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(54) Titre : PROCEDE DE PRODUCTION DE COPOLYMERES D'ETHYLENE/OLEFINE
(54) Title: PROCESS FOR PRODUCING ETHYLENE/OLEFIN INTERPOLYMERS

(57) **Abrégé/Abstract:**

There is described a process for producing ethylene/olefin interpolymers which, for a given melt index and density, have a reduced melting peak temperature (T_m). The process involves contacting ethylene and at least one other olefin under polymerization conditions with an olefin polymerization catalyst and at least one modifier comprising at least one element from Group 15 and/or Group 16 in amounts sufficient to reduce the melting peak temperature of the ethylene/olefin interpolymer. Also described herein are ethylene/olefin interpolymers resulting from the process.



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(54) Title: PROCESS FOR PRODUCING ETHYLENE/OLEFIN INTERPOLYMERS

(57) Abstract: There is described a process for producing ethylene/olefin interpolymers which, for a given melt index and density, have a reduced melting peak temperature (T_m). The process involves contacting ethylene and at least one other olefin under polymerization conditions with an olefin polymerization catalyst and at least one modifier comprising at least one element from Group 15 and/or Group 16 in amounts sufficient to reduce the melting peak temperature of the ethylene/olefin interpolymer. Also described herein are ethylene/olefin interpolymers resulting from the process.

WO 00/75203 A1

TITLE OF THE INVENTION**Process For Producing Ethylene/Olefin Interpolymers**

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FIELD OF INVENTION

The present invention relates to a process for producing ethylene/olefin
interpolymers, which for a given melt index (MI) and density, have reduced
melting peak temperatures (T_m). Melting peak temperature (T_m) is alternatively
10 referred to as melt transition temperature or melting point. The present invention
also relates to a process for reducing the melting peak temperature (T_m) of
ethylene/olefin interpolymers having a given melt index and density.
Additionally, this invention relates to novel ethylene/olefin interpolymers, and
films and articles of manufacture produced therefrom.

15

BACKGROUND OF INVENTION

Polyethylene and interpolymers of ethylene are well known and are
useful in many applications. In particular linear interpolymers of ethylene, also
20 known as copolymers, terpolymers, and the like of ethylene, possess properties
which distinguish them from other polyethylene polymers, such as branched
ethylene homopolymers commonly referred to as LDPE (low density
polyethylene). Certain of these properties are described by Anderson et al, U.S.
Patent No. 4,076,698.

25 A particularly useful polymerization medium for producing polymers and
interpolymers of ethylene is a gas phase process. Examples of such are given in
U.S. Patent Nos. 3,709,853; 4,003,712; 4,011,382; 4,302,566; 4,543,399;
4,882,400; 5,352,749 and 5,541,270 and Canadian Patent No. 991,798 and
Belgian Patent No. 839,380.

There are known various catalysts for polymerizing and interpolymers of ethylene. Exemplary of such catalysts are as follow:

1. Chromium oxide catalysts which polymerize ethylene to high molecular weight high density polyethylenes (HDPE) having a broad molecular weight distribution. These catalysts are typically based on Cr(6+) and are supported on a carrier.
2. Organochromium catalysts such as bis(triphenylsilyl)chromate supported on silica and activated with organoaluminum compounds, and bis(cyclopentadienyl)chromium supported on silica.
3. Ziegler-Natta catalysts which typically consist of a transition metal component and an organometallic co-catalyst that is typically an organoaluminum compound.
4. An olefin polymerization catalyst that polymerizes olefins to produce homopolymers and interpolymers of olefins having a molecular weight distribution (MWD) of from 1 to 2.5.
5. Metallocene catalysts which typically consist of a transition metal having at least one substituted or unsubstituted cyclopentadienyl or cyclopentadienyl moiety, and an organometallic co-catalyst that is typically alkyl aluminosilane, such as methyl aluminosilane, or an aryl substituted boron compound.
6. Group 13 catalysts of the type described in U.S. Patent No. 5,777,120, such as cationic aluminum alkyl amidinate complexes with an organometallic co-catalyst that is typically alkylaluminosilane, such as methylaluminosilane, or an aryl substituted boron compound.
7. Catalysts of the type described in U.S. Patent No. 5,866,663, such as cationic nickel alkyl diimine complexes with an organometallic co-catalyst that is typically alkylaluminosilane, such as methylaluminosilane, or an aryl substituted boron compound.
8. Catalysts of the type described in Organometallics, 1998, Volume 17, pages 3149-3151, such as neutral nickel alkyl salicylaldiminato complexes.

9. Catalysts of the type described in the Journal of the American Chemical Society, 1998, Volume 120, pages 7143-7144, such as cationic iron alkyl pyridinebisimine complexes with an organometallic co-catalyst that is typically alkylaluminumoxane, such as methylaluminumoxane, or an aryl substituted boron compound.
10. Catalysts of the type described in the Journal of the American Chemical Society, 1996, Volume 118, pages 10008-10009, such as cationic titanium alkyl diamide complexes with an organometallic co-catalyst that is typically alkylaluminumoxane, such as methylaluminumoxane, or an aryl substituted boron compound.

The above catalysts are, or can be, supported on an inert porous particulate carrier.

It is also well known in the polymerization of olefins, particularly where Ziegler-Natta catalysts are employed, to utilize, optionally, electron donors.

- Such electron donors often aid in increasing the efficiency of the catalyst and/or in controlling the stereospecificity of the polymer when an olefin, other than ethylene, is polymerized. Electron donors when employed during the catalyst preparation step are referred to as internal electron donors. Electron donors when utilized other than during the catalyst preparation step are referred to as external electron donors. For example, the external electron donor may be added to the preformed catalyst, to the prepolymer, and/or to the polymerization medium.

- The use of electron donors in the field of propylene polymerization is well known and is primarily used to reduce the atactic form of the polymer and increase the production of the isotactic polymers. The use of electron donors generally improves the productivity of the catalyst in the production of isotactic polypropylene. This is shown generally in U.S. Patent No. 4,981,930. It is also known to utilize electron donors to control molecular weight and molecular weight distribution of polypropylene. The result of increasing the stereoregularity, either the isotactic or syndiotactic content, of polypropylene is

to increase the crystallinity of the polymer which generally correlates to an increase in the melting peak temperature (T_m). This is shown generally in U.S. Patent Nos. 5,710,222 and 5,688,735.

5 The concept of stereoregularity is not relevant in the field of ethylene interpolymers where ethylene constitutes at least about 50% by weight of the total monomers present in the polymer. See for example U.S. Patent No. 5,055,535. In ethylene polymerization electron donors are utilized to control the molecular weight distribution (MWD) of the polymer and the activity of the catalyst in the polymerization medium. Exemplary patents describing the use of
10 internal electron donors in producing polyethylene are U.S. Patents Nos. 3,917,575; 4,187,385, 4,256,866; 4,293,673; 4,296,223; Reissue 33,683; 4,302,565; 4,302,566; and 5,470,812. Exemplary patents describing the use of external electron donors in producing polyethylene are U.S. Patents Nos. 4,234,710; 4,287,328; 5,055,535 and 5,192,729.

15 U.S. Patent No. 5,399,638 discloses the use of a morphology protector obtained by reacting alkylaluminum with an electron donor during a prepolymerization step to maintain the morphology of the support and the catalytic component on the prepolymerized support. Also disclosed is the use of the alkylaluminum electron donor complex to increase the effectiveness of the
20 comonomer in reducing the density of the interpolymers in the case of interpolation.

U.S. Patent No. 5,055,535 discloses the use of an external monoether electron donor, such as tetrahydrofuran (THF), to control molecular weight distribution.

25 U.S. Patent No. 5,244,987 and 5,410,002 disclose the use of external electron donors to control the reactivity of catalyst particles in the polymerization reactor.

U.S. Patent No. 4,652,540 discloses the use of carbonyl sulfide to reduce the adverse effect on polymerization activity resulting from poison impurities
30 contained in the olefin feed streams.

The use of internal electron donors with metallocene catalysts is disclosed in U.S. Patent No. 5,106,804. The use of external electron donors with metallocene catalysts to control molecular weight is disclosed in U.S. Patent No. 5,883,203.

5 Illustrative examples of electron donors include carboxylic acids, carboxylic acid esters, alcohols, ethers, ketones, amines, amides, nitriles, aldehydes, thioethers, thioesters, carbonic esters, organosilicon compounds containing at least one oxygen atom, and nitrogen, phosphorus, arsenic or antimony compounds connected to an organic group through a carbon or oxygen
10 atom.

SUMMARY OF THE INVENTION

Applicants have unexpectedly found that the addition of at least one
15 compound comprising at least one element from Group 15 and/or Group 16 of the Periodic Table of Elements, herein referred to as a modifier, in a process for preparing ethylene/olefin interpolymers, having a given melt index and density, reduces the melting peak temperature (T_m) of the ethylene/olefin interpolymers. The melting peak temperature (T_m) values herein were obtained by Differential
20 Scanning Calorimetry in accordance with ASTM D 3418-97.

The polymerization process of the present invention for producing an ethylene/olefin interpolymers having, at a given melt index and density, a reduced melting peak temperature (T_m) comprises the introduction into a polymerization medium comprising ethylene and at least one or more other olefin(s), an olefin
25 polymerization catalyst and at least one modifier, wherein the modifier is present in the polymerization medium in an amount sufficient to reduce the melting peak temperature (T_m) of the ethylene/olefin interpolymers to a level lower than would result in the same polymerization process in the absence of the modifier.

The present invention also relates to a process for reducing the melting
30 peak temperature (T_m) of an ethylene/olefin interpolymers having a given melt

index (MI) and density. The process comprises introducing a modifier, into a polymerization process comprising ethylene and at least one or more other olefin(s) and an olefin polymerization catalyst, in an amount sufficient to reduce the melting peak temperature (T_m).

- 5 The present invention also relates to ethylene/olefin interpolymers, which for a given melt index and density, have a reduced melting peak temperatures (T_m).

 All mention herein to elements of Groups of the Periodic Table are made in reference to the Periodic Table of the Elements, as published in "Chemical
10 and Engineering News", 63(5), 27, 1985. In this format, the Groups are numbered 1 to 18.

DETAILED DESCRIPTION OF THE INVENTION

- 15 Applicants have unexpectedly found that the addition of at least one compound comprising at least one element from Group 15 and/or Group 16 of the Periodic Table of Elements, herein referred to as a modifier, in a process for preparing ethylene/olefin interpolymers, having a given melt index and density, reduces the melting peak temperature (T_m) of the ethylene/olefin interpolymers.
- 20 The melting peak temperature (T_m) values herein were obtained by Differential Scanning Calorimetry in accordance with ASTM D 3418-97.

 The polymerization process of the present invention for producing an ethylene/olefin interpolymers having, at a given melt index and density, a reduced melting peak temperature (T_m) comprises the introduction into a polymerization
25 medium comprising ethylene and at least one or more other olefin(s), an olefin polymerization catalyst and at least one modifier, wherein the modifier is present in the polymerization medium in an amount sufficient to reduce the melting peak temperature (T_m) of the ethylene/olefin interpolymers to a level lower than would result in the same polymerization process in the absence of the modifier.

The present invention also relates to a process for reducing the melting peak temperature (T_m) of an ethylene/olefin interpolpolymer having a given melt index (MI) and density. The process comprises introducing a modifier, into a polymerization process comprising ethylene and at least one or more other
5 olefin(s) and an olefin polymerization catalyst, in an amount sufficient to reduce the melting peak temperature (T_m).

The present invention also relates to ethylene/olefin interpolymers, which for a given melt index and density, have a reduced melting peak temperatures (T_m).

10 Optionally a halogenated hydrocarbon may be added to the polymerization medium. Any halogenated hydrocarbon may be used in the process of the present invention. If desired more than one halogenated hydrocarbon can be used. Typical of such halogenated hydrocarbons are monohalogen and polyhalogen substituted saturated or unsaturated aliphatic,
15 alicyclic, or aromatic hydrocarbons having 1 to 12 carbon atoms. Preferred for use in the process of the present invention are dichloromethane, chloroform, carbon tetrachloride, chlorofluoromethane, chlorodifluoromethane, dichlorodifluoromethane, fluorodichloromethane, chlorotrifluoromethane, fluorotrichloromethane and 1,2-dichloroethane. Most preferred for use in the
20 process of the present invention is chloroform.

The modifier and the optional halogenated hydrocarbon may be added to the polymerization medium in any manner. The modifier and the halogenated hydrocarbon may be added to the olefin polymerization catalyst prior to addition to the polymerization medium, or added separately from the catalyst to the
25 polymerization medium in any manner known in the art. For example, the modifier may optionally be premixed with the halogenated hydrocarbon prior to addition to the polymerization medium.

If a gas phase fluidized bed process is utilized for interpolpolymerization of ethylene, it may be advantageous to add the modifier prior to the heat removal
30 means, e.g., the heat exchanger, to slow the rate of fouling of said heat removal

means in addition to reducing the melting peak temperature of the polymer product.

The modifier used herein to reduce the melting peak temperature (T_m) of the ethylene/olefin interpolymer is any compound comprising at least one
5 element selected from Group 15 and/or Group 16 of the Periodic Table of Elements. Illustrative examples of modifiers include carboxylic acid esters, anhydrides, acid halides, ethers, thioethers, aldehydes, ketones, imines, amines, amides, nitriles, isonitriles, cyanates, isocyanates, thiocyanates, isothiocyanates, thioesters, dithioesters, carbonic esters, hydrocarbyl carbamates, hydrocarbyl
10 thiocarbamates, hydrocarbyl dithiocarbamates, urethanes, sulfoxides, sulfones, sulfonamides, organosilicon compounds containing at least one oxygen atom, and nitrogen, phosphorus, arsenic or antimony compounds connected to an organic group through a carbon or oxygen atom. Also illustrative are compounds such as O₂, CO, CO₂, COS, NO, N₂O, NO₂ and the like.

