



(51) International Patent Classification:

C08F 10/06 (2006.01) *C07F 17/00* (2006.01)
C08F 4/16 (2006.01) *C07F 7/00* (2006.01)

(21) International Application Number:

PCT/US2012/027675

(22) International Filing Date:

5 March 2012 (05.03.2012)

(25) Filing Language:

English

(26) Publication Language:

English

(30) Priority Data:

61/467,681 25 March 2011 (25.03.2011) US
11165831.6 12 May 2011 (12.05.2011) EP

(71) Applicant (for all designated States except US): **EXXON-MOBIL CHEMICAL PATENTS INC.** [US/US]; A Corporation Of The State Of Delaware, 5200 Bayway Drive, Baytown, TX 77520-2101 (US).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **JIANG, Peijun** [US/US]; 119 Mariner Cove Court, League City, TX 77573 (US). **BRANT, Patrick** [US/US]; 1038 Shorewood Drive, Seabrook, TX 77586 (US).

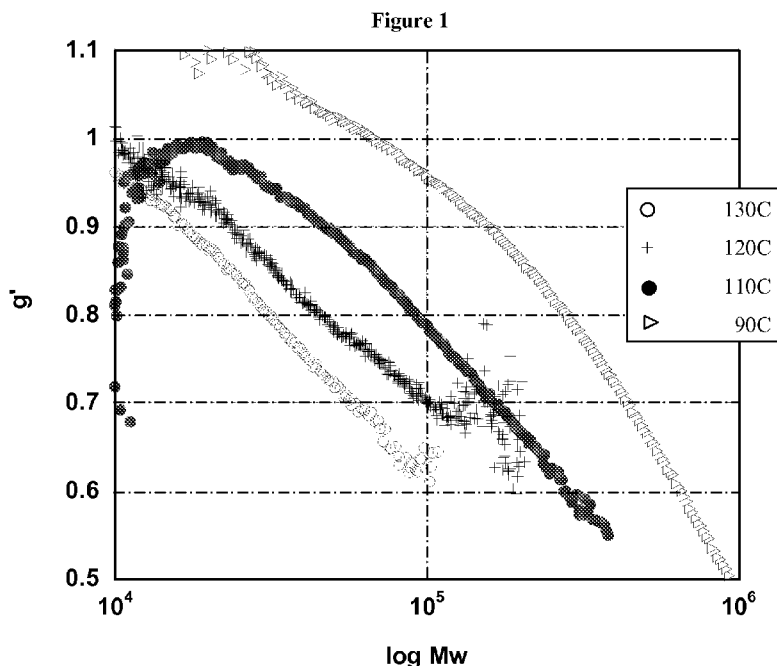
(74) Agents: **BELL, Catherine L.** et al.; Exxonmobil Chemical Company, Law Technology, P.o.box 2149, Baytown, TX 77522-2149 (US).

(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LT, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

[Continued on next page]

(54) Title: BRANCHED VINYL TERMINATED POLYMERS AND METHODS FOR PRODUCTION THEREOF



(57) Abstract: This invention relates to a process for polymerization, comprising (i) contacting, at a temperature greater than 35°C, one or more monomers comprising ethylene and/or propylene, with a catalyst system comprising a metallocene catalyst compound and an activator, (ii) converting at least 50 mol% of the monomer to polyolefin; and (iii) obtaining a branched polyolefin having greater than 50% allyl chain ends, relative to total unsaturated chain ends. The invention also relates to the branched polyolefins and functionalized branched polyolefins.

**Declarations under Rule 4.17:**

- *as to applicant's entitlement to apply for and be granted a patent (Rule 4.17(ii))*
- *as to the applicant's entitlement to claim the priority of the earlier application (Rule 4.17(iii))*

Published:

- *without international search report and to be republished upon receipt of that report (Rule 48.2(g))*

TITLE: BRANCHED VINYL TERMINATED POLYMERS AND METHODS FOR PRODUCTION THEREOF

INVENTORS: Peijun Jiang and Patrick Brant

5 **PRIORITY**

[0001] This application claims priority to and the benefit of 61/467,681, filed March 25, 2011 and EP 11165831.6, filed May 12, 2011.

FIELD OF THE INVENTION

10 [0002] This invention relates to olefin polymerization, particularly to produce vinyl terminated polymers.

BACKGROUND OF THE INVENTION

15 [0003] Alpha-olefins, especially those containing about 6 to about 20 carbon atoms, have been used as intermediates in the manufacture of detergents or other types of commercial products. Such alpha-olefins have also been used as comonomers, especially in linear low density polyethylene. Commercially produced alpha-olefins are typically made by oligomerizing ethylene. Longer chain alpha-olefins, such as vinyl-terminated polyethylenes are also known and can be useful as building blocks following functionalization or as macromonomers.

20 [0004] Allyl terminated low molecular weight solids and liquids of ethylene or propylene have also been produced, typically for use as branches in polymerization reactions. See, for example, Rulhoff, Sascha and Kaminsky, ("Synthesis and Characterization of Defined Branched Poly(propylene)s with Different Microstructures by Copolymerization of Propylene and Linear Ethylene Oligomers ($C_n=26-28$) with Metallocenes/MAO Catalysts," Macromolecules, 16, 2006, pp. 1450-1460), and Kaneyoshi, Hiromu et al. ("Synthesis of Block and Graft Copolymers with Linear Polyethylene Segments by Combination of Degenerative Transfer Coordination Polymerization and Atom Transfer Radical Polymerization," Macromolecules, 38, 2005, pp. 5425-5435).

25 [0005] Further, U.S. Patent No. 4,814,540 discloses bis(pentamethyl cyclopentadienyl) hafnium dichloride, bis(pentamethyl cyclopentadienyl) zirconium dichloride and
30 bis(tetramethyl n-butyl cyclopentadienyl) hafnium dichloride with methylalumoxane in toluene or hexane with or without hydrogen to make allylic vinyl terminated propylene homo-oligomers having a low degree of polymerization of 2-10. These oligomers do not

have high Mns and do not have at least 93% allylic vinyl unsaturation. Likewise, these oligomers lack comonomer and are produced at low productivities with a large excess of alumoxane (molar ratio ≥ 600 Al/M ; M= Zr, Hf). Additionally, no less than 60 wt% solvent (solvent + propylene basis) is present in all of the examples.

5 [0006] Teuben, et al. (J. Mol. Catal., 62, 1990, pp. 277-287) discloses the use of [Cp*₂MMe(THT)]+[BPh₄] (M= Zr and Hf; Cp* = pentamethylcyclopentadienyl; Me = methyl, Ph = phenyl; THT = tetrahydrothiophene), to make propylene oligomers. For M = Zr, a broad product distribution with oligomers up to C₂₄ (number average molecular weight (Mn) of 336) was obtained at room temperature. Whereas, for M = Hf, only the dimer 4-
10 methyl-1-pentene and the trimer 4,6-dimethyl-1-heptene were formed. The dominant termination mechanism appeared to be beta-methyl transfer from the growing chain back to the metal center, as was demonstrated by deuterium labeling studies.

[0007] X. Yang, et al. (Angew. Chem. Intl Ed. Engl., 31, 1992, pp. 1375) discloses amorphous, low molecular weight polypropylene made at low temperatures where the
15 reactions showed low activity and product having 90% allylic vinyls, relative to all unsaturations, by ¹H NMR. Thereafter, Resconi, et al. (J. Am. Chem. Soc., 114, 1992, pp. 1025-1032), discloses the use of bis(pentamethylcyclopentadienyl)zirconium and bis(pentamethylcyclopentadienyl)hafnium to polymerize propylene and obtained beta-methyl
20 termination resulting in oligomers and low molecular weight polymers with "mainly allyl- and iso-butyl-terminated" chains. As is the case in U.S. Patent No. 4,814,540, the oligomers produced do not have at least 93% allyl chain ends, an Mn of about 500 to about 20,000 g/mol (as measured by ¹H NMR), and the catalyst has low productivity (1-12,620 g/mmol metallocene/hr; >3000 wppm Al in products).

[0008] Similarly, Small and Brookhart, (Macromolecules, 32, 1999, pp. 2322) disclose
25 the use of a pyridylbisamido iron catalyst in a low temperature polymerization to produce low molecular weight amorphous propylene materials apparently having predominant or exclusive 2,1 chain growth, chain termination via beta-hydride elimination, and high amounts of vinyl end groups.

[0009] Weng et al. (Macromol Rapid Comm. 2000, 21, pp. 1103-1107) discloses
30 materials with up to about 81% vinyl termination made using dimethylsilyl bis(2-methyl, 4-phenyl-indenyl) zirconium dichloride and methylalumoxane in toluene at about 120°C. The

materials have a Mn of about 12,300 (measured with ^1H NMR) and a melting point of about 143°C.

[0010] Markel et al. (Macromolecules, 33, 2000, pp. 8541-8548) discloses comb branch-block polyethylene made with Cp_2ZrCl_2 and $(\text{C}_5\text{Me}_4\text{SiMe}_2\text{NC}_{12}\text{H}_{23})\text{TiCl}_2$, activated with methyl alumoxane.

[0011] Moscardi, et al. (Organometallics, 20, 2001, pp. 1918) discloses the use of *rac*-dimethylsilylmethylenebis(3-*t*-butyl indenyl)zirconium dichloride with methylalumoxane in batch polymerizations of propylene to produce materials where "...allyl end group always prevails over any other end groups, at any [propene]." In these reactions, morphology control was limited and approximately 60% of the chain ends are allylic.

[0012] Coates, et al. (Macromolecules, 38, 2005, pp. 6259) discloses preparation of low molecular weight syndiotactic polypropylene ($[\text{rrrr}] = 0.46\text{-}0.93$) with about 100% allyl end groups using bis(phenoxyimine)titanium dichloride $(\text{PHI})_2\text{TiCl}_2$ activated with modified methyl alumoxane (MMAO; Al/Ti molar ratio = 200) in batch polymerizations run between -20°C and +20°C for four hours. For these polymerizations, propylene was dissolved in toluene to create a 1.65 M toluene solution. Catalyst productivity was very low (0.95 to 1.14 g/mmol Ti/hr).

[0013] JP 2005-336092 A2 discloses the manufacture of vinyl-terminated propylene polymers using materials such as H_2SO_4 treated montmorillonite, triethylaluminum, triisopropyl aluminum, where the liquid propylene is fed into a catalyst slurry in toluene. This process produces substantially isotactic macromonomers that do not have a significant amount of amorphous material.

[0014] U.S. Patent No. 6,897,261 discloses olefin graft copolymers obtained by copolymerizing an atactic branched macromonomer, wherein the macromonomer is derived from monomers selected from the group consisting of (1) propylene and (2) the combination of propylene and at least one selected from ethylene, alpha-olefins having from 4 to 20 carbon atoms, cyclic olefins and styrenes, and of which the propylene content falls between 0.1 mol% and 100 mol%, and which macromonomer satisfies the following (a) and (b): (a) its weight-average molecular weight (Mw) measured through gel permeation chromatography (GPC) falls between 400 and 200000; (b) its vinyl content is at least 70 mol% of all the unsaturated groups in the macromonomer, wherein the macromonomer satisfies each of the following (i), (ii), and (iii): (i) the ratio of the temperature dependency

(E_2) of the macromonomer solution viscosity to the temperature dependency (E_1) of the solution viscosity of the linear polymer which has the same type of monomer, the same chemical composition and the same intrinsic viscosity as those of the macromonomer, E_2 / E_1 , satisfies the following relationship: $1.0 < E_2 / E_1 < 2.5$.

- 5 **[0015]** Rose, et al. (Macromolecules, 41, 2008, pp. 559-567) discloses poly(ethylene-co-propylene) macromonomers not having significant amounts of iso-butyl chain ends. Those were made with bis(phenoxyimine) titanium dichloride ($(\text{PHI})_2\text{TiCl}_2$) activated with modified methylalumoxane (MMAO; Al/Ti molar ratio range 150 to 292) in semi-batch polymerizations (30 psi propylene added to toluene at 0°C for 30 min, followed by ethylene
10 gas flow at 32 psi of over-pressure at about 0°C for polymerization times of 2.3 to 4 hours to produce E-P copolymer having an M_n of about 4,800 to 23,300. In four reported copolymerizations, allylic chain ends decreased with increasing ethylene incorporation roughly according to the equation:

$$\% \text{ allylic chain ends (of total unsaturations)} = -0.95(\text{mol\% ethylene incorporated}) + 100.$$

- 15 For example, 65% allyl (compared to total unsaturation) was reported for E-P copolymer containing 29 mol% ethylene. This is the highest allyl population achieved. For 64 mol% incorporated ethylene, only 42% of the unsaturations are allylic. Productivity of these polymerizations ranged from 0.78×10^2 g/mmol Ti/hr to 4.62×10^2 g/mmol Ti/hr.

- 20 **[0016]** Prior to this work, Zhu, et al. (Macromolecules, 35, 2002, pp. 10062-10070 and Macromolecules Rap. Commun., 24, 2003, pp. 311-315) reported only low (~38%) vinyl terminated ethylene-propylene copolymer made with the constrained geometry metallocene catalyst $[\text{C}_5\text{Me}_4(\text{SiMe}_2\text{N-tert-butyl})\text{TiMe}_2]$ activated with $\text{B}(\text{C}_6\text{F}_5)_3$ and MMAO.

- 25 **[0017]** Janiak and Blank summarize a variety of work related to oligomerization of olefins (Macromol. Symp., 236, 2006, pp. 14-22).

- 30 **[0018]** U.S. Patent No. 6,225,432 discloses branched polypropylene compositions which have improved melt strength and good processability. The branched polypropylene compositions have a polydispersity of less than 4.0 and a melt point greater than 90°C. The weight average branching index g of the polypropylene compositions is less than 0.95.

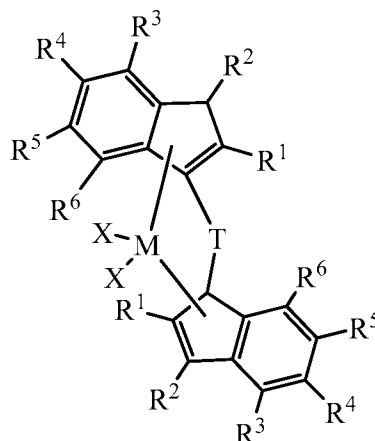
- 30 **[0019]** However, processes to make branched polyolefins having high amounts of allyl terminations on a commercial scale are not known. Accordingly, there is a need for new processes that produce allyl terminated branched polyolefins that have allyl termination present in high amounts (50% or more), particularly in high yields and with a wide range of

molecular weights, that can be made at commercial rates (5,000 g/mmol/hr productivity or more). There is further a need for branched polyolefin reactive materials having high amounts of allyl termination which can be functionalized and used in additive applications or as blending components.

5 SUMMARY OF THE INVENTION

[0020] The invention relates to processes for polymerization, comprising:

- (i) contacting, preferably at a temperature greater than 35°C, one or more monomers comprising ethylene and/or propylene, with a catalyst system comprising a metallocene catalyst compound and an activator, wherein the metallocene catalyst compound is
- 10 represented by the following formula:



where

- M is selected from the group consisting of zirconium or hafnium;
- each X is, independently, selected from the group consisting of hydrocarbyl radicals having
- 15 from 1 to 20 carbon atoms, hydrides, amides, alkoxides, sulfides, phosphides, halides, dienes, amines, phosphines, ethers, and a combination thereof, (two X's may form a part of a fused ring or a ring system);
- each R¹, R², R³, R⁴, R⁵, and R⁶, is, independently, hydrogen or a substituted or unsubstituted hydrocarbyl group, a heteroatom or heteroatom containing group;
- 20 further provided that any two adjacent R groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or saturated; and
- further provided that any of adjacent R⁴, R⁵, and R⁶ groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or saturated;

T is a bridging group represented by the formula R_2^aJ , where J is one or more of C, Si, Ge, N, or P, and each R^a is, independently, hydrogen, halogen, C_1 to C_{20} hydrocarbyl or a C_1 to C_{20} substituted hydrocarbyl,

provided that at least one R^3 is a substituted or unsubstituted phenyl group, if any of R^1 , R^2 , R^4 , R^5 or R^6 are not hydrogen;

(ii) preferably converting at least 50 mol% of the monomer to polyolefin; and

(iii) obtaining a branched polyolefin having greater than 50% allyl chain ends, relative to total unsaturated chain ends and a T_m of 60 °C or more.

[0021] This invention also relates to a branched polyolefin having an M_n (1H NMR) of

7,500 to 60,000 g/mol comprising one or more alpha olefin derived units comprising ethylene and/or propylene, and having:

(i) 50% or greater allyl chain ends, relative to total number of unsaturated chain ends; and

(ii) a g'_{vis} of 0.90 or less.

[0022] This invention also relates to branched polyolefins having an M_n (GPC) greater

than 60,000 g/mol comprising one or more alpha olefins comprising ethylene and/or propylene, and having: (i) 50% or greater allyl chain ends, relative to total unsaturated chain ends; (ii) a g'_{vis} of 0.90 or less; and optionally; and (iii) a bromine number which, upon complete hydrogenation, decreases by at least 50%.

[0023] The invention further relates to branched polyolefins having an M_n (1H NMR) of

less than 7,500 g/mol comprising one or more alpha olefin derived units comprising ethylene and/or propylene, and having:

(i) a ratio of percentage of saturated chain ends to percentage of allyl chain ends of 1.2 to 2.0; and

(ii) 50% or greater allyl chain ends, relative to total moles of unsaturated chain ends.

BRIEF DESCRIPTION OF THE DRAWINGS

[0024] Figure 1 is a plot of the relationship between g'_{vis} and log M_w for allyl terminated branched polypropylene polymers made with Metallocene A/Activator III (Examples, Table 3, Runs 59-65).

DETAILED DESCRIPTION

[0025] The inventors have surprisingly discovered new processes to make branched polyolefins having high amounts of allyl terminations. These new processes can be run under commercial conditions and are capable of producing the branched polyolefins at commercial

rates. Furthermore, these processes are typically run using non-coordinating anion activators, preferably bulky activators, as defined below.

[0026] Described herein are such processes to produce the branched polyolefins, the branched olefin products, and compositions comprising such branched polyolefins.

5 “Branched” as used herein, means a polyolefin having a g’vis of 0.90 or less, or if the polyolefin has a Mn (¹H MNR) of less than 7,500 g/mol, the branched polyolefin has a ratio of saturated chain ends to percentage of allyl chain ends of 1.2 to 2.0. These branched polyolefins having high amounts of allyl chain ends may find utility as macromonomers for the synthesis of branched poly(macromonomers), block copolymers, and as additives, for
10 example, as additives to, or blending agents in, lubricants, waxes, and adhesives. Advantageously, when used as an additive, such as to film compositions, the branched nature of these polyolefins may improve the desired mechanical properties by allowing optimal thermoforming and molding at lower temperatures, thereby reducing energy consumption of the film forming process, as compared to linear polyolefin analogues. Further
15 advantageously, the high amounts of allyl chain ends of these branched polyolefins provides a facile path to functionalization. The functionalized branched polyolefins may be also useful as additives or blending agents.

[0027] For the purposes of this invention and the claims thereto, the new numbering scheme for the Periodic Table Groups is used as in CHEMICAL AND ENGINEERING NEWS,
20 63(5), page 27, (1985). Therefore, a “Group 4 metal” is an element from Group 4 of the Periodic Table.

[0028] “Catalyst productivity” is a measure of how many kilograms of polymer (P) are produced using a polymerization catalyst comprising W moles of catalyst (W); and may be expressed in units of kilograms of polymer per mole of catalyst.

25 [0029] Conversion is the amount of monomer that is converted to polymer product, and is reported as mol% and is calculated based on the polymer yield and the amount of monomer fed into the reactor.

[0030] Catalyst activity is a measure of how active the catalyst is and is reported as the mass of product polymer (P) produced per kg of catalyst (cat) used (kgP/kgcat).

30 [0031] An “olefin,” alternatively referred to as “alkene,” is a linear, branched, or cyclic compound of carbon and hydrogen having at least one double bond. For purposes of this specification and the claims appended thereto, when a polymer or copolymer is referred to as

comprising an olefin, including, but not limited to ethylene, propylene, and butene, the olefin present in such polymer or copolymer is the polymerized form of the olefin. For example, when a copolymer is said to have an "ethylene" content of 35 wt% to 55 wt%, it is understood that the mer unit in the copolymer is derived from ethylene in the polymerization reaction and said derived units are present at 35 wt% to 55 wt%, based upon the weight of the copolymer. A "polymer" has two or more of the same or different mer units. The term "polymer," as used herein, includes oligomers (up to 100 mer units), and larger polymers (greater than 100 mer units). A "homopolymer" is a polymer having mer units that are the same. A "copolymer" is a polymer having two or more mer units that are different from each other. A "terpolymer" is a polymer having three mer units that are different from each other. "Different" as used to refer to mer units indicates that the mer units differ from each other by at least one atom or are different isomerically. Accordingly, the definition of copolymer, as used herein, includes terpolymers and the like.

