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(54) **SOLID SINGLE SITE CATALYSTS WITH HIGH POLYMERISATION ACTIVITY**

FESTE SINGLE-SITE-KATALYSATOREN MIT HOHER POLYMERISATIONSAKTIVITÄT

CATALYSEURS SOLIDES À SITE UNIQUE AVEC UNE ACTIVITÉ DE POLYMÉRISATION ÉLEVÉE

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**EP 3 063 185 B9**

**Description**

**[0001]** The present invention is directed to a new method for preparing a solid catalyst system enabling the efficient preparation of polymers. Furthermore, the present invention is directed at a solid catalyst system obtainable, preferably obtained from the inventive method.

**[0002]** In the field of catalysts since many years great efforts are undertaken to further improve the catalyst types tailored for specific purposes. For instance in polymerisation processes single site, like metallocene, catalyst systems are widely used having many advantages.

**[0003]** At the beginning of the development of new metallocene catalyst systems only homogeneous catalyst systems were available. Such homogeneous catalyst systems are solutions of one or more catalyst components, e.g. a transition metal compound and optionally a cocatalyst. Homogeneous systems are used as liquids in the polymerisation process. Such systems have in general a satisfactory catalytic activity, but their problem has been that the polymer thus produced has a poor morphology (e.g. the polymer obtained is in a form of a fluff having a low bulk density). As a consequence, operation of slurry and gas phase reactors using a homogeneous catalyst system causes problems in practice, for instance in terms of reactor fouling.

**[0004]** To overcome the problems of the homogeneous catalyst systems, supported systems have been developed. These supported systems, known as heterogeneous catalyst systems, comprise carrier materials, such as porous organic and inorganic support materials, like silica, aluminosilicate or porous polymeric materials onto which the catalyst is loaded or supported.

**[0005]** However, also supported catalyst systems cause problems. To mention only one among many, it is difficult to get an even distribution of the catalyst components in the porous carrier material. Further leaching of the catalyst components from the support can occur. Such drawbacks lead to an unsatisfactory polymerisation behavior of the catalyst, and as a result, the morphology of the polymer product thus obtained is also poor. Further such classic heterogeneous catalyst systems show reduced catalytic activity, which is of course detrimental, as the catalyst amount must be increased, which in turn leads to polymer products contaminated with rather high amounts of catalyst residues including silica residues, which might be very detrimental in some product applications.

**[0006]** For this reason a new single site, like metallocene catalyst system has been developed which significantly reduces the drawbacks of the known heterogeneous catalyst systems. Such new catalyst systems are solid catalyst systems, but are not in need of catalytically inert support material, and are further featured by spherical particles with low porosity. Such new metallocene catalyst systems enable to increase the output rate of polymers, since the bulk density of the polymerised product can be increased. For the first time such new metallocene catalyst systems have been described in WO 03/051934. These types of catalysts have solved many problems caused by catalysts of earlier prior art.

**[0007]** Many prior art catalysts have, however, a general drawback relating to their tendency to dissolve in the polymerisation medium, and thus causing undesired fouling in the reactors. Thus, there remains still some work to do to improve the properties of the catalyst, especially in view of morphology and in that the desired morphology would remain and be effectively used, during the polymerisation, which would also decrease fouling and sheeting problems.

**[0008]** Moreover, nowadays the catalyst shall be not only suitable for specific processes for producing desired polymers but there is a general tendency to find out methods, also in catalyst preparation field, where the starting materials are safer and easier to be used both in environmental as well handling point of view. Thus there is the strong need to develop preparation methods of such catalyst systems based on materials which promote sustainable preparation method as well as are easily commercially accessible and thus well priced.

**[0009]** Much effort has been put into improving the methods for preparing support-free metallocene catalyst as described in WO 03/051934. Most research since has been focused at improving the emulsification/solidification technology in which an emulsion is formed wherein the continuous phase, in which a solution of the catalyst components forms the dispersed phase in the form of droplets, is immiscible with said catalyst component solution.

**[0010]** WO 2011/138211 describes an improved and suitable process for preparing solid metallocene catalyst systems with the emulsion/solidification technology, in which a liquid clathrate constitutes the dispersed phase of the emulsion and the solvent used for the continuous phase of the emulsion is a non-reactive fluorinated synthetic oil.

**[0011]** Unfortunately such catalyst systems, prepared by the emulsification/solidification technology comprising a metallocene catalyst in combination with an aluminosilicate co-catalyst, have also some disadvantages, even when having the dispersed phase in form of a liquid clathrate.

**[0012]** For example, such catalyst systems have a tendency to dissolve to some extent in common polymerisation media. The solubility can lead to catalyst leaching, which is further associated with reactor fouling and sheeting.