15 Exemplary of ethers used herein to reduce the melting peak temperature are any compounds containing at least one C-O-C ether linkage. Included within the ether compounds are compounds containing heteroatoms, which are atoms other than carbon, selected from Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements. Exemplary ethers are dialkyl ethers, diaryl ethers, dialkaryl
20 ethers, diaralkyl ethers, alkyl aryl ethers, alkyl alkaryl ethers, alkyl aralkyl ethers, aryl alkaryl ethers, aryl aralkyl ethers and alkaryl aralkyl ethers. Included within the ethers are compounds such as dimethyl ether; diethyl ether; dipropyl ether; diisopropyl ether; dibutyl ether; diisoamyl ether; di-*tert*-butyl ether; diphenyl ether; dibenzyl ether; divinyl ether; butyl methyl ether; butyl ethyl
25 ether; *sec*-butyl methyl ether; *tert*-butyl methyl ether; cyclopentyl methyl ether; cyclohexyl ethyl ether; *tert*-amyl methyl ether; *sec*-butyl ethyl ether; chloromethyl methyl ether; trimethylsilylmethyl methyl ether; bis(trimethylsilylmethyl) ether; bis(2,2,2-trifluoroethyl) ether; methyl phenyl ether; ethylene oxide; propylene oxide; 1,2-epoxybutane; cyclopentene oxide;
30 epichlorohydrin; furan; 2,3-dihydrofuran; 2,5-dihydrofuran; tetrahydrofuran; 2-

methyltetrahydrofuran; 2,5-dimethyltetrahydrofuran; 2-methylfuran; 2,5-dimethylfuran; tetrahydropyran; 1,2-epoxybut-3-ene; styrene oxide; 2-ethylfuran; oxazole; 1,3,4-oxadiazole; 3,4-dichloro-1,2-epoxybutane; 3,4-dibromo-1,2-epoxybutane ; dimethoxymethane; 1,1-dimethoxyethane; 1,1,1-trimethoxymethane; 1,1,1-trimethoxyethane; 1,1,2-trimethoxyethane; 1,1-dimethoxypropane; 1,2-dimethoxypropane; 2,2-dimethoxypropane; 1,3-dimethoxypropane; 1,1,3-trimethoxypropane; 1,4-dimethoxybutane; 1,2-dimethoxybenzene; 1,3-dimethoxybenzene; 1,4-dimethoxybenzene; ethylene glycol dimethyl ether; di(ethylene glycol) dimethyl ether; di(ethylene glycol) diethyl ether; di(ethylene glycol) dibutyl ether; di(ethylene glycol) *tert*-butyl methyl ether; tri(ethylene glycol) dimethyl ether; tri(ethylene glycol) diethyl ether; tetra(ethylene glycol) dimethyl ether; 2,2-diethyl-1,3-dimethoxypropane; 2-methyl-2-ethyl-1,3-dimethoxypropane; 2-methoxyfuran; 3-methoxyfuran; 1,3-dioxolane; 2-methyl-1,3-dioxolane; 2,2-dimethyl-1,3-dioxolane; 2-ethyl-2-methyl-1,3-dioxolane; 2,2-tetramethylene-1,3-dioxolane; 2,2-pentamethylene-1,3-dioxolane; 1,3-dioxane; 1,4-dioxane; 4-methyl-1,3-dioxane; 1,3,5-trioxane and 3,4-epoxytetrahydrofuran and the like.

Preferred for use herein as ether compounds to reduce the melting peak temperature are tetrahydrofuran, diethyl ether, dipropyl ether, diisopropyl ether, dibutyl ether, dioctyl ether, *tert*-butyl methyl ether, trimethylene oxide, 1,2-dimethoxyethane, 1,2-dimethoxypropane, 1,3-dimethoxypropane, 1,2-dimethoxybutane, 1,3-dimethoxybutane, 1,4-dimethoxybutane, and tetrahydropyran.

Exemplary of thioethers used herein to reduce the melting peak temperature are any compounds containing at least one C-S-C thioether linkage. Included within the thioether compounds are compounds containing heteroatoms, which are atoms other than carbon, selected from Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements. Exemplary thioethers are dialkyl thioethers, diaryl thioethers, dialkaryl thioethers, diaralkyl thioethers, alkyl aryl thioethers, alkyl alkaryl thioethers, alkyl aralkyl thioethers, aryl alkaryl

thioethers, aryl aralkyl thioethers and alkaryl aralkyl thioethers. Included are compounds such as dimethyl sulfide; diethyl sulfide; dipropyl sulfide; diisopropyl sulfide; dibutyl sulfide; dipentyl sulfide; dihexyl sulfide; dioctyl sulfide; diisoamyl sulfide; di-*tert*-butyl sulfide; diphenyl sulfide; dibenzyl sulfide; divinyl sulfide; diallyl sulfide; dipropargyl sulfide; dicyclopropyl sulfide; dicyclopentyl sulfide; dicyclohexyl sulfide; allyl methyl sulfide; allyl ethyl sulfide; allyl cyclohexyl sulfide; allyl phenyl sulfide; allyl benzyl sulfide; allyl 2-tolyl sulfide; allyl 3-tolyl sulfide; benzyl methyl sulfide; benzyl ethyl sulfide; benzyl isoamyl sulfide; benzyl chloromethyl sulfide; benzyl cyclohexyl sulfide; benzyl phenyl sulfide; benzyl 1-naphthyl sulfide; benzyl 2-naphthyl sulfide; butyl methyl sulfide; butyl ethyl sulfide; sec-butyl methyl sulfide; *tert*-butyl methyl sulfide; butyl cyclopentyl sulfide; butyl 2-chloroethyl sulfide; cyclopentyl methyl sulfide; cyclohexyl ethyl sulfide; cyclohexyl vinyl sulfide; *tert*-amyl methyl sulfide; sec-butyl ethyl sulfide; *tert*-butyl ethyl sulfide; *tert*-amyl ethyl sulfide; cyclododecyl methyl sulfide; bis(2-cyclopenten-1-yl) sulfide; 1-methylthio-1,3-cyclohexadiene; 1-methylthio-1,4-cyclohexadiene; chloromethyl methyl sulfide; chloromethyl ethyl sulfide; bis(2-tolyl) sulfide; trimethylsilylmethyl methyl sulfide; trimethylene sulfide; thiophene; 2,3-dihydrothiophene; 2,5-dihydrothiophene; tetrahydrothiophene; 2-methyltetrahydrothiophene; 2,5-dimethyltetrahydrothiophene; 4,5-dihydro-2-methylthiophene; 2-methylthiophene; 2,5-dimethylthiophene; 3-bromothiophene; 2,3-benzothiophene; 2-methylbenzothiophene; dibenzothiophene; isobenzothiophene; 1,1-bis(methylthio)ethane; 1,1,1-tris(methylthio)ethane; 1,1,2-tris(methylthio)ethane; 1,1-bis(methylthio)propane; 1,2-bis(methylthio)propane; 2,2-bis(methylthio)propane; 1,3-bis(methylthio)propane; 1,1,3-tris(methylthio)propane; 1,4-bis(methylthio)butane; 1,2-bis(methylthio)benzene; 1,3-bis(methylthio)benzene; 1,4-bis(methylthio)benzene; ethylene glycol dimethyl sulfide; ethylene glycol diethyl sulfide; ethylene glycol divinyl sulfide; ethylene glycol diphenyl sulfide; ethylene glycol *tert*-butyl methyl sulfide; ethylene glycol *tert*-butyl ethyl sulfide;

2,5-bis(methylthio)thiophene; 2-methylthiothiophene; 3-methylthiothiophene; 2-methylthiotetrahydropyran; 3-methylthiotetrahydropyran; 1,3-dithiolane; 2-methyl-1,3-dithiolane; 2,2-dimethyl-1,3-dithiolane; 2-ethyl-2-methyl-1,3-dithiolane; 2,2-tetramethylene-1,3-dithiolane; 2,2-pentamethylene-1,3-dithiolane; 2-vinyl-1,3-dithiolane; 2-chloromethyl-1,3-dithiolane; 2-methylthio-1,3-dithiolane; 1,3-dithiane; 1,4-dithiane; 4-methyl-1,3-dithiane; 1,3,5-trithiane; 2-(2-ethylhexyl)-1,3-bis(methylthio)propane; 2-isopropyl-1,3-bis(methylthio)propane; 2-butyl-1,3-bis(methylthio)propane; 2-sec-butyl-1,3-bis(methylthio)propane; 2-*tert*-butyl-1,3-bis(methylthio)propane; 2-cyclohexyl-1,3-bis(methylthio)propane; 2-phenyl-1,3-bis(methylthio)propane; 2-cumyl-1,3-bis(methylthio)propane; 2-(2-phenylethyl)-1,3-bis(methylthio)propane; 2-(2-cyclohexylethyl)-1,3-bis(methylthio)propane; 2-(*p*-chlorophenyl)-1,3-bis(methylthio)propane; 2-(*p*-fluorophenyl)-1,3-bis(methylthio)propane; 2-(diphenylmethyl)-1,3-bis(methylthio)propane; 2,2-dicyclohexyl-1,3-bis(methylthio)propane; 2,2-diethyl-1,3-bis(methylthio)propane; 2,2-dipropyl-1,3-bis(methylthio)propane; 2,2-diisopropyl-1,3-bis(methylthio)propane; 2,2-dibutyl-1,3-bis(methylthio)propane; 2,2-diisobutyl-1,3-bis(methylthio)propane; 2-methyl-2-ethyl-1,3-bis(methylthio)propane; 2-methyl-2-propyl-1,3-bis(methylthio)propane; 2-methyl-2-butyl-1,3-bis(methylthio)propane; 2-methyl-2-benzyl-1,3-bis(methylthio)propane; 2-methyl-2-methylcyclohexyl-1,3-bis(methylthio)propane; 2-isopropyl-2-isopentyl-1,3-bis(methylthio)propane; 2,2-bis(2-cyclohexylmethyl)-1,3-bis(methylthio)propane and the like.

Any amine may be used herein to reduce the melting peak temperature. Included are amine compounds containing heteroatoms, which are atoms other than carbon, selected from Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements. Exemplary amines are primary, secondary and tertiary alkyl, aryl, alkaryl and aralkyl substituted amines. Exemplary of amines are ammonia; methylamine; ethylamine; propylamine; isopropylamine; butylamine; isobutylamine; amylamine; isoamylamine; octylamine; cyclohexylamine; aniline; dimethylamine; diethylamine; dipropylamine; diisopropylamine;

dibutylamine; diisobutylamine; diamylamine; diisoamylamine; dioctylamine; dicyclohexylamine; trimethylamine; triethylamine; tripropylamine; triisopropylamine; tributylamine; triisobutylamine; triamylamine; triisoamylamine; trioctylamine; tricyclohexylamine; *N*-methylaniline; *N*-ethylaniline; *N*-propylaniline; *N*-isopropylaniline; *N*-butylaniline; *N*-isobutylaniline; *N*-amylaniline; *N*-isoamylaniline; *N*-octylaniline; *N*-cyclohexylaniline; *N,N*-dimethylaniline; *N,N*-diethylaniline; *N,N*-dipropylaniline; *N,N*-diisopropylaniline; *N,N*-dibutylaniline; *N,N*-diisobutylaniline; *N,N*-diamylaniline; *N,N*-diisoamylaniline; *N,N*-dioctylaniline; *N,N*-dicyclohexylaniline; azetidine; 1-methylazetidine; 1-ethylazetidine; 1-propylazetidine; 1-isopropylazetidine; 1-butylazetidine; 1-isobutylazetidine; 1-amylazetidine; 1-isoamylazetidine; pyrrolidine; *N*-methylimidazole; 1-methylpyrrolidine; 1-ethylpyrrolidine; 1-propylpyrrolidine; 1-isopropylpyrrolidine; 1-butylpyrrolidine; 1-isobutylpyrrolidine; 1-amylpyrrolidine; 1-isoamylpyrrolidine; 1-octylpyrrolidine; 1-cyclohexylpyrrolidine; 1-phenylpyrrolidine; piperidine; 1-methylpiperidine; 1-ethylpiperidine; 1-propylpiperidine; 1-isopropylpiperidine; 1-butylpiperidine; 1-isobutylpiperidine; 1-amylpiperidine; 1-isoamylpiperidine; 1-octylpiperidine; 1-cyclohexylpiperidine; 1-phenylpiperidine; piperazine; 1-methylpiperazine; 1-ethylpiperazine; 1-propylpiperazine; 1-isopropylpiperazine; 1-butylpiperazine; 1-isobutylpiperazine; 1-amylpiperazine; 1-isoamylpiperazine; 1-octylpiperazine; 1-cyclohexylpiperazine; 1-phenylpiperazine; 1,4-dimethylpiperazine; 1,4-diethylpiperazine; 1,4-dipropylpiperazine; 1,4-diisopropylpiperazine; 1,4-dibutylpiperazine; 1,4-diisobutylpiperazine; 1,4-diamylpiperazine; 1,4-diisoamylpiperazine; 1,4-dioctylpiperazine; 1,4-dicyclohexylpiperazine; 1,4-diphenylpiperazine; pyridine; 2-methyl pyridine; 4-methyl pyridine; hexamethyldisilazane; morpholine; *N*-methylmorpholine and the like. Preferred for use herein are pyridine, 4-methyl pyridine, *N*-methylmorpholine and *N*-methylimidazole.