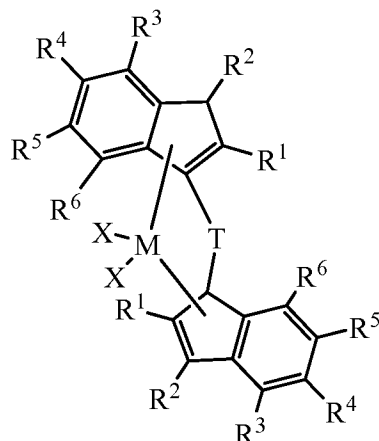
[0032] As used herein, Mn is number average molecular weight (measured by ¹H NMR, unless stated otherwise), Mw is weight average molecular weight (measured by Gel Permeation Chromatography, GPC), and Mz is z average molecular weight (measured by GPC), wt% is weight percent, mol% is mole percent, vol% is volume percent and mol is mole. Molecular weight distribution (MWD) is defined to be Mw divided by Mn (measured by GPC), Mw/Mn. Unless otherwise noted, all molecular weights (e.g., Mw, Mn, Mz) have units of g/mol. Also, room temperature is 23°C unless otherwise noted.

[0033] Bromine number is determined by ASTM D 1159.

Processes For Making Vinyl Terminated Branched Polyolefins

[0034] This invention relates to a process for polymerization, comprising:

(i) contacting, preferably at a temperature greater than 35°C, preferably in the range of from about 35 to 150°C, from 40 to 140°C, from 60 to 140°C, or from 80 to 130°C, one or more monomers comprising ethylene and/or propylene (preferably propylene) and, optionally, one or more C₄ to C₄₀ alpha olefin monomers (preferably butene, pentene, hexene, heptene, octene, nonene, decene, cyclopentene, cycloheptene, cyclooctene, cyclooctadiene, and isomers thereof), with a catalyst system capable of producing a branched polyolefin having allyl chain ends, the catalyst system comprising a metallocene catalyst compound and an activator, wherein the metallocene catalyst compound is represented by the following formula:



where:

M is selected from the group consisting of zirconium or hafnium (preferably hafnium);

each X is, independently, selected from the group consisting of hydrocarbyl radicals having
 5 from 1 to 20 carbon atoms, hydrides, amides, alkoxides, sulfides, phosphides, halides, dienes, amines, phosphines, ethers, and a combination thereof, (two X's may form a part of a fused ring or a ring system) (preferably X is a halide or a hydrocarbyl radical having from 1 to 20 carbon atoms, preferably X is chloride or methyl);

each R¹, R², R³, R⁴, R⁵, and R⁶, is, independently, hydrogen or a substituted or unsubstituted
 10 hydrocarbyl group, a heteroatom or heteroatom containing group;

further provided that any two adjacent R groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or saturated; and

further provided that any of adjacent R⁴, R⁵, and R⁶ groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or
 15 saturated;

T is a bridging group represented by the formula R₂^aJ, where J is one or more of C, Si, Ge, N, or P (preferably J is Si), and each R^a is, independently, hydrogen, halogen, C₁ to C₂₀ hydrocarbyl or a C₁ to C₂₀ substituted hydrocarbyl (preferably R^a is methyl, ethyl, chloride),
 20 provided that at least one R³, preferably both, are a substituted or unsubstituted phenyl group, if any of R¹, R², R⁴, R⁵ or R⁶ are not hydrogen;

(ii) preferably converting at least 50 mol% of the monomer to polyolefin, more preferably at least 60 mol%, at least 70 mol%, at least 80 mol%; and

(iii) obtaining a branched polyolefin having greater than 50% allyl chain ends, relative to total unsaturated chain ends (preferably 60% or more, preferably 70% or more, preferably
 25 80% or more, preferably 90% or more, preferably 95% or more) and a T_m of 60 °C or more

(preferably 100 °C or more, preferably 120 °C or more).

[0035] The inventive processes described herein are run at commercial rates. In some embodiments, the productivity is 4500 g/mmol or more, preferably 5000 g/mmol or more, preferably 10,000 g/mmol or more, preferably 50,000 g/mmol or more. In other
5 embodiments, the productivity is at least 80,000 g/mmol, preferably at least 150,000 g/mmol, preferably at least 200,000 g/mmol, preferably at least 250,000 g/mmol, preferably at least 300,000 g/mmol.

[0036] In an alternate embodiment, the activity of the catalyst is at least 10,000 kg polymer per kg catalyst, preferably 50,000 or more kg polymer per kg catalyst, preferably
10 100,000 or more kg polymer per kg catalyst, preferably 150,000 or more kg polymer per kg catalyst.

[0037] In an alternate embodiment, the conversion of olefin monomer is at least 50 mol%, based upon the weight of the monomer entering the reaction zone, preferably 60 mol% or more, preferably 70 mol% or more, preferably 80 mol% or more.

15 [0038] The inventive processes described herein can be run at temperatures and pressures suitable for commercial production of these branched vinyl terminated polymers. Typical temperatures and/or pressures include a temperature greater than 35°C (preferably in the range of from about 35 to 150°C, from 40 to 140°C, from 60 to 140°C, or from 80 to 130°C) and a pressure in the range of from about 0.35 to 10 MPa (preferably from 0.45 to 6 MPa or
20 from 0.5 to 4 MPa).

[0039] The inventive processes described herein have a residence time suitable for commercial production of these branched vinyl terminated polymers. In a typical polymerization, the residence time of the polymerization process is up to 300 minutes, preferably in the range of from about 1 to 300 minutes, preferably from 5 to 250 minutes,
25 preferably from about 10 to 120 minutes, or preferably from about 10 to 60 minutes.

[0040] Suitable diluents/solvents for polymerization include non-coordinating, inert liquids. Examples include straight and branched-chain hydrocarbons such as isobutane, butane, pentane, isopentane, hexanes, isohexane, heptane, octane, dodecane, and mixtures thereof; cyclic and alicyclic hydrocarbons such as cyclohexane, cycloheptane,
30 methylcyclohexane, methylcycloheptane, and mixtures thereof, such as can be found commercially (Isopar™); and perhalogenated hydrocarbons such as perfluorinated C₄₋₁₀ alkanes. Suitable solvents also include liquid olefins which may act as monomers or

comonomers including ethylene, propylene, 1-butene, 1-hexene, 1-pentene, 3-methyl-1-pentene, 4-methyl-1-pentene, 1-octene, 1-decene, and mixtures thereof. In a preferred embodiment, aliphatic hydrocarbons are used as the solvent, such as isobutane, butane, pentane, isopentane, hexanes, isohexane, heptane, octane, dodecane, and mixtures thereof; 5 cyclic and alicyclic hydrocarbons, such as cyclohexane, cycloheptane, methylcyclohexane, methylcycloheptane, and mixtures thereof. In another embodiment, the solvent is not aromatic, preferably aromatics are present in the solvent at less than 1 wt%, preferably at 0.5 wt%, preferably at 0 wt% based upon the weight of the solvents.

[0041] In a preferred embodiment, the feed concentration for the polymerization is 60 10 vol% solvent or less, preferably 40 vol% or less, or preferably 20 vol% or less, preferably 0 vol% based on the total volume of the feedstream. Preferably the polymerization is run in a bulk process.

[0042] In some embodiments, where butene is the comonomer, the butene source may be a mixed butene stream comprising various isomers of butene. The 1-butene monomers are 15 expected to be preferentially consumed by the polymerization process. Use of such mixed butene streams will provide an economic benefit, as these mixed streams are often waste streams from refining processes, for example C₄ raffinate streams, and can therefore be substantially less expensive than pure 1-butene.

[0043] Processes of this invention can be carried out in any manner known in the art. 20 Any suspension, homogeneous bulk, solution, slurry, or gas phase polymerization process known in the art can be used. Such processes can be run in a batch, semi-batch, or continuous mode. Homogeneous polymerization processes and slurry are preferred. (A homogeneous polymerization process is defined to be a process where at least 90 wt% of the product is soluble in the reaction media.) A bulk homogeneous process is particularly 25 preferred. (A bulk process is defined to be a process where monomer concentration in all feeds to the reactor is 70 vol% or more.) Alternately, no solvent or diluent is present or added in the reaction medium, (except for the small amounts used as the carrier for the catalyst system or other additives, or amounts typically found with the monomer; e.g., propane in propylene). Preferably, the process is a single stage polymerization process. In 30 another embodiment, the process is a slurry process. As used herein the term "slurry polymerization process" means a polymerization process where a supported catalyst is employed and monomers are polymerized on the supported catalyst particles. At least 95

wt% of polymer products derived from the supported catalyst are in granular form as solid particles (not dissolved in the diluent). By “continuous mode” is meant that there is continuous addition to, and withdrawal of reactants and products from, the reactor system. Continuous processes can be operated in steady state; i.e., the composition of effluent
5 remains fixed with time if the flow rate, temperature/pressure and feed composition remain invariant. For example, a continuous process to produce a polymer would be one where the reactants are continuously introduced into one or more reactors and polymer product is continuously withdrawn.

[0044] In a preferred embodiment hydrogen is present in the polymerization reactor at a
10 partial pressure of 0.001 to 50 psig (0.007 to 345 kPa), preferably from 0.01 to 25 psig (0.07 to 172 kPa), more preferably 0.1 to 10 psig (0.7 to 70 kPa). It has been found that in the present systems, hydrogen can be used to provide increased activity without significantly impairing the catalyst's ability to produce allylic chain ends. Preferably the catalyst activity (calculated as g/mmol catalyst/hr) is at least 20% higher than the same reaction without
15 hydrogen present, preferably at least 50% higher, preferably at least 100% higher.

[0045] Useful reaction vessels include reactors (including continuous stirred tank reactors, batch reactors, reactive extruder, pipe or pump. A “reaction zone” also referred to as a “polymerization zone” is defined as an area where activated catalysts and monomers are contacted and a polymerization reaction takes place. When multiple reactors are used in
20 either series or parallel configuration, each reactor is considered as a separate polymerization zone. For a multi-stage polymerization in both a batch reactor and a continuous reactor, each polymerization stage is considered as a separate polymerization zone. In a preferred embodiment, the polymerization described herein occurs within a single reaction zone. Alternately the polymerization described herein may occur in multiple reaction zones.

[0046] In a preferred embodiment hydrogen is present in the polymerization reactor at a
25 partial pressure of 0.001 to 50 psig (0.007 to 345 kPa), preferably from 0.01 to 25 psig (0.07 to 172 kPa), more preferably 0.1 to 10 psig (0.7 to 70 kPa). It has been found that in the present systems, hydrogen can be used to provide increased activity without significantly impairing the catalyst's ability to produce allylic chain ends. Preferably the catalyst activity
30 (calculated as g/mmol catalyst/hr) is at least 20% higher than the same reaction without hydrogen present, preferably at least 50% higher, preferably at least 100% higher.

[0047] In a preferred embodiment, little or no alumoxane is used in the process to produce the vinyl terminated polymers. Preferably, alumoxane is present at zero mol%, alternately the alumoxane is present at a molar ratio of aluminum to transition metal less than 500:1, preferably less than 300:1, preferably less than 100:1, preferably less than 1:1.

- 5 [0048] In an alternate embodiment, if an alumoxane is used to produce the vinyl terminated polymers, then the alumoxane has been treated to remove free alkyl aluminum compounds, particularly trimethyl aluminum.

[0049] Further, in a preferred embodiment, the activator used herein to produce the vinyl terminated polymer is a bulky activator as defined herein and is discrete.

- 10 [0050] In a preferred embodiment, little or no scavenger is used in the process to produce the vinyl terminated polymers. Preferably, scavenger (such as tri alkyl aluminum) is present at zero mol%, alternately the scavenger is present at a molar ratio of scavenger metal to transition metal of less than 100:1, preferably less than 50:1, preferably less than 15:1, preferably less than 10:1.

- 15 [0051] In a preferred embodiment, the polymerization: 1) is conducted at temperatures of 0 to 300°C (preferably 25 to 150°C, preferably 40 to 120°C, preferably 45 to 80°C); 2) is conducted at a pressure of atmospheric pressure to 10 MPa (preferably 0.35 to 10 MPa, preferably from 0.45 to 6 MPa, preferably from 0.5 to 4 MPa); 3) is conducted in an aliphatic hydrocarbon solvent (such as isobutane, butane, pentane, isopentane, hexanes, isohexane, 20 heptane, octane, dodecane, and mixtures thereof; cyclic and alicyclic hydrocarbons, such as cyclohexane, cycloheptane, methylcyclohexane, methylcycloheptane, and mixtures thereof; preferably where aromatics are present in the solvent at less than 1 wt%, preferably at 0.5 wt%, preferably at 0 wt% based upon the weight of the solvents); 4) wherein the catalyst system used in the polymerization comprises less than 0.5 mol%, preferably 0 mol% 25 alumoxane, alternately the alumoxane is present at a molar ratio of aluminum to transition metal less than 500:1, preferably less than 300:1, preferably less than 100:1, preferably less than 1:1); 5) the polymerization occurs in one reaction zone; 6) the productivity of the catalyst compound is at least 80,000 g/mmol (preferably at least 150,000 g/mmol, preferably at least 200,000 g/mmol, preferably at least 250,000 g/mmol, preferably at least 300,000 30 g/mmol); 7) optionally scavengers (such as trialkyl aluminum compounds) are absent (e.g., present at zero mol%, alternately the scavenger is present at a molar ratio of scavenger metal to transition metal of less than 100:1, preferably less than 50:1, preferably less than 15:1,

preferably less than 10:1); and 8) optionally hydrogen is present in the polymerization reactor at a partial pressure of 0.001 to 50 psig (0.007 to 345 kPa) (preferably from 0.01 to 25 psig (0.07 to 172 kPa), more preferably 0.1 to 10 psig (0.7 to 70 kPa)). In a preferred embodiment, the catalyst system used in the polymerization comprises no more than one catalyst compound. A "reaction zone" also referred to as a "polymerization zone" is a vessel where polymerization takes place, for example a batch reactor. When multiple reactors are used in either series or parallel configuration, each reactor is considered as a separate polymerization zone. For a multi-stage polymerization in both a batch reactor and a continuous reactor, each polymerization stage is considered as a separate polymerization zone. In a preferred embodiment, the polymerization occurs in one reaction zone. Room temperature is 23°C unless otherwise noted.

Catalyst Systems

[0052] In embodiments herein, the invention relates to processes for making vinyl terminated branched polyolefins at commercial rates and under commercial conditions, wherein the process comprises contacting the monomers in the presence of a catalyst system comprising a metallocene catalyst compound and an activator capable of producing branched polyolefins having 50% or more allyl chain ends. It is within the scope of this invention that the catalyst system is a mixed catalyst system comprising one or more non-metallocene catalyst compounds, one or more metallocene catalyst compounds, or a combination thereof, preferably the mixed catalyst system comprises two or more metallocene catalyst compounds. Preferably, the catalyst system is a single catalyst system. Likewise one, two, or more activators may be used in the catalyst system.

[0053] In the description herein, the catalyst may be described as a catalyst precursor, a pre-catalyst compound, a catalyst compound, or a transition metal compound, and these terms are used interchangeably. A polymerization catalyst system is a catalyst system that can polymerize monomers to polymer. A "catalyst system" is a combination of at least one catalyst compound, at least one activator, an optional co-activator, and an optional support material. An "anionic ligand" is a negatively charged ligand which donates one or more pairs of electrons to a metal ion. A "neutral donor ligand" is a neutrally charged ligand which donates one or more pairs of electrons to a metal ion.

[0054] For the purposes of this invention and the claims thereto, when catalyst systems are described as comprising neutral stable forms of the components, it is well understood by

one of ordinary skill in the art, that the ionic form of the component is the form that reacts with the monomers to produce polymers.

[0055] A metallocene catalyst is defined as an organometallic compound with at least one π -bound cyclopentadienyl moiety (or substituted cyclopentadienyl moiety) and more frequently two π -bound cyclopentadienyl-moieties or substituted moieties. This includes other π -bound moieties such as indenyls or fluorenyls or derivatives thereof.

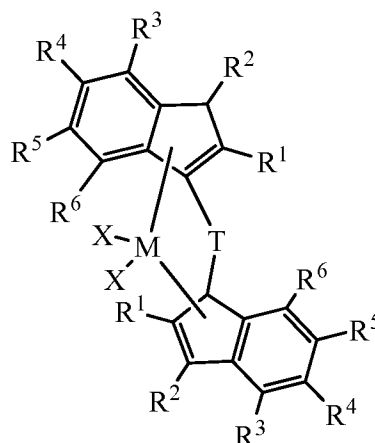
[0056] The metallocene, activator, optional co-activator, and optional support components of the particularly useful catalyst systems are discussed below.

(a) Metallocene Catalyst Compound

[0057] A “hydrocarbyl” is a radical made of hydrogen and carbon. The term “substituted” means that a hydrogen group has been replaced with a hydrocarbyl group, a heteroatom, or a heteroatom containing group. For example, methyl cyclopentadiene (Cp) is a Cp group substituted with a methyl group, ethyl alcohol is an ethyl group substituted with an -OH group, and a “substituted hydrocarbyl” is a radical made of carbon and hydrogen where at least one hydrogen is replaced by a heteroatom.

[0058] For purposes of this invention and claims thereto, “alkoxides” include those where the alkyl group is a C₁ to C₄₀ hydrocarbyl. The alkyl group may be straight chain, branched, or cyclic. The alkyl group may be saturated or unsaturated. In some embodiments, the alkyl group may comprise at least one aromatic group.

[0059] The metallocene catalyst compound of the catalyst system is represented by the formula:



where

M is selected from the group consisting of zirconium or hafnium (preferably hafnium);

- each X is, independently, selected from the group consisting of hydrocarbyl radicals having from 1 to 20 carbon atoms, hydrides, amides, alkoxides, sulfides, phosphides, halides, dienes, amines, phosphines, ethers, and a combination thereof, (two X's may form a part of a fused ring or a ring system) (preferably X is a halide or a hydrocarbyl radical having from 1 to 20 carbon atoms, preferably X is chloride or methyl);
- each R^1 , R^2 , R^3 , R^4 , R^5 , and R^6 , is, independently, hydrogen or a substituted or unsubstituted hydrocarbyl group, a heteroatom or heteroatom containing group;
- further provided that any two adjacent R groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or saturated;
- 10 further provided that any of adjacent R^4 , R^5 , and R^6 groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or saturated; and
- T is a bridging group represented by the formula R_2^aJ , where J is one or more of C, Si, Ge, N, or P (preferably J is Si), and each R^a is, independently, hydrogen, halogen, C_1 to C_{20} hydrocarbyl or a C_1 to C_{20} substituted hydrocarbyl, (preferably R^a is methyl, ethyl, chloride),
- 15 provided that at least one R^3 , preferably both, are a substituted or unsubstituted phenyl group, if any of R^1 , R^2 , R^4 , R^5 or R^6 are not hydrogen;
- [0060]** Particularly preferred R^a substituent groups include a C_1 to C_{20} hydrocarbyls, such as methyl, ethyl, propyl (including isopropyl, sec-propyl), butyl (including t-butyl and
- 20 sec-butyl), neopentyl, cyclopentyl, hexyl, octyl, nonyl, decyl, phenyl, substituted phenyl, benzyl (including substituted benzyl), cyclohexyl, cyclododecyl, norbornyl, and all isomers thereof.
- [0061]** Examples of bridging group R_2^aT useful herein may be represented by R'_2C , R'_2Si , R'_2Ge , $R'_2CCR'_2$, $R'_2CCR'_2CR'_2$, $R'_2CCR'_2CR'_2CR'_2$, $R'C=CR'$, $R'C=CR'CR'_2$, $R'_2CCR'=CR'CR'_2$, $R'C=CR'CR'=CR'$, $R'C=CR'CR'_2CR'_2$, $R'_2CSiR'_2$, $R'_2SiSiR'_2$, $R'_2CSiR'_2CR'_2$, $R'_2SiCR'_2SiR'_2$, $R'C=CR'SiR'_2$, $R'_2CGeR'_2$, $R'_2GeGeR'_2$, $R'_2CGeR'_2CR'_2$, $R'_2GeCR'_2GeR'_2$, $R'_2SiGeR'_2$, $R'C=CR'GeR'_2$, $R'B$, R'_2C-BR' , $R'_2C-BR'-CR'_2$, $R'_2C-O-CR'_2$, $R'_2CR'_2C-O-CR'_2CR'_2$, $R'_2C-O-CR'_2CR'_2$, $R'_2C-O-CR'=CR'$, $R'_2C-S-CR'_2$, $R'_2CR'_2C-S-CR'_2CR'_2$, $R'_2C-S-CR'_2CR'_2$, $R'_2C-S-CR'=CR'$, $R'_2C-Se-CR'_2$, $R'_2CR'_2C-Se-CR'_2CR'_2$, $R'_2C-Se-CR'_2CR'_2$, $R'_2C-Se-CR'=CR'$, $R'_2C-N=CR'$, $R'_2C-NR'-CR'_2$, $R'_2C-NR'-CR'_2CR'_2$, $R'_2C-NR'-CR'=CR'$, $R'_2CR'_2C-NR'-CR'_2CR'_2$, $R'_2C-P=CR'$, and $R'_2C-PR'-CR'_2$ where R' is hydrogen or a C_1 - C_{20} containing hydrocarbyl or substituted hydrocarbyl.

