

The hydrogenated rosin ester subjected to partial hydrogenation exhibited a Gardner color (neat) of 5.3, an acid number of 12.4, a softening point of 83.7°C, and an oxidative-induction time of >180 minutes. The hydrogenated rosin ester subjected to full hydrogenation exhibited a Gardner color (neat) of 5.1, an acid number of 13.1, a softening point of 85.3°C, and an oxidative-induction time of >180 minutes. The isomeric composition of the tall oil rosin, the rosin ester, the hydrogenated rosin ester subjected to partial hydrogenation, and the hydrogenated rosin ester subjected to full hydrogenation are included in Table 1.

Table 1

		Rosin	Rosin Ester	Hydrogenated Rosin Ester	Hydrogenated Rosin Ester
	HYROGENATION	-	NONE	PARTIAL	FULL
Physical Properties	Gardner Color (neat)	10.1	9	5.3	5.1
	Acid Number	164	13.6	12.4	13.1
	Softening Point (°C)	64.1	83.1	83.7	85.3
	Oxidative-Induction Time (@130°C, time of exotherm onset in minutes)		37	>180	>180
Isomeric Composition (weight percent)	Abietic Types	38.4	3.8	0	0
	Pimaric Types	11.5	8.9	0.0	0.0
	Dehydroabietic	16.0	35.3	37.8	36.5
	Dihydroabietic	3.1	16.3	36.7	37.1
	Other abietics	8.6	2.4	1.0	1.0
	Secodehydroabietic Acids	0.0	3.1	0.0	0.0
	Polyunsaturated rosin acids	0.0	3.1	2.7	2.5
	Unidentified rosin isomers	5.6	3.4	1.6	1.6
	Fatty acids, neutrals, rosin peaks	1.0	5.8	5.4	5.1
	Non Eluting	11.1	17.8	14.8	16.2

For purposes of comparison, SYLVAROS® NCY tall oil rosin was esterified using the procedure described above, except that no activated carbon was added during the esterification reaction. The resulting rosin ester was analyzed to have a Gardner color (neat) of 7.7, an acid number of 11.2, a softening point of 102.9°C, and an oxidative-induction time of 2.8 minutes. This rosin ester was then fully hydrogenated with a palladium catalyst using the procedure described above. The resulting hydrogenated rosin ester was analyzed to have a Gardner color (neat) of 4.8, an acid number of 11.2, a softening point of 101.7°C, and an oxidative-induction time of 46.1 minutes. The isomeric composition of the tall oil rosin, the rosin ester prepared without the use of activated carbon, and the hydrogenated rosin ester prepared without the use of activated carbon are included in Table 2. As shown by comparing the results in Table 1 and Table 2, esterification performed using activated carbon yields rosin esters having improved oxidative stability.

Table 2

		Rosin	Rosin Ester (no AC)	Hydrogenated Rosin Ester (no AC)
	HYDROGENATION CATALYST			Pd/C
Physical Properties	Gardner Color (neat)	10.1	7.7	4.8
	Acid Number	164	11.2	11.2
	Softening Point (°C)	64.1	102.9	101.7
	Oxidative-Induction Time (@130°C, time of exotherm onset in minutes)		2.8	46.1
Isomeric Composition (weight percent)	Abietic Types	38.4	23.85	0.3
	Pimaric Types	11.5	12.83	0.0
	Dehydroabietic	16.0	27.10	32.2
	Dihydroabietic	3.1	7.27	50.3
	Other abietics	8.6	9.02	1.0
	Secodehydroabietic Acids	0.0	1.62	0.3
	Polyunsaturated rosin acids	0.0	1.94	0.9
	Unidentified rosin isomers	5.6	2.87	0.4
	Fatty acids, neutrals, rosin peaks	1.0	3.61	3.2
	Non Eluting	11.1	9.87	11.4

Variation of Activated Carbon Catalyst and Catalyst Loading

5 The procedure described above was repeated using the full hydrogenation conditions, except that two different activated carbon catalysts (NORIT® CA1, powdered activated carbon having a pH of 2.0 to 3.5, a surface area of 1400 m²/g, and a methylene blue absorption of at least 25 g/100g, commercially available from Cabot Norit Americas, Inc.; and DARCO® 60, powdered activated carbon having a pH of 6 and a methylene blue
10 absorption of at least 15 g/100g, commercially available from Cabot Norit Americas, Inc.) at two different catalyst loadings (5% and 10% by weight based on the weight of rosin added to the reaction).