Exemplary of carboxylic acid esters used herein to reduce the melting peak temperature are any carboxylic acid ester compounds containing at least one C(=O)-O-C ester linkage. Exemplary carboxylic acid esters are saturated or unsaturated aliphatic, alicyclic, or aromatic compounds containing an ester linkage. Included within the carboxylic acid esters are compounds containing heteroatoms, which are atoms other than carbon, selected from Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements. Further exemplary are carboxylic acid esters such as methyl formate; methyl acetate; ethyl acetate; vinyl acetate; propyl acetate; butyl acetate; isopropyl acetate; isobutyl acetate; octyl acetate; cyclohexyl acetate; ethyl propionate; ethyl valerate; methyl chloroacetate; ethyl dichloroacetate, methyl methacrylate; ethyl crotonate; ethyl pivalate; methyl benzoate; ethyl benzoate; propyl benzoate; butyl benzoate; isobutyl benzoate; isopropyl benzoate; octyl benzoate; cyclohexyl benzoate; phenyl benzoate; benzyl benzoate; methyl 2-methylbenzoate; ethyl 2-methylbenzoate; propyl 2-methylbenzoate; isopropyl 2-methylbenzoate; butyl 2-methylbenzoate; isobutyl 2-methylbenzoate; octyl 2-methylbenzoate; cyclohexyl 2-methylbenzoate; phenyl 2-methylbenzoate; benzyl 2-methylbenzoate; methyl 3-methylbenzoate; ethyl 3-methylbenzoate; propyl 3-methylbenzoate; isopropyl 3-methylbenzoate; butyl 3-methylbenzoate; isobutyl 3-methylbenzoate; octyl 3-methylbenzoate; cyclohexyl 3-methylbenzoate; phenyl 3-methylbenzoate; benzyl 3-methylbenzoate; methyl 4-methylbenzoate; ethyl 4-methylbenzoate; propyl 4-methylbenzoate; isopropyl 4-methylbenzoate; butyl 4-methylbenzoate; isobutyl 4-methylbenzoate; octyl 4-methylbenzoate; cyclohexyl 4-methylbenzoate; phenyl 4-methylbenzoate; benzyl 4-methylbenzoate; methyl *o*-chlorobenzoate; ethyl *o*-chlorobenzoate; propyl *o*-chlorobenzoate; isopropyl *o*-chlorobenzoate; butyl *o*-chlorobenzoate; isobutyl *o*-chlorobenzoate; amyl *o*-chlorobenzoate; isoamyl *o*-chlorobenzoate; octyl *o*-chlorobenzoate; cyclohexyl *o*-chlorobenzoate; phenyl *o*-chlorobenzoate; benzyl *o*-chlorobenzoate; methyl *m*-chlorobenzoate; ethyl *m*-chlorobenzoate; propyl *m*-chlorobenzoate; isopropyl *m*-chlorobenzoate; butyl *m*-chlorobenzoate; isobutyl *m*-chlorobenzoate; amyl *m*-chlorobenzoate;

isoamyl *m*-chlorobenzoate; octyl *m*-chlorobenzoate; cyclohexyl *m*-chlorobenzoate; phenyl *m*-chlorobenzoate; benzyl *m*-chlorobenzoate; methyl *p*-chlorobenzoate; ethyl *p*-chlorobenzoate; propyl *p*-chlorobenzoate; isopropyl *p*-chlorobenzoate; butyl *p*-chlorobenzoate; isobutyl *p*-chlorobenzoate; amyl *p*-chlorobenzoate; isoamyl *p*-chlorobenzoate; octyl *p*-chlorobenzoate; cyclohexyl *p*-chlorobenzoate; phenyl *p*-chlorobenzoate; benzyl *p*-chlorobenzoate; dimethyl maleate; dimethyl phthalate; diethyl phthalate; dipropyl phthalate; dibutyl phthalate; diisobutyl phthalate; methyl ethyl phthalate; methyl propyl phthalate; methyl butyl phthalate; methyl isobutyl phthalate; ethyl propyl phthalate; ethyl butyl phthalate; ethyl isobutyl phthalate; propyl butyl phthalate; propyl isobutyl phthalate; dimethyl terephthalate; diethyl terephthalate; dipropyl terephthalate; dibutyl terephthalate; diisobutyl terephthalate; methyl ethyl terephthalate; methyl propyl terephthalate; methyl butyl terephthalate; methyl isobutyl terephthalate; ethyl propyl terephthalate; ethyl butyl terephthalate; ethyl isobutyl terephthalate; propyl butyl terephthalate; propyl isobutyl terephthalate; dimethyl isophthalate; diethyl isophthalate; dipropyl isophthalate; dibutyl isophthalate; diisobutyl isophthalate; methyl ethyl isophthalate; methyl propyl isophthalate; methyl butyl isophthalate; methyl isobutyl isophthalate; ethyl propyl isophthalate; ethyl butyl isophthalate; ethyl isobutyl isophthalate; propyl butyl isophthalate; propyl isobutyl isophthalate, cellulose acetate, cellulose butyrate, mixed esters of cellulose and the like.

Exemplary of thioesters used herein to reduce the melting peak temperature are compounds containing at least one C(=O)-S-C thioester linkage. Exemplary are saturated or unsaturated aliphatic, alicyclic, or aromatic compounds containing a thioester linkage. Included within the thioesters are compounds containing heteroatoms, which are atoms other than carbon, selected from Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements. Exemplary thioesters are methyl thiolacetate; ethyl thiolacetate; propyl thiolacetate; isopropyl thiolacetate; butyl thiolacetate; isobutyl thiolacetate; amyl thiolacetate; isoamyl thiolacetate; octyl thiolacetate; cyclohexyl thiolacetate;

phenyl thiolacetate; 2-chloroethyl thiolacetate; 3-chloropropyl thiolacetate; methyl thiobenzoate; ethyl thiobenzoate; propyl thiobenzoate; isopropyl thiobenzoate; butyl thiobenzoate; isobutyl thiobenzoate; amyl thiobenzoate; isoamyl thiobenzoate; octyl thiobenzoate; cyclohexyl thiobenzoate; phenyl thiobenzoate; 2-chloroethyl thiobenzoate; 3-chloropropyl thiobenzoate and the like.

Exemplary of amides used herein to reduce the melting peak temperature are compounds containing at least one C(=O)-N amide linkage. Exemplary are saturated or unsaturated aliphatic, alicyclic, or aromatic compounds containing an amide linkage. Included within the amides are compounds containing heteroatoms, which are atoms other than carbon, selected from Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements. Exemplary of amides are formamide; acetamide; propionamide; isobutyramide; trimethylacetamide; hexanoamide; octadecanamide; cyclohexanecarboxamide; 1-adamantanecarboxamide; acrylamide; methacrylamide; 2-fluoroacetamide; 2-chloroacetamide; 2-bromoacetamide; 2,2-dichloroacetamide; 2,2,2-trifluoroacetamide; 2,2,2-trichloroacetamide; 2-chloropropionamide; benzamide; *N*-methylformamide; *N*-ethylformamide; *N*-propylformamide; *N*-butylformamide; *N*-isobutylformamide; *N*-amylformamide; *N*-cyclohexylformamide; formanilide; *N*-methylacetamide; *N*-ethylacetamide; *N*-propylacetamide; *N*-butylacetamide; *N*-isobutylacetamide; *N*-amylacetamide; *N*-cyclohexylacetamide; acetanilide; *N*-methylpropionamide; *N*-ethylpropionamide; *N*-propylpropionamide; *N*-butylpropionamide; *N*-isobutylpropionamide; *N*-amylpropionamide; *N*-cyclohexylpropionamide; *N*-phenylpropionamide; *N*-methylisobutyramide; *N*-methyltrimethylacetamide; *N*-methylhexanoamide; *N*-methyloctadecanamide; *N*-methylacrylamide; *N*-methylmethacrylamide; *N*-methyl-2-fluoroacetamide; *N*-methyl-2-chloroacetamide; *N*-methyl-2-bromoacetamide; *N*-methyl-2,2-dichloroacetamide; *N*-methyl-2,2,2-trifluoroacetamide; *N*-methyl-2,2,2-trichloroacetamide; *N*-methyl-2-chloropropionamide; *N,N*-dimethylformamide; *N,N*-diethylformamide; *N,N*-

diisopropylformamide; *N,N*-dibutylformamide; *N*-methylformanilide; *N,N*-dimethylacetamide; *N,N*-diethylacetamide; *N,N*-diisopropylacetamide; *N,N*-dibutylacetamide; *N*-methylacetanilide; *N,N*-dimethylpropionamide; *N,N*-diethylpropionamide; *N,N*-diisopropylpropionamide; *N,N*-dibutylpropionamide; 5 *N,N*-dimethylisobutyramide; *N,N*-dimethyltrimethylacetamide; *N,N*-dimethylhexanoamide; *N,N*-dimethyloctadecanamide; *N,N*-dimethylacrylamide; *N,N*-dimethylmethacrylamide; *N,N*-dimethyl-2-fluoroacetamide; *N,N*-dimethyl-2-chloroacetamide; *N,N*-dimethyl-2-bromoacetamide; *N,N*-dimethyl-2,2-dichloroacetamide; *N,N*-dimethyl-2,2,2-trifluoroacetamide; *N,N*-diethyl-2,2,2-trifluoroacetamide; *N,N*-diisopropyl-2,2,2-trifluoroacetamide; *N,N*-dibutyl-2,2,2-trifluoroacetamide; *N,N*-dimethyl-2,2,2-trichloroacetamide; *N,N*-diethyl-2,2,2-trichloroacetamide; *N,N*-diisopropyl-2,2,2-trichloroacetamide; *N,N*-dibutyl-2,2,2-trichloroacetamide; *N,N*-dimethyl-2-chloropropionamide; 1-acetylazetidine; 1-acetylpyrrolidine; 1-acetylpiperidine; 1-acetylpiperazine; 1-acetylpiperazine; 1,4-diacetylpiperazine and the like. Preferred for use herein are *N,N*-formamide, *N,N*-dimethylacetamide and *N,N*-diisopropylformamide. 15

Exemplary of anhydrides used herein to reduce the melting peak temperature are compounds containing at least one C(=O)-O-C(=O) anhydride linkage. Exemplary are saturated or unsaturated aliphatic, alicyclic, or aromatic 20 compounds containing an anhydride linkage. Included within the anhydrides are compounds containing heteroatoms, which are atoms other than carbon, selected from Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements.

Exemplary of anhydrides are acetic anhydride; propionic anhydride; butyric anhydride; isobutyric anhydride; valeric anhydride; trimethylacetic anhydride; 25 hexanoic anhydride; heptanoic anhydride; decanoic anhydride; lauric anhydride; myristic anhydride; palmitic anhydride; stearic anhydride; docosanoic anhydride; crotonic anhydride; methacrylic anhydride; oleic anhydride; linoleic anhydride; chloroacetic anhydride; iodoacetic anhydride; dichloroacetic anhydride; trifluoroacetic anhydride; chlorodifluoroacetic anhydride; trichloroacetic 30 anhydride; pentafluoropropionic anhydride; heptafluorobutyric anhydride;

succinic anhydride; methylsuccinic anhydride; 2,2-dimethylsuccinic anhydride; itaconic anhydride; maleic anhydride; glutaric anhydride; diglycolic anhydride; benzoic anhydride; phenylsuccinic anhydride; phenylmaleic anhydride; homophthalic anhydride; isatoic anhydride; phthalic anhydride;
5 tetrafluorophthalic anhydride; tetrabromophthalic anhydride, mixed anhydrides and the like.

Exemplary of acid halides used herein to reduce the melting peak temperature are compounds containing at least one -C(=O)-X acid halide group where X is a halogen. Exemplary are saturated or unsaturated aliphatic, alicyclic,
10 or aromatic compounds containing an acid halide group. Included within the acid halides are compounds containing heteroatoms, which are atoms other than carbon, selected from Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements. Exemplary of acid halides are acetyl chloride; acetyl bromide; chloroacetyl chloride; dichloroacetyl chloride; trichloroacetyl chloride;
15 trifluoroacetyl chloride; tribromoacetyl chloride; propionyl chloride; propionyl bromide; butyryl chloride; isobutyryl chloride; trimethylacetyl chloride; 3-cyclopentylpropionyl chloride; 2-chloropropionyl chloride; 3-chloropropionyl chloride; *tert*-butylacetyl chloride; isovaleryl chloride; hexanoyl chloride; heptanoyl chloride; decanoyl chloride; lauroyl chloride; myristoyl chloride;
20 palmitoyl chloride; stearoyl chloride; oleoyl chloride; cyclopentanecarbonyl chloride; oxalyl chloride; malonyl dichloride; succinyl chloride glutaryl dichloride; adipoyl chloride; pimeloyl chloride; suberoyl chloride; azelaoyl chloride; sebacoyl chloride; dodecanedioyl dichloride; methoxyacetyl chloride; acetoxyacetyl chloride and the like.

25 Exemplary of aldehydes used herein to reduce the melting peak temperature are compounds containing at least one C-C(=O)-H aldehyde group. Exemplary are saturated or unsaturated aliphatic, alicyclic, or aromatic compounds containing an aldehyde group. Included within the aldehydes are compounds containing heteroatoms, which are atoms other than carbon, selected
30 from Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements.

Exemplary of aldehydes are formaldehyde; acetaldehyde; propionaldehyde; isobutyraldehyde; trimethylacetaldehyde; butyraldehyde; 2-methylbutyraldehyde; valeraldehyde; isovaleraldehyde; hexanal; 2-ethylhexanal; heptaldehyde; decyl aldehyde; crotonaldehyde; acrolein; methacrolein; 2-ethylacrolein; chloroacetaldehyde; iodoacetaldehyde; dichloroacetaldehyde; trifluoroacetaldehyde; chlorodifluoroacetaldehyde; trichloroacetaldehyde; pentafluoropropionaldehyde; heptafluorobutyraldehyde; phenylacetaldehyde; benzaldehyde; *o*-tolualdehyde; *m*-tolualdehyde; *p*-tolualdehyde; *trans*-cinnamaldehyde; *trans*-2-nitrocinnamaldehyde; 2-bromobenzaldehyde; 2-chlorobenzaldehyde; 3-chlorobenzaldehyde; 4-chlorobenzaldehyde and the like.

Exemplary of ketones used herein to reduce the melting peak temperature are compounds containing at least one C-C(=O)-C ketone linkage. Exemplary are saturated or unsaturated aliphatic, alicyclic, or aromatic compounds containing a ketone linkage. Included within the ketones are compounds containing heteroatoms, which are atoms other than carbon, selected from Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements. Exemplary of ketones are acetone; 2-butanone; 3-methyl-2-butanone; pinacolone; 2-pentanone; 3-pentanone; 3-methyl-2-pentanone; 4-methyl-2-pentanone; 2-methyl-3-pentanone; 4,4-dimethyl-2-pentanone; 2,4-dimethyl-3-pentanone; 2,2,4,4-tetramethyl-3-pentanone; 2-hexanone; 3-hexanone; 5-methyl-2-hexanone; 2-methyl-3-hexanone; 2-heptanone; 3-heptanone; 4-heptanone; 2-methyl-3-heptanone; 5-methyl-3-heptanone; 2,6-dimethyl-4-heptanone; 2-octanone; 3-octanone; 4-octanone; acetophenone; benzophenone; mesityl oxide; hexafluoroacetone; perfluoro-2-butanone; 1,1,1-trichloroacetone and the like.

Exemplary of nitriles used herein to reduce the melting peak temperature are compounds containing at least one C≡N nitrile group. Exemplary are saturated or unsaturated aliphatic, alicyclic, or aromatic compounds containing a nitrile group. Included within the nitriles are compounds containing heteroatoms, which are atoms other than carbon, selected from Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements. Exemplary of nitriles are

- acetonitrile; propionitrile; isopropionitrile; butyronitrile; isobutyronitrile; valeronitrile; isovaleronitrile; trimethylacetonitrile; hexanenitrile; heptanenitrile; heptyl cyanide; octyl cyanide; undecanenitrile; malononitrile; succinonitrile; glutaronitrile; adiponitrile; sebaconitrile; allyl cyanide; acrylonitrile;
- 5 crotononitrile; methacrylonitrile; fumaronitrile; tetracyanoethylene; cyclopentanecarbonitrile; cyclohexanecarbonitrile; dichloroacetonitrile; fluoroacetonitrile; trichloroacetonitrile; benzonitrile; benzyl cyanide; 2-methylbenzyl cyanide; 2-chlorobenzonitrile; 3-chlorobenzonitrile; 4-chlorobenzonitrile; *o*-tolunitrile; *m*-tolunitrile; *p*-tolunitrile and the like.
- 10 Preferred for use herein are acetonitrile; isopropionitrile; trimethylacetonitrile and benzonitrile.