Preferably, the bridging group R_2^aT comprises carbon or silica, such as dialkylsilyl, preferably the bridging group is selected from CH_2 , CH_2CH_2 , $C(CH_3)_2$, $SiMe_2$, $SiPh_2$, $SiMePh$, and $(Ph)_2C$.

[0062] Catalyst compounds that are particularly useful in this invention include one or
5 more of:

rac-dimethylsilylbis(indenyl)hafnium dimethyl,

rac-dimethylsilylbis(2-methylindenyl)zirconium dimethyl,

dimethyl *rac*-dimethylsilyl-bis(5,6,7,8-tetrahydro-5,5,8,8-tetramethyl-2-methyl-1H-benz(f)indene)hafnium dimethyl, and

10 *rac*-dimethylsilylbis(2-methyl-4-phenylindenyl)zirconium dimethyl.

[0063] In an alternate embodiment, the “dimethyl” after the transition metal in the list of catalyst compounds above is replaced with a dihalide (such as dichloride or difluoride) or a bisphenoxide.

[0064] In an alternate embodiment, “hafnium” in the list of catalyst compounds above is
15 replaced with zirconium. In an alternate embodiment, “zirconium” in the list of catalyst compounds above is replaced with hafnium.

(b) Activator

[0065] The terms “cocatalyst” and “activator” are used herein interchangeably and are defined to be any compound which can activate any one of the catalyst compounds described
20 above by converting the neutral catalyst compound to a catalytically active catalyst compound cation. Non-limiting activators, for example, include ionizing activators, which may be neutral or ionic, and conventional-type cocatalysts. Preferred activators typically include ionizing anion precursor compounds that abstract one reactive, σ -bound, metal ligand making the metal complex cationic and providing a charge-balancing noncoordinating or
25 weakly coordinating anion.

[0066] Preferably, little or no alumoxane is used in the process to produce the branched polyolefins. Preferably, alumoxane is present at zero mol%, alternately the alumoxane is present at a molar ratio of aluminum to transition metal less than 500:1, preferably less than 300:1, preferably less than 100:1, preferably less than 1:1. In an alternate embodiment, if an
30 alumoxane is used to produce the branched polyolefins then, the alumoxane has been treated to remove free alkyl aluminum compounds, particularly trimethyl aluminum.

[0067] Preferably a non-alumoxane is used as the activator. Further, in a preferred

embodiment, the activator used herein to produce the branched polyolefins is bulky as defined herein and is discrete.

Ionizing Activators

[0068] It is within the scope of this invention to use an ionizing or stoichiometric
5 activator, neutral or ionic, such as tri (n-butyl) ammonium tetrakis (pentafluorophenyl)
borate, a tris perfluorophenyl boron metalloid precursor or a tris perfluoronaphthyl boron
metalloid precursor, polyhalogenated heteroborane anions (WO 98/43983), boric acid (U.S.
Patent No. 5,942,459) or combination thereof. It is also within the scope of this invention to
use neutral or ionic activators alone or in combination with alumoxane or modified
10 alumoxane activators. Much preferred activators are the ionic ones, not the neutral boranes.

[0069] Examples of neutral stoichiometric activators include tri-substituted boron,
tellurium, aluminum, gallium and indium, or mixtures thereof. The three substituent groups
are each independently selected from alkyls, alkenyls, halogens, substituted alkyls, aryls,
arylhaldes, alkoxy, and halides. Preferably, the three groups are independently selected from
15 halogen, mono or multicyclic (including halosubstituted) aryls, alkyls, and alkenyl
compounds and mixtures thereof, preferred are alkenyl groups having 1 to 20 carbon atoms,
alkyl groups having 1 to 20 carbon atoms, alkoxy groups having 1 to 20 carbon atoms and
aryl groups having 3 to 20 carbon atoms (including substituted aryls). More preferably, the
three groups are alkyls having 1 to 4 carbon groups, phenyl, naphthyl, or mixtures thereof.
20 Even more preferably, the three groups are halogenated, preferably fluorinated, aryl groups.
Most preferably, the neutral stoichiometric activator is tris perfluorophenyl boron or tris
perfluoronaphthyl boron.

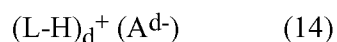
[0070] Ionic stoichiometric activator compounds may contain an active proton, or some
other cation associated with, but not coordinated to, or only loosely coordinated to, the
25 remaining ion of the ionizing compound. Such compounds and the like are described in
European publications EP 0 570 982 A; EP 0 520 732 A; EP 0 495 375 A; EP 0 500 944 B1;
EP 0 277 003 A; EP 0 277 004 A; U.S. Patent Nos. 5,153,157; 5,198,401; 5,066,741;
5,206,197; 5,241,025; 5,384,299; 5,502,124; and U.S. Patent Application Serial No.
08/285,380, filed August 3, 1994, all of which are herein fully incorporated by reference.

30 [0071] Ionic catalysts can be prepared by reacting a transition metal compound with
some neutral Lewis acids, such as $B(C_6F_5)_3$, which upon reaction with the hydrolyzable
ligand (X) of the transition metal compound forms an anion, such as $[B(C_6F_5)_3(X)]^-$, which

stabilizes the cationic transition metal species generated by the reaction. The catalysts can be, and preferably are, prepared with activator components which are ionic compounds or compositions.

[0072] Compounds useful as an activator component in the preparation of the ionic catalyst systems used in the process of this invention comprise a cation, which is preferably a Bronsted acid capable of donating a proton, and a compatible non-coordinating anion which anion is relatively large (bulky), capable of stabilizing the active catalyst species (the Group 4 cation) which is formed when the two compounds are combined and said anion will be sufficiently labile to be displaced by olefinic, diolefinic and acetylenically unsaturated substrates or other neutral Lewis bases such as ethers, amines and the like. Two classes of compatible non-coordinating anions have been disclosed in EP 0 277,003 A and EP 0 277,004 A published 1988: 1) anionic coordination complexes comprising a plurality of lipophilic radicals covalently coordinated to and shielding a central charge-bearing metal or metalloid core; and 2) anions comprising a plurality of boron atoms such as carboranes, metallacarboranes and boranes.

[0073] In a preferred embodiment, the stoichiometric activators include a cation and an anion component, and may be represented by the following formula:



wherein L is a neutral Lewis base; H is hydrogen; $(L-H)^+$ is a Bronsted acid; A^{d-} is a non-coordinating anion having the charge d^- ; and d is 1, 2, or 3.

[0074] The cation component, $(L-H)_d^+$ may include Bronsted acids such as protonated Lewis bases capable of protonating a moiety, such as an alkyl or aryl, from the bulky ligand metallocene containing transition metal catalyst precursor, resulting in a cationic transition metal species.

[0075] The activating cation $(L-H)_d^+$ may be a Bronsted acid, capable of donating a proton to the transition metal catalytic precursor resulting in a transition metal cation, including ammoniums, oxoniums, phosphoniums, silyliums, and mixtures thereof, preferably ammoniums of methylamine, aniline, dimethylamine, diethylamine, N-methylaniline, diphenylamine, trimethylamine, triethylamine, N,N-dimethylaniline, methyldiphenylamine, pyridine, p-bromo N,N-dimethylaniline, p-nitro-N,N-dimethylaniline, phosphoniums from triethylphosphine, triphenylphosphine, and diphenylphosphine, oxoniums from ethers, such

as dimethyl ether diethyl ether, tetrahydrofuran, and dioxane, sulfoniums from thioethers, such as diethyl thioethers and tetrahydrothiophene, and mixtures thereof.

[0076] The anion component A^{d-} include those having the formula $[M^{k+}Q_n]^{d-}$ wherein k is 1, 2, or 3; n is 2, 3, 4, 5, or 6; $n - k = d$; M is an element selected from Group 13 of the Periodic Table of the Elements, preferably boron or aluminum, and Q is independently a hydride, bridged or unbridged dialkylamido, halide, alkoxide, aryloxy, hydrocarbyl, substituted hydrocarbyl, halocarbyl, substituted halocarbyl, and halosubstituted-hydrocarbyl radicals, said Q having up to 20 carbon atoms with the proviso that in not more than 1 occurrence is Q a halide. Preferably, each Q is a fluorinated hydrocarbyl group having 1 to 20 carbon atoms, more preferably each Q is a fluorinated aryl group, and most preferably each Q is a pentafluorophenyl aryl group. Examples of suitable A^{d-} also include diboron compounds as disclosed in U.S. Patent No. 5,447,895, which is fully incorporated herein by reference.

[0077] Illustrative, but not limiting examples of boron compounds which may be used as an activating cocatalyst in the preparation of the catalyst system of the processes of this invention are tri-substituted ammonium salts, such as:

trimethylammonium tetraphenylborate, triethylammonium tetraphenylborate, tripropylammonium tetraphenylborate, tri(n-butyl)ammonium tetraphenylborate, tri(t-butyl)ammonium tetraphenylborate, N,N-dimethylanilinium tetraphenylborate, N,N-diethylanilinium tetraphenylborate, N,N-dimethyl-(2,4,6-trimethylanilinium) tetraphenylborate, tropillium tetraphenylborate, triphenylcarbenium tetraphenylborate, triphenylphosphonium tetraphenylborate triethylsilylium tetraphenylborate, benzene(diazonium)tetraphenylborate, trimethylammonium tetrakis(pentafluorophenyl)borate, triethylammonium tetrakis(pentafluorophenyl)borate, tripropylammonium tetrakis(pentafluorophenyl)borate, tri(n-butyl)ammonium tetrakis(pentafluorophenyl)borate, tri(sec-butyl)ammonium tetrakis(pentafluorophenyl)borate, N,N-dimethylanilinium tetrakis(pentafluorophenyl)borate, N,N-diethylanilinium tetrakis(pentafluorophenyl)borate, N,N-dimethyl-(2,4,6-trimethylanilinium) tetrakis(pentafluorophenyl)borate, tropillium tetrakis(pentafluorophenyl)borate, triphenylcarbenium tetrakis(pentafluorophenyl)borate, triphenylphosphonium tetrakis(pentafluorophenyl)borate, triethylsilylium tetrakis(pentafluorophenyl)borate, benzene(diazonium) tetrakis(pentafluorophenyl)borate,

trimethylammonium tetrakis-(2,3,4,6-tetrafluorophenyl) borate, triethylammonium tetrakis-
 (2,3,4,6-tetrafluorophenyl)borate, tripropylammonium tetrakis-(2,3,4,6-
 tetrafluorophenyl)borate, tri(n-butyl)ammonium tetrakis-(2,3,4,6-tetrafluoro-phenyl)borate,
 dimethyl(t-butyl)ammonium tetrakis-(2,3,4,6-tetrafluorophenyl)borate, N,N-
 5 dimethylanilinium tetrakis-(2,3,4,6-tetrafluorophenyl)borate, N,N-diethylanilinium tetrakis-
 (2,3,4,6-tetrafluorophenyl)borate, N,N-dimethyl-(2,4,6-trimethylanilinium) tetrakis-(2,3,4,6-
 tetrafluorophenyl)borate, tropillium tetrakis-(2,3,4,6-tetrafluorophenyl)borate,
 triphenylcarbenium tetrakis-(2,3,4,6-tetrafluorophenyl)borate, triphenylphosphonium
 tetrakis-(2,3,4,6-tetrafluorophenyl)borate, triethylsilylium tetrakis-(2,3,4,6-
 10 tetrafluorophenyl)borate, benzene(diazonium) tetrakis-(2,3,4,6-tetrafluorophenyl)borate,
 trimethylammonium tetrakis(perfluoronaphthyl)borate, triethylammonium
 tetrakis(perfluoronaphthyl)borate, tripropylammonium tetrakis(perfluoronaphthyl)borate,
 tri(n-butyl)ammonium tetrakis(perfluoronaphthyl)borate, tri(t-butyl)ammonium
 tetrakis(perfluoronaphthyl)borate, N,N-dimethylanilinium tetrakis(perfluoronaphthyl)borate,
 15 N,N-diethylanilinium tetrakis(perfluoronaphthyl)borate, N,N-dimethyl-(2,4,6-
 trimethylanilinium) tetrakis(perfluoronaphthyl)borate, tropillium
 tetrakis(perfluoronaphthyl)borate, triphenylcarbenium tetrakis(perfluoronaphthyl)borate,
 triphenylphosphonium tetrakis(perfluoronaphthyl)borate, triethylsilylium
 tetrakis(perfluoronaphthyl)borate, benzene(diazonium) tetrakis(perfluoronaphthyl)borate,
 20 trimethylammonium tetrakis(perfluorobiphenyl)borate, triethylammonium
 tetrakis(perfluorobiphenyl)borate, tripropylammonium tetrakis(perfluorobiphenyl)borate,
 tri(n-butyl)ammonium tetrakis(perfluorobiphenyl)borate, tri(t-butyl)ammonium
 tetrakis(perfluorobiphenyl)borate, N,N-dimethylanilinium tetrakis(perfluorobiphenyl)borate,
 N,N-diethylanilinium tetrakis(perfluorobiphenyl)borate, N,N-dimethyl-(2,4,6-
 25 trimethylanilinium) tetrakis(perfluorobiphenyl)borate, tropillium
 tetrakis(perfluorobiphenyl)borate, triphenylcarbenium tetrakis(perfluorobiphenyl)borate,
 triphenylphosphonium tetrakis(perfluorobiphenyl)borate, triethylsilylium
 tetrakis(perfluorobiphenyl)borate, benzene(diazonium) tetrakis(perfluorobiphenyl)borate,
 trimethylammonium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, triethylammonium
 30 tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, tripropylammonium tetrakis(3,5-
 bis(trifluoromethyl)phenyl)borate, tri(n-butyl)ammonium tetrakis(3,5-
 bis(trifluoromethyl)phenyl)borate, tri(t-butyl)ammonium tetrakis(3,5-

bis(trifluoromethyl)phenyl)borate, N,N-dimethylanilinium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, N,N-diethylanilinium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, N,N-dimethyl-(2,4,6-trimethylanilinium) tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, tropillium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, triphenylcarbenium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, triphenylphosphonium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, triethylsilylium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, benzene(diazonium) tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, and dialkyl ammonium salts, such as: di-(i-propyl)ammonium tetrakis(pentafluorophenyl)borate, and dicyclohexylammonium tetrakis(pentafluorophenyl)borate; and additional tri-substituted phosphonium salts, such as tri(o-tolyl)phosphonium tetrakis(pentafluorophenyl)borate, and tri(2,6-dimethylphenyl)phosphonium tetrakis(pentafluorophenyl)borate.

[0078] Most preferably, the ionic stoichiometric activator $(L-H)_d^+ (A^{d-})$ is, N,N-dimethylanilinium tetrakis(perfluoronaphthyl)borate, N,N-dimethylanilinium tetrakis(perfluorobiphenyl)borate, N,N-dimethylanilinium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, triphenylcarbenium tetrakis(perfluoronaphthyl)borate, triphenylcarbenium tetrakis(perfluorobiphenyl)borate, triphenylcarbenium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, or triphenylcarbenium tetrakis(perfluorophenyl)borate.

[0079] In one embodiment, an activation method using ionizing ionic compounds not containing an active proton but capable of producing a bulky ligand metallocene catalyst cation and their non-coordinating anion are also contemplated, and are described in EP 0 426 637 A, EP 0 573 403 A, and U.S. Patent No. 5,387,568, which are all herein incorporated by reference.

[0080] The term “non-coordinating anion” (NCA) means an anion which either does not coordinate to said cation or which is only weakly coordinated to said cation thereby remaining sufficiently labile to be displaced by a neutral Lewis base. “Compatible” non-coordinating anions are those which are not degraded to neutrality when the initially formed complex decomposes. Further, the anion will not transfer an anionic substituent or fragment to the cation so as to cause it to form a neutral four coordinate metallocene compound and a neutral by-product from the anion. Non-coordinating anions useful in accordance with this invention are those that are compatible, stabilize the metallocene cation in the sense of balancing its ionic charge at +1, yet retain sufficient lability to permit displacement by an

ethylenically or acetylenically unsaturated monomer during polymerization. In addition to these activator compounds or co-catalysts, scavengers are used such as tri-isobutyl aluminum or tri-octyl aluminum. Preferably, the activator is a non-coordinating anion activator.

[0081] Inventive processes also can employ cocatalyst compounds or activator compounds that are initially neutral Lewis acids but form a cationic metal complex and a noncoordinating anion, or a zwitterionic complex upon reaction with the invention compounds. For example, tris(pentafluorophenyl) boron or aluminum act to abstract a hydrocarbyl or hydride ligand to yield an invention cationic metal complex and stabilizing noncoordinating anion, see EP 0 427 697 A and EP 0 520 732 A for illustrations of analogous Group-4 metallocene compounds. Also, see the methods and compounds of EP 0 495 375 A. For formation of zwitterionic complexes using analogous Group 4 compounds, see U.S. Patents 5,624,878; 5,486,632; and 5,527,929.

[0082] Another suitable ion forming, activating cocatalyst comprises a salt of a cationic oxidizing agent and a noncoordinating, compatible anion represented by the formula:



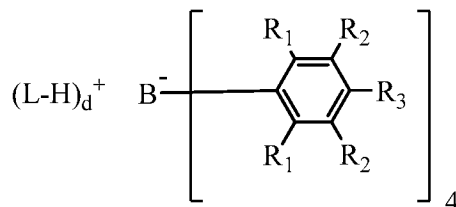
wherein OX^{e+} is a cationic oxidizing agent having a charge of $e+$; e is 1, 2, or 3; and A^{d-} is a non-coordinating anion having the charge $d-$; and d is 1, 2, or 3. Examples of cationic oxidizing agents include: ferrocenium, hydrocarbyl-substituted ferrocenium, Ag^+ or Pb^{+2} . Preferred embodiments of A^{d-} are those anions previously defined with respect to the Bronsted acid containing activators, especially tetrakis(pentafluorophenyl)borate.

[0083] The typical NCA (or non-alumoxane activator) activator-to-catalyst ratio is a 1:1 molar ratio. Alternate preferred ranges include from 0.1:1 to 100:1, alternately from 0.5:1 to 200:1, alternately from 1:1 to 500:1, alternately from 1:1 to 1000:1. A particularly useful range is from 0.5:1 to 10:1, preferably 1:1 to 5:1.

25 Bulky Activators

[0084] The inventors have surprisingly found that bulky activators are particularly useful. Bulky activators can advantageously produce higher M_w , higher T_m , and/or a greater amount of allyl chain ends than the same catalyst with a non-bulky activator, under the same polymerization conditions.

30 [0085] "Bulky activator" as used herein refers to anionic activators represented by the formula:



where

each R_1 is, independently, a halide, preferably a fluoride;

each R_2 is, independently, a halide, a C_6 to C_{20} substituted aromatic hydrocarbyl group or a siloxy group of the formula $-O-Si-R_a$, where R_a is a C_1 to C_{20} hydrocarbyl or hydrocarbylsilyl group (preferably R_2 is a fluoride or a perfluorinated phenyl group);

each R_3 is a halide, C_6 to C_{20} substituted aromatic hydrocarbyl group or a siloxy group of the formula $-O-Si-R_a$, where R_a is a C_1 to C_{20} hydrocarbyl or hydrocarbylsilyl group (preferably R_3 is a fluoride or a C_6 perfluorinated aromatic hydrocarbyl group); wherein R_2 and R_3 can form one or more saturated or unsaturated, substituted or unsubstituted rings (preferably R_2 and R_3 form a perfluorinated phenyl ring);

L is an neutral Lewis base;

$(L-H)^+$ is a Bronsted acid;

d is 1, 2, or 3;

wherein the anion has a molecular weight of greater than 1020 g/mol; and

wherein at least three of the substituents on the B atom each have a molecular volume of greater than 250 cubic Å, alternately greater than 300 cubic Å, or alternately greater than 500 cubic Å.