The results obtained using a 10% loading of NORIT® CA1 and DARCO® 60 are presented in Table 3. The rosin ester obtained using a 10% loading of NORIT® CA1
15 exhibited a Gardner color (neat) of 8.8, an acid number of 14.7, a softening point of 85.1°C, and an oxidative-induction time of 35.5 minutes. The hydrogenated rosin ester obtained

using a 10% loading of NORIT® CA1 exhibited a Gardner color (neat) of 6.1, an acid number of 13.8, a softening point of 84.3°C, and an oxidative-induction time of >180 minutes. The rosin ester obtained using a 10% loading of DARCO® 60 exhibited a Gardner color (neat) of 5.6, an acid number of 14.1, a softening point of 81.4°C, and an oxidative-induction time of 9.4 minutes. The hydrogenated rosin ester obtained using a 10% loading of DARCO® 60 exhibited a Gardner color (neat) of 4.1, an acid number of 12.9, a softening point of 84.1°C, and an oxidative-induction time of 79.5 minutes. The thermal color stability of these samples was also evaluated. All samples obtained using a 10% loading of NORIT® CA1 and DARCO® 60 exhibited less than a 5% change in neat Gardner color when heated to a temperature of 160°C for a period of three hours.

The results obtained using a 5% loading of NORIT® CA1 and DARCO® 60 are presented in Table 4. The rosin ester obtained using a 5% loading of NORIT® CA1 exhibited a Gardner color (neat) of 9.4, an acid number of 14.4, a softening point of 89.5°C, and an oxidative-induction time of 20.9 minutes. The hydrogenated rosin ester obtained using a 5% loading of NORIT® CA1 exhibited a Gardner color (neat) of 6.8, an acid number of 12.8, a softening point of 81.7°C, and an oxidative-induction time of >180 minutes. The rosin ester obtained using a 5% loading of DARCO® 60 exhibited a Gardner color (neat) of 6.6, an acid number of 10.6, a softening point of 95.0°C, and an oxidative-induction time of 7.2 minutes. The hydrogenated rosin ester obtained using a 5% loading of DARCO® 60 exhibited a Gardner color (neat) of 5, an acid number of 10.5, and an oxidative-induction time of 130.7 minutes.

Table 3

		Rosin	Rosin Ester	Hydrogenated Rosin Ester	Rosin Ester	Hydrogenated Rosin Ester
	CATALYST		10% NORIT® CA1	10% NORIT® CA1	10% DARCO® 60	10% DARCO® 60
Physical Properties	Gardner Color (neat)	10.1	8.8	6.1	5.6	4.1
	Acid Number	164	14.7	13.8	14.1	12.9
	Softening Point (°C)	64.1	85.1	84.3	81.4	84.1
	Oxidative-Induction Time (@130°C, time of exotherm onset in minutes)		35.5	>180	9.4	79.5
Color Stability [†]	0 minutes		8.2	5.9	5.6	3.2
	30 minutes		8.2	5.9	5.7	3.2
	60 minutes		8.2	6	5.8	3.4
	120 minutes		8	6.1	5.7	3.3
	180 minutes		7.9	6.1	5.7	3.2
Isomeric Composition (weight percent)	Abietic Types	38.4	3.8	0.1	11.0	0.1
	Pimaric Types	11.5	8.8	0.0	11.1	0.0
	Dehydroabietic	16.0	34.1	38.9	31.1	35.6
	Dihydroabietic	3.1	16.9	34.4	14.7	39.4
	Other abietics	8.6	2.8	2.0	4.3	1.1
	Secodehydroabietic Acids	0.0	3.4	0.0	2.5	0.0
	Polyunsaturated rosin acids	4.7	3.2	1.9	2.5	1.1
	Unidentified rosin isomers	5.6	3.7	3.2	3.9	3.4
	Fatty acids, neutrals, rosin peaks	1.0	7.2	8.1	4.0	4.8
	Non Eluting	11.1	16.1	11.4	15.0	14.5
[†] Gardner Color (neat) measured following sample incubation at 160°C for various time intervals (0 minutes-180 minutes).						