**[0013]** Recently it has been found that support-free catalyst systems comprising a metallocene catalyst in combination with an aluminosilicate co-catalyst can be obtained from a solution without applying the emulsion/solidification technology. EP 2 386 582 A1 describes a process in which a solid catalyst is obtained from preparing a liquid clathrate from aluminosilicate, organometallic compound (metallocene) and a compound being able to form lattice with aluminosilicate and

metallocene, and a hydrocarbon compound, and subsequent precipitation. The compound being able to form lattice with aluminosilicate and metallocene is said to be either M-X compound or an organosilicon compound, and precipitation is carried out with silicon oil. From this precipitation technology, solid catalyst particles could be obtained with improved leaching properties, however, this approach resulted in solid catalyst particles with lower catalytic activity compared to similar solid catalyst particles obtained by the emulsion/solidification technology. In this respect exceptionally low catalytic activities in propylene polymerisation could be observed, in particular when catalysts were prepared in presence of siloxanes.

**[0014]** Thus the object of the present invention is to find an improved and suitable process for the manufacture of solid catalyst systems without the need of external support materials, and which render possible to produce polymers in an efficient manner, i.e. using solid catalyst systems which are less soluble in the polymerisation media, and are obtained by a reliable process yielding catalyst systems with high catalytic activities towards olefins such as propylene and ethylene, in particular towards propylene.

**[0015]** The finding of the present invention is that the solid catalyst system must be produced by preparing first a liquid clathrate of activator and clathrating agent using a specific ratio with respect to clathrating agent and activator, and after that forming a liquid mixture of said liquid clathrate and an organometallic compound, which liquid mixture is converted into solid form by precipitation using specified precipitation agent.

**[0016]** Thus the present invention is directed to a process for the preparation of a solid catalyst system (CS) comprising the steps of

- (i) preparing a liquid clathrate (LC) comprising a mixing step of an aluminosilicate (A), an aromatic compound (AC) and an organo-silicon compound (OS), wherein the mol-ratio between the organo-silicon compound (OS) and aluminum (Al) of the aluminosilicate (A)  $[(OS)/(Al)]$  is equal or below 0.1,
- (ii) mixing said liquid clathrate (LC) with an organometallic compound (C) obtaining a liquid mixture (MI), wherein the liquid mixture (MI) is homogeneous,
- (iii) precipitating the solid catalyst system (CS) out of said liquid mixture (MI) by adding a saturated aliphatic compound to said mixture (MI)
- (iv) optionally recovering particles of the solid catalyst system (CS),

wherein preferably during the process no carrier material, i.e. no external catalytically inert support material, is added.

**[0017]** Surprisingly it has been found out that with the above defined process in an effective manner solid catalyst systems (CS) can be obtained, which enables a person skilled in the art to efficiently produce polymers having good morphology and with acceptable activity. The process of the invention is easy to control due to the separate process steps for producing liquid clathrate (LC) and further liquid catalyst mixture (MI) as well due to the improved precipitation step. When applying said solid catalyst systems (CS) in polymerisation processes, high catalytic activities could be observed without the occurrence of reactor fouling.

**[0018]** The solid catalyst system (CS) obtained according to the instant process is solid without external catalytically inert support material.

**[0019]** External catalytically inert support material according to this invention is any material which is used to decrease solubility of the catalyst systems in media which are generally used in polymerization processes. Of course such material has no catalytic activity, especially in the polymerization process, like in a polyolefin polymerization process, e.g. in a polyethylene or polypropylene polymerization process. Accordingly said external catalytically inert support material is a material which effectively decreases solubility in common polymerization media. Typical external catalytically inert support materials are organic and inorganic support materials, like silica, solid aluminosilicate or porous polymeric materials, onto which catalyst components are loaded. These support materials are generally used in amounts of at least 50wt.-%, more preferably of at least 70.0 wt.-%. Accordingly in the inventive process rather low amount of external catalytically inert support material is used (if used at all). Preferably the amount of external catalytically inert support material used in the process is below 10.0 wt.-%, more preferably below 5.0 wt.-%, yet more preferably no external catalytically inert support material used. Accordingly the amount of such external catalytically inert support material within the obtained solid catalyst system (CS) is below 10.0 wt.-%, yet more preferably below 5.0 wt.-%, yet more preferably not detectable, like not present.

**[0020]** Throughout the invention the terms "external catalytically inert support material" and "carrier material" are interchangeable.

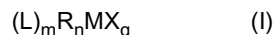
**[0021]** Furthermore, it has been found that the activity decreasing effect of the clathrating agent (OS) can be compensated when the ratio between the clathrating agent (OS) and aluminosilicate (A) is carefully controlled.

**[0022]** Further, using saturated hydrocarbon compound instead of silicone fluid in precipitation step shows a clear benefit in activity of the catalyst.