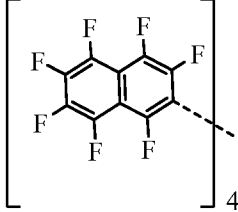
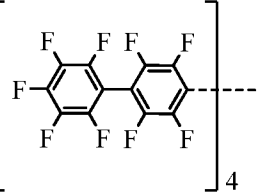
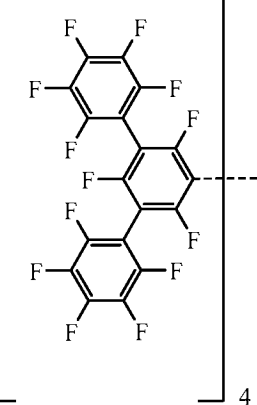
[0086] “Molecular volume” is used herein as an approximation of spatial steric bulk of an activator molecule in solution. Comparison of substituents with differing molecular volumes allows the substituent with the smaller molecular volume to be considered “less bulky” in comparison to the substituent with the larger molecular volume. Conversely, a substituent with a larger molecular volume may be considered “more bulky” than a substituent with a smaller molecular volume.

[0087] Molecular volume may be calculated as reported in “A Simple “Back of the Envelope” Method for Estimating the Densities and Molecular Volumes of Liquids and Solids,” Journal of Chemical Education, , Vol. 71, No. 11, November 1994, pp. 962-964. Molecular volume (MV), in units of cubic Å, is calculated using the formula: $MV = 8.3V_s$, where V_s is the scaled volume. V_s is the sum of the relative volumes of the constituent

atoms, and is calculated from the molecular formula of the substituent using the following table of relative volumes. For fused rings, the V_s is decreased by 7.5% per fused ring.

Element	Relative Volume
H	1
1 st short period, Li to F	2
2 nd short period, Na to Cl	4
1 st long period, K to Br	5
2 nd long period, Rb to I	7.5
3 rd long period, Cs to Bi	9

[0088] Exemplary bulky substituents of activators suitable herein and their respective scaled volumes and molecular volumes are shown in the table below. The dashed bonds indicate binding to boron, as in the general formula above.

Activator	Structure of boron substituents	Molecular Formula of each substituent	V_s	MV ($\text{\AA}^3$)	Total MV ($\text{\AA}^3$)
Dimethylanilinium tetrakis(perfluoronaphthyl) borate		$C_{10}F_7$	34	261	1044
Dimethylanilinium tetrakis(perfluorobiphenyl) borate		$C_{12}F_9$	42	349	1396
[4-tButyl-PhNMe ₂ H] [(C ₆ F ₃ (C ₆ F ₅) ₂) ₄ B]		$C_{18}F_{13}$	62	515	2060

[0089] Exemplary bulky activators useful in catalyst systems herein include:

trimethylammonium tetrakis(perfluoronaphthyl)borate, triethylammonium
 tetrakis(perfluoronaphthyl)borate, tripropylammonium tetrakis(perfluoronaphthyl)borate,
 tri(n-butyl)ammonium tetrakis(perfluoronaphthyl)borate, tri(t-butyl)ammonium
 tetrakis(perfluoronaphthyl)borate, N,N-dimethylanilinium tetrakis(perfluoronaphthyl)borate,
 5 N,N-diethylanilinium tetrakis(perfluoronaphthyl)borate, N,N-dimethyl-(2,4,6-
 trimethylanilinium) tetrakis(perfluoronaphthyl)borate, tropillium
 tetrakis(perfluoronaphthyl)borate, triphenylcarbenium tetrakis(perfluoronaphthyl)borate,
 triphenylphosphonium tetrakis(perfluoronaphthyl)borate, triethylsilylium
 tetrakis(perfluoronaphthyl)borate, benzene(diazonium) tetrakis(perfluoronaphthyl)borate,
 10 trimethylammonium tetrakis(perfluorobiphenyl)borate, triethylammonium
 tetrakis(perfluorobiphenyl)borate, tripropylammonium tetrakis(perfluorobiphenyl)borate,
 tri(n-butyl)ammonium tetrakis(perfluorobiphenyl)borate, tri(t-butyl)ammonium
 tetrakis(perfluorobiphenyl)borate, N,N-dimethylanilinium tetrakis(perfluorobiphenyl)borate,
 N,N-diethylanilinium tetrakis(perfluorobiphenyl)borate, N,N-dimethyl-(2,4,6-
 15 trimethylanilinium) tetrakis(perfluorobiphenyl)borate, tropillium
 tetrakis(perfluorobiphenyl)borate, triphenylcarbenium tetrakis(perfluorobiphenyl)borate,
 triphenylphosphonium tetrakis(perfluorobiphenyl)borate, triethylsilylium
 tetrakis(perfluorobiphenyl)borate, benzene(diazonium) tetrakis(perfluorobiphenyl)borate, [4-
 t-butyl-PhNMe₂H][(C₆F₃(C₆F₅)₂)₄B], and the types disclosed in U.S. Patent No. 7,297,653.

20 **[0090]** It is within the scope of this invention that catalyst compounds can be combined with one or more activators or activation methods described above.

(iii) Optional Co-Activators and Scavengers

[0091] In addition to these activator compounds, scavengers or co-activators may be used. Aluminum alkyl or organoaluminum compounds which may be utilized as co-
 25 activators (or scavengers) include, for example, trimethylaluminum, triethylaluminum, triisobutylaluminum, tri-n-hexylaluminum, and tri-n-octylaluminum.

(iv) Optional Support Materials

[0092] In embodiments herein, the catalyst system may comprise an inert support material. Preferably, the supported material is a porous support material, for example, talc,
 30 and inorganic oxides. Other support materials include zeolites, clays, organoclays, or any other organic or inorganic support material, and the like, or mixtures thereof.

[0093] Preferably, the support material is an inorganic oxide in a finely divided form. Suitable inorganic oxide materials for use in metallocene catalyst systems herein include Groups 2, 4, 13, and 14 metal oxides such as silica, alumina, and mixtures thereof. Other inorganic oxides that may be employed either alone or in combination with the silica, or alumina are magnesia, titania, zirconia, and the like. Other suitable support materials, however, can be employed, for example, finely divided functionalized polyolefins such as finely divided polyethylene. Particularly useful supports include magnesia, titania, zirconia, montmorillonite, phyllosilicate, zeolites, talc, clays, and the like. Also, combinations of these support materials may be used, for example, silica-chromium, silica-alumina, silica-titania and the like. Preferred support materials include Al_2O_3 , ZrO_2 , SiO_2 , and combinations thereof, more preferably SiO_2 , Al_2O_3 , or $\text{SiO}_2/\text{Al}_2\text{O}_3$.

[0094] It is preferred that the support material, most preferably an inorganic oxide, has a surface area in the range of from about 10 to about 700 m^2/g , pore volume in the range of from about 0.1 to about 4.0 cc/g and average particle size in the range of from about 5 to about 500 μm . More preferably, the surface area of the support material is in the range of from about 50 to about 500 m^2/g , pore volume of from about 0.5 to about 3.5 cc/g and average particle size of from about 10 to about 200 μm . Most preferably the surface area of the support material is in the range of from about 100 to about 400 m^2/g , pore volume from about 0.8 to about 3.0 cc/g and average particle size is from about 5 to about 100 μm . The average pore size of the support material useful in the invention is in the range of from 10 to 1000 Å, preferably 50 to about 500 Å, and most preferably 75 to about 350 Å. In some embodiments, the support material is a high surface area, amorphous silica (surface area = 300 m^2/gm ; pore volume of 1.65 cm^3/gm), examples of which are marketed under the tradenames of DAVISON 952 or DAVISON 955 by the Davison Chemical Division of W.R. Grace and Company. In other embodiments, DAVISON 948 is used.

[0095] The support material should be dry, that is, free of absorbed water. Drying of the support material can be effected by heating or calcining at about 100°C to about 1000°C, preferably at least about 600°C. When the support material is silica, it is heated to at least 200°C, preferably about 200°C to about 850°C, and most preferably at about 600°C; and for a time of about 1 minute to about 100 hours, from about 12 hours to about 72 hours, or from about 24 hours to about 60 hours. The calcined support material must have at least some reactive hydroxyl (OH) groups to produce the catalyst system of this invention. The calcined

support material is then contacted with at least one polymerization catalyst comprising at least one metallocene compound and an activator.

Methods of Making the Supported Catalyst Systems

[0096] The support material, having reactive surface groups, typically hydroxyl groups, is slurried in a non-polar solvent and the resulting slurry is contacted with a solution of a metallocene compound and an activator. The slurry of the support material in the solvent is prepared by introducing the support material into the solvent, and heating the mixture to about 0 to about 70°C, preferably to about 25 to about 60°C, preferably at room temperature. Contact times typically range from about 0.5 hours to about 24 hours, from about 0.5 hours to about 8 hours, or from about 0.5 hours to about 4 hours.

[0097] Suitable non-polar solvents are materials in which all of the reactants used herein, i.e., the activator, and the metallocene compound, are at least partially soluble and which are liquid at reaction temperatures. Preferred non-polar solvents are alkanes, such as isopentane, hexane, n-heptane, octane, nonane, and decane, although a variety of other materials including cycloalkanes, such as cyclohexane, aromatics, such as benzene, toluene and ethylbenzene, may also be employed.

[0098] In embodiments herein, the support material is contacted with a solution of a metallocene compound and an activator, such that the reactive groups on the support material are titrated, to form a supported polymerization catalyst. The period of time for contact between the metallocene compound, the activator, and the support material is as long as is necessary to titrate the reactive groups on the support material. To "titrate" is meant to react with available reactive groups on the surface of the support material, thereby reducing the surface hydroxyl groups by at least 80%, at least 90%, at least 95%, or at least 98%. The surface reactive group concentration may be determined based on the calcining temperature and the type of support material used. The support material calcining temperature affects the number of surface reactive groups on the support material available to react with the metallocene compound and an activator: the higher the drying temperature, the lower the number of sites. For example, where the support material is silica which, prior to the use thereof in the first catalyst system synthesis step, is dehydrated by fluidizing it with nitrogen and heating at about 600°C for about 16 hours, a surface hydroxyl group concentration of about 0.7 millimoles per gram (mmols/gm) is typically achieved. Thus, the exact molar ratio of the activator to the surface reactive groups on the carrier will vary. Preferably, this is

determined on a case-by-case basis to assure that only so much of the activator is added to the solution as will be deposited onto the support material without leaving excess of the activator in the solution.

[0099] The amount of the activator which will be deposited onto the support material without leaving excess in the solution can be determined in any conventional manner, e.g., by adding the activator to the slurry of the carrier in the solvent, while stirring the slurry, until the activator is detected as a solution in the solvent by any technique known in the art, such as by ^1H NMR. For example, for the silica support material heated at about 600°C , the amount of the activator added to the slurry is such that the molar ratio of B to the hydroxyl groups (OH) on the silica is about 0.5:1 to about 4:1, preferably about 0.8:1 to about 3:1, more preferably about 0.9:1 to about 2:1 and most preferably about 1:1. The amount of boron on the silica may be determined by using ICPES (Inductively Coupled Plasma Emission Spectrometry), which is described in J. W. Olesik, "Inductively Coupled Plasma-Optical Emission Spectroscopy," in the Encyclopedia of Materials Characterization, C. R. Brundle, C. A. Evans, Jr. and S. Wilson, Eds., Butterworth-Heinemann, Boston, Mass., 1992, pp. 633-644. In another embodiment, it is also possible to add such an amount of activator which is in excess of that which will be deposited onto the support, and then remove, e.g., by filtration and washing, any excess of the activator.

Vinyl Terminated Branched Polyolefins

[00100] Embodiments herein relate to branched polyolefins having allyl chain ends of 50% or more. The inventors have surprisingly found that the processes disclosed herein give rise to an increased population of long chain branched products, possibly through vinyl macromonomer re-incorporation. Without wishing to be bound by theory, the inventors opine that the branching is likely of the "T" variety, and these branched polyolefins retain high amounts of allyl chain ends.

[00101] The branched polyolefins having 50% or more allyl chain ends produced by the processes disclosed herein is:

(a) branched, having at least one of:

(i) a branching index (g'_{vis}) of less than 0.90 (preferably 0.85 or less, preferably 0.80 or less); or

(ii) a ratio of percentage of saturated chain ends (preferably isobutyl chain ends) to percentage of allyl chain ends of 1.2 to 2.0 (preferably 1.6 to 1.8), wherein the percentage of

saturated chain ends is determined using ^{13}C NMR as described in WO 2009/155471 at paragraph [0095] and [0096] except that the spectra are referenced to the chemical shift of the solvent, tetrachloroethane- d_2 ; or

(iii) a ratio of $\text{Mn}(\text{GPC})/\text{Mn}(^1\text{H NMR})$ of 0.95 or less (preferably 0.90 or less, preferably 0.85 or less, preferably 0.80 or less); and

(b) has at least 50% allyl chain ends, relative to total unsaturated chain ends (preferably 60% or more, preferably 70% or more, preferably 75% or more, preferably 80% or more, preferably 90% or more, preferably 95% or more) and having at least one of:

(i) a bromine number which, upon complete hydrogenation, decreases by at least 50% (preferably at least 75%); or

(ii) an allyl chain end to internal vinylidene ratio of greater than 5:1 (preferably greater than 10:1); or

(iii) an allyl chain end to vinylidene chain end ratio of greater than 10:1 (preferably greater than 15:1), or

(iv) an allyl chain end to vinylene chain end ratio of greater than 1:1 (preferably greater than 2:1, greater than 5:1, or greater than 10:1).

[00102] With respect to branching, in embodiments where the branched polyolefins have an Mn (measured by ^1H NMR) of 7,500 to 60,000 g/mol, the branched polyolefin has:

(i) a branching index (g'_{vis}) of less than 0.90 (preferably less than 0.85, less than 0.80, or less than 0.75); and/or

(ii) a ratio of percentage of saturated chain ends (preferably isobutyl chain ends) to percentage of allyl chain ends of 1.2 to 2.0 (preferably 1.6 to 1.8), wherein the percentage of saturated chain ends is determined using ^{13}C NMR as described in WO 2009/155471 at paragraph [0095] and [0096] except that the spectra are referenced to the chemical shift of the solvent, tetrachloroethane- d_2 ; and/or

(iii) a ratio of $\text{Mn}(\text{GPC})/\text{Mn}(^1\text{H NMR})$ of 0.95 or less (preferably 0.90 or less, preferably 0.85 or less, preferably 0.80 or less). In the event of conflict, g'_{vis} shall be used (if g'_{vis} cannot be determined, then the ratio of percentage of saturated chain ends to percentage of allyl chain ends shall be used; if the ratio of percentage of saturated chain ends to percentage of allyl chain ends cannot be determined, then the ratio of $\text{Mn}(\text{GPC})/\text{Mn}(^1\text{H NMR})$ shall be used).

[00103] In embodiments where the branched polyolefins have an Mn (measured by GPC)

of greater than 60,000 g/mol, the branched polyolefin has a g'vis of less than 0.90 (preferably 0.85 or less, preferably 0.80 or less) and, optionally, a bromine number which, upon complete hydrogenation, decreases by at least 50% (preferably by at least 75%).

- [00104]** In embodiments where the branched polyolefins have an Mn (measured by ¹H NMR) of less than 7,500 g/mol (preferably from 100 to 7,500 g/mol), comprise one or more alpha olefins (preferably propylene and/or ethylene, preferably propylene) and, optionally, a C₄ to C₄₀ alpha olefin (preferably a C₄ to C₂₀ alpha olefin, preferably a C₄ to C₁₂ alpha olefin, preferably butene, pentene, hexene, heptene, octene, nonene, decene, cyclopentene, cycloheptene, cyclooctene, cyclooctadiene, and isomers thereof), and have:
- 5 (i) a ratio of percentage of saturated chain ends (preferably isobutyl chain ends) to percentage of allyl chain ends of 1.2 to 2.0 (preferably 1.6 to 1.8), wherein the percentage of saturated chain ends is determined using ¹³C NMR as described in WO 2009/155471 at paragraph [0095] and [0096] except that the spectra are referenced to the chemical shift of the solvent, tetrachloroethane-d₂; and/or
- 10 (ii) a ratio of Mn(GPC)/Mn(¹H NMR) of 0.95 or less (preferably 0.90 or less, preferably 0.85 or less, preferably 0.80 or less).
- 15

[00105] In an alternate embodiment, the branched polyolefins having an Mn (measured by ¹H NMR) of less than 7,500 g/mol (preferably from 100 to 7,500 g/mol) has a g'vis of 0.90 or less (preferably 0.85 or less, preferably 0.80 or less).

- 20 **[00106]** In one embodiment, the branched polyolefins produced herein have an Mn (measured by ¹H NMR) of 7,500 to 60,000 g/mol, comprise one or more alpha olefins (preferably propylene and/or ethylene, preferably propylene) and, optionally, a C₄ to C₄₀ alpha olefin (preferably a C₄ to C₂₀ alpha olefin, preferably a C₄ to C₁₂ alpha olefin, preferably butene, pentene, hexene, heptene, octene, nonene, decene, cyclopentene, cycloheptene, cyclooctene, cyclooctadiene, and isomers thereof), and have:
- 25 (i) 50% or greater allyl chain ends, relative to total unsaturated chain ends (preferably 60% or more, preferably 70% or more, preferably 75% or more, preferably 80% or more, preferably 90% or more, preferably 95% or more);
- (ii) a g'vis of 0.90 or less (preferably 0.85 or less, preferably 0.80 or less); and/or a ratio of
- 30 percentage of saturated chain ends (preferably isobutyl chain ends) to percentage of allyl chain ends of 1.2 to 2.0 (preferably 1.6 to 1.8), wherein the percentage of saturated chain ends is determined using ¹³C NMR as described in WO 2009/155471 at paragraph [0095]

and [0096] except that the spectra are referenced to the chemical shift of the solvent, tetrachloroethane-d₂, and/or a ratio of Mn(GPC)/Mn(¹H NMR) of 0.95 or less (preferably 0.90 or less, preferably 0.85 or less, preferably 0.80 or less);

(iii) optionally, a peak melting point (T_m) of greater than 60°C (preferably greater than 100°C, preferably from 60 to 180°C, preferably from 80 to 175°C);

(iv) optionally, a heat of fusion (H_f) of greater than 7 J/g (preferably greater than 15 J/g, greater than 30 J/g, greater than 50 J/g, greater than 60 J/g, or greater than 80 J/g);

(v) optionally, an allyl chain end to internal vinylidene ratio of greater than 5:1 (preferably greater than 10:1);

(vi) optionally, an allyl chain end to vinylidene chain end ratio of greater than 10:1 (preferably greater than 15:1); and

(vii) optionally, an allyl chain end to vinylene chain end ratio of greater than 1:1 (preferably greater than 2:1, greater than 5:1, or greater than 10:1).

[00107] In another embodiment, the branched polyolefins produced herein have an Mn (measured by GPC) of greater than 60,000 g/mol, comprise one or more alpha olefins (preferably propylene and/or ethylene, preferably propylene) and optionally, a C₄ to C₄₀ alpha olefin (preferably a C₄ to C₂₀ alpha olefin, preferably a C₄ to C₁₂ alpha olefin, preferably butene, pentene, hexene, heptene, octene, nonene, decene, cyclopentene, cycloheptene, cyclooctene, cyclooctadiene, and isomers thereof) and have:

(i) 50% or greater allyl chain ends, relative to total unsaturated chain ends (preferably 60% or more, preferably 70 % or more, preferably 75% or more, preferably 80% or more, preferably 90% or more, preferably 95% or more);

(ii) a g'vis of 0.90 or less (preferably 0.85 or less, preferably 0.80 or less);

(iii) optionally, a bromine number which, upon complete hydrogenation, decreases by at least 50% (preferably at least 75%);

(iv) optionally, a T_m of greater than 60°C (preferably greater than 100°C, preferably from 60 to 180°C, preferably from 80 to 175°C); and

(v) optionally, an H_f of greater than 7 J/g (preferably greater than 15 J/g, greater than 30 J/g, greater than 50 J/g, greater than 60 J/g, or greater than 80 J/g).