- Exemplary of isonitriles or isocyanides used herein to reduce the melting peak temperature are compounds containing at least one C-N $\equiv$ C isocyanide group. Exemplary are saturated or unsaturated aliphatic, alicyclic, or aromatic
- 15 compounds containing a isocyanide group. Included within the isocyanides are compounds containing heteroatoms, which are atoms other than carbon, selected from Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements.
- Exemplary of isocyanides are methyl isocyanide; ethyl isocyanide; propyl isocyanide; isopropyl isocyanide; n-butyl isocyanide; t-butyl isocyanide; s-butyl
- 20 isocyanide; pentyl cyanide; hexyl isocyanide; heptyl isocyanide; octyl isocyanide; nonyl isocyanide; decyl isocyanide; undecane isocyanide; benzyl isocyanide; 2-methylbenzyl isocyanide; 2-chlorobenzo isocyanide; 3-chlorobenzo isocyanide; 4-chlorobenzo isocyanide; *o*-toluyl isocyanide; *m*-toluyl isocyanide; *p*-toluyl isocyanide; phenyl isocyanide dichloride; 1,4-phenylene
- 25 diisocyanide and the like.

- Exemplary of thiocyanates used herein to reduce the melting peak temperature are compounds containing at least one C-SCN thiocyanate group. Exemplary are saturated or unsaturated aliphatic, alicyclic, or aromatic
- 30 compounds containing a thiocyanate group. Included within the thiocyanates are compounds containing heteroatoms, which are atoms other than carbon,

selected from Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements. Exemplary of thiocyanates are methyl thiocyanate; ethyl thiocyanate; propyl thiocyanate; isopropyl thiocyanate; n-butyl thiocyanate; t-butyl thiocyanate; s-butyl thiocyanate; pentyl thiocyanate; hexyl thiocyanate; heptyl thiocyanate; 5 octyl thiocyanate; nonyl thiocyanate; decyl thiocyanate; undecane thiocyanate; benzyl thiocyanate; phenyl thiocyanate; 4'-bromophenyacyl thiocyanate; 2-methylbenzyl thiocyanate; 2-chlorobenzo thiocyanate; 3-chlorobenzo thiocyanate; 4-chlorobenzo thiocyanate; *o*-toluyl thiocyanate; *m*-toluyl thiocyanate; *p*-toluyl thiocyanate and the like.

10 Exemplary of isothiocyanates used herein to reduce the melting peak temperature are compounds containing at least one C-NCS isothiocyanate group. Exemplary are saturated or unsaturated aliphatic, alicyclic, or aromatic compounds containing a isothiocyanate group. Included within the isothiocyanates are compounds containing heteroatoms, which are atoms other
15 than carbon, selected from Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements. Exemplary of isothiocyanates are methyl isothiocyanate; ethyl isothiocyanate; propyl isothiocyanate; isopropyl isothiocyanate; n-butyl isothiocyanate; t-butyl isothiocyanate; s-butyl isothiocyanate; pentyl isothiocyanate; hexyl isothiocyanate; heptyl isothiocyanate; octyl isothiocyanate; 20 nonyl isothiocyanate; decyl isothiocyanate; undecane isothiocyanate; phenyl isothiocyanate; benzyl isothiocyanate; phenethyl isothiocyanate; *o*-tolyl isothiocyanate; 2-fluorophenyl isothiocyanate; 3-fluorophenyl isothiocyanate; 4-fluorophenyl isothiocyanate; 2-nitrophenyl isothiocyanate; 3-nitrophenyl isothiocyanate; 4-nitrophenyl isothiocyanate; 2-chlorophenyl isothiocyanate; 2-
25 bromophenyl isothiocyanate; 3-chlorophenyl isothiocyanate; 3-bromophenyl isothiocyanate; 4-chlorophenyl isothiocyanate; 2,4-dichlorophenyl isothiocyanate; R-(+)-alpha-methylbenzyl isothiocyanate; S-(-)-alpha-methylbenzyl isothiocyanate; 3-isoprenyl-alpha,alpha-dimethylbenzyl isothiocyanate; trans-2-phenylcyclopropyl isothiocyanate; 1,3-
30 bis(isocyanatomethyl)-benzene; 1,3-bis(1-isocyanato-1-methylethyl)benzene; 2-

ethylphenyl isothiocyanate; benzoyl isothiocyanate; 1-naphthyl isothiocyanate; benzoyl isothiocyanate; 4-bromophenyl isothiocyanate; 2-methoxyphenyl isothiocyanate; m-tolyl isothiocyanate; alpha, alpha, alpha-trifluoro-m-tolyl isothiocyanate; 3-fluorophenyl isothiocyanate; 3-chlorophenyl isothiocyanate; 3-bromophenyl isothiocyanate; 1,4-phenylene diisothiocyanate; 1-isothiocyanato-4-(trans-4-propylcyclohexyl)benzene; 1-(trans-4-hexylcyclohexyl)-4-isothiocyanatobenzene; 1-isothiocyanato-4-(trans-4-octylcyclohexyl) benzene; 2-methylbenzyl isothiocyanate; 2-chlorobenzo isothiocyanate; 3-chlorobenzo isothiocyanate; 4-chlorobenzo isothiocyanate; m-toluyyl isothiocyanate; p-toluyyl isothiocyanate and the like.

Exemplary of sulfoxides used herein to reduce the melting peak temperature are compounds containing at least one C-S(=O)-C sulfoxo group. Exemplary are saturated or unsaturated aliphatic, alicyclic, or aromatic compounds containing a sulfoxo group. Included within the sulfoxides are compounds containing heteroatoms, which are atoms other than carbon, selected from Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements. Exemplary of sulfoxides are methyl sulfoxide; ethylsulfoxide; propylsulfoxide; butyl sulfoxide; pentyl sulfoxide; hexyl sulfoxide; heptyl sulfoxide; octyl sulfoxide; nonyl sulfoxide; decyl sulfoxide; phenyl sulfoxide; p-tolyl sulfoxide; m-tolyl sulfoxide; o-tolyl sulfoxide; methyl phenyl sulfoxide; (R) – (+) – methyl p-tolyl sulfoxide; (S) – (-) – methyl phenyl sulfoxide; phenyl vinyl sulfoxide; 4-chlorophenyl sulfoxide; methyl (phenylsulfinyl)acetate; benzyl sulfoxide; tetramethylene sulfoxide; methyl methylsulfinylmethyl sulfide; dl-methionine sulfoxide; dl-methionine sulfoximine and the like.

Exemplary of sulfones used herein to reduce the melting peak temperature are compounds containing at least one C-S(=O)₂-C sulfone group. Exemplary are saturated or unsaturated aliphatic, alicyclic, or aromatic compounds containing a sulfone group. Included within the sulfones are compounds containing heteroatoms, which are atoms other than carbon, selected from Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements. Exemplary

of sulfones are methyl sulfone; ethyl sulfone; propyl sulfone; butyl sulfone; methyl vinyl sulfone; ethyl vinyl sulfone; divinyl sulfone; phenyl vinyl sulfone; allyl phenyl sulfone; cis-1,2-bis(phenylsulfonyl)ethylene; 2-(phenylsulfonyl)tetrahydropyran; chloromethyl phenyl sulfone; bromomethyl phenyl sulfone; phenyl tribromomethyl sulfone; 2-chloroethyl phenyl sulfone; methylthiomethyl phenyl sulfone; (phenylsulfonyl)acetonitrile; chloromethyl p-tolyl sulfone; N, N-bis(p-tolylsulfonylmethyl)-ethylamine; methylthiomethyl p-tolyl sulfone; 2-(phenylsulfonyl)acetophenone; methyl phenylsulfonylacetate; 4-fluorophenyl methyl sulfone; 4-chlorophenyl 2-chloro-1,1,2-trifluoroethyl sulfone; tosylmethyl isocyanide; phenyl sulfone; benzyl sulfone; phenyl trans-styryl sulfone; 1-methyl-2-((phenylsulfonyl)methyl)-benzene; 1-bromomethyl-2-((phenylsulfonyl)-methyl)benzene; p-tolyl sulfone; bis(phenylsulfonyl)methane; 4-chlorophenyl phenyl sulfone; 4-fluorophenyl sulfone; 4-chlorophenyl sulfone; 4,4'-sulfonylbis(methyl benzoate); 9-oxo-9H-thioxanthene-3-carbonitrile 10,10-dioxide; tetramethylene sulfone; 3-methylsulfolane; 2,4-dimethylsulfolane; trans-3,4-dichlorotetrahydrothiophene 1,1-dioxide; trans-3,4-dibromotetrahydrothiophene 1,1-dioxide; 3,4-epoxytetrahydrothiophene-1,1-dioxide; butadiene sulfone; 3-ethyl-2,5-dihydrothiophene-1,1-dioxide and the like.

Exemplary of phosphorous compounds used herein to reduce the melting peak temperature are saturated or unsaturated aliphatic, alicyclic, or aromatic phosphorous compounds having 2 to 50 carbon atoms containing at least one phosphorous atom. Included within the phosphorous compounds are compounds containing heteroatoms, which are atoms other than carbon, selected from Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements. Exemplary of phosphorous compounds are trimethylphosphine; triethylphosphine; trimethyl phosphite; triethyl phosphite; hexamethylphosphorus triamide; hexamethylphosphoramidate; tripiperidinophosphine oxide; triphenylphosphine; tri-*p*-tolylphosphine; tri-*m*-tolylphosphine; tri-*o*-tolylphosphine; methyldiphenylphosphine; ethyldiphenylphosphine;

isopropyldiphenylphosphine; allyldiphenylphosphine;
cyclohexyldiphenylphosphine; benzyldiphenylphosphine; di-*tert*-butyl
dimethylphosphoramidite; di-*tert*-butyl diethylphosphoramidite; di-*tert*-butyl
diisopropylphosphoramidite; diallyl diisopropylphosphoramidite and the like.

- 5 Exemplary of organosilicon compounds used herein to reduce the melting
peak temperature are saturated or unsaturated aliphatic, alicyclic, or aromatic
organosilicon compounds having 2 to 50 carbon atoms containing at least one
oxygen atom. Included within the organosilicon compounds are compounds
containing heteroatoms, which are atoms other than carbon, selected from
10 Groups 13, 14, 15, 16 and 17 of the Periodic Table of Elements. Exemplary of
organosilicon compounds are tetramethyl orthosilicate; tetraethyl orthosilicate;
tetrapropyl orthosilicate; tetrabutyl orthosilicate; trichloromethoxysilane;
trichloroethoxysilane; trichloropropoxysilane; trichloroisopropoxysilane;
trichlorobutoxysilane; trichloroisobutoxysilane; dichlorodimethoxysilane;
15 dichlorodiethoxysilane; dichlorodipropoxysilane; dichlorodiisopropoxysilane;
dichlorodibutoxysilane; dichlorodiisobutoxysilane; chlorotrimethoxysilane;
chlorotriethoxysilane; chlorotripropoxysilane; chlorotriisopropoxysilane;
chlorotributoxysilane; chlorotriisobutoxysilane; dimethylmethoxysilane;
diethylmethoxysilane; dipropylmethoxysilane; diisopropylmethoxysilane;
20 dibutylmethoxysilane; diisobutylmethoxysilane; dipentylmethoxysilane;
dicyclopentylmethoxysilane; dihexylmethoxysilane; dicyclohexylmethoxysilane;
diphenylmethoxysilane; dimethylethoxysilane; diethylethoxysilane;
dipropylethoxysilane; diisopropylethoxysilane; dibutylethoxysilane;
diisobutylethoxysilane; dipentylethoxysilane; dicyclopentylethoxysilane;
25 dihexylethoxysilane; dicyclohexylethoxysilane; diphenylethoxysilane;
trimethylmethoxysilane; triethylmethoxysilane; tripropylmethoxysilane;
triisopropylmethoxysilane; tributylmethoxysilane; triisobutylmethoxysilane;
tripentylmethoxysilane; tricyclopentylmethoxysilane; trihexylmethoxysilane;
tricyclohexylmethoxysilane; triphenylmethoxysilane; trimethylethoxysilane;
30 triethylethoxysilane; tripropylethoxysilane; triisopropylethoxysilane;

- tributylethoxysilane; triisobutylethoxysilane; tripentylethoxysilane;
tricyclopentylethoxysilane; trihexylethoxysilane; tricyclohexylethoxysilane;
triphenylethoxysilane; dimethyldimethoxysilane; diethyldimethoxysilane;
dipropyldimethoxysilane; diisopropyldimethoxysilane; dibutyldimethoxysilane;
5 diisobutyldimethoxysilane; dipentyldimethoxysilane;
dicyclopentyldimethoxysilane; dihexyldimethoxysilane;
dicyclohexyldimethoxysilane; diphenyldimethoxysilane;
dimethyldiethoxysilane; diethyldiethoxysilane; dipropyldiethoxysilane;
diisopropyldiethoxysilane; dibutyldiethoxysilane; diisobutyldiethoxysilane;
10 dipentyldiethoxysilane; dicyclopentyldiethoxysilane; dihexyldiethoxysilane;
dicyclohexyldiethoxysilane;
diphenyldiethoxysilane; cyclopentylmethyldimethoxysilane;
cyclopentylethyldimethoxysilane; cyclopentylpropyldimethoxysilane;
cyclopentylmethyldiethoxysilane; cyclopentylethyldiethoxysilane;
15 cyclopentylpropyldiethoxysilane; cyclohexylmethyldimethoxysilane;
cyclohexylethyldimethoxysilane; cyclohexylpropyldimethoxysilane;
cyclohexylmethyldiethoxysilane; cyclohexylethyldiethoxysilane;
cyclohexylpropyldiethoxysilane; methyltrimethoxysilane; ethyltrimethoxysilane;
vinyltrimethoxysilane; propyltrimethoxysilane; isopropyltrimethoxysilane;
20 butyltrimethoxysilane; isobutyltrimethoxysilane; tert-butyltrimethoxysilane;
phenyltrimethoxysilane; norbornanetrimethoxysilane; methyltriethoxysilane;
ethyltriethoxysilane; vinyltriethoxysilane; propyltriethoxysilane;
isopropyltriethoxysilane; butyltriethoxysilane; isobutyltriethoxysilane; tert-
butyltriethoxysilane; phenyltriethoxysilane; norbornanetriethoxysilane; 2,3-
25 dimethyl-2-(trimethoxysilyl)butane; 2,3-dimethyl-2-(triethoxysilyl)butane; 2,3-
dimethyl-2-(tripropoxysilyl)butane; 2,3-dimethyl-2-(triisopropoxysilyl)butane;
2,3-dimethyl-2-(trimethoxysilyl)pentane; 2,3-dimethyl-2-(triethoxysilyl)pentane;
2,3-dimethyl-2-(tripropoxysilyl)pentane; 2,3-dimethyl-2-
(triisopropoxysilyl)pentane; 2-methyl-3-ethyl-2-(trimethoxysilyl)pentane; 2-
30 methyl-3-ethyl-2-(triethoxysilyl)pentane; 2-methyl-3-ethyl-2-

(tripropoxysilyl)pentane; 2-methyl-3-ethyl-2-(triisopropoxysilyl)pentane; 2,3,4-trimethyl-2-(trimethoxysilyl)pentane; 2,3,4-trimethyl-2-(triethoxysilyl)pentane; 2,3,4-trimethyl-2-(tripropoxysilyl)pentane; 2,3,4-trimethyl-2-(triisopropoxysilyl)pentane; 2,3-dimethyl-2-(trimethoxysilyl)hexane; 2,3-dimethyl-2-(triethoxysilyl)hexane; 2,3-dimethyl-2-(tripropoxysilyl)hexane; 2,3-dimethyl-2-(triisopropoxysilyl)hexane; 2,4-dimethyl-3-ethyl-2-(trimethoxysilyl)pentane; 2,4-dimethyl-3-ethyl-2-(triethoxysilyl)pentane; 2,4-dimethyl-3-ethyl-2-(tripropoxysilyl)pentane; 2,4-dimethyl-3-ethyl-2-(triisopropoxysilyl)pentane; 2,4-dimethyl-3-isopropyl-2-(trimethoxysilyl)pentane; 2,4-dimethyl-3-isopropyl-2-(triethoxysilyl)pentane; 2,4-dimethyl-3-isopropyl-2-(tripropoxysilyl)pentane; 2,4-dimethyl-3-isopropyl-2-(triisopropoxysilyl)pentane; hexamethyldisiloxane; 1,1,1,3,3,3-hexamethyldisilazane and the like. Preferred for use herein are cyclohexylmethyldimethoxysilane, tetraethyl orthosilicate and dicyclopentyldimethoxysilane.