Table 4

		Rosin	Rosin Ester	Hydrogenated Rosin Ester	Rosin Ester	Hydrogenated Rosin Ester
	CATALYST		5% NORIT® CA1	5% NORIT® CA1	5% DARCO® 60	5% DARCO® 60
Physical Properties	Gardner Color (neat)	10.1	9.4	6.8	6.6	5
	Acid Number	164	14.4	12.8	10.6	10.5
	Softening Point (°C)	64.1	89.5	81.7	95	N/A
	Oxidative-Induction Time (@130°C, time of exotherm onset in minutes)		20.9	>180	7.2	130.7
Isomeric Composition (weight percent)	Abietic Types	38.4	7.1	0.1	17.6	0.1
	Pimaric Types	11.5	11.2	0.0	13.1	0.0
	Dehydroabietic	16.0	31.5	35.9	30.2	34.8
	Dihydroabietic	3.1	12.7	36.2	10.5	43.4
	Other abietics	8.6	4.2	1.6	6.6	0.6
	Secodehydroabietic Acids	0.0	1.4	0.0	1.4	0.0
	Polyunsaturated resin acids	4.7	3.0	1.6	2.4	1.0
	Unidentified rosin isomers	5.6	4.4	2.8	4.7	3.5
	Fatty acids, neutrals, rosin peaks	1.0	5.9	5.4	3.6	2.8
	Non Eluting	11.1	18.7	16.3	9.8	13.8

5 The compositions and methods of the appended claims are not limited in scope by the specific compositions and methods described herein, which are intended as illustrations of a few aspects of the claims. Any compositions and methods that are functionally equivalent are intended to fall within the scope of the claims. Various modifications of the compositions and methods in addition to those shown and described herein are intended to

10 fall within the scope of the appended claims. Further, while only certain representative compositions and method steps disclosed herein are specifically described, other combinations of the compositions and method steps also are intended to fall within the scope of the appended claims, even if not specifically recited. Thus, a combination of steps,

elements, components, or constituents may be explicitly mentioned herein or less, however, other combinations of steps, elements, components, and constituents are included, even though not explicitly stated.

5 The term “comprising” and variations thereof as used herein is used synonymously with the term “including” and variations thereof and are open, non-limiting terms. Although the terms “comprising” and “including” have been used herein to describe various embodiments, the terms “consisting essentially of” and “consisting of” can be used in place of “comprising” and “including” to provide for more specific embodiments of the invention and are also disclosed. Other than where noted, all numbers expressing geometries,
10 dimensions, and so forth used in the specification and claims are to be understood at the very least, and not as an attempt to limit the application of the doctrine of equivalents to the scope of the claims, to be construed in light of the number of significant digits and ordinary rounding approaches.

Unless defined otherwise, all technical and scientific terms used herein have the
15 same meanings as commonly understood by one of skill in the art to which the disclosed invention belongs. Publications cited herein and the materials for which they are cited are specifically incorporated by reference.

WHAT IS CLAIMED IS:

1. A rosin ester comprising at least 70% by weight of an esterified dehydroabietic acid and an esterified dihydroabietic acid, wherein, when 1000 ppm or less of an antioxidant is present in combination with the rosin ester, the rosin ester exhibits an oxidative-induction time at 130°C of at least 75 minutes, as measured using the methods specified in ASTM D5483-05(2010).
2. The rosin ester of claim 1, wherein the weight ratio of the esterified dehydroabietic acid to the esterified dihydroabietic acid ranges from 1.3:1 to 1:2.6.
3. The rosin ester of claim 1 or 2, wherein the weight ratio of the esterified dehydroabietic acid to the esterified dihydroabietic acid ranges from 1.3:1 to 1:1.6.
4. The rosin ester of any of claims 1-3, wherein the weight ratio of the esterified dehydroabietic acid to the esterified dihydroabietic acid ranges from 1.2:1 to 1:1.5.
5. The rosin ester of any of claims 1-4, wherein the esterified dehydroabietic acid and the esterified dihydroabietic acid are derived from a polyhydric alcohol selected from the group consisting of ethylene glycol, propylene glycol, diethylene glycol, triethylene glycol, tetraethylene glycol, trimethylene glycol, glycerol, trimethylolpropane, trimethylolethane, pentaerythritol, mannitol, and combinations thereof.
6. The rosin ester of any of claims 1-5, wherein the rosin ester has a neat Gardner color of 8.5 or less.
7. The rosin ester of any of claims 1-6, wherein the rosin ester has a neat Gardner color of 6 or less.
8. The rosin ester of any of claims 1-7, wherein the rosin ester has a neat Gardner color of 4 or less.