[00108] In another embodiment, the branched polyolefins produced herein have an Mn (measured by ¹H NMR) of less than 7,500 g/mol (preferably from 100 to 7,500 g/mol), comprise one or more alpha olefins (preferably propylene and/or ethylene, preferably

propylene) and, optionally, a C₄ to C₄₀ alpha olefin (preferably a C₄ to C₂₀ alpha olefin, preferably a C₄ to C₁₂ alpha olefin, preferably butene, pentene, hexene, heptene, octene, nonene, decene, cyclopentene, cycloheptene, cyclooctene, cyclooctadiene, and isomers thereof) and have:

- 5 (i) 50% or greater allyl chain ends, relative to total number of unsaturated chain ends (preferably 60% or more, preferably 70% or more, preferably 75% or more, preferably 80% or more, preferably 90% or more, preferably 95% or more);
- (ii) a ratio of percentage of saturated chain ends (preferably isobutyl chain ends) to percentage of allyl chain ends of 1.2 to 2.0 (preferably 1.6 to 1.8), wherein the percentage of
10 saturated chain ends is determined using ¹³C NMR as described in WO 2009/155471 at paragraph [0095] and [0096] except that the spectra are referenced to the chemical shift of the solvent, tetrachloroethane-d₂, and/or a ratio of Mn(GPC)/Mn(¹H NMR) of 0.95 or less (preferably 0.90 or less, preferably 0.85 or less, preferably 0.80 or less);
- (iii) optionally, a T_m of greater than 60°C (preferably greater than 100°C, preferably from 60
15 to 180°C, preferably from 80 to 175°C);
- (iv) optionally, an H_f of greater than 7 J/g (preferably greater than 15 J/g, greater than 30 J/g, greater than 50 J/g, greater than 60 J/g, or greater than 80 J/g);
- (v) optionally, an allyl chain end to internal vinylidene ratio of greater than 5:1 (preferably greater than 10:1);
- 20 (vi) optionally, an allyl chain end to vinylidene chain end ratio of greater than 10:1 (preferably greater than 15:1); and
- (vii) optionally, an allyl chain end to vinylene chain end ratio of greater than 1:1 (preferably greater than 2:1, greater than 5:1, or greater than 10:1).

[00109] In some embodiments, the branched polyolefins have a branching index, g'_{vis} (as
25 determined by GPC), of 0.90 or less (preferably 0.85 or less, preferably 0.80 or less), relative to a linear polymer of the same composition and microstructure.

[00110] The preferred branched polyolefins described herein have an Mn (measured by ¹H
NMR) of 7,500 to 60,000 g/mol or alternately greater than 60,000 g/mol or alternately from
100 g/mol to less than 7,500 g/mol. Further, a desirable molecular weight range can be any
30 combination of any upper molecular weight limit with any lower molecular weight limit described above. Mn (¹H NMR) is determined according to the NMR method described below in the Examples section. Mn may also be determined using a GPC-DRI method, as

described below. For the purpose of the claims, unless indicated otherwise, Mn is determined by ^1H NMR.

[00111] In another embodiment, the branched polyolefins described herein have an Mw (measured using a GPC-DRI method, as described below) of 1000 g/mol or more (preferably from about 1,000 to about 400,000 g/mol, preferably from about 2000 to 300,000 g/mol, preferably from about 3,000 to 200,000 g/mol) and/or an Mz in the range of from about 1700 to about 150,000 g/mol or preferably from about 800 to 100,000 g/mol, and/or an Mw/Mn in the range of from about 1.2 to 20 (alternately from about 1.7 to 10, alternately from about 1.8 to 5.5).

10 [00112] In particular embodiments, the branched polyolefins described herein have a ratio of $\text{Mn}(\text{GPC})/\text{Mn}(^1\text{H NMR})$ of 0.95 or less (preferably 0.90 or less, preferably 0.85 or less, preferably 0.80 or less). With respect to Figure 1, Figure 1 shows a plot of Mn as determined by GPC versus Mn calculated from ^1H NMR data, as shown below. The plot of the best fit line for the experimental data (shown as a solid line) lies below the parity plot (dashed line).
15 The slope of the best fit line is 0.73065.

[00113] Mn is calculated from ^1H NMR data, assuming one unsaturation per polyolefin chain. ^1H NMR data is collected at either room temperature or 120°C (for purposes of the claims, 120°C shall be used) in a 5 mm probe using a Varian spectrometer with a proton frequency of 250 MHz, 400 MHz, or 500 MHz (for the purpose of the claims, a proton frequency of 400 MHz is used). Data is recorded using a maximum pulse width of 45°C, 8
20 seconds between pulses and signal averaging 120 transients. Spectral signals are integrated and the number of unsaturation types per 1000 carbons is calculated by multiplying the different unsaturation groups by 1000 and dividing the result by the total number of carbons. Mn (^1H NMR) is calculated by dividing the total number of unsaturated species into 14,000,
25 and has units of g/mol.

[00114] Mn, Mw, Mz, carbon number, and g'vis are measured by a GPC-DRI (Gel Permeation Chromatograph-Differential Refractive Index) method using a High Temperature Size Exclusion Chromatograph (SEC, either from Waters Corporation or Polymer Laboratories), equipped with a DRI. Experimental details, are described in: T. Sun, P. Brant,
30 R. R. Chance, and W. W. Graessley, *Macromolecules*, Volume 34, Number 19, pp. 6812-6820, (2001) and references therein. Three Polymer Laboratories PLgel 10mm Mixed-B columns are used. The nominal flow rate is 0.5 cm³/min, and the nominal injection volume is

300 μ L. The various transfer lines, columns and differential refractometer (the DRI detector) are contained in an oven maintained at 135°C. Solvent for the SEC experiment is prepared by dissolving 6 grams of butylated hydroxy toluene as an antioxidant in 4 liters of Aldrich reagent grade 1, 2, 4-trichlorobenzene (TCB). The TCB mixture is then filtered through a 0.7 μ m glass pre-filter and subsequently through a 0.1 μ m Teflon filter. The TCB is then degassed with an online degasser before entering the SEC. Polymer solutions are prepared by placing dry polymer in a glass container, adding the desired amount of TCB, then heating the mixture at 160°C with continuous agitation for about 2 hours. All quantities are measured gravimetrically. The TCB densities used to express the polymer concentration in mass/volume units are 1.463 g/mL at room temperature and 1.324 g/mL at 135°C. The injection concentration is from 1.0 to 2.0 mg/mL, with lower concentrations being used for higher molecular weight samples. Prior to running each sample the DRI detector and the injector are purged. Flow rate in the apparatus is then increased to 0.5 mL/minute, and the DRI is allowed to stabilize for 8 to 9 hours before injecting the first sample. The concentration, c , at each point in the chromatogram is calculated from the baseline-subtracted DRI signal, I_{DRI} , using the following equation:

$$c = K_{DRI} I_{DRI} / (dn/dc)$$

where K_{DRI} is a constant determined by calibrating the DRI, and (dn/dc) is the refractive index increment for the system. The refractive index, $n = 1.500$ for TCB at 135°C and $\lambda = 690$ nm. For purposes of this invention and the claims thereto $(dn/dc) = 0.104$ for propylene polymers and 0.1 otherwise. Units of parameters used throughout this description of the SEC method are: concentration is expressed in g/cm³, molecular weight is expressed in g/mol, and intrinsic viscosity is expressed in dL/g.

[00115] The LS detector is a Wyatt Technology High Temperature mini-DAWN. The molecular weight, M , at each point in the chromatogram is determined by analyzing the LS output using the Zimm model for static light scattering (M.B. Huglin, LIGHT SCATTERING FROM POLYMER SOLUTIONS, Academic Press, 1971):

$$\frac{K_o c}{\Delta R(\theta)} = \frac{1}{MP(\theta)} + 2A_2 c$$

Here, $\Delta R(\theta)$ is the measured excess Rayleigh scattering intensity at scattering angle θ , c is the polymer concentration determined from the DRI analysis, A_2 is the second virial coefficient [for purposes of this invention, $A_2 = 0.0006$ for propylene polymers, 0.0015 for butene

polymers and 0.001 otherwise], $(dn/dc) = 0.104$ for propylene polymers, 0.098 for butene polymers and 0.1 otherwise, $P(\theta)$ is the form factor for a monodisperse random coil, and K_o is the optical constant for the system:

$$K_o = \frac{4\pi^2 n^2 (dn/dc)^2}{\lambda^4 N_A}$$

- 5 where N_A is Avogadro's number, and (dn/dc) is the refractive index increment for the system. The refractive index, $n = 1.500$ for TCB at 145°C and $\lambda = 690$ nm.

[00116] A high temperature Viscotek Corporation viscometer, which has four capillaries arranged in a Wheatstone bridge configuration with two pressure transducers, is used to determine specific viscosity. One transducer measures the total pressure drop across the
 10 detector, and the other, positioned between the two sides of the bridge, measures a differential pressure. The specific viscosity, η_s , for the solution flowing through the viscometer is calculated from their outputs. The intrinsic viscosity, $[\eta]$, at each point in the chromatogram is calculated from the following equation:

$$\eta_s = c[\eta] + 0.3(c[\eta])^2$$

- 15 where c is concentration and was determined from the DRI output.

[00117] The branching index (g'_{vis}) is calculated using the output of the SEC-DRI-LS-VIS method as follows. The average intrinsic viscosity, $[\eta]_{avg}$, of the sample is calculated by:

$$[\eta]_{avg} = \frac{\sum c_i [\eta]_i}{\sum c_i}$$

where the summations are over the chromatographic slices, i , between the integration limits.

- 20 The branching index g'_{vis} is defined as:

$$g'_{vis} = \frac{[\eta]_{avg}}{kM_v^\alpha}$$

where, for purpose of this invention and claims thereto, $\alpha = 0.695$ and $k = 0.000579$ for linear ethylene polymers, $\alpha = 0.705$ $k = 0.000262$ for linear propylene polymers, and $\alpha = 0.695$ and $k = 0.000181$ for linear butene polymers. M_v is the viscosity-average molecular weight
 25 based on molecular weights determined by LS analysis. See Macromolecules, 2001, 34, pp. 6812-6820 and Macromolecules, 2005, 38, pp. 7181-7183, for guidance on selecting a linear standard having similar molecular weight and comonomer content, and determining k coefficients and α exponents.

[00118] In some embodiments, the branched polyolefin has 50% or greater allyl chain

ends (preferably 60% or more, preferably 70% or more, preferably 80% or more, preferably 90% or more, preferably 95% or more). Branched polyolefins generally have a chain end (or terminus) which is saturated and/or an unsaturated chain end. The unsaturated chain end of the inventive polymers comprises "allyl chain ends." An allyl chain end is represented by the
5 formula:



where M represents the polymer chain. "Allylic vinyl group," "allyl chain end," "vinyl chain end," "vinyl termination," "allylic vinyl group" and "vinyl terminated" are used interchangeably in the following description.

10 **[00119]** The "allyl chain end to vinylidene chain end ratio" is defined to be the ratio of the percentage of allyl chain ends to the percentage of vinylidene chain ends. In some embodiments, the allyl chain end to vinylidene chain end ratio is more than 10:1 (preferably greater than 15:1).

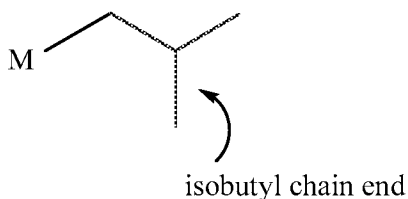
15 **[00120]** The "allyl chain end to vinylene chain end ratio" is defined to be the ratio of the percentage of allyl chain ends to the percentage of vinylene chain ends. In some embodiments, the allyl chain end to vinylene chain end ratio is greater than 1:1 (preferably greater than 2:1, greater than 5:1, or greater than 10:1).

20 **[00121]** The "allyl chain end to internal vinylidene ratio" is defined to be the ratio of the percentage of allyl chain ends to the percentage of internal (or non-terminal) vinylidene groups. In some embodiments, the allyl chain end to internal vinylidene ratio is greater than 5:1 (preferably greater than 10:1).

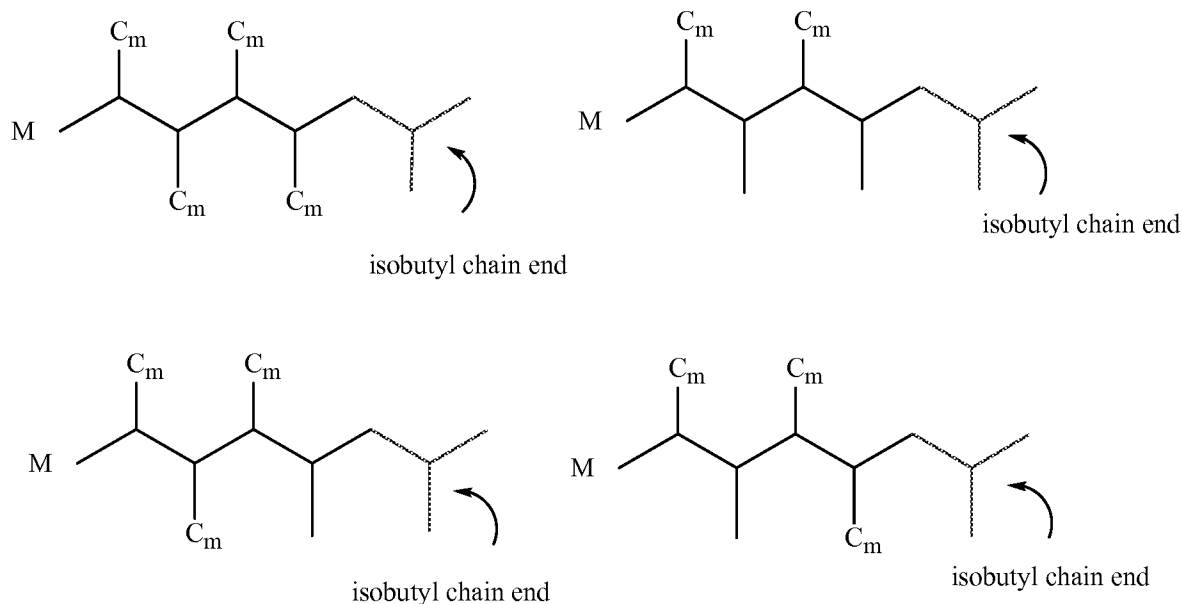
25 **[00122]** The number of allyl chain ends, vinylidene chain ends and vinylene chain ends is determined using ^1H NMR at 120°C using deuterated tetrachloroethane as the solvent on an at least 250 MHz NMR spectrometer, and in selected cases, confirmed by ^{13}C NMR. Resconi has reported proton and carbon assignments (neat perdeuterated tetrachloroethane used for proton spectra, while a 50:50 mixture of normal and perdeuterated tetrachloroethane was used for carbon spectra; all spectra were recorded at 100°C on a Bruker spectrometer operating at 500 MHz for proton and 125 MHz for carbon) for vinyl terminated propylene oligomers in J. American Chemical Soc., 114, 1992, pp. 1025-1032 that are useful herein.
30 Allyl chain ends are reported as a molar percentage of the total number of moles of unsaturated groups (that is, the sum of allyl chain ends, vinylidene chain ends, vinylene chain ends, and the like).

[00123] The unsaturated chain ends may be further characterized by using bromine electrometric titration, as described in ASTM D 1159. The bromine number obtained is useful as a measure of the unsaturation present in the sample. In embodiments herein, branched polyolefins have a bromine number which, upon complete hydrogenation,
 5 decreases by at least 50% (preferably by at least 75%).

[00124] The branched polyolefin also has at least one saturated chain end, preferably at least two saturated chain ends, per branched polyolefin molecule. In some embodiments, the branched polyolefins produced herein have a ratio of percentage of saturated chain ends (preferably isobutyl chain ends) to percentage of allyl chain ends of 1.2 to 2.0 (preferably 1.6
 10 to 1.8), wherein the percentage of saturated chain ends is determined using ^{13}C NMR as described in WO 2009/155471 at paragraph [0095] and [0096] except that the spectra are referenced to the chemical shift of the solvent, tetrachloroethane- d_2 . Where the branched polyolefins comprise propylene-derived units, the saturated chain end which may comprise an isobutyl chain end. An “isobutyl chain end” is defined to be an end or terminus of a
 15 polymer, represented as shown in the formula below:



where M represents the polymer chain. The structure of the branched polyolefin near the saturated chain end may differ, depending on the types and amounts of monomer(s) used, and method of insertion during the polymerization process. In some preferred embodiments,
 20 where the branched polyolefins comprise propylene-derived units and C_4 to C_{40} alpha olefin derived units, the structure of the polymer within four carbons of the isobutyl chain end is represented by one of the following formulae:



where M represents the rest of the polymer chain and C_m represents the polymerized monomer, each C_m may be the same or different, and where m is an integer from 2 to 8.

- 5 **[00125]** The percentage of isobutyl chain ends is determined using ^{13}C NMR (as described in the Example section) and the chemical shift assignments in Resconi et al, J. Am. Chem. Soc. 114, 1992, pp. 1025-1032 for 100% propylene oligomers and reported herein for branched polyolefins.

- 10 **[00126]** In some embodiments, the branched polyolefin has a ratio of percentage of saturated chain ends (preferably isobutyl chain ends) to percentage of allyl chain ends of 1.2 to 2.0 (preferably 1.6 to 1.8), wherein the percentage of saturated chain ends is determined using ^{13}C NMR as described in WO 2009/155471 at paragraph [0095] and [0096] except that the spectra are referenced to the chemical shift of the solvent, tetrachloroethane- d_2 .

- 15 **[00127]** In other embodiments, the branched polyolefins described herein have a T_m of greater than 60°C (preferably greater than 100°C , preferably from 60 to 180°C , preferably from 80 to 175°C).

[00128] In other embodiments, the branched polyolefins described herein have an H_f of greater than 7 J/g (preferably greater than 15 J/g , greater than 30 J/g , greater than 50 J/g , greater than 60 J/g , or greater than 80 J/g).

- 20 **[00129]** In other embodiments, the branched polyolefins described herein have a glass transition temperature (T_g) of less than 0°C or less (as determined by differential scanning

calorimetry as described below), preferably -10°C or less, more preferably -20°C or less, more preferably -30°C or less, more preferably -50°C or less.

[00130] T_m, H_f, and T_g are measured using Differential Scanning Calorimetry (DSC) using commercially available equipment such as a TA Instruments Model Q100. Typically, 6
5 to 10 mg of the sample, that has been stored at room temperature for at least 48 hours, is sealed in an aluminum pan and loaded into the instrument at room temperature. The sample is equilibrated at 25°C, then it is cooled at a cooling rate of 10°C/min to -80°C. The sample is held at -80°C for 5 min and then heated at a heating rate of 10°C/min to 25°C. The glass transition temperature is measured from the heating cycle. Alternatively, the sample is
10 equilibrated at 25°C for 5 minutes, then heated at a heating rate of 10°C/min to 200°C, followed by an equilibration at 200°C for 5 minutes, and cooled at 10°C/min to -80°C. The endothermic melting transition, if present, is analyzed for onset of transition and peak temperature. The melting temperatures reported are the peak melting temperatures from the first heat unless otherwise specified. For samples displaying multiple peaks, the melting
15 point (or melting temperature) is defined to be the peak melting temperature associated with the largest endothermic calorimetric response in that range of temperatures from the DSC melting trace. Areas under the DSC curve are used to determine the heat of transition (heat of fusion, H_f, upon melting or heat of crystallization, H_c, upon crystallization, if the H_f value from the melting is different from the H_c value obtained for the heat of crystallization, then
20 the value from the melting (T_m) shall be used), which can be used to calculate the degree of crystallinity (also called the percent crystallinity). The percent crystallinity (X%) is calculated using the formula: [area under the curve (in J/g) / H° (in J/g)] * 100, where H° is the heat of fusion for the homopolymer of the major monomer component. These values for H° are to be obtained from the *Polymer Handbook, Fourth Edition*, published by John Wiley
25 and Sons, New York 1999, except that a value of 290 J/g is used as the equilibrium heat of fusion (H°) for 100% crystalline polyethylene, a value of 140 J/g is used as the equilibrium heat of fusion (H°) for 100% crystalline polybutene, and a value of 207 J/g (H°) is used as the heat of fusion for a 100% crystalline polypropylene.

[00131] In another embodiment, any of the branched polyolefins described herein have a
30 viscosity at 190°C of greater than 50 mPa.sec, greater than 100 mPa.sec, or greater than 500 mPa.sec. In other embodiments, the branched polyolefins have a viscosity of less than 15,000 mPa.sec, or less than 10,000 mPa.sec. Viscosity is defined herein as resistance to

flow and is measured at an elevated temperature using a Brookfield Viscometer according to ASTM D-3236.

[00132] In a preferred embodiment, any of the branched polyolefins described herein comprises less than 3 wt% of functional groups selected from hydroxide, aryls and substituted aryls, halogens, alkoxys, carboxylates, esters, acrylates, oxygen, nitrogen, and carboxyl (preferably less than 2 wt%, less than 1 wt%, less than 0.5 wt%, less than 0.1 wt%, or 0 wt%), based upon the weight of the copolymer.

[00133] In another embodiment, any of the branched polyolefins described herein comprises at least 50 wt% (preferably at least 75 wt%, preferably at least 90 wt%), based upon the weight of the copolymer composition, of olefins having at least 36 carbon atoms (preferably at least 51 carbon atoms or at least 102 carbon atoms) as measured by ¹H NMR, assuming one unsaturation per chain.