Mixtures or combinations of two or more of the above modifiers can also be used herein as the modifier to reduce the melting peak temperature.

In the present invention, any catalyst for polymerizing olefins to produce ethylene/olefin interpolymers may be used. Preferably the olefin polymerization catalyst comprises at least one metal from Groups 3, 4, 5, 6, 7, 8, 9, 10, 11, 12 and 13 of the Periodic Table of the Elements, as defined herein. The olefin polymerization catalyst may be neutral or cationic. Exemplary metals are titanium, zirconium, vanadium, iron, chromium, nickel and aluminum. Exemplary of such polymerization catalysts are:

1. Any compound containing a Group 6 element. Preferred are chromium containing compounds. Exemplary are chromium oxide catalysts which polymerize ethylene to high molecular weight high density polyethylenes (HDPE) having a broad molecular weight distribution. These catalysts are typically based on Cr(6+) and are supported on a carrier. Further exemplary are organochromium catalysts such as bis(triphenylsilyl)chromate supported

on silica and activated with organoaluminum compounds, and
bis(cyclopentadienyl)chromium supported on silica.

2. Ziegler-Natta catalysts which typically consist of a transition metal component and an organometallic co-catalyst that is typically an
5 organoaluminum compound.
3. An olefin polymerization catalyst that polymerizes olefins to produce interpolymers of olefins having a molecular weight distribution (MWD) of from 1 to 2.5.
4. Metallocene catalysts which consist of a transition metal component having
10 at least one moiety selected from substituted or unsubstituted cyclopentadienyl, substituted or unsubstituted pentadienyl, substituted or unsubstituted pyrrole, substituted or unsubstituted phosphole, substituted or unsubstituted arsole, substituted or unsubstituted boratabenzene, and substituted or unsubstituted carborane, and an organometallic co-catalyst that
15 is typically alkyl aluminoxane, such as methyl aluminoxane, or an aryl substituted boron compound.
5. Any compound containing a Group 13 element. Preferred are aluminum containing compounds. Exemplary are catalysts of the type described in U.S. Patent No. 5,777,120, such as cationic aluminum alkyl amidinate complexes
20 with an organometallic co-catalyst that is typically alkylaluminoxane, such as methylaluminoxane, or an aryl substituted boron containing compound.
6. Any compound containing a Group 10 element. Preferred are nickel containing compounds. Exemplary are catalysts of the type described in U.S. Patent No. 5,866,663, such as cationic nickel alkyl diimine complexes with
25 an organometallic co-catalyst that is typically alkylaluminoxane, such as methylaluminoxane, or an aryl substituted boron containing compound.
Further exemplary are catalysts of the type described in Organometallics, 1998, Volume 17, pages 3149-3151, such as neutral nickel alkyl salicylaldiminato complexes.

7. Any compound containing a Group 8 element. Preferred are iron containing compounds. Exemplary are catalysts of the type described in the Journal of the American Chemical Society, 1998, Volume 120, pages 7143-7144, such as cationic iron alkyl pyridinebisimine complexes with an organometallic co-catalyst that is typically alkylaluminumoxane, such as methylaluminumoxane, or an aryl substituted boron containing compound.
8. Any compound containing a Group 4 element. Preferred are titanium and zirconium containing compounds. Exemplary are catalysts of the type described in the Journal of the American Chemical Society, 1996, Volume 118, pages 10008-10009, such as cationic titanium alkyl diamide complexes with an organometallic co-catalyst that is typically alkylaluminumoxane, such as methylaluminumoxane, or an aryl substituted boron containing compound.

The above catalysts are, or can be, supported on inert porous particulate carriers.

- 15 The above olefin polymerization catalysts can be introduced in the process of the present invention in any manner. For example, the catalyst component(s) can be introduced directly into the polymerization medium in the form of a solution, a slurry or a dry free flowing powder. The catalyst if requiring a co-catalyst can be premixed to form an activated catalyst prior to addition to the polymerization medium, or the components can be added separately to the polymerization medium, or the components can be premixed and then contacted with one or more olefins to form a prepolymer and then added to the polymerization medium in prepolymer form. When a prepolymer form of the catalyst is used, there may be added additional organometallic compound(s) to the reactor. The additional organometallic compounds may be the same or different from that used to activate the catalyst for prepolymerization.

- Any or all of the components of the olefin polymerization catalysts can be supported on a carrier. The carrier can be any particulate organic or inorganic material. Preferably the carrier particle size should not be larger than about 200

microns in diameter. The most preferred particle size of the carrier material can be easily established by experiment. Preferably, the carrier should have an average particle size of 5 to 200 microns in diameter, more preferably 10 to 150 microns and most preferably 20 to 100 microns.

5 Examples of suitable inorganic carriers include metal oxides, metal hydroxides, metal halogenides or other metal salts, such as sulphates, carbonates, phosphates, nitrates and silicates. Exemplary of inorganic carriers suitable for use herein are compounds of metals from Groups 1 and 2 of the Periodic Table of the Elements, such as salts of sodium or potassium and oxides or salts of
10 magnesium or calcium, for instance the chlorides, sulphates, carbonates, phosphates or silicates of sodium, potassium, magnesium or calcium and the oxides or hydroxides of, for instance, magnesium or calcium. Also suitable for use are inorganic oxides such as silica, titania, alumina, zirconia, chromia, boron oxide, silanized silica, silica hydrogels, silica xerogels, silica aerogels, and mixed
15 oxides such as talcs, silica/chromia, silica/chromia/titania, silica/alumina, silica/titania, silica/magnesia, silica/magnesia/titania, aluminum phosphate gels, silica co-gels and the like. The inorganic oxides may contain small amounts of carbonates, nitrates, sulfates and oxides such as Na_2CO_3 , K_2CO_3 , CaCO_3 , MgCO_3 , Na_2SO_4 , $\text{Al}_2(\text{SO}_4)_3$, BaSO_4 , KNO_3 , $\text{Mg}(\text{NO}_3)_2$, $\text{Al}(\text{NO}_3)_3$, Na_2O , K_2O
20 and Li_2O . Carriers containing at least one component selected from the group consisting of MgCl_2 , SiO_2 , Al_2O_3 or mixtures thereof as a main component are preferred.

 Examples of suitable organic carriers include polymers such as, for example, polyethylene, polypropylene, interpolymers of ethylene and alpha-
25 olefins, polystyrene, functionalized polystyrene, polyamides and polyesters.

 The Ziegler-Natta catalysts utilized herein are well known in the industry. The Ziegler-Natta catalysts in the simplest form are comprised of a component comprising at least one transition metal and a co-catalyst comprising at least one organometallic compound. The metal of the transition metal component is a
30 metal selected from Groups 4, 5, 6, 7, 8, 9 and/or 10 of the Periodic Table of the

Elements, as published in "Chemical and Engineering News", 63(5), 27, 1985. In this format, the groups are numbered 1-18. Exemplary of such transition metals are titanium, zirconium, vanadium, chromium, manganese, iron, cobalt, nickel, and the like, and mixtures thereof. In a preferred embodiment the transition metal is selected from the group consisting of titanium, zirconium, vanadium and chromium, and in a still further preferred embodiment, the transition metal is titanium. The Ziegler-Natta catalyst can optionally contain magnesium and/or chlorine. Such magnesium and chlorine containing catalysts may be prepared by any manner known in the art.

10

The co-catalyst used in the process of the present invention can be any organometallic compound, or mixtures thereof, that can activate the transition metal component in a Ziegler-Natta catalyst in the polymerization of olefins. In particular, the organometallic co-catalyst compound that is reacted with the transition metal component contains a metal selected from Groups 1, 2, 11, 12, 13 and/or 14 of the above described Periodic Table of the Elements. Exemplary of such metals are lithium, magnesium, copper, zinc, boron, silicon and the like, or mixtures thereof.

Furthermore there may be added to the Ziegler-Natta catalysts any internal electron donor. Preferred for use as internal electron donors are carbon containing compounds having 1 to 30 heteroatoms, which are atoms other than carbon, or mixtures thereof, selected from Groups 14, 15, 16 and 17 of the Periodic Table of Elements. The internal electron donor compound is more preferably selected from the group consisting of ethers, thioethers, esters, thioesters, dithioesters, carbamates, thiocarbamates, dithiocarbamates, amines, amides, thioamides, aldehydes, ketones, imines, nitriles, isonitriles, cyanates, isocyanates, thiocyanates, isothiocyanates, phosphines, sulfoxides, sulfones, silanes, acid anhydrides, acid halides, amides, aldehydes, and organic acid derivatives.

The Ziegler-Natta catalyst may be prepared by any method known in the art. The catalyst can be in the form of a solution, a slurry or a dry free flowing powder. The amount of Ziegler-Natta catalyst and co-catalyst used is that which is sufficient to allow production of the desired amount of the polyolefin.

5 Metalocene catalysts are well known in the industry and are typically comprised of at least one transition metal component and a co-catalyst. The transition metal component has at least one moiety selected from substituted or unsubstituted cyclopentadienyl, substituted or unsubstituted pentadienyl, substituted or unsubstituted pyrrole, substituted or unsubstituted phosphole,
10 substituted or unsubstituted arsole, substituted or unsubstituted boratabenzene, and substituted or unsubstituted carborane. The transition metal is selected from Groups 3, 4, 5, 6, 7, 8, 9 and 10 of the Periodic Table of the Elements. Exemplary of such transition metals are titanium, zirconium, hafnium, vanadium, chromium, manganese, iron, cobalt, nickel, and the like, and mixtures thereof. In
15 a preferred embodiment the transition metal is selected from Groups 4, 5 or 6 such as, for example, titanium, zirconium, hafnium, vanadium and chromium, and in a still further preferred embodiment, the transition metal is titanium or zirconium or mixtures thereof.

 The co-catalyst component of the metallocene catalyst can be any
20 compound, or mixtures thereof, that can activate the transition metal component of the metallocene catalyst in olefin polymerization. Typically the co-catalyst is an alkylaluminumoxane such as, for example, methylaluminumoxane (MAO) and aryl substituted boron compounds such as, for example, tris(perfluorophenyl)borane and the salts of tetrakis(perfluorophenyl)borate.

25 There are many references describing metallocene catalysts in great detail. For example, metallocene catalysts are described in U.S. Patent Nos. 4,564,647; 4,752,597; 5,106,804; 5,132,380; 5,227,440; 5,296,565; 5,324,800; 5,331,071; 5,332,706; 5,350,723; 5,399,635; 5,466,766; 5,468,702; 5,474,962; 5,578,537 and 5,863,853.

In carrying out the polymerization process of the present invention, the co-catalyst(s), if utilized, is added to the polymerization medium in any amount sufficient to effect production of the desired ethylene/olefin interpolymers. It is preferred to utilize the co-catalyst(s) in a molar ratio of co-catalyst(s) to metal component(s) of the olefin polymerization catalyst ranging from about 0.5:1 to about 10000:1. In a more preferred embodiment, the molar ratio of co-catalyst(s) to metal component(s) ranges from about 0.5:1 to about 1000:1.

The polymerization process of the present invention may be carried out using any suitable process, for example, solution, slurry and gas phase. A particularly desirable method for producing ethylene/olefin interpolymers according to the present invention is a gas phase polymerization process preferably utilizing a fluidized bed reactor. This type reactor and means for operating the reactor are well known and completely described in U.S. Patents Nos. 3,709,853; 4,003,712; 4,011,382; 4,012,573; 4,302,566; 4,543,399; 4,882,400; 5,352,749; 5,541,270; Canadian Patent No. 991,798 and Belgian Patent No. 839,380. These patents disclose gas phase polymerization processes wherein the polymerization medium is either mechanically agitated or fluidized by the continuous flow of the gaseous monomer and diluent. The entire contents of these patents are incorporated herein by reference.

In general, the polymerization process of the present invention may be effected as a continuous gas phase process such as a fluid bed process. A fluid bed reactor for use in the process of the present invention typically comprises a reaction zone and a so-called velocity reduction zone. The reaction zone comprises a bed of growing polymer particles, formed polymer particles and a minor amount of catalyst particles fluidized by the continuous flow of the gaseous monomer and diluent to remove heat of polymerization through the reaction zone. Optionally, some of the recirculated gases may be cooled and compressed to form liquids that increase the heat removal capacity of the circulating gas stream when readmitted to the reaction zone. A suitable rate of gas flow may be readily determined by simple experiment. Make up of gaseous

monomer to the circulating gas stream is at a rate equal to the rate at which particulate polymer product and monomer associated therewith is withdrawn from the reactor and the composition of the gas passing through the reactor is adjusted to maintain an essentially steady state gaseous composition within the reaction zone. The gas leaving the reaction zone is passed to the velocity reduction zone where entrained particles are removed. Finer entrained particles and dust may be removed in a cyclone and/or fine filter. The gas is passed through a heat exchanger wherein the heat of polymerization is removed, compressed in a compressor and then returned to the reaction zone.