9. The rosin ester of any of claims 1-8, wherein the rosin ester exhibits less than a 10% change in neat Gardner color when heated to a temperature of 160°C for a period of three hours.
10. The rosin ester of any of claims 1-9, wherein the rosin ester exhibits less than a 5% change in Gardner color when heated to a temperature of 160°C for a period of three hours.
11. The rosin ester of any of claims 1-10, wherein when 1000 ppm or less of an antioxidant is present in combination with the rosin ester, the rosin ester exhibits an oxidative-induction time at 130°C of at least 120 minutes, as measured using the methods specified in ASTM D5483-05(2010).
12. The rosin ester of any of claims 1-11, wherein when 1000 ppm or less of an antioxidant is present in combination with the rosin ester, the rosin ester exhibits an oxidative-induction time at 130°C of at least 180 minutes, as measured using the methods specified in ASTM D5483-05(2010).
13. The rosin ester of any of claims 1-12, wherein the rosin ester comprises less than 400 ppm sulfur.
14. A rosin ester comprising at least 70% by weight of an esterified dehydroabiatic acid and an esterified dihydroabiatic acid,
wherein, when 1000 ppm or less of an antioxidant is present in combination with the rosin ester, the rosin ester exhibits an oxidative-induction time at 130°C of at least 10 minutes as measured using the methods specified in ASTM D5483-05(2010), and
wherein the weight ratio of the esterified dehydroabiatic acid to the esterified dihydroabiatic acid ranges from 1:0.80 to 1:0.25.
15. The rosin ester of claim 14, wherein the rosin ester exhibits less than a 10% change in neat Gardner color when heated to a temperature of 160°C for a period of three hours.

16. A method of making a hydrogenated rosin ester comprising:
 - (a) esterifying a rosin with an alcohol to form a rosin ester; and
 - (b) hydrogenating the rosin ester to form the hydrogenated rosin ester,wherein the esterifying step (a) and hydrogenating step (b) are conducted in the presence of activated carbon.
17. The method of claim 16, wherein the rosin is esterified with the alcohol in the absence of an additional esterification catalyst.
18. The method of claim 16 or 17, wherein the rosin is selected from the group consisting of tall oil rosins, gum rosins, wood rosins, or combinations thereof.
19. The method of any of claims 16-18, wherein the alcohol comprises a polyhydric alcohol.
20. The method of claim 19, wherein the polyhydric alcohol is selected from the group consisting of ethylene glycol, propylene glycol, diethylene glycol, triethylene glycol, tetraethylene glycol, trimethylene glycol, glycerol, trimethylolpropane, trimethylolethane, pentaerythritol, mannitol, and combinations thereof.
21. The method of any of claims 16-20, wherein the rosin ester has an acid number of 15 or less.
22. The method of any of claims 16-21, wherein the activated carbon is present in an amount ranging from 0.01% to 15% by weight, based on the weight of the rosin.
23. The method of any of claims 16-22, wherein the activated carbon has a pH of 5 or less.
24. The method of any of claims 16-23, wherein the activated carbon has a surface area of greater than 1000 m²/g.
25. The method of any of claims 16-24, wherein the activated carbon has a methylene blue absorption, measured in g/100 g, of at least 20.

26. The method of any of claims 16-25, wherein step (a) comprises contacting the rosin with the alcohol and the activated carbon at an elevated temperature.
27. The method of any of claims 16-26, wherein the hydrogenated rosin ester comprises at least 70% by weight of an esterified dehydroabiatic acid and an esterified dihydroabiatic acid.
28. The method of claim 27, wherein the weight ratio of the esterified dehydroabiatic acid to the esterified dihydroabiatic acid ranges from 1.3:1 to 1:2.6.
29. The method of any of claims 16-28, wherein when 1000 ppm or less of an antioxidant is present in combination with the hydrogenated rosin ester, the hydrogenated rosin ester exhibits an oxidative-induction time at 130°C of at least 75 minutes, as measured using the methods specified in ASTM D5483-05(2010).
30. The method of any of claims 16-29, wherein when 1000 ppm or less of an antioxidant is present in combination with the hydrogenated rosin ester, the hydrogenated rosin ester exhibits an oxidative-induction time at 130°C of at least 120 minutes, as measured using the methods specified in ASTM D5483-05(2010).
31. The method of any of claims 16-30, wherein when 1000 ppm or less of an antioxidant is present in combination with the hydrogenated rosin ester, the hydrogenated rosin ester exhibits an oxidative-induction time at 130°C of at least 180 minutes, as measured using the methods specified in ASTM D5483-05(2010).
32. The method of any of claims 16-31, wherein the hydrogenated rosin ester exhibits less than a 10% change in neat Gardner color when heated to a temperature of 160°C for a period of three hours.
33. The method of any of claims 16-32, wherein the hydrogenated rosin ester composition exhibits less than a 5% change in neat Gardner color when heated to a temperature of 160°C for a period of three hours.