[00134] In another embodiment, the branched polyolefins comprise less than 20 wt% dimer and trimer (preferably less than 10 wt%, preferably less than 5 wt%, more preferably less than 2 wt%, based upon the weight of the copolymer composition), as measured by gas chromatography. "Dimer" (and "trimer") are defined as copolymers having two (or three) monomer units, where the monomer units may be the same or different from each other (where "different" means differing by at least one carbon). Products are analyzed by gas chromatograph (Agilent 6890N with auto-injector) using helium as a carrier gas at 38 cm/sec. A column having a length of 60m (J & W Scientific DB-1, 60 m x 0.25 mm I.D. x 1.0 μm film thickness) packed with a flame ionization detector (FID), an Injector temperature of 250°C, and a Detector temperature of 250°C are used. The sample is injected into the column in an oven at 70°C, then heated to 275°C over 22 minutes (ramp rate 10°C/min to 100°C, 30°C/min to 275°C, hold). An internal standard, usually the monomer, is used to derive the amount of dimer or trimer product that is obtained. Yields of dimer and trimer product are calculated from the data recorded on the spectrometer. The amount of dimer or trimer product is calculated from the area under the relevant peak on the GC trace, relative to the internal standard.

[00135] In another embodiment, any of the branched polyolefins described herein contain less than 25 ppm hafnium or zirconium, preferably less than 10 ppm hafnium or zirconium, preferably less than 5 ppm hafnium or zirconium, based on the yield of polymer produced and the mass of catalyst employed. ICPES (Inductively Coupled Plasma Emission

Spectrometry), which is described in J. W. Olesik, "Inductively Coupled Plasma-Optical Emission Spectroscopy," in the Encyclopedia of Materials Characterization, C. R. Brundle, C. A. Evans, Jr. and S. Wilson, eds., Butterworth-Heinemann, Boston, Mass., 1992, pp. 633-644, is used to determine the amount of an element in a material.

5 **[00136]** In yet other embodiments, the branched polyolefin is a liquid at 25°C.

[00137] In some embodiments, the branched polyolefin may be a homopolymer of propylene. The branched polyolefin may also be a copolymer, a terpolymer, or so on. In some embodiments herein, the branched polyolefin comprises from about 0.1 to 99.9 mol% (preferably from about 5 to about 90 mol%, from about 15 to about 85 mol%, from about 25
10 to about 80 mol%, from about 35 to about 75 mol%, or from about 45 to about 95 mol%) of propylene. In other embodiments, the branched polyolefin comprises greater than 5 mol% (preferably greater than 10 mol%, greater than 20 mol%, greater than 35 mol%, greater than 45 mol%, greater than 55 mol%, greater than 70 mol%, or greater than 85 mol%) of propylene.

15 **[00138]** In some embodiments, the branched polyolefin comprises C₄ to C₄₀ monomers, preferably C₄ to C₂₀ monomers, or preferably C₄ to C₁₂ monomers. The C₄ to C₄₀ monomers, may be linear or cyclic. The cyclic olefins may be strained or unstrained, monocyclic or polycyclic, and may optionally include hetero atoms and/or one or more functional groups. Exemplary monomers include butene, pentene, hexene, heptene, octene,
20 nonene, decene, undecene, dodecene, norbornene, cyclopentene, cycloheptene, cyclooctene, cyclododecene, 7-oxanorbornene, substituted derivatives thereof, and isomers thereof, preferably hexane, heptene, octene, nonene, decene, dodecene, cyclooctene, 1-hydroxy-4-cyclooctene, 1-acetoxy-4-cyclooctene, cyclopentene, norbornene, and their respective homologs and derivatives.

25 **[00139]** In some embodiments, the branched polyolefin comprises two or more different C₄ to C₄₀ monomers, three or more different C₄ to C₄₀ monomers, or four or more different C₄ to C₄₀ monomers. In some embodiments herein, the branched polyolefin comprises from about 0.1 to 99.9 mol% (preferably from about 5 to about 90 mol%, from about 15 to about 85 mol%, from about 25 to about 80 mol%, from about 35 to about 75 mol%, or from about
30 45 to about 95 mol%) of at least one (preferably two or more, three or more, four or more, and the like) C₄ to C₄₀ (preferably butene, pentene, hexene, heptene, octene, nonene, decene, cyclopentene, cycloheptene, cyclooctene, cyclooctadiene, and isomers thereof) monomers.

In other embodiments, the branched polyolefin comprises greater than 5 mol% (preferably greater than 10 mol%, greater than 20 mol%, greater than 35 mol%, greater than 45 mol%, greater than 55 mol%, greater than 70 mol%, or greater than 85 mol%) of C₄ to C₄₀ (preferably butene, pentene, hexene, octene, and decene) monomer.

- 5 **[00140]** In some embodiments, the branched polyolefins are homopolypropylene, propylene/ethylene copolymers, propylene/hexene copolymers, propylene/octene copolymers, propylene/decene copolymers, propylene/hexene/octene terpolymers, propylene/hexene/decene terpolymers, propylene/octene/decene terpolymers, and the like.

Uses of Vinyl Terminated Polymers

- 10 **[00141]** The vinyl terminated branched polymers prepared herein may be functionalized by reacting a heteroatom containing group with the allyl group of the polymer, with or without a catalyst. Examples include catalytic hydrosilylation, hydroformylation, hydroboration, epoxidation, hydration, dihydroxylation, hydroamination, or maleation with or without activators such as free radical generators (e.g., peroxides).

- 15 **[00142]** In some embodiments, the vinyl terminated branched polymers produced herein are functionalized as described in U.S. Patent No. 6,022,929; A. Toyota, T. Tsutsui, and N. Kashiwa, Polymer Bulletin 48, pp. 213-219, 2002; J. Am. Chem. Soc., 1990, 112, pp. 7433-7434; and USSN 12/487,739 filed on June 19, 2009 (Published as WO 2009/155472).

- 20 **[00143]** The functionalized branched polymers can be used in oil additivation and many other applications. Preferred uses include additives for lubricants and/or fuels. Preferred heteroatom containing groups include amines, aldehydes, alcohols, acids, succinic acid, maleic acid, and maleic anhydride.

- 25 **[00144]** In particular embodiments herein, the vinyl terminated branched polymers disclosed herein, or functionalized analogs thereof, are useful as additives. In some embodiments, the vinyl terminated polymers disclosed herein, or functionalized analogs thereof, are useful as additives to a lubricant. Particular embodiments relate to a lubricant comprising the vinyl terminated polymers disclosed herein, or functionalized analogs thereof.

- 30 **[00145]** In other embodiments, the vinyl terminated branched polymers disclosed herein may be used as monomers for the preparation of polymer products. Processes that may be used for the preparation of these polymer products include coordinative polymerization and acid-catalyzed polymerization. In some embodiments, the polymeric products may be homopolymers. For example, if a vinyl terminated polymer (A) were used as a monomer, it

is possible to form a homopolymer product with the formulation $(A)_n$, where n is the degree of polymerization.

[00146] In other embodiments, the polymer products formed from mixtures of monomer vinyl terminated polymers may be mixed polymers, comprising two or more repeating units that are different from each. For example, if a vinyl terminated polymer (A) and a different vinyl terminated polymer (B) were copolymerized, it is possible to form a mixed polymer product with the formulation $(A)_n(B)_m$, where n is the number of molar equivalents of vinyl terminated polymer (A) and m is the number of molar equivalents of vinyl terminated polymer (B) that are present in the mixed polymer product.

[00147] In yet other embodiments, polymer products may be formed from mixtures of the vinyl terminated branched polymer with another alkene. For example, if a vinyl terminated branched polymer (A) and alkene (B) were copolymerized, it is possible to form a mixed polymer product with the formulation $(A)_n(B)_m$, where n is the number of molar equivalents of vinyl terminated polymer and m is the number of molar equivalents of alkene that are present in the mixed polymer product.

[00148] In another embodiment, this invention relates to a functionalized branched polyolefin comprising the reaction product of a heteroatom containing group and any vinyl terminated branched polyolefin described herein, preferably where the functional group comprises one or more heteroatoms selected from the group consisting of P, O, S, N, Br, Cl, F, I, and/or B, and the functionalized branched polyolefin has 0.60 to 1.2, alternately, 0.75 to 1.10, functional groups per chain (preferably assuming that M_n has not altered by more than 15% as compared to the M_n of the vinyl terminated branched polyolefin prior to functionalization and optional derivatization). The number of functional groups per chain (F/M_n) is determined by 1H NMR as described in WO 2009/155472 (See pages 26 to 27, paragraphs [00111] to [00114], including that VDRA is VRDA, which is the normalized integrated signal intensity for the vinylidene resonances between from about 4.65 to 4.85 ppm and the vinylene resonances at from about 5.15 to 5.6 ppm.)

[00149] Preferred heteroatom containing groups comprise one or more of sulfonates, amines, aldehydes, alcohols, or acids, preferably the heteroatom containing group comprises an epoxide, succinic acid, maleic acid or maleic anhydride, alternately the heteroatom containing group comprises one or more of acids, esters, anhydrides, acid-esters, oxycarbonyls, carbonyls, formyls, formylcarbonyls, hydroxyls, and acetyl halides.

[00150] Percent functionalization of the branched polyolefin = $(F * 100)/(F + VI + VE)$. The number of vinyl groups/1000 carbons (VI*) and number of vinylidene groups/1000 carbons (VE*) for the functionalized branched polyolefin are determined from the ¹H NMR spectra of the functionalized polyolefin in the same manner as VI and VE for the
5 unfunctionalized polymer. Preferably, the percent functionalization of the branched polyolefin is 75% or more, preferably 80% or more, preferably 90% or more, preferably 95% or more.

[00151] In another embodiment the functionalized polyolefins described herein have the same Mn, and/or Mw and/or Mz as, or up to 15% greater than (preferably up to 10% greater
10 than), as the starting vinyl terminated polyolefins, "same" is defined to mean within 5%.

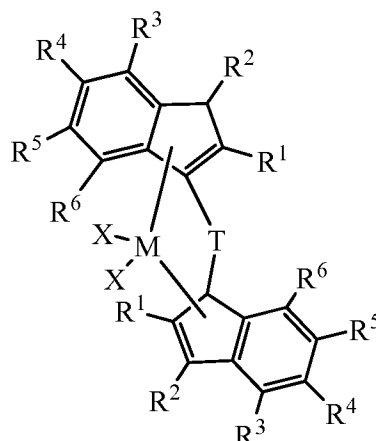
[00152] In another embodiment, the vinyl terminated branched polyolefins described herein can be use in any process, blend, product, or composition disclosed in WO 2009/155472, which is incorporated by reference herein. In some embodiments, the composition is a lubricant blend, an adhesive, or a wax. In some embodiments, the invention
15 relates to the use of the composition as a lubricant blend, an adhesive, or a wax.

[00153] In another embodiment this invention relates to:

1. A process for polymerization, comprising:

(i) contacting, preferably at a temperature greater than 35°C (more preferably in the range of from about 35 to 150°C, from 40 to 140°C, from 60 to 140°C, or from 80 to 130°C) and,
20 optionally, at a pressure in the range of from about 0.35 to 10 MPa (preferably from 0.45 to 6 MPa or from 0.5 to 4 MPa), one or more monomers comprising ethylene and/or propylene (preferably propylene) and optionally, one or more C₄ to C₄₀ alpha olefin monomers (preferably C₄ to C₂₀ alpha olefin monomers, preferably C₄ to C₁₂ alpha olefin monomers, preferably butene, pentene, hexene, heptene, octene, nonene, decene, cyclopentene,
25 cycloheptene, cyclooctene, cyclooctadiene, and isomers thereof), with a catalyst system capable of producing a branched polyolefin, preferably the catalyst system comprises a metallocene catalyst compound and an activator (preferably the activator is a non-alumoxane compound, preferably alumoxane is present at 0 wt%, preferably the activator is a non-coordinating anion activator) (alternately the catalyst system is a mixed catalyst system
30 comprising one or more non-metallocene catalyst compounds, one or more metallocene catalyst compounds, or a combination thereof, preferably the catalyst system comprises a single metallocene catalyst), wherein the metallocene catalyst compound is represented by

the following formula:



where

M is selected from the group consisting of zirconium or hafnium (preferably hafnium);

5 each X is, independently, selected from the group consisting of hydrocarbyl radicals having from 1 to 20 carbon atoms, hydrides, amides, alkoxides, sulfides, phosphides, halides, dienes, amines, phosphines, ethers, and a combination thereof, (two X's may form a part of a fused ring or a ring system) (preferably X is a halide or a hydrocarbyl radical having from 1 to 20 carbon atoms, preferably X is chloride or methyl);

10 each R¹, R², R³, R⁴, R⁵, and R⁶, is, independently, hydrogen or a substituted or unsubstituted hydrocarbyl group, a heteroatom or heteroatom containing group;

further provided that any two adjacent R groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or saturated; and

15 further provided that any of adjacent R⁴, R⁵, and R⁶ groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or saturated;

T is a bridging group represented by the formula R₂^aJ, where J is one or more of C, Si, Ge, N or P (preferably J is Si), and each R^a is, independently, hydrogen, halogen, C₁ to C₂₀ hydrocarbyl or a C₁ to C₂₀ substituted hydrocarbyl, (preferably R^a is methyl, ethyl, chloride)

20 provided that at least one R³, preferably both, are a substituted or unsubstituted phenyl group, if any of R¹, R², R⁴, R⁵ or R⁶ are not hydrogen;

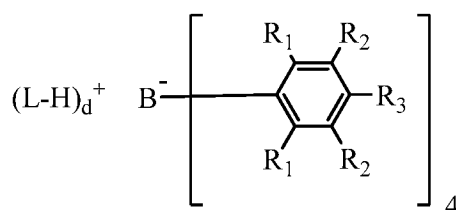
(ii) preferably converting at least 50 mol% of the monomer to polyolefin, more preferably at least 60 mol%, at least 70 mol%, at least 80 mol%; and

25 (iii) obtaining a branched polyolefin having greater than 50% allyl chain ends, relative to total unsaturated chain ends (preferably 60% or more, preferably 70% or more, preferably

80% or more, preferably 90% or more, preferably 95% or more) and a T_m of 60 °C or more (preferably 100 °C or more, preferably 120 °C or more).

2. The processes of paragraph 1 or 12, wherein butene comonomer is present and a mixed butene stream is the source of the butene comonomer.

- 5 3. The processes of paragraphs 1, 2, or 12, wherein the activator is a bulky activator represented by the formula:



where

each R_1 is, independently, a halide, preferably a fluoride;

- 10 each R_2 is, independently, a halide, a C_6 to C_{20} substituted aromatic hydrocarbyl group or a siloxy group of the formula $-O-Si-R_a$, where R_a is a C_1 to C_{20} hydrocarbyl or hydrocarbylsilyl group (preferably R_2 is a fluoride or a perfluorinated phenyl group);

each R_3 is a halide, C_6 to C_{20} substituted aromatic hydrocarbyl group or a siloxy group of the formula $-O-Si-R_a$, where R_a is a C_1 to C_{20} hydrocarbyl or hydrocarbylsilyl group (preferably

- 15 R_3 is a fluoride or a C_6 perfluorinated aromatic hydrocarbyl group); wherein R_2 and R_3 can form one or more saturated or unsaturated, substituted or unsubstituted rings (preferably R_2 and R_3 form a perfluorinated phenyl ring);

L is an neutral Lewis base;

$(L-H)^+$ is a Bronsted acid;

- 20 d is 1, 2, or 3;

wherein the anion has a molecular weight of greater than 1020 g/mol; and

wherein at least three of the substituents on the B atom each have a molecular volume of greater than 250 cubic Å, alternately greater than 300 cubic Å, or alternately greater than 500 cubic Å.

- 25 4. The process of paragraph 3, wherein the bulky activator is at least one of: trimethylammonium tetrakis(perfluoronaphthyl)borate, triethylammonium tetrakis(perfluoronaphthyl)borate, tripropylammonium tetrakis(perfluoronaphthyl)borate, tri(n-butyl)ammonium tetrakis(perfluoronaphthyl)borate, tri(t-butyl)ammonium tetrakis(perfluoronaphthyl)borate, N,N-dimethylanilinium tetrakis(perfluoronaphthyl)borate,

- N,N-diethylanilinium tetrakis(perfluoronaphthyl)borate, N,N-dimethyl-(2,4,6-trimethylanilinium) tetrakis(perfluoronaphthyl)borate, tropillium tetrakis(perfluoronaphthyl)borate, triphenylcarbenium tetrakis(perfluoronaphthyl)borate, triphenylphosphonium tetrakis(perfluoronaphthyl)borate, triethylsilylium tetrakis(perfluoronaphthyl)borate, benzene(diazonium) tetrakis(perfluoronaphthyl)borate, trimethylammonium tetrakis(perfluorobiphenyl)borate, triethylammonium tetrakis(perfluorobiphenyl)borate, tripropylammonium tetrakis(perfluorobiphenyl)borate, tri(n-butyl)ammonium tetrakis(perfluorobiphenyl)borate, tri(t-butyl)ammonium tetrakis(perfluorobiphenyl)borate, N,N-diethylanilinium tetrakis(perfluorobiphenyl)borate, N,N-diethylanilinium tetrakis(perfluorobiphenyl)borate, N,N-dimethyl-(2,4,6-trimethylanilinium) tetrakis(perfluorobiphenyl)borate, tropillium tetrakis(perfluorobiphenyl)borate, triphenylcarbenium tetrakis(perfluorobiphenyl)borate, triphenylphosphonium tetrakis(perfluorobiphenyl)borate, triethylsilylium tetrakis(perfluorobiphenyl)borate, benzene(diazonium) tetrakis(perfluorobiphenyl)borate, and [4-t-butyl-PhNMe₂H][(m-C₆F₅-C₆F₄)₄B].
5. The process of paragraph 1, 2, 3, 4, or 12, wherein the process occurs in a single reaction zone (preferably a solution polymerization).
6. The process of paragraph 1, 2, 3, 4, 5, or 12, wherein the productivity is 4500 g/mmol or more (preferably 5000 g/mmol or more, preferably 10,000 g/mmol or more, preferably 50,000 g/mmol or more; alternately the productivity is at least 80,000 g/mmol, preferably at least 150,000 g/mmol, preferably at least 200,000 g/mmol, preferably at least 250,000 g/mmol, preferably at least 300,000 g/mmol).
7. The process of paragraph 1, 2, 3, 4, 5, 6, or 12, wherein the residence time of the polymerization is up to 300 minutes (preferably in the range of from about 1 to 300 minutes, preferably from about 5 to 250 minutes, or preferably from about 10 to 120 minutes).
8. A branched polyolefin produced by the process of paragraphs 1 to 7 or 12, having an Mn (measured by ¹H NMR) of 7,500 to 60,000 g/mol, comprising one or more alpha olefins (preferably propylene and/or ethylene, preferably propylene) and, optionally, one or more C₄ to C₄₀ alpha olefin monomers (preferably C₄ to C₂₀ alpha olefin monomers, preferably C₄ to C₁₂ alpha olefin monomers, preferably butene, pentene, hexene, heptene, octene, nonene, decene, cyclopentene, cycloheptene, cyclooctene, cyclooctadiene, and isomers thereof) and having:

- (i) 50% or greater allyl chain ends, relative to total number of unsaturated chain ends (preferably 60% or more, preferably 70% or more, preferably 75% or more, preferably 80% or more, preferably 90% or more, preferably 95% or more);
- (ii) a g'_{vis} of 0.90 or less (preferably 0.85 or less, preferably 0.80 or less) and/or a ratio of percentage of saturated chain ends (preferably isobutyl chain ends) to percentage of allyl chain ends of 1.2 to 2.0 (preferably 1.6 to 1.8), and/or a ratio of $Mn(GPC)/Mn(^1H\ NMR)$ of 0.95 or less (preferably 0.90 or less, preferably 0.85 or less, preferably 0.80 or less);
- (iii) optionally, a T_m of greater than 60°C (preferably greater than 100°C, preferably from 60 to 180°C, preferably from 80 to 175°C);
- (iv) optionally, an H_f of greater than 7 J/g (preferably greater than 15 J/g, greater than 30 J/g, greater than 50 J/g, greater than 60 J/g, or greater than 80 J/g);
- (v) optionally, an allyl chain end to internal vinylidene ratio of greater than 5:1 (preferably greater than 10:1);
- (vi) optionally, an allyl chain end to vinylidene chain end ratio of greater than 10:1 (preferably greater than 15:1); and
- (vii) optionally, an allyl chain end to vinylene chain end ratio of greater than 1:1 (preferably greater than 2:1, greater than 5:1, or greater than 10:1).
9. A branched polyolefin produced by the process of paragraphs 1 to 7 or 12, having an M_n (measured by GPC) of greater than 60,000 g/mol, comprising one or more alpha olefins (preferably propylene and/or ethylene, preferably propylene) and, optionally, one or more C_4 to C_{40} alpha olefin monomers (preferably C_4 to C_{20} alpha olefin monomers, preferably C_4 to C_{12} alpha olefin monomers, preferably butene, pentene, hexene, heptene, octene, nonene, decene, cyclopentene, cycloheptene, cyclooctene, cyclooctadiene, and isomers thereof) and having:
- (i) 50% or greater allyl chain ends, relative to total number of unsaturated chain ends (preferably 60% or more, preferably 70% or more, preferably 75% or more, preferably 80% or more, preferably 90% or more, preferably 95% or more);
- (ii) having a g'_{vis} of 0.90 or less (preferably 0.85 or less, preferably 0.80 or less);
- (iii) optionally, a bromine number which, upon complete hydrogenation, decreases by at least 50% (preferably at least 75%);
- (iv) optionally, a T_m of greater than 60°C (preferably greater than 100°C, preferably from 60 to 180°C, preferably from 80 to 175°C); and

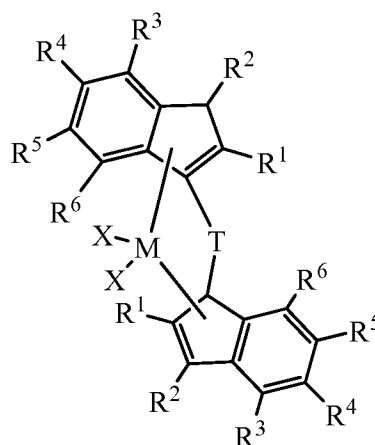
(v) optionally, an Hf of greater than 7 J/g (preferably greater than 15 J/g, greater than 30 J/g, greater than 50 J/g, greater than 60 J/g, or greater than 80 J/g).