10 In more detail, the reactor temperature of the fluid bed process herein ranges from about 30°C to about 120°C. In general, the reactor temperature is operated at the highest temperature that is feasible taking into account the sintering temperature of the polymer product within the reactor.

The process of the present invention is suitable for the production of interpolymers of ethylene, including copolymers, terpolymers, and the like, of ethylene and at least one or more other olefins wherein the ethylene content is at least about 50% by weight of the total monomers involved. Preferably the olefins are alpha-olefins. The olefins, for example, may contain from 3 to 16 carbon atoms. Exemplary olefins that may be utilized herein are propylene, 1-butene, 1-pentene, 1-hexene, 1-heptene, 1-octene, 4-methylpent-1-ene, 1-decene, 1-dodecene, 1-hexadecene and the like. Also utilizable herein are polyenes such as 1,3-hexadiene, 1,4-hexadiene, cyclopentadiene, dicyclopentadiene, 4-vinylcyclohex-1-ene, 1,5-cyclooctadiene, 5-vinylidene-2-norbornene, 5-vinyl-2-norbornene, and olefins formed in situ in the polymerization medium. When olefins are formed in situ in the polymerization medium, the formation of ethylene/olefin interpolymers containing long chain branching may occur.

In carrying out the polymerization process of the present invention the modifier used to reduce the melting peak temperature of the ethylene/olefin interpolymers is added in any manner. For example, the modifier may be added to the preformed catalyst, to the prepolymer during the prepolymerization step, to

the preformed prepolymer and/or to the polymerization medium. The modifier may optionally be premixed with the co-catalyst when utilized. The modifier is added in any amount sufficient to reduce the melting peak temperature of the ethylene/olefin interpolymer to a level lower than would result in the same polymerization process in the absence of the modifier. In a preferred embodiment the melting peak temperature is reduced by at least 0.5°C. More preferably the melting peak temperature is reduced by at least 1.0°C. Most preferred the melting peak temperature is reduced by at least 2.0°C.

When the modifier is a liquid or solid at 1 atmosphere of pressure and at 20°C, it is preferred to incorporate the modifier in a molar ratio of modifier to metal component of the olefin polymerization catalyst ranging from about 0.001:1 to about 100:1. In a more preferred embodiment, where the modifier is a liquid or solid, the molar ratio of the modifier to metal component ranges from about 0.01:1 to about 50:1. When the modifier is a gas at 1 atmosphere of pressure and at 20°C, it is preferred to incorporate the gaseous modifier at a concentration in the polymerization medium ranging from about 1 ppm by volume to about 10,000 ppm by volume. In a more preferred embodiment, the concentration of the gaseous modifier in the polymerization medium ranges from about 1 ppm by volume to about 1000 ppm by volume.

In carrying out the polymerization process of the present invention, the halogenated hydrocarbon may be added to the polymerization medium in any amount sufficient to effect production of the desired polyolefin. It is preferred to incorporate the halogenated hydrocarbon in a molar ratio of halogenated hydrocarbon to metal component of the olefin polymerization catalyst ranging from about 0.001:1 to about 100:1. In a more preferred embodiment, the molar ratio of halogenated hydrocarbon to metal component ranges from about 0.001:1 to about 10:1.

Any conventional additive may be added to the ethylene/olefin interpolymers obtained by the invention. Examples of the additives include nucleating agents, heat stabilizers, antioxidants of phenol type, sulfur type and

phosphorus type, lubricants, antistatic agents, dispersants, copper harm
inhibitors, neutralizing agents, foaming agents, plasticizers, anti-foaming agents,
flame retardants, crosslinking agents, flowability improvers such as peroxides,
ultraviolet light absorbers, light stabilizers, weathering stabilizers, weld strength
5 improvers, slip agents, anti-blocking agents, antifogging agents, dyes, pigments,
natural oils, synthetic oils, waxes, fillers and rubber ingredients.

The ethylene/olefin interpolymers of the present invention may be
fabricated into films by any technique known in the art. For example, films may
be produced by the well known cast film, blown film and extrusion coating
10 techniques.

Further ethylene/olefin interpolymers may be fabricated into other
articles of manufacture, such as molded articles, by any of the well known
techniques.

The invention will be more readily understood by reference to the
15 following examples. There are, of course, many other forms of this invention
which will become obvious to one skilled in the art, once the invention has been
fully disclosed, and it will accordingly be recognized that these examples are
given for the purpose of illustration only, and are not to be construed as limiting
the scope of this invention in any way. All patents referred to herein are
20 incorporated by reference in their entirety.

Examples

In the following examples the test procedures listed below were used in
evaluating the analytical properties of the ethylene/olefin interpolymers herein.

- 25 a) Density is determined according to ASTM D-4883 from a plaque
made according to ASTM D1928;
- b) Melt Index (MI), I_2 , is determined in accord with ASTM D-1238,
condition E, measured at 190°C, and reported as decigrams per
minute;

- c) High Load Melt Index (HLMI), I_{21} , is measured in accord with ASTM D-1238, Condition F, measured at 10.0 times the weight used in the melt index test above;
- d) Melt Flow Ratio (MFR) = I_{21}/I_2 or High Load Melt Index/Melt Index;
- 5 e) Residual Titanium Content in the Product. The residual titanium content in the product is measured by X-Ray Fluorescence Spectroscopy (XRF) using a Philips Sequential X-Ray Spectrometer Model PW 1480. The samples of the polymer to be evaluated were compression molded into a circular shaped plaque approximately 43
- 10 mm in diameter so as to fit the sample holder on the spectrometer and 3 to 5 mm in thickness and having a smooth flat surface. The molded test specimens were then placed in the XRF unit and the x-ray fluorescence arising from the titanium in the test specimen was measured. The residual titanium content was then determined based
- 15 on a calibration curve obtained by measurements from polyethylene calibration specimens containing a known amount of titanium. The residual titanium content is reported as parts per million (ppm) relative to the polymer matrix;
- f) Dart Impact is determined according to ASTM D-1709, Method A;
- 20 with a 38.1 mm dart having a smooth phenolic head, and a drop height of 0.66 meter. The film thickness is about 1 mil;
- g) n-Hexane Extractable – is determined in accordance with 21 CFR 177.1520 (Option 2). More particularly, an approximately 1 square
- 25 inch film test specimen having a thickness ≤ 4 mils weighing 2.5 ± 0.05 grams is placed into a tared sample basket and accurately weighed to the nearest 0.1 milligram. The sample basket containing the test specimen is then placed in a 2-liter extraction vessel containing approximately 1 liter of n-hexane. The basket is placed
- 30 such that it is totally below the level of n-hexane solvent. The sample resin film is extracted for 2 hours at $49.5 \pm 0.5^\circ\text{C}$ and then the basket

- is raised above the solvent level to drain momentarily. The basket is removed and the contents are rinsed by immersing several times in fresh n-hexane. The basket is allowed to dry between rinsing. The excess solvent is removed by briefly blowing the basket with a stream of nitrogen or dry air. The basket is placed in the vacuum oven for 2 hours at $80 \pm 5^\circ\text{C}$. After 2 hours, it is removed and placed in a desiccator to cool to room temperature (about 1 hour). After cooling, the basket is reweighed to the nearest 0.1 milligram. The percent n-hexane extractables content is then calculated from the weight loss of the original sample; and
- h) Melting Peak Temperature (T_m) was determined in accordance with ASTM D 3418-97 using a Differential Scanning Calorimeter (DSC). The T_m values listed in the tables are not true equilibrium melting points but are DSC peak temperatures of the melt transition recorded on the second heat cycle. In each case, approximately 10 mg of polymer sample was placed in an aluminum sample pan and the sample lid was crimped in place. The sample was then heated to 160°C at a rate of $50^\circ\text{C}/\text{minute}$ and held at 160°C for 10 minutes. The sample was then cooled to -30°C at a rate of $10^\circ\text{C}/\text{minute}$ while recording the freezing or crystallization curve. After holding for 2 minutes at -30°C , the second heat cycle was initiated and the sample was heated at a rate of $10^\circ\text{C}/\text{minute}$ to a final temperature of 160°C while recording the heating curve. The melting peak temperature, T_m , was obtained from the melt transition on the heating curve of the second heat cycle.
- i) The molecular weight distribution (MWD), the ratio of M_w/M_n , of the ethylene/olefin interpolymers are determined with a Waters Gel Permeation Chromatograph Series 150C equipped with Ultrastrogel columns and a refractive index detector. The operating temperature of the instrument was set at 140°C , the eluting solvent was *o*-

dichlorobenzene, and the calibration standards included 10 polystyrenes of precisely known molecular weight, ranging from a molecular weight of 1000 to a molecular weight of 1.3 million, and a polyethylene standard, NBS 1475.

5

Olefin Polymerization Catalysts Utilized in the Examples

The Ziegler-Natta catalyst used in Examples 1 through 6 was prepared in accordance with Example 1-a of European Patent Application EP 0 703 246 A1. The catalyst was used in prepolymer form and was prepared in accordance with
10 Example 1-b of European Patent Application EP 0 703 246 A1. A prepolymer containing about 34 grams of polyethylene per millimole of titanium was thus obtained. This catalyst is herein referred to as Catalyst I.

The Ziegler-Natta catalyst used in Examples 7 and 8 was obtained from Toho Titanium Company, Limited under the product name THC-C. The catalyst
15 contained 2.5 weight percent titanium and was supported on magnesium chloride. This catalyst is herein referred to as Catalyst II.

The Ziegler-Natta catalyst used in Examples 9 – 13 was obtained from Grace Davison, Baltimore, Maryland under the product name XPO-5021. The catalyst contained 0.44 weight percent titanium and was supported on silica. This
20 catalyst is herein referred to as Catalyst III.

Polymerization Process

The polymerization process utilized in Examples 1-13 herein was carried out in a fluidized-bed reactor for gas-phase polymerization, consisting of a
25 vertical cylinder of diameter 0.74 meters and height 7 meters and surmounted by a velocity reduction chamber. The reactor is provided in its lower part with a fluidization grid and with an external line for recycling gas, which connects the top of the velocity reduction chamber to the lower part of the reactor, at a point below the fluidization grid. The recycling line is equipped with a compressor for
30 circulating gas and a heat transfer means such as a heat exchanger. In particular

the lines for supplying ethylene, an olefin such as 1-butene, 1-pentene and 1-hexene, hydrogen and nitrogen, which represent the main constituents of the gaseous reaction mixture passing through the fluidized bed, feed into the recycling line. Above the fluidization grid, the reactor contains a fluidized bed
5 consisting of a polyethylene powder made up of particles with a weight-average diameter of about 0.5 mm to about 1.4 mm. The gaseous reaction mixture, which contains ethylene, olefin comonomer, hydrogen, nitrogen and minor amounts of other components, passes through the fluidized bed under a pressure ranging from about 280 psig to about 300 psig with an ascending fluidization
10 speed, referred to herein as fluidization velocity, ranging from about 1.6 feet per second to about 2.0 feet per second.

In Examples 1-6 the Ziegler-Natta catalyst, Catalyst I, as described above in prepolymer form, was introduced intermittently into the reactor. The said catalyst contained magnesium, chlorine and titanium. The prepolymer form
15 contained about 34 grams of polyethylene per millimole of titanium and an amount of tri-n-octylaluminum (TnOA) such that the molar ratio, TnOA/Ti, ranged from 0.9:1 to about 1.0:1. In Examples 7 and 8 the Ziegler-Natta catalyst, Catalyst II, supplied by Toho Titanium Company, Limited was introduced directly into the reactor without having been formed into a
20 prepolymer. In Examples 9 - 13 the Ziegler-Natta catalyst, Catalyst III, supplied by Grace Davison was introduced directly into the reactor without having been formed into a prepolymer. The rate of introduction of the prepolymer or catalyst into the reactor was adjusted for each given set of conditions in achieving the desired production rate. During the polymerization the co-catalyst was
25 introduced continuously into the line for recycling the gaseous reaction mixture, at a point situated downstream of the heat transfer means. The feed rate of co-catalyst is expressed as a molar ratio of trialkylaluminum to titanium (Al/Ti), and is defined as the ratio of the co-catalyst feed rate (in moles of trialkylaluminum per hour) to the catalyst or prepolymer feed rate (in moles of titanium per hour).
30 Optionally, a solution of chloroform (CHCl_3) in n-hexane, at a concentration of

about 0.5 weight percent, was introduced continuously into the line for recycling the gaseous reaction mixture. The feed rate of the halogenated hydrocarbon is expressed as a molar ratio of CHCl_3 to titanium (CHCl_3/Ti), and is defined as the ratio of the CHCl_3 feed rate (in moles of CHCl_3 per hour) to the catalyst or prepolymer feed rate (in moles of titanium per hour).

The modifier was tetrahydrofuran (THF) in Examples 2, 8 and 10. The modifier was N_2O in Examples 4 and 5. A combination of THF and N_2O as the modifier was utilized in Examples 3 and 6. The modifier was acetonitrile (MeCN) in Example 11. The modifier was pyridine (Py) in Example 12. A combination of acetonitrile and pyridine was used in Example 13.

When a liquid modifier was utilized (for example THF, MeCN and Py), the liquid modifier was introduced continuously into the line for recycling the gaseous reaction mixture as a solution in either n-hexane or 1-hexene at a concentration of about 1 weight percent. The feed rate of modifier (Mod) is expressed as a molar ratio of modifier to titanium (Mod/Ti), and is defined as the ratio of the modifier feed rate (in moles of modifier per hour) to the catalyst or prepolymer feed rate (in moles of titanium per hour).

When gaseous modifier was utilized (for example, O_2 , N_2O , CO or CO_2), the gaseous modifier was introduced continuously into the line for recycling the gaseous reaction mixture. The concentration of gaseous modifier (for example, N_2O) in the gas phase polymerization medium is expressed in units of parts per million (ppm) by volume.

EXAMPLE 1 (Comparative)

The gas phase process conditions are given in Table 1, and the resin properties are given in Table 2. The molar ratio of trimethylaluminum (TMA) to titanium (Al/Ti) was 3:1. The molar ratio of chloroform (CHCl_3) to titanium (CHCl_3/Ti) was 0.03:1. The operation was conducted without the addition of a modifier. 1-Hexene was used as comonomer. Under these conditions an ethylene interpolymer free from agglomerate was withdrawn from the reactor at

a rate of 150 lb/h (pounds per hour). The productivity of the prepolymer was 375 pounds of polyethylene per pound of prepolymer.