34. A method of making a rosin ester comprising:
esterifying a rosin with an alcohol to form a rosin ester in the presence of activated carbon and in the absence of an additional esterification catalyst.
35. The method of claim 34, further comprising hydrogenating the rosin ester to form a hydrogenated rosin ester.
36. A composition comprising
(a) a polymer derived from one or more ethylenically-unsaturated monomers, or a blend of two or more polymers derived from one or more ethylenically-unsaturated monomers, and
(b) a rosin ester comprising at least 70% by weight of an esterified dehydroabietic acid and an esterified dihydroabietic acid, wherein the weight ratio of the esterified dehydroabietic acid to the esterified dihydroabietic acid ranges from 1.3:1 to 1:2.6.
37. The composition of claim 36, wherein the polymer is a copolymer.
38. The composition of claim 36 or 37, wherein the polymer is a block copolymer.
39. The composition of any of claims 36-38, wherein the one or more ethylenically-unsaturated monomers are selected from the group consisting of styrene, ethylene, butadiene, isoprene, (meth)acrylate monomers, vinyl acetate, vinyl ester monomers, and combinations thereof.
40. The composition of any of claims 36-39, wherein the composition is a hot-melt adhesive.
41. The composition of any of claims 36-40, wherein the polymer is derived from vinyl acetate.
42. The composition of any of claims 36-41, wherein the polymer is poly(ethylene-co-vinyl acetate).

43. The composition of any of claims 36-42, wherein the polymer is derived from between 10% by weight and 40% by weight vinyl acetate.
44. The composition of any of claims 36 or 39-41, wherein the polymer is polyvinyl acetate.
45. The composition of any of claims 36-40, wherein the polymer is a copolymer of ethylene and n-butyl acrylate.
46. The composition of any of claims 36-40, wherein the polymer is a copolymer of styrene and one or more of isoprene and butadiene.
47. The composition of any of claims 36-46, wherein the polymer is present in an amount ranging from 20% to 60% by weight, based on the total weight of the composition.
48. The composition of any of claims 36-47, wherein the polymer is present in an amount ranging from 30% to 40% by weight, based on the total weight of the composition.
49. The composition of any of claims 36-48, wherein the rosin ester is present in an amount ranging from 20% to 50% by weight, based on the total weight of the composition.
50. The composition of any of claims 36-49, wherein the rosin ester is present in an amount ranging from 30% to 40% by weight, based on the total weight of the composition.
51. The composition of any of claims 36-50, wherein the weight ratio of the esterified dehydroabiatic acid to the esterified dihydroabiatic acid ranges from 1.3:1 to 1:1.6.
52. The composition of any of claims 36-51, wherein the weight ratio of the esterified dehydroabiatic acid to the esterified dihydroabiatic acid ranges from 1.2:1 to 1:1.5.

53. The composition of any of claims 36-52, further comprising a wax.
54. The composition of any of claims 36-53, further comprising an antioxidant.
55. The composition of any of claims 36-54, wherein when 1000 ppm or less of an antioxidant is present in combination with the rosin ester, the rosin ester exhibits an oxidative-induction time at 130°C of at least 75 minutes, as measured using the methods specified in ASTM D5483-05(2010).
56. The composition of any of claims 36-55, wherein when 1000 ppm or less of an antioxidant is present in combination with the rosin ester, the rosin ester exhibits an oxidative-induction time at 130°C of at least 120 minutes, as measured using the methods specified in ASTM D5483-05(2010).
57. The composition of any of claims 36-56, wherein when 1000 ppm or less of an antioxidant is present in combination with the rosin ester, the rosin ester exhibits an oxidative-induction time at 130°C of at least 180 minutes, as measured using the methods specified in ASTM D5483-05(2010).
58. The composition of any of claims 36-57, wherein the rosin ester exhibits less than a 10% change in neat Gardner color when heated to a temperature of 160°C for a period of three hours.
59. The composition of any of claims 36-58, wherein the rosin ester exhibits less than a 5% change in neat Gardner color when heated to a temperature of 160°C for a period of three hours.
60. The composition of any of claims 36-59, wherein the rosin ester comprises more than one rosin ester.
61. A composition comprising
 - (a) a polymer derived from one or more ethylenically-unsaturated monomers, or a blend of two or more polymers derived from one or more ethylenically-unsaturated monomers, and