10. A branched polyolefin produced by the process of paragraph 1 to 7 or 12, having an Mn (measured by ^1H NMR) of less than 7,500 g/mol, preferably from 100 up to 7,500 g/mol, comprising one or more alpha olefins (preferably propylene and/or ethylene, preferably propylene) and, optionally, one or more C_4 to C_{40} alpha olefin monomers (preferably C_4 to C_{20} alpha olefin monomers, preferably C_4 to C_{12} alpha olefin monomers, preferably butene, pentene, hexene, heptene, octene, nonene, decene, cyclopentene, cycloheptene, cyclooctene, cyclooctadiene, and isomers thereof) and having:
- 5 (i) 50% or greater allyl chain ends, relative to total number of unsaturated chain ends (preferably 60% or more, preferably 70% or more, preferably 75% or more, preferably 80% or more, preferably 90% or more, preferably 95% or more);
- (ii) a ratio of percentage of saturated chain ends (preferably isobutyl chain ends) to percentage of allyl chain ends of 1.2 to 2.0 (preferably 1.6 to 1.8), and/or a ratio of
- 15 $\text{Mn}(\text{GPC})/\text{Mn}(\text{NMR})$ of 0.95 or less (preferably 0.90 or less, preferably 0.85 or less, preferably 0.80 or less);
- (iii) optionally, a T_m of greater than 60°C (preferably greater than 100°C , preferably from 60 to 180°C , preferably from 80 to 175°C);
- (iv) optionally, an Hf of greater than 7 J/g (preferably greater than 15 J/g, greater than 30 J/g, greater than 50 J/g, greater than 60 J/g, or greater than 80 J/g);
- 20 (v) optionally, an allyl chain end to internal vinylidene ratio of greater than 5:1 (preferably greater than 10:1);
- (vi) optionally, an allyl chain end to vinylidene chain end ratio of greater than 10:1 (preferably greater than 15:1); and
- 25 (vii) optionally, an allyl chain end to vinylene chain end ratio of greater than 1:1 (preferably greater than 2:1, greater than 5:1, or greater than 10:1).

11. A functionalized branched polyolefin of paragraphs 8 to 10, wherein the functional group is selected from amines, aldehydes, alcohols, acids, succinic acid, maleic acid, and maleic anhydride.

- 30 12. A process for polymerization, comprising:
- (i) contacting, at a temperature greater than 35°C (preferably in the range of from about 35 to 150°C , from 40 to 140°C , from 60 to 140°C , or from 80 to 130°C) and, optionally, a

pressure in the range of from about 0.35 to 10 MPa (preferably from 0.45 to 6 MPa or from 0.5 to 4 MPa), one or more monomers comprising ethylene and/or propylene (preferably propylene) and optionally, one or more C₄ to C₄₀ alpha olefin monomers (preferably C₄ to C₂₀ alpha olefin monomers, preferably C₄ to C₁₂ alpha olefin monomers, preferably butene, pentene, hexene, heptene, octene, nonene, decene, cyclopentene, cycloheptene, cyclooctene, cyclooctadiene, and isomers thereof), with a catalyst system capable of producing a branched polyolefin, preferably the catalyst system comprises a metallocene catalyst compound and an activator (preferably the activator is a non-alumoxane compound, preferably alumoxane is present at 0 wt%, preferably the activator is a non-coordinating anion activator) (alternately the catalyst system is a mixed catalyst system comprising one or more non-metallocene catalyst compounds, one or more metallocene catalyst compounds, or a combination thereof, preferably the catalyst system comprises a single metallocene catalyst), wherein the metallocene catalyst compound is represented by the following formula:



where

M is selected from the group consisting of zirconium or hafnium (preferably hafnium);
 each X is, independently, selected from the group consisting of hydrocarbyl radicals having from 1 to 20 carbon atoms, hydrides, amides, alkoxides, sulfides, phosphides, halides, dienes, amines, phosphines, ethers, and a combination thereof, (two X's may form a part of a fused ring or a ring system) (preferably X is a halide or a hydrocarbyl radical having from 1 to 20 carbon atoms, preferably X is chloride or methyl);
 each R¹, R², R³, R⁴, R⁵, and R⁶, is, independently, hydrogen or a substituted or unsubstituted hydrocarbyl group, a heteroatom or heteroatom containing group;
 further provided that any two adjacent R groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or saturated; and

further provided that any of adjacent R^4 , R^5 , and R^6 groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or saturated;

T is a bridging group represented by the formula R_2^aJ , where J is one or more of C, Si, Ge, N or P (preferably J is Si), and each R^a is, independently, hydrogen, halogen, C_1 to C_{20} hydrocarbyl or a C_1 to C_{20} substituted hydrocarbyl, (preferably R^a is methyl, ethyl, chloride) provided that at least one R^3 , preferably both, are a substituted or unsubstituted phenyl group, if any of R^1 , R^2 , R^4 , R^5 or R^6 are not hydrogen;

(ii) converting at least 50 mol% of the monomer to polyolefin (preferably at least 60 mol%, at least 70 mol%, at least 80 mol%); and

(iii) obtaining a branched polyolefin having greater than 50% allyl chain ends, relative to total unsaturated chain ends (preferably 60% or more, preferably 70% or more, preferably 80% or more, preferably 90% or more, preferably 95% or more) and a T_m of 60 °C or more (preferably 100 °C or more, preferably 120 °C or more).

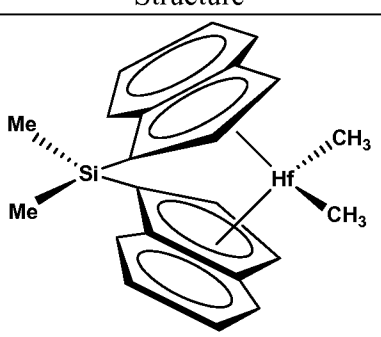
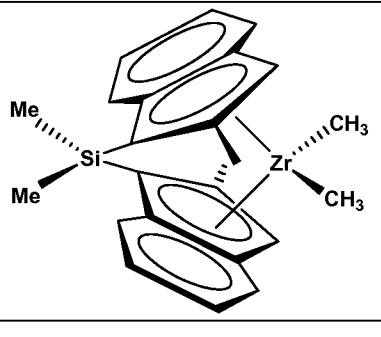
15 EXAMPLES

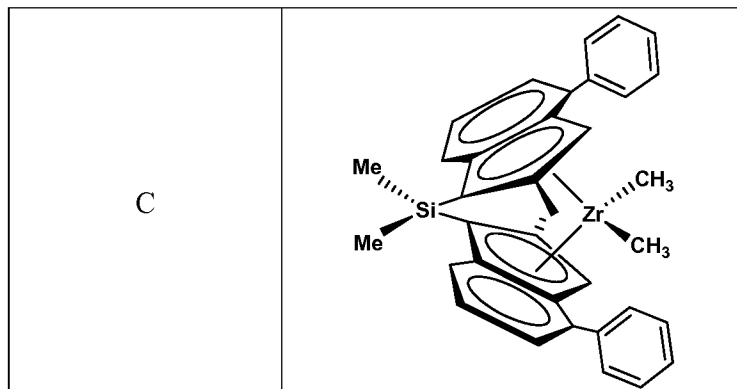
Product Characterization

[00154] Products were characterized by 1H NMR, GPC-3D, and DSC, as indicated above.

Metallocenes Used In Examples

[00155] The following metallocenes were used in the examples below.

Metallocene	Structure
A	
B	



Metallocenes A and C were obtained from Albemarle (Baton Rouge, LA) and used without further purification. Metallocene B was synthesized as shown below.

Synthesis of Metallocene B

- 5 **[00156]** Typical dry-box procedures for synthesis of air-sensitive compounds were followed including using dried glassware (90°C, 4 hours) and anhydrous solvents purchased from Sigma Aldrich (St. Louis, MO) which were further dried over 3 Å sieves. All reagents were purchased from Sigma-Aldrich (Milwaukee, WI) and used without further purification, unless otherwise noted.
- 10 **[00157]** The dichloride precursor of Metallocene B ($B-Cl_2$) was obtained from Albemarle, and converted to Metallocene B using the following procedure: Under inert atmosphere, in a purged Vacuum Atmospheres™ dry box, 3.02g of $B-Cl_2$ was dissolved in 150 mL of dried toluene in a 250 mL single neck round-bottom flask. To this 4.0 mL (5eq) of 3.0M methylmagnesium bromide was added dropwise. The solution was heated in an oil bath at
- 15 90°C overnight. The mixture was then allowed to cool to room temperature, at which time 10.0 mL of trimethylsilylchloride was added drop-wise. After stirring for 10 min, 10.0 mL of dried 1,4-dioxane was added and the mixture stirred an additional 10 min. The mixture was then filtered through an oven dried fine fritted funnel to remove magnesium salts. The flask was rinsed with about 20 mL n-pentane and this was combined with the filtrate by passing
- 20 through the frit. Solvent was removed under vacuum to yield 2.23g of Metallocene B as an off-white powder (74% yield).

Activators Used In Examples

[00158] The following activators were used in the examples below. Activators I and III were purchased from Albemarle. Activator II was purchased from Single Site Catalyst.

Activator	Chemical Name
I	Dimethylaniliniumtetrakis(pentafluorophenyl)borate
II	Trityl(perfluorophenyl)borate
III	Dimethylaniliniumtetrakis(perfluoronaphthyl)borate

Polymerization Conditions For Examples 1-2

[00159] All of the examples were produced in a 0.5-liter Autoclave reactor operated in the continuous stirred-tank solution process. The autoclave was equipped with a stirrer, a water-cooling/steam-heating element with a temperature controller, and a pressure controller.

5 Solvents, monomers such as propylene were first purified by passing through a three-column purification system. Purification columns were regenerated periodically whenever there was evidence of lower activity of polymerization.

[00160] The solvent feed to the reactors was measured by a mass-flow meter. A Pulsafeed pump controlled the solvent flow rate and increased the solvent pressure to the reactors.

10 The compressed, liquefied propylene feed was measured by a mass flow meter and the flow was controlled by a Pulsafeed pump. The solvent and monomers were fed into a manifold first. The mixture of solvent and monomers were then chilled to about -15°C by passing through a chiller prior to feeding into the reactor through a single tube. The collected

15 samples were first air-dried in a hood to evaporate most of the solvent, and then dried in a vacuum oven at a temperature of about 90°C for about 12 hours. The vacuum oven dried samples were weighed to obtain yields. Monomer conversion was calculated basing the polymer yield on the amount of monomers fed into the reactor. All the reactions were carried out at a pressure of about 2.4 MPa/g.

20 **[00161]** Catalysts used in the following examples were *rac*-dimethylsilyl bisindenyl hafnium dimethyl (Catalyst A), *rac*-dimethylsilyl bis(2-methylindenyl)zirconium dimethyl (Catalyst B), and *rac*-dimethylsilyl bis(2-methyl-4-phenylindenyl) zirconium dimethyl (Catalyst C). The activators used were N,N-dimethylanilinium tetrakis(pentafluorophenyl) borate (Activator I), trityl tetrakis(pentafluorophenyl) borate (Activator II), and N,N-dimethyl

25 anilinium tetrakis (heptafluoro-2-naphthyl) borate (Activator III). All of the metallocene catalysts were preactivated with an activator at a molar ratio of about 1:1 in 900 ml of toluene. All catalyst solutions were kept in an inert atmosphere and fed into reactors by metering pumps. Tri-*n*-octylaluminum (TNOAL) solution (available from Sigma Aldrich, Milwaukee, WI) was further diluted in isohexane and used as a scavenger.

Propylene Polymerizations

[00162] The polymerization conditions, % conversion of feed, and catalyst productivity are listed in Table 1, below. In all runs, inlet propylene feed concentration was between 3.5 and 4 M. Two standard cubic centimeter of H₂ was used in the feed of Run #42. Tri(n-octyl)aluminum (TNOAL) was used throughout as scavenger. Molar ratio of TNOAL to metallocene was about 20. Residence time was constant at 5 minutes.

TABLE 1: Conversion and Productivity					
RUN	Met. ¹	Act. ²	T _p , °C	% Conversion*	Productivity x10 ³ kg/mol
1	B	I	100	73.82	4.5
2	B	I	90	77.00	4.7
3	B	I	80	77.64	4.7
4	B	I	70	77.82	4.7
5	B	I	60	78.14	4.8
6	B	II	60	64.34	15.7
7	B	II	70	65.23	15.9
8	B	II	75	64.99	15.9
9	B	II	80	67.24	16.4
10	B	II	85	66.39	16.2
11	B	II	90	63.51	15.5
12	B	II	95	61.03	14.9
13	B	II	100	60.77	14.8
14	B	II	105	53.86	13.1
15	B	II	110	57.45	14.0
16	B	III	120	63.61	9.8
17	B	III	110	66.43	10.2
18	B	III	100	62.79	15.3
19	B	III	90	66.89	16.3
20	B	III	80	68.39	16.7
21	B	III	70	59.36	29.6
22	C	I	125	94.07	46.5
23	C	I	120	95.68	47.3
24	C	I	115	98.11	48.6
25	C	I	110	98.79	48.9
26	C	I	105	100.61	46.9
27	C	I	100	100.71	66.2

TABLE 1: Conversion and Productivity					
RUN	Met. ¹	Act. ²	T _p , °C	% Conversion*	Productivity x10 ³ kg/mol
28	C	I	95	100.64	66.2
29	C	I	90	100.39	66.0
30	C	II	130	65.68	1.83
31	C	II	120	67.36	32.4
32	C	II	110	70.14	33.3
33	C	II	100	72.61	34.6
34	C	II	90	73.54	36.3
35	C	II	80	73.57	36.3
36	C	III	130	57.93	28.6
37	C	III	120	60.79	30.0
38	C	III	110	62.04	30.6
39	C	III	100	62.46	30.8
40	C	III	90	63.43	31.3
41	A	I	90	-	-
42	A	I	80	-	-
43	A	I	130	73.90	5.4
44	A	I	120	81.80	6.0
45	A	I	110	88.10	6.4
46	A	I	100	85.60	6.3
47	A	I	90	86.10	6.3
48	A	I	80	89.40	6.5
49	A	I	70	-	-
50	A	I	60	89.90	6.6
51	A	II	130	62.57	4.6
52	A	II	120	68.43	5.0
53	A	II	110	71.86	5.3
54	A	II	100	73.61	5.4
55	A	II	90	70.18	5.1
56	A	II	80	69.71	5.1
57	A	II	70	70.71	5.2
58	A	II	60	-	-
59	A	III	130	77.25	5.7

TABLE 1: Conversion and Productivity					
RUN	Met. ¹	Act. ²	T _p , °C	% Conversion*	Productivity x10 ³ kg/mol
60	A	III	120	79.04	5.8
61	A	III	110	81.46	6.0
62	A	III	100	81.36	6.0
63	A	III	90	77.11	5.7
64	A	III	80	82.25	6.0
65	A	III	70	79.57	5.8

KEY: ¹: Met. = metallocene, ²: Act. = Activator; T_p = polymerization reaction temperature;

*Propylene conversion calculated to be > 100% is taken to be 100%.

[00163] Propylene conversion was high: 53 to 100%. Productivity of Metallocene C was observed to be 3 to 6 times higher than that of Metallocene A. The productivity of Metallocene B was comparable to Metallocene C, in most cases.

Characterization of Polymer Products

Differential Scanning Calorimetry (DSC)

[00164] Polymer from Runs 1-65 were analyzed using DSC. Data from the analysis of some of the polymer products is shown in the Table 2, below.

TABLE 2: Thermal Characterization of Polypropylene Products					
Polymer	Met. ¹	Act. ²	T _p , °C	T _m , °C	Hf, J/g
2	B	I	90	----	----
3	B	I	80	80.29	28.08
4	B	I	70	99.74	38.85
5	B	I	60	117.76	59.14
6	B	II	60	137.0	82.2
7	B	II	70	129.8	76.8
8	B	II	75	122.4	39.9
9	B	II	80	----	----
10	B	II	85	109.8	69.5
11	B	II	90	107.8	52.4
12	B	II	95	100.1	53.7
13	B	II	100	97.47	42.8
14	B	II	105	98.1	59.29
15	B	II	110	78.76	20.1
16	B	III	120	65.6	10.09

TABLE 2: Thermal Characterization of Polypropylene Products					
Polymer	Met. ¹	Act. ²	T _p , °C	T _m , °C	H _f , J/g
17	B	III	110	80.6	32.1
18	B	III	100	110.08	53.9
19	B	III	90	106.99	64.1
20	B	III	80	113.68	80.7
21	B	III	70	137.95	89.6
22	C	I	125	131.93	82.65
23	C	I	120	134.32	87.26
24	C	I	115	136.91	84.17
25	C	I	110	140.77	90.01
26	C	I	105	142.31	92.33
27	C	I	100	145.07	97.75
28	C	I	95	146.07	96.40
29	C	I	90	148.15	103.70
30	C	II	130	127.14	78.58
31	C	II	120	132.64	84.16
32	C	II	110	138.27	91.6
33	C	II	100	140.83	127.15
34	C	II	90	145.42	95.89
35	C	II	80	151.24	103.60
36	C	III	130	132.33	89.6
37	C	III	120	137.18	87.8
38	C	III	110	143.44	96.72
39	C	III	100	146.0	100.70
40	C	III	90	152.85	93.78
41	A	I	90	----	----
42	A	I	80	86.6	31.0
43	A	I	130	69.04	19.59
44	A	I	120	80.38	23.63
45	A	I	110	90.25	35.64
46	A	I	100	99.38	44.54
47	A	I	90	107.78	56.51
48	A	I	80	118.01	61.19
49	A	I	70	127.57	67.58
50	A	I	60	131.25	73.25

TABLE 2: Thermal Characterization of Polypropylene Products					
Polymer	Met. ¹	Act. ²	T _p , °C	T _m , °C	Hf, J/g
51	A	II	130	57.8	10.10
52	A	II	120	62.1	15.8
53	A	II	110	75.16	27.97
54	A	II	100	89.6	38.24
55	A	II	90	103.7	52.49
56	A	II	80	119.0	61.29
57	A	II	70	127.0	70.86
58	A	II	60	104.0	47.64
59	A	III	130	62.4	7.6
60	A	III	120	79.4	24.78
61	A	III	110	93.16	33.78
62	A	III	100	105.38	50.96
63	A	III	90	116.76	60.97
64	A	III	80	128.96	77.76
65	A	III	70	134.7	76.86

KEY: ¹: Met. = metallocene, ²: Act. = Activator; T_p is polymerization reaction temperature;
 *Propylene conversion calculated to be > 100% is taken to be 100%.

[00165] Metallocene C offers excellent melting point capability. Increasing polymerization temperature results in a decrease in melting point. The decrease in melting point is thought to arise from a higher population of stereo- and region- defects in the products. Among the activators, Activator III appears to be the most effective at increasing the melting point.

Gel Permeation Chromatography (GPC-3D)

[00166] GPC 3D results for some of the polymers are summarized in Table 3.