The ethylene interpolmer had a density of 0.917 g/cc and a melt index MI (I_2) of 0.9 dg/min. The Melt Flow Ratio, I_{21}/I_2 , was 33 and the n-hexane
5 extractables were 2.9 % by weight. The DSC melting peak temperature (T_m) was 124.5 °C.

EXAMPLE 2

The gas phase process conditions are given in Table 1, and the resin
10 properties are given in Table 2. The molar ratio TMA to titanium (Al/Ti) was 7:1. The molar ratio CHCl_3/Ti was 0.06:1. The molar ratio of tetrahydrofuran (THF) to titanium (Mod/Ti) was 1:1. 1-Hexene was used as comonomer. Under these conditions an ethylene interpolmer free from agglomerate was withdrawn from the reactor at a rate of 192 lb/h. The productivity of the prepolymer was
15 231 pounds of polyethylene per pound of prepolymer.

The ethylene interpolmer had a density of 0.917 g/cc and a melt index MI (I_2) of 0.9 dg/min. The Melt Flow Ratio, I_{21}/I_2 , was 31 and the n-hexane extractables were 2.0 % by weight. The DSC melting peak temperature (T_m) was 123.9 °C.

20

EXAMPLE 3

The gas phase process conditions are given in Table 1, and the resin properties are given in Table 2. The molar ratio TMA to titanium (Al/Ti) was 7:1. The molar ratio CHCl_3/Ti was 0.06:1. The molar ratio THF to titanium
25 (Mod/Ti) was 1:1. The concentration of dinitrogen monoxide (N_2O) in the polymerization medium was 70 ppm by volume. 1-Hexene was used as comonomer. Under these conditions an ethylene interpolmer free from agglomerate was withdrawn from the reactor at a rate of 180 lb/h. The productivity of the prepolymer was 79 pounds of polyethylene per pound of
30 prepolymer.

The ethylene interpolpolymer had a density of 0.917 g/cc and a melt index MI (I_2) of 0.9 dg/min. The Melt Flow Ratio, I_{21}/I_2 , was 28 and the n-hexane extractables were 1.1 % by weight. The DSC melting peak temperature (T_m) was 122.3 °C.

5

EXAMPLE 4

The gas phase process conditions are given in Table 1, and the resin properties are given in Table 2. The molar ratio TMA to titanium (Al/Ti) was 7:1. The molar ratio CHCl_3/Ti was 0.06:1. The concentration of N_2O in the polymerization medium was 130 ppm by volume. 1-Hexene was used as comonomer. Under these conditions an ethylene interpolpolymer free from agglomerate was withdrawn from the reactor at a rate of 211 lb/h. The productivity of the prepolymer was 121 pounds of polyethylene per pound of prepolymer.

15 The ethylene interpolpolymer had a density of 0.917 g/cc and a melt index MI (I_2) of 0.9 dg/min. The Melt Flow Ratio, I_{21}/I_2 , was 28 and the n-hexane extractables were 1.6 % by weight. The DSC melting peak temperature (T_m) was 122.7 °C.

20

EXAMPLE 5

The gas phase process conditions are given in Table 1, and the resin properties are given in Table 2. The molar ratio TMA to titanium (Al/Ti) was 7:1. The molar ratio CHCl_3/Ti was 0.06:1. The concentration of N_2O in the polymerization medium was 210 ppm by volume. 1-Hexene was used as comonomer. Under these conditions an ethylene interpolpolymer free from agglomerate was withdrawn from the reactor at a rate of 194 lb/h. The productivity of the prepolymer was 124 pounds of polyethylene per pound of prepolymer.

25 The ethylene interpolpolymer had a density of 0.917 g/cc and a melt index MI (I_2) of 0.9 dg/min. The Melt Flow Ratio, I_{21}/I_2 , was 28 and the n-hexane

30

extractables were 1.1 % by weight. The DSC melting peak temperature (T_m) was 122.2 °C.

EXAMPLE 6

5 The gas phase process conditions are given in Table 1, and the resin properties are given in Table 2. The molar ratio TMA to titanium (Al/Ti) was 7:1. The molar ratio CHCl_3 /Ti was 0.06:1. The molar ratio THF to titanium (Mod/Ti) was 0.3:1. The concentration of N_2O in the polymerization medium was 300 ppm by volume. 1-Hexene was used as comonomer. Under these
10 conditions an ethylene interpolymer free from agglomerate was withdrawn from the reactor at a rate of 192 lb/h. The productivity of the prepolymer was 83 pounds of polyethylene per pound of prepolymer.

 The ethylene interpolymer had a density of 0.917 g/cc and a melt index MI (I_2) of 0.9 dg/min. The Melt Flow Ratio, I_{21}/I_2 , was 27 and the n-hexane
15 extractables were 0.8% by weight. The DSC melting peak temperature (T_m) was 120.0 °C.

Table 1: Reactor Conditions for Examples 1 through 6

		Example					
		1	2	3	4	5	6
5	Reactor Pressure (psig)	290	296	295	294	295	297
	Reactor Temperature (°C)	84	84	84	84	84	86
	Fluidization Velocity (ft/sec)	1.8	1.9	1.9	1.9	1.9	1.8
10	Fluidized Bulk Density (lb/ft ³)	17.0	17.8	17.1	17.5	16.7	15.2
	Reactor Bed Height (ft)	9.4	10.2	10.2	10.0	10.4	12.8
	Ethylene (mole%)	38	32	32	32	32	41
	H ₂ /C ₂ (molar ratio)	0.178	0.157	0.140	0.113	0.110	0.080
	1-Hexene/C ₂ (molar ratio)	0.191	0.153	0.138	0.128	0.124	0.115
15	Co-catalyst	TMA	TMA	TMA	TMA	TMA	TMA
	Al/Ti (molar ratio)	3	7	7	7	7	7
	CHCl ₃ /Ti	0.03	0.06	0.06	0.06	0.06	0.06
	Modifier 1	none	THF	THF	none	none	THF
	Mod ₁ /Ti (molar ratio) ¹	-	1	1	-	-	0.3
20	Modifier 2	none	none	N ₂ O	N ₂ O	N ₂ O	N ₂ O
	N ₂ O (ppm by volume)	-	-	70	130	210	300
	Catalyst Type	I	I	I	I	I	I
	Prepolymer Rate (lb/h)	0.4	0.83	2.29	1.74	1.56	2.30
	Production Rate (lb/h)	150	192	180	211	194	192
25	Productivity (mass ratio)	375	231	79	121	124	83
	Space Time Yield (lb/h-ft ³)	3.6	4.0	3.8	4.6	4.0	3.2
	Residual Titanium (ppm)	3.8	5.9	17.5	11.3	11.0	16.9

¹modifier 1 denoted as Mod₁.

Table 2: Resin Properties for Ethylene/Olefin Interpolymers Prepared in Examples 1-6

5		Example					
		1	2	3	4	5	6
	Density (g/cc)	0.917	0.917	0.917	0.917	0.917	0.917
	Melt Index, I ₂ (dg/min)	0.9	0.9	0.9	0.9	0.9	0.9
10	Melt Flow Ratio (I ₂₁ /I ₂)	33	31	28	28	28	27
	n-Hexane Extractable (wt%)	2.9	2.0	1.1	1.6	1.1	0.8
	DSC, T _m (°C) ¹	124.5	123.9	122.3	122.7	122.2	120.0
	Dart Impact (g/mil)	200	330	380	400	580	1750

¹ DSC melting peak temperature, T_m.

15

From the above data in Examples 1-6 and Tables 1 and 2 the following observations may be made. The addition of a modifier to the polymerization medium resulted in the preparation of an ethylene/1-hexene interpolymers, of a given melt index and density, having a reduced melting peak temperature (T_m) as measured by DSC. From the Examples 1-6 and Tables 1 and 2 it is further observed that the extent of the decrease in the DSC melting peak temperature is dependent upon the modifier utilized and/or the amount of modifier utilized.

20

EXAMPLE 7 (COMPARATIVE)

The gas phase process conditions are given in Table 3, and the resin properties are given in Table 4. The molar ratio of trimethylaluminum (TMA) to titanium was 30:1. 1-Hexene was used as comonomer. Under these conditions an ethylene interpolymer free from agglomerate was withdrawn from the reactor at a rate of 229 lb/h.

The ethylene interpolymer had a density of 0.918 g/cc and a melt index MI (I_2) of 0.9 dg/min. The Melt Flow Ratio, I_{21}/I_2 , was 30. The DSC melting peak temperature (T_m) was 124.8°C.

EXAMPLE 8

The gas phase process conditions are given in Table 3, and the resin properties are given in Table 4. The molar ratio of trimethylaluminum (TMA) to titanium was 19:1. The molar ratio of CHCl_3 to titanium was 0.06:1. The molar ratio of THF to titanium was 2.5:1. 1-Hexene was used as comonomer. Under these conditions an ethylene interpolymer free from agglomerate was withdrawn from the reactor at a rate of 201 lb/h.

The ethylene interpolymer had a density of 0.918 g/cc and a melt index MI (I_2) of 0.8 dg/min. The Melt Flow Ratio, I_{21}/I_2 , was 27. The DSC melting peak temperature (T_m) was 124.4°C.

EXAMPLE 9 (COMPARATIVE)

The gas phase process conditions are given in Table 3, and the resin properties are given in Table 4. The molar ratio of triethylaluminum (TEAL) to titanium was 20:1. 1-Hexene was used as comonomer. Under these conditions an ethylene interpolymer free from agglomerate was withdrawn from the reactor at a rate of 212 lb/h.

The ethylene interpolymer had a density of 0.917 g/cc and a melt index MI (I_2) of 0.9 dg/min. The Melt Flow Ratio, I_{21}/I_2 , was 27. The DSC melting peak temperature (T_m) was 124.4°C.

EXAMPLE 10

The gas phase process conditions are given in Table 3, and the resin properties are given in Table 4. The molar ratio of triethylaluminum (TEAL) to titanium was 20:1. The molar ratio of CHCl_3 to titanium was 0.06:1. The molar ratio of THF to titanium was 4:1. 1-Hexene was used as comonomer. Under these conditions an ethylene interpolymer free from agglomerate was withdrawn from the reactor at a rate of 208 lb/h.

The ethylene interpolymer had a density of 0.917 g/cc and a melt index MI (I_2) of 0.9 dg/min. The Melt Flow Ratio, I_{21}/I_2 , was 27. The DSC melting peak temperature (T_m) was 122.9°C.

Table 3: Reactor Conditions for Examples 7 through 10

		Example			
		7	8	9	10
5	Reactor Pressure (psig)	295	294	294	294
	Reactor Temperature (°C)	85	85	86	86
	Fluidization Velocity (ft/sec)	1.8	1.9	1.8	1.8
10	Fluidized Bulk Density (lb/ft ³)	17.1	18.1	13.9	14.3
	Reactor Bed Height (ft)	10	10	12	12
	Ethylene (mole%)	27.7	25.2	40.3	32.3
	H ₂ /C ₂ (molar ratio)	0.210	0.283	0.276	0.287
15	1-Hexene/C ₂ (molar ratio)	0.175	0.193	0.112	0.110
	Co-catalyst	TMA	TMA	TEAL	TEAL
	Al/Ti (molar ratio)	30	19	20	20
	CHCl ₃ /Ti	0	0.06	0	0.06
	Modifier 1	none	THF	none	THF
20	Mod ₁ /Ti (molar ratio) ¹	-	2.5	-	4
	Catalyst Type	II	II	III	III
	Production Rate (lb/h)	229	201	212	208
	Space Time Yield (lb/h-ft ³)	78.3	72.8	60.8	59.9
	Residual Titanium (ppm)	0.8	1.1	0.6	0.4

¹modifier 1 denoted as Mod₁.

Table 4: Resin Properties for Ethylene/Olefin Interpolymers prepared in Examples 7-10

		Example			
5		7	8	9	10
	Density (g/cc)	0.918	0.918	0.917	0.917
	Melt Index, I ₂ (dg/min)	0.9	0.8	0.9	0.9
10	Melt Flow Ratio (I ₂₁ /I ₂)	30	27	27	27
	DSC, T _m (°C) ¹	124.8	124.4	124.4	122.9
	Dart Impact (g/mil)	249	454	1570	1075

¹ DSC melting peak temperature, T_m.

15 From the above data in Examples 7 and 8 and Tables 3 and 4 the following observations may be made. The addition of a modifier to the polymerization medium resulted in the production of an ethylene/1-hexene interpolpolymer, of a given melt index and density, having a reduced melting peak temperature (T_m) as measured by DSC.

20 From the above data in Examples 9-10 and Tables 3 and 4 the following observations may be made. The addition of a modifier to the polymerization medium resulted in the production of an ethylene/1-hexene interpolpolymer, of a given melt index and density, having a reduced melting peak temperature (T_m) as measured by DSC.

25

EXAMPLE 11 –13

The process of Example 10 was followed with the exception that in place of THF, the modifier(s) utilized was as follows.

- Example 11 acetonitrile at a molar ratio to titanium of 1:1,
- 30 Example 12 pyridine at a molar ratio to titanium of 1:1,

Example 13 acetonitrile at a molar ratio to titanium of 1:1 and
pyridine at a molar ratio to titanium of 1:1.

In each of the above Examples 11-13 a satisfactory ethylene/1-hexene
interpolymer was produced.

5

EXAMPLES 14 - 38

The process of Example 2 is followed with the exception that in place of
THF, the modifier utilized to reduce the DSC melting peak temperature of the
ethylene/1-hexene interpolymer is as follows. The particular modifier is utilized
10 in an amount sufficient to reduce the melting peak temperature of the ethylene/1-
hexene interpolymer.

	Example 14	diethyl ether,
	Example 15	dibutyl ether,
	Example 16	diisopropyl ether,
15	Example 17	tert-butyl methyl ether,
	Example 18	1,2-dimethoxyethane,
	Example 19	furan,
	Example 20	ethyl benzoate,
	Example 21	<i>p</i> -ethoxy ethyl benzoate,
20	Example 22	2-butanone,
	Example 23	2,4-dimethyl-3-pentanone,
	Example 24	triisopropylamine,
	Example 25	1-isobutylpiperidine,
	Example 26	<i>N,N</i> -dimethylformamide,
25	Example 27	<i>N,N</i> -dimethylacetamide,
	Example 28	benzonitrile,
	Example 29	isopropionitrile,
	Example 30	trifluoroacetaldehyde,
	Example 31	benzaldehyde,
30	Example 32	tetrahydrothiophene,

	Example 33	2,5-dimethyltetrahydrothiophene,
	Example 34	isopropyl thiobenzoate,
	Example 35	isobutyl thiolacetate,
	Example 36	cyclohexylmethyldimethoxysilane,
5	Example 37	tetraethyl orthosilicate,
	Example 38	dicyclopentyldimethoxysilane,

In each of the above Examples 14-38 the DSC melting peak temperature (T_m) of the ethylene interpolpolymer, having a given melt index and density, is
10 expected to be reduced as a result of utilizing the particular modifier compound hereinabove in the polymerization medium in place of THF as the modifier.