- (b) a rosin ester comprising at least 70% by weight of an esterified dehydroabietic acid and an esterified dihydroabietic acid, wherein when 1000 ppm or less of an antioxidant is present in combination with the rosin ester, the rosin ester exhibits an oxidative-induction time at 130°C of at least 75 minutes, as measured using the methods specified in ASTM D5483-05(2010).
62. The composition of claim 61, wherein the polymer is a copolymer.
63. The composition of claim 61 or 62, wherein the polymer is a block copolymer.
64. The composition of any of claims 61-63, wherein the one or more ethylenically-unsaturated monomers are selected from the group consisting of styrene, ethylene, butadiene, isoprene, (meth)acrylate monomers, vinyl acetate, vinyl ester monomers, and combinations thereof.
65. The composition of any of claims 61-64, wherein the composition is a hot-melt adhesive.
66. The composition of any of claims 61-65, wherein the polymer is derived from vinyl acetate.
67. The composition of any of claims 61-66, wherein the polymer is poly(ethylene-co-vinyl acetate).
68. The composition of any of claims 61-67, wherein the polymer is derived from between 10% by weight and 40% by weight vinyl acetate.
69. The composition of any of claims 61 or 64-66, wherein the polymer is polyvinyl acetate.
70. The composition of any of claims 61-65, wherein the polymer is a copolymer of ethylene and n-butyl acrylate.

71. The composition of any of claims 61-65, wherein the polymer is a copolymer of styrene and one or more of isoprene and butadiene.
72. The composition of any of claims 61-71, wherein the polymer is present in an amount ranging from 20% to 60% by weight, based on the total weight of the composition.
73. The composition of any of claims 61-72, wherein the polymer is present in an amount ranging from 30% to 40% by weight, based on the total weight of the composition.
74. The composition of any of claims 61-73, wherein the rosin ester is present in an amount ranging from 20% to 50% by weight, based on the total weight of the composition.
75. The composition of any of claims 61-74, wherein the rosin ester is present in an amount ranging from 30% to 40% by weight, based on the total weight of the composition.
76. The composition of any of claims 61-75, wherein the weight ratio of the esterified dehydroabietic acid to the esterified dihydroabietic acid ranges from 1.3:1 to 1:2.6
77. The composition of any of claims 61-76, wherein the weight ratio of the esterified dehydroabietic acid to the esterified dihydroabietic acid ranges from 1.3:1 to 1:1.6.
78. The composition of any of claims 61-77, wherein the weight ratio of the esterified dehydroabietic acid to the esterified dihydroabietic acid ranges from 1.2:1 to 1:1.5.
79. The composition of any of claims 61-78, further comprising a wax.
80. The composition of any of claims 61-79, further comprising an antioxidant.
81. The composition of any of claims 61-80, wherein when 1000 ppm or less of an antioxidant is present in combination with the rosin ester, the rosin ester exhibits an

oxidative-induction time at 130°C of at least 120 minutes, as measured using the methods specified in ASTM D5483-05(2010).

82. The composition of any of claims 61-81, wherein when 1000 ppm or less of an antioxidant is present in combination with the rosin ester, the rosin ester exhibits an oxidative-induction time at 130°C of at least 180 minutes, as measured using the methods specified in ASTM D5483-05(2010).
83. The composition of any of claims 61-82, wherein the rosin ester exhibits less than a 10% change in neat Gardner color when heated to a temperature of 160°C for a period of three hours.
84. The composition of any of claims 61-83, wherein the rosin ester exhibits less than a 5% change in neat Gardner color when heated to a temperature of 160°C for a period of three hours.
85. The composition of any of claims 61-84, wherein the rosin ester comprises more than one rosin ester.
86. A composition comprising
 - (a) 45% by weight to 75% by weight of an oil, and
 - (b) 25% by weight to 55% by weight of a rosin ester defined by any of claims 1-15.