Table 3: Summary of GPC-3D Data					
Polym Temp °C	Run No.	Molecular Weight Moments			
		Mn	Mw	Mz	g'vis
Metallocene B/Activator I					
100	1	----	----	----	----
90	2	3,590	5,450	7,900	
80	3	5,440	8,330	12,630	0.91
70	4	8,810	13,040	18,860	0.98
60	5	14,240	21,740	31,360	0.97
Metallocene B/Activator II					
60	6	28,014	48,576	69,668	0.976
70	7	3,438	28,203	40,678	0.957
75	8	6,406	15,960	25,601	0.961
80	9	1,646	8,222	12,873	0.972
85	10	3,391	11,718	17,971	0.986
90	11	5,013	10,289	16,529	0.974
95	12	1,698	4,809	8,041	0.954
100	13	2,439	7,490	11,719	0.970
105	14	2,266	6,726	13,140	0.943
110	15	1,308	4,515	7,773	0.859
Metallocene B/Activator III					
120	16	2,693	10,701	23,039	0.977
110	17	8,427	19,411	35,295	0.887
100	18	5,751	33,934	61,807	1.005
90	19	7,980	13,832	21,377	0.970
80	20	8,688	18,937	28,533	0.942
70	21	26,036	45,472	70,218	1.008
Metallocene C/Activator I					
125	22	6,324	16,922	30,721	-----
120	23	6,692	20,476	37,823	0.832
115	24	9,820	24,758	44,867	0.83
110	25	9,360	29,356	55,191	0.825
105	26	13,136	36,624	69,815	0.801
100	27	18,665	47,461	87,325	-----
95	28	19,736	57,000	109,401	0.814
90	29	32,110	73,822	151,184	0.822
Metallocene C/Activator II					
120	31	6,810	17,887	35,399	0.832

Table 3: Summary of GPC-3D Data					
Polym Temp °C	Run No.	Molecular Weight Moments			
		Mn	Mw	Mz	g'vis
110	32	9,029	26,094	49,403	0.801
100	33	16,553	39,113	73,365	0.796
90	34	24,989	60,579	112,107	0.787
80	35	40,160	94,821	175,322	0.812
Metallocene C/Activator III					
130	36	8,679	21,099	45,377	0.818
120	37	16,218	35,192	70,346	0.816
110	38	24,286	59,994	119,250	0.791
100	39	36,835	96,306	183,656	0.807
90	40	56,615	158,033	303,296	0.800
Metallocene A/Activator I					
90	41	3,641	21,141	36,168	0.876
80	42	8,921	21,925	34,197	0.966
130	43	3,117	7,247	60,527	1.089
120	44	----	----	----	----
110	45	6,131	12,490	21,444	0.946
100	46	----	----	----	----
90	47	15,592	27,769	45,011	0.925
80	48	----	----	----	----
70	49	37,866	73,700	116,121	0.952
60	50	----	----	----	----
Metallocene A/Activator II					
130	51	156	7,320	39,833	0.695
120	52	3,235	6,773	12,905	0.941
110	53	405	12,346	40,531	0.844
100	54	7,632	15,444	26,660	0.915
90	55	2,749	30,059	67,565	0.870
80	56	20,402	38,965	63,618	0.963
70	57	33,090	66,336	109,933	1.022
60	58	----	----	----	----
Metallocene A/Activator III					
130	59	4,152	16,575	32,527	0.811
120	60	11,452	27,160	51,854	0.852
110	61	18,170	51,559	119,333	0.832
100	62	31,274	80,916	155,858	0.819

Table 3: Summary of GPC-3D Data					
Polym Temp °C	Run No.	Molecular Weight Moments			
		Mn	Mw	Mz	g'vis
90	63	44,361	189,479	714,702	0.775
80	64	64,545	148,873	254,838	0.933
70	65	20,820	189,133	348,530	1.002

[00167] Molecular weight was observed to decrease with increasing polymerization temperature. Significant enhancement of Mw, for all three metallocenes, was observed when Activator III was used. Polymers made with Activators I and II tended to fall in the same
5 Mw range for each metallocene, within the temperature range tested.

[00168] Taking the DSC and GPC data together, the following metallocene/activator trends (1) and (2) were observed when comparison was made at the same polymerization temperature:

$$\text{Mw: } C/\text{III} > A/\text{III} > C/\text{I} \geq C/\text{II} > B/\text{III} > A/\text{I} \approx A/\text{II} > B/\text{I} > B/\text{II} \quad (1)$$

$$10 \quad \text{Tm: } C/\text{III} > C/\text{I} \geq C/\text{II} > A/\text{III} > A/\text{I} \approx A/\text{II} > B/\text{III} > B/\text{II} > B/\text{I} \quad (2)$$

[00169] Depression of g'vis with increasing Mw was observed in most GPC chromatograms, and this was taken as evidence of long chain branching. In Figure 2, g' f(log Mw) was compared for four of the Metallocene A/Activator III products. All four show signatures for substantial long chain branching. Other products, such as those obtained using
15 Metallocene B/Activator I and Metallocene B/Activator II have g' f(log MW) plots consistent with much less LCB. All these products were made under relatively high propylene conversion conditions (60 to 100%) that may be conducive to long chain branching.

¹H NMR Results

[00170] Data from the analysis of some of the polymer products of Runs 1-65 is shown in
20 the Table 4, below.

TABLE 4: Summary Of Olefin Populations Measured by ¹ H NMR						
Sample	Tp, °C	Olefin/1000C			Mn x 1000	
		Vinyl	Vinylidene	Vinylene	¹ H NMR	GPC
Metallocene B/Activator I						
2	90	0.25	4.42	0.08	2.95	3.59
3	80	0.13	3.14	0.03	4.24	5.44
4	70	0.05	2.00	0.00	6.83	8.81
5	60	0.00	1.30	0.00	10.8	14.24

TABLE 4: Summary Of Olefin Populations Measured by ¹ H NMR						
Sample	Tp, °C	Olefin/1000C			Mn x 1000	
		Vinyl	Vinylidene	Vinylene	¹ H NMR	GPC
Metallocene B/Activator II						
6	60	0.04	0.52	0.00	23.2	28.4
9	80	0.24	0.82	0.01	10.8	1.6
12	95	0.39	2.16	0.06	5.1	1.7
15	110	0.72	4.33	0.09	2.7	1.3
Metallocene B/Activator III						
16	120	1.09	1.39	0.01	5.53	10.0
18	100	0.29	0.42	0.00	18.7	24.4
20	80	0.27	1.13	0.01	8.4	13.0
21	70	0.14	0.23	0.05	21.5	30.5
Metallocene C/Activator I						
22	125	----	----	----	----	----
23	120	0.93	1.14	0	6.76	6.69
24	115	0.51	0.82	0.09	9.86	9.82
25	110	0.78	1.21	0.11	6.67	9.36
26	105	----	----	----	----	----
27	100	----	----	----	----	----
28	95	0.24	0.43	0.08	18.7	19.74
29	90	0.21	0.28	0.15	18.9	32.11
Metallocene C/Activator II						
30	130	0.99	1.11	0.01	6.1	6.0
32	110	0.46	0.40	0.01	14.4	9.0
34	90	0.17	0.35	0.00	23.7	25.0
Metallocene C/Activator III						
36	130	0.78	0.47	0.03	10.5	8.7
38	110	0.37	0.19	0.00	23.7	24.3
40	90	0.25	0.22	0.01	29.2	56.6
Metallocene A/Activator I						
43	130	1.58	2.18	0.06	3.66	3.12
44	120	0.85	1.87	0.05	5.05	----
45	110	0.49	1.55	0.07	6.64	6.13
46	100	0.26	1.12	0.04	9.86	----
47	90	0.12	0.82	0.04	14.29	15.59
48	80	0.05	0.48	0.04	24.56	----
49	70	0.11	0.28	0.05	31.82	37.87
50	60	0.04	0.23	0.04	45.16	----
Metallocene A/Activator II						
51	130	1.90	3.24	0.27	2.6	0.2

TABLE 4: Summary Of Olefin Populations Measured by ^1H NMR						
Sample	Tp, °C	Olefin/1000C			Mn x 1000	
		Vinyl	Vinylidene	Vinylene	^1H NMR	GPC
53	110	0.63	2.06	0.08	5.0	0.4
55	90	0.17	0.92	0.17	11.1	2.8
57	70	0.03	0.26	0.04	40.0	33.1
Metallocene A/Activator III						
59	130	1.67	0.31	0.02	6.4	4.2
61	110	0.50	0.18	0.03	19.7	18.2
63	90	0.09	0.03	0.03	82.4	44.4
65	70	0.28	0.19	0.00	29.2	20.8

[00171] ^1H NMR spectra were recorded for most samples. A summary of the concentrations of the olefin unsaturations is provided in Table 4. The number average molecular weight of each sample was calculated from the ^1H NMR data assuming one unsaturation per chain, and in Table 4 these values were compared with the number average molecular weights derived from GPC. Given signal-to-noise limitations, Mn calculated from ^1H NMR is considered reasonably reliable up to about 50,000 g/mol. A parity plot of Mn (^1H NMR) versus Mn (GPC-DRI) is shown in Figure 1. In most cases, Mns derived from the two methods are in close agreement, although there are notable exceptions. Departures from parity are thought to be due to contributions from long chain branching.

[00172] For a given polymerization temperature, the ranking of % vinyl as a function of metallocene-activator used is summarized in (3) below:

$$\% \text{ vinyl: } A/III > C/III > B/III > C/II > C/I > A/I \geq B/II \sim A/II > B/I \quad (3)$$

It was also observed that % vinyl generally increases, often substantially, with increasing polymerization temperature for every metallocene/activator pair examined.

[00173] All documents described herein are incorporated by reference herein, including any priority documents, related applications and/or testing procedures to the extent they are not inconsistent with this text, provided however that any priority document not named in the initially filed application or filing documents is NOT incorporated by reference herein. As is apparent from the foregoing general description and the specific embodiments, while forms of the invention have been illustrated and described, various modifications can be made without departing from the spirit and scope of the invention. Accordingly, it is not intended that the invention be limited thereby. Likewise, the term “comprising” is considered synonymous with the term “including” for purposes of Australian law. Likewise,

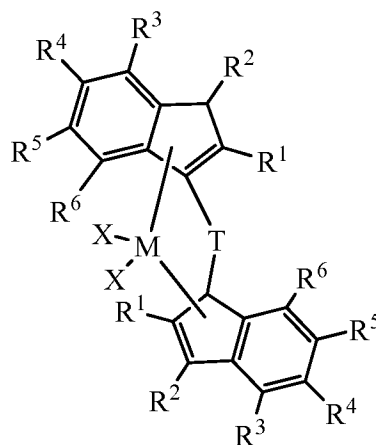
“comprising” encompasses the terms “consisting essentially of,” “is,” and “consisting of” and any place “comprising” is used “consisting essentially of,” “is,” or “consisting of” may be substituted therefore.

CLAIMS

What is claimed is:

1. A process for polymerization, comprising:

- (i) contacting one or more monomers comprising ethylene and/or propylene, with
 5 a catalyst system comprising a metallocene catalyst compound and an activator, wherein the metallocene catalyst compound is represented by the following formula:



where:

M is selected from the group consisting of zirconium or hafnium;

- 10 each X is, independently, selected from the group consisting of hydrocarbyl radicals having from 1 to 20 carbon atoms, hydrides, amides, alkoxides, sulfides, phosphides, halides, dienes, amines, phosphines, ethers, and a combination thereof, (two X's may form a part of a fused ring or a ring system);

- each R¹, R², R³, R⁴, R⁵, and R⁶, is, independently, hydrogen or a substituted or unsubstituted
 15 hydrocarbyl group, a heteroatom or heteroatom containing group;

further provided that any two adjacent R groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or saturated;

- further provided that any of adjacent R⁴, R⁵, and R⁶ groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or
 20 saturated;

T is a bridging group represented by the formula R₂^aJ, where J is one or more of C, Si, Ge, N or P, and each R^a is, independently, hydrogen, halogen, C₁ to C₂₀ hydrocarbyl or a C₁ to C₂₀ substituted hydrocarbyl, provided that at least one R³ is a substituted or unsubstituted phenyl group, if any of R¹, R², R⁴, R⁵, or R⁶ are not hydrogen; and

(ii) obtaining a branched polyolefin having greater than 50% allyl chain ends, relative to total unsaturated chain ends and a T_m of 60°C or more.

2. The process of claim 1, wherein step (i) occurs at a temperature of greater than 35°C and at least 50 mol% of the monomer to polyolefin.

5 3. The process of claim 1 or 2, wherein the monomer is propylene.

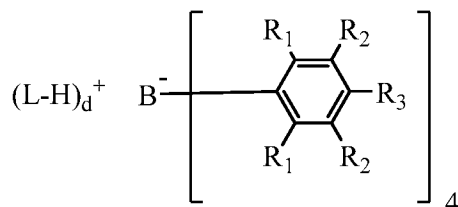
4. The process of claim 1, 2, or 3, where the contacting with the catalyst system further comprises contacting with one or more C₄ to C₄₀ alpha olefin comonomers.

5. The process of claim 4, wherein the C₄ to C₄₀ alpha olefin comonomers are selected from butene, pentene, hexene, heptene, octene, nonene, decene, cyclopentene, cycloheptene, 10 cyclooctene, cyclooctadiene, and isomers thereof.

6. The process of any of claims 1 to 5, wherein the catalyst system is a single catalyst system.

7. The process of any of claims 1 to 6, wherein the activator is a non-alumoxane activator or a non-coordinating anion activator.

15 8. The process of any of claims 1 to 6, wherein the activator is represented by the formula:



where

each R₁ is, independently, a halide;

20 each R₂ is, independently, a halide, a C₆ to C₂₀ substituted aromatic hydrocarbyl group or a siloxy group of the formula –O–Si–R_a, where R_a is a C₁ to C₂₀ hydrocarbyl or hydrocarbylsilyl group;

each R₃ is a halide, C₆ to C₂₀ substituted aromatic hydrocarbyl group or a siloxy group of the formula –O–Si–R_a, where R_a is a C₁ to C₂₀ hydrocarbyl or hydrocarbylsilyl group; wherein

25 R₂ and R₃ can form one or more saturated or unsaturated, substituted or unsubstituted rings;

L is a neutral Lewis base;

(L–H)⁺ is a Bronsted acid;

d is 1, 2, or 3; and

wherein the anion has a molecular weight of greater than 1020 g/mol; and

wherein at least three of the substituents on the B atom each have a molecular volume of greater than 250 cubic Å.

9. The process of any of claims 1 to 5, wherein the activator is one or more of:
 trimethylammonium tetrakis(perfluoronaphthyl)borate, triethylammonium
 5 tetrakis(perfluoronaphthyl)borate, tripropylammonium tetrakis(perfluoronaphthyl)borate,
 tri(n-butyl)ammonium tetrakis(perfluoronaphthyl)borate, tri(t-butyl)ammonium
 tetrakis(perfluoronaphthyl)borate, N,N-dimethylanilinium tetrakis(perfluoronaphthyl)borate,
 N,N-diethylanilinium tetrakis(perfluoronaphthyl)borate, N,N-dimethyl-(2,4,6-
 trimethylanilinium) tetrakis(perfluoronaphthyl)borate, tropillium
 10 tetrakis(perfluoronaphthyl)borate, triphenylcarbenium tetrakis(perfluoronaphthyl)borate,
 triphenylphosphonium tetrakis(perfluoronaphthyl)borate, triethylsilylium
 tetrakis(perfluoronaphthyl)borate, benzene(diazonium) tetrakis(perfluoronaphthyl)borate,
 trimethylammonium tetrakis(perfluorobiphenyl)borate, triethylammonium
 tetrakis(perfluorobiphenyl)borate, tripropylammonium tetrakis(perfluorobiphenyl)borate,
 15 tri(n-butyl)ammonium tetrakis(perfluorobiphenyl)borate, tri(t-butyl)ammonium
 tetrakis(perfluorobiphenyl)borate, N,N-dimethylanilinium tetrakis(perfluorobiphenyl)borate,
 N,N-diethylanilinium tetrakis(perfluorobiphenyl)borate, N,N-dimethyl-(2,4,6-
 trimethylanilinium) tetrakis(perfluorobiphenyl)borate, tropillium
 tetrakis(perfluorobiphenyl)borate, triphenylcarbenium tetrakis(perfluorobiphenyl)borate,
 20 triphenylphosphonium tetrakis(perfluorobiphenyl)borate, triethylsilylium
 tetrakis(perfluorobiphenyl)borate, benzene(diazonium) tetrakis(perfluorobiphenyl)borate, [4-
 t-butyl-PhNMe₂H][(m-C₆F₅-C₆F₄)₄B].
10. The process of any of claims 1 to 9, wherein the process occurs in a single reaction zone.
- 25 11. The process of any of claims 1 to 10, wherein alumoxane is present at 0 mol%.
12. The process of any of claims 1 to 11, wherein the polymerization is a solution polymerization.
13. The process of any of claims 1 to 12, wherein the productivity is 4500 g/mmol or more.
- 30 14. The process of any of claims 1 to 13, wherein the contacting occurs at a temperature in the range of from about 35 to 150°C.
15. The process of any of claims 1 to 14, wherein the residence time is up to 300 minutes.

16. The process of any of claims 1 to 15, wherein the metallocene is selected from (*rac*-dimethylsilylbis(indenyl) hafniumdimethyl, (*rac*-dimethylsilylbis(2-methylindenyl)zirconiumdimethyl, (*rac*-dimethylsilylbis(2-methyl-4-phenylindenyl)zirconiumdimethyl, and dimethyl *rac*-dimethylsilyl-bis(5,6,7,8-tetrahydro-5,5,8,8-tetramethyl-2-methyl-1H-benz(f)indene)hafnium dimethyl.
17. The process of any of claims 1 to 16, wherein the process is a continuous process.
18. A branched polyolefin having an Mn (¹H NMR) of 7,500 to 60,000 g/mol, comprising one or more alpha olefin derived units comprising ethylene and/or propylene, and having;
- (i) 50% or greater allyl chain ends, relative to total number of unsaturated chain ends; and
- (ii) a g'vis of 0.90 or less.
19. The branched polyolefin of claim 18, having a ratio of percentage of saturated chain ends to percentage of allyl chain ends of 1.2 to 2.0.
20. A branched polyolefin having an Mn (¹H NMR) of less than 7,500 g/mol, comprising one or more alpha olefin derived units comprising ethylene and/or propylene, and having;
- (i) a ratio of percentage of saturated chain ends to percentage of allyl chain ends of 1.2 to 2.0; and
- (ii) 50% or greater allyl chain ends, relative to total moles of unsaturated chain ends.
21. The branched polyolefin of claim 20, having an Mn of greater than 100 g/mol.
22. The branched polyolefin of claim 18, 19, 20, or 21, having a ratio of Mn(GPC)/Mn(¹H NMR) of 0.95 or less.
23. The branched polyolefin of claim 18, 19, 20, 21, or 22, having an allyl chain end to internal vinylidene ratio of greater than 5:1.
24. The branched polyolefin of claim 18, 19, 20, 21, 22, or 23, having an allyl chain end to vinylidene chain end ratio of greater than 10:1.
25. The branched polyolefin of claim 18, 19, 20, 21, 22, 23, or 24, having an allyl chain end to vinylene chain end ratio of greater than 1:1.
26. A branched polyolefin having an Mn (GPC) greater than 60,000 g/mol, comprising one or more alpha olefin derived units comprising ethylene and/or propylene, and having;
- (i) 50% or greater allyl chain ends, relative to total unsaturated chain ends;
- (ii) a g'vis of 0.90 or less; and

(iii) optionally, a bromine number which, upon complete hydrogenation, decreases by at least 50%.

27. A functionalized branched polyolefin having an Mn of 7,500 to 60,000 g/mol, comprising propylene derived units, and having:

- 5 (i) a g'vis of 0.90 or less; and
 (ii) a ratio of saturated chain ends to functional group of 1.2 to 2.0.

28. The branched polyolefin of any of claims 18 to 27, comprising propylene and ethylene derived units.

29. The branched polyolefin of any of claims 18 to 28, further comprising C₄ to C₄₀ alpha
10 olefin derived units.

30. The branched polyolefin of any of claims 18 to 29, having a Tm of greater than 60°C.

31. The branched polyolefin of any of claims 18 to 30, having an Hf of greater than 7 J/g.

32. The functionalized polyolefin of any of claims 27 to 31, wherein the functional group is selected from amines, aldehydes, alcohols, acids, succinic acid, maleic acid, and maleic
15 anhydride.

33. The functionalized polyolefin of claim 32, wherein the functional group is maleic acid or maleic anhydride.

34. A lubricant comprising the functionalized polyolefin of any of claim 27 to 33.

1/1

Figure 1