EXAMPLES 39-43

The process of Example 2 is followed with the exception that in place of
15 the 1-hexene there is utilized the following comonomers:

	Example 39	propylene,
	Example 40	1-butene,
	Example 41	1-pentene,
	Example 42	4-methylpent-1-ene,
20	Example 43	1-octene.

In each of the above Examples 39-43 the DSC melting peak temperature (T_m) of the ethylene interpolpolymer, having a given melt index and density, is
expected to be reduced as a result of incorporating THF in the polymerization medium.

25

EXAMPLES 44-46

The process of Example 10 is generally followed with the exception that in place of Catalyst III there is used a metallocene catalyst, supported on silica, as follows. Further, the hydrogen concentration in the polymerization medium is

adjusted to a level where high molecular weight ethylene/olefin interpolymers can be produced.

	Example 44	bis(1-butyl-3-methylcyclopentadienyl)zirconium dichloride and methylaluminoxane,
5	Example 45	bis(1-butyl-3-methylcyclopentadienyl)dimethyl zirconocene and tris(perfluorophenyl)borane,
	Example 46	(tert-butylamido)dimethyl(tetramethyl- η^5 -cyclopentadienyl)silane titanium dimethyl and triphenylmethylmethyl tetrakis(perfluorophenyl)borate
10		.

In each of the above Examples 44-46 the DSC melting peak temperature of the ethylene/1-hexene interpolymers, having a given melt index and density, is expected to be reduced as a result of incorporating THF in the polymerization medium.

15 Films can be prepared from the ethylene/olefin interpolymers of the present invention.

Articles such as molded items can also be prepared from the ethylene/olefin interpolymers of the present invention.

20 It should be clearly understood that the forms of the invention herein described are illustrative only and are not intended to limit the scope of the invention. The present invention includes all modifications falling within the scope of the following claims.

CLAIMS

We claim:

1. A process for polymerizing ethylene and at least one or more other olefin(s)
5 to produce an ethylene/olefin interpolymers having, at a given melt index and density, a reduced melting peak temperature (T_m) comprising contacting in a polymerization medium ethylene and at least one or more other olefin(s), an olefin polymerization catalyst and at least one modifier comprising at least one element selected from Group 15 and Group 16 of the Periodic Table of
10 Elements in an amount sufficient to reduce the melting peak temperature (T_m) of the ethylene/olefin interpolymers to a level lower than would result in the same polymerization process in the absence of the modifier.
2. The process according to Claim 1 wherein the olefin polymerization catalyst comprises at least one metal selected from Groups 3, 4, 5, 6, 7, 8, 9, 10 and
15 13 of the Periodic Table of the Elements, as defined herein and mixtures thereof.
3. The process according to Claim 2 wherein the metal is selected from the group consisting of titanium, zirconium, vanadium, iron, chromium, nickel, aluminum, and mixtures thereof.
- 20 4. The process according to Claim 3 wherein the metal is selected from the group consisting of titanium, zirconium, vanadium, and mixtures thereof.
5. The process according to Claim 2 wherein the olefin polymerization catalyst is neutral or cationic.
6. The process according to Claim 1 wherein the olefin polymerization catalyst
25 is selected from the group consisting of organochromium catalysts, chromium oxide catalysts, Ziegler-Natta catalysts, olefin polymerization catalysts that polymerize olefins to produce ethylene/olefin interpolymers having a molecular weight distribution (MWD) of from 1 to 2.5, and metallocene catalysts.

7. The process according to Claim 6 wherein the olefin polymerization catalyst is selected from the group consisting of Ziegler-Natta catalysts and metallocene catalysts.
8. The process according to Claim 1 wherein the olefin polymerization catalyst
5 is supported on a carrier.
9. The process according to Claim 8 wherein the carrier is selected from the group consisting of silica, alumina, magnesium chloride, and mixtures thereof.
10. The process according to Claim 1 further comprising adding a halogenated
10 hydrocarbon to the polymerization medium.
11. The process according to Claim 10 wherein the halogenated hydrocarbon is selected from the group consisting of dichloromethane, chloroform, carbon tetrachloride, chlorofluoromethane, chlorodifluoromethane, dichlorodifluoromethane, fluorodichloromethane, chlorotrifluoromethane, fluorotrichloromethane, and 1,2-dichloroethane.
15
12. The process according to Claim 11 wherein the halogenated hydrocarbon is chloroform.
13. The process according to Claim 1 wherein the at least one modifier is selected from the group consisting of carboxylic acid esters, anhydrides, acid
20 halides, ethers, thioethers, aldehydes, ketones, imines, amines, amides, nitriles, isonitriles, cyanates, isocyanates, thiocyanates, isothiocyanates, thioesters, dithioesters, carbonic esters, hydrocarbyl carbamates, hydrocarbyl thiocarbamates, hydrocarbyl dithiocarbamates, urethanes, sulfoxides, sulfones, sulfonamides, organosilicon compounds containing at least one
25 oxygen atom, compounds of nitrogen, phosphorus, arsenic or antimony connected to an organic group through a carbon or oxygen atom, O₂, CO, CO₂, COS, NO, N₂O, and NO₂.
14. The process according to Claim 13 wherein the at least one modifier is selected from the group consisting of carboxylic acid esters, ethers, amines,

amides, nitriles, organosilicon compounds containing at least one oxygen atom, O₂, CO, CO₂, and N₂O.

15. The process according to Claim 14 wherein the at least one modifier is an ether selected from the group consisting of tetrahydrofuran, diethyl ether,
5 dipropyl ether, diisopropyl ether, dibutyl ether, dioctyl ether, tert-butyl methyl ether, trimethylene oxide, 1,2-dimethoxyethane, 1,2-dimethoxypropane, 1,3-dimethoxypropane, 1,2-dimethoxybutane, 1,3-dimethoxybutane, 1,4-dimethoxybutane, and tetrahydropyran.
16. The process according to Claim 14 wherein the at least one modifier is an
10 amine selected from the group consisting of pyridine, 4-methyl pyridine, *N*-methyldmorpholine, and *N*-methylimidazole.
17. The process according to Claim 14 wherein the at least one modifier is an organosilicon compound containing at least one oxygen atom selected from the group consisting of cyclohexylmethyldimethoxysilane, tetraethyl
15 orthosilicate, and dicyclopentyldimethoxysilane.
18. The process according to Claim 14 wherein the at least one modifier is a nitrile selected from the group consisting of acetonitrile, trimethylacetonitrile, benzonitrile, and isopropionitrile.
19. The process according to Claim 14 wherein the at least one modifier is an
20 amide selected from the group consisting of *N,N*-dimethylformamide, *N,N*-dimethylacetamide, and *N,N*-diisopropylformamide.
20. The process according to Claim 14 wherein the at least one modifier is selected from the group consisting of O₂, CO, CO₂, and N₂O.
21. The process according to Claim 20 wherein the at least one modifier is N₂O.
- 25 22. The process according to Claim 1 wherein the modifier is liquid or solid and is added in a molar ratio of to metal component of the olefin polymerization catalyst ranging from about 0.01:1 to about 100:1.
23. The process according to Claim 22 wherein the molar ratio of modifier to metal component of the olefin polymerization catalyst ranges from about
30 0.1:1 to about 50:1.

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24. The process according to Claim 1 wherein the at least one modifier is gaseous and is added in an amount ranging from about 1 ppm by volume to about 10,000 ppm by volume.
25. The process according to Claim 24 wherein the at least one modifier is added
5 in an amount ranging from about 1 ppm by volume to about 1000 ppm by volume.
26. The process according to Claim 1 wherein the polymerization medium is gas phase.
27. The process according to Claim 1 wherein the polymerization medium is
10 slurry phase.
28. The process according to Claim 1 wherein the at least one or more other olefin(s) is selected from the group consisting of olefins having 3 to 16 carbon atoms.
29. The process according to Claim 28 wherein the at least one or more other
15 olefin(s) is selected from the group consisting of 1-octene, 1-hexene, 4-methylpent-1-ene, 1-pentene, 1-butene, and propylene.
30. The process according to Claim 1 wherein the ethylene/olefin interpolymers comprises ethylene in an amount of at least about 50% by weight of the interpolymers.
- 20 31. An ethylene/olefin interpolymers product prepared in accordance with the process of Claim 1.
32. A film fabricated from the ethylene/olefin interpolymers produced in accordance with Claim 1.
- 25 33. An article fabricated from the ethylene/olefin interpolymers produced in accordance with Claim 1.

AMENDED SHEET

Art. 34

33. The process according to Claim 32 wherein the metal is selected from the group consisting of titanium, zirconium, vanadium, iron, chromium, nickel, aluminum, and mixtures thereof.
34. The process according to Claim 33 wherein the metal is selected from the group consisting of titanium, zirconium, vanadium, and mixtures thereof.
35. The process according to Claim 32 wherein the olefin polymerization catalyst is neutral or cationic.
36. The process according to Claim 31 wherein the olefin polymerization catalyst is selected from the group consisting of organochromium catalysts, chromium oxide catalysts, Ziegler-Natta catalysts, olefin polymerization catalysts that polymerize olefins to produce ethylene/olefin interpolymers having a molecular weight distribution (MWD) of from 1 to 2.5, and metallocene catalysts.
37. The process according to Claim 36 wherein the olefin polymerization catalyst is selected from the group consisting of Ziegler-Natta catalysts and metallocene catalysts.
38. The process according to Claim 31 wherein the olefin polymerization catalyst is supported on a carrier.
39. The process according to Claim 38 wherein the carrier is selected from the group consisting of silica, alumina, magnesium chloride, and mixtures thereof.
40. The process according to Claim 31 further comprising adding a halogenated hydrocarbon to the polymerization medium.
41. The process according to Claim 40 wherein the halogenated hydrocarbon is selected from the group consisting of dichloromethane, chloroform, carbon tetrachloride, chlorofluoromethane, chlorodifluoromethane, dichlorodifluoromethane, fluorodichloromethane, chlorotrifluoromethane, fluorotrichloromethane, and 1,2-dichloroethane.
42. The process according to Claim 41 wherein the halogenated hydrocarbon is chloroform.

43. The process according to Claim 31 wherein the at least one modifier is selected from the group consisting of carboxylic acid esters, anhydrides, acid halides, ethers, thioethers, aldehydes, ketones, imines, amines, amides, nitriles, isonitriles, cyanates, isocyanates, thiocyanates, isothiocyanates, thioesters, dithioesters, carbonic esters, hydrocarbyl carbamates, hydrocarbyl thiocarbamates, hydrocarbyl dithiocarbamates, urethanes, sulfoxides, sulfones, sulfonamides, organosilicon compounds containing at least one oxygen atom, compounds of nitrogen, phosphorus, arsenic or antimony connected to an organic group through a carbon or oxygen atom, O₂, CO, CO₂, COS, NO, N₂O, and NO₂.
44. The process according to Claim 43 wherein the at least one modifier is selected from the group consisting of carboxylic acid esters, ethers, amines, amides, nitriles, organosilicon compounds containing at least one oxygen atom, O₂, CO, CO₂, and N₂O.
45. The process according to Claim 44 wherein the at least one modifier is an ether selected from the group consisting of tetrahydrofuran, diethyl ether, dipropyl ether, diisopropyl ether, dibutyl ether, dioctyl ether, tert-butyl methyl ether, trimethylene oxide, 1,2-dimethoxyethane, 1,2-dimethoxypropane, 1,3-dimethoxypropane, 1,2-dimethoxybutane, 1,3-dimethoxybutane, 1,4-dimethoxybutane, and tetrahydropyran.
46. The process according to Claim 44 wherein the at least one modifier is an amine selected from the group consisting of pyridine, 4-methyl pyridine, *N*-methylemorpholine, and *N*-methylimidazole.
47. The process according to Claim 44 wherein the at least one modifier is an organosilicon compound containing at least one oxygen atom selected from the group consisting of cyclohexylmethyldimethoxysilane, tetraethyl orthosilicate, and dicyclopentyldimethoxysilane.
48. The process according to Claim 44 wherein the at least one modifier is a nitrile selected from the group consisting of acetonitrile, trimethylacetonitrile, benzonitrile, and isopropionitrile.

49. The process according to Claim 44 wherein the at least one modifier is an amide selected from the group consisting of *N,N*-dimethylformamide, *N,N*-dimethylacetamide, and *N,N*-diisopropylformamide.
50. The process according to Claim 44 wherein the at least one modifier is
5 selected from the group consisting of O₂, CO, CO₂, and N₂O.
51. The process according to Claim 50 wherein the at least one modifier is N₂O.
52. The process according to Claim 31 wherein the at least one modifier is liquid or solid and is added in a molar ratio of to metal component of the olefin polymerization catalyst ranging from about 0.01:1 to about 100:1.
- 10 53. The process according to Claim 52 wherein the molar ratio of modifier to metal component of the olefin polymerization catalyst ranges from about 0.1:1 to about 50:1.
54. The process according to Claim 31 wherein the at least one modifier is gaseous and is added in an amount ranging from about 1 ppm by volume to
15 about 10,000 ppm by volume.
55. The process according to Claim 54 wherein the at least one modifier is added in an amount ranging from about 1 ppm by volume to about 1000 ppm by volume.
56. The process according to Claim 31 wherein the polymerization medium is
20 gas phase.
57. The process according to Claim 31 wherein the polymerization medium is slurry phase.
58. The process according to Claim 31 wherein the at least one or more other olefin(s) is selected from the group consisting of olefins having 3 to 16
25 carbon atoms.
59. The process according to Claim 58 wherein the at least one or more other olefin(s) is selected from the group consisting of 1-octene, 1-hexene, 4-methylpent-1-ene, 1-pentene, 1-butene, and propylene.

60. The process according to Claim 31 wherein the ethylene/olefin interpolymer comprises ethylene in an amount of at least about 50% by weight of the interpolymer.
61. An ethylene/olefin interpolymer product prepared in accordance with the
5 process of Claim 1.
62. A film fabricated from the ethylene/olefin interpolymer produced in accordance with Claim 1.
63. An article fabricated from the ethylene/olefin interpolymer produced in accordance with Claim 1.