**[0023]** The organometallic compound (C) preferably comprises a transition metal (M) of group 3 to 10 of the Periodic Table (IUPAC 2007) or of an actinide or lanthanide.

**[0024]** The term "an organometallic compound (C)" in accordance with the present invention preferably includes any metallocene or non-metallocene compound of a transition metal which bears at least one organic (coordination) ligand and exhibits the catalytic activity alone or together with a cocatalyst. The transition metal compounds are well known in the art and the present invention covers compounds of metals from group 3 to 10, e.g. group 3 to 7, or 3 to 6, such as

**[0025]** In one embodiment the organometallic compound (C) has the following formula (I):



wherein

"M" is a transition metal (M) of group 3 to 10 of the Periodic Table (IUPAC 2007),  
 each "X" is independently a mono anionic ligand, such as a  $\sigma$ -ligand,  
 each "L" is independently an organic ligand which coordinates to the transition metal "M",  
 "R" is a bridging group linking said organic ligands (L),  
 "m" is 1, 2 or 3, preferably 2,  
 "n" is 0, 1 or 2, preferably 1,  
 "q" is 1, 2 or 3, preferably 2, and  
 m+q is equal to the valency of the transition metal (M).

**[0026]** "M" is preferably selected from the group consisting of zirconium (Zr), hafnium (Hf), or titanium (Ti), more preferably selected from the group consisting of zirconium (Zr) and hafnium (Hf).

**[0027]** In a more preferred definition, each organic ligand (L) is independently

- (a) a substituted or unsubstituted cyclopentadienyl or a bi- or multicyclic derivative of a cyclopentadienyl which optionally bear further substituents and/or one or more hetero ring atoms from a group 13 to 16 of the Periodic Table (IUPAC 2007); or
- (b) an acyclic  $\eta^1$ - to  $\eta^4$ - or  $\eta^6$ -ligand composed of atoms from groups 13 to 16 of the Periodic Table, and in which the open chain ligand may be fused with one or two, preferably two, aromatic or non-aromatic rings and/or bear further substituents; or
- (c) a cyclic  $\eta^1$ - to  $\eta^4$ - or  $\eta^6$ -, mono-, bi- or multidentate ligand composed of unsubstituted or substituted mono-, bi- or multicyclic ring systems selected from aromatic or non-aromatic or partially saturated ring systems, such ring systems containing optionally one or more heteroatoms selected from groups 15 and 16 of the Periodic Table (IUPAC 2007).

**[0028]** Organometallic compounds (C), preferably used in the present invention, have at least one organic ligand (L) belonging to the group (a) above. Such organometallic compounds are called metallocenes.

**[0029]** More preferably at least one of the organic ligands (L) belonging to group (a), preferably both organic ligands (L), is (are) selected from the group consisting of cyclopentadienyl, indenyl, tetrahydroindenyl, fluorenyl, which can be independently substituted or unsubstituted. Further, in case said organic ligands (L) are substituted it is preferred that at least one organic ligand (L), preferably both organic ligands (L), comprise one or more substituents independently selected from  $C_1$  to  $C_{20}$  hydrocarbyl or silyl groups, which optionally contain one or more heteroatoms selected from groups 14 to 16 and/or are optionally substituted by halogen atom(s),

**[0030]** The term  $C_1$  to  $C_{20}$  hydrocarbyl group, whenever used in the present application, includes  $C_1$  to  $C_{20}$  alkyl,  $C_2$  to  $C_{20}$  alkenyl,  $C_2$  to  $C_{20}$  alkynyl,  $C_3$  to  $C_{20}$  cycloalkyl,  $C_3$  to  $C_{20}$  cycloalkenyl,  $C_6$  to  $C_{20}$  aryl,  $C_7$  to  $C_{20}$  alkylaryl or  $C_7$  to  $C_{20}$  arylalkyl groups or mixtures of these groups such as cycloalkyl substituted by alkyl.

**[0031]** Further, two substituents, which can be same or different, attached to adjacent C-atoms of a ring of the ligands (L) can also taken together form a further mono or multicyclic ring fused to the ring.

**[0032]** Preferred hydrocarbyl groups are independently selected from linear or branched  $C_1$  to  $C_{10}$  alkyl groups, optionally interrupted by one or more heteroatoms of groups 14 to 16, like O, N or S, and substituted or unsubstituted  $C_6$  to  $C_{20}$  aryl groups.

**[0033]** Linear or branched  $C_1$  to  $C_{10}$  alkyl groups, optionally interrupted by one or more heteroatoms of groups 14 to 16, are more preferably selected from methyl, ethyl, propyl, isopropyl, tertbutyl, isobutyl,  $C_{5-6}$  cycloalkyl, OR, SR, where R is  $C_1$  to  $C_{10}$  alkyl group,

**[0034]**  $C_6$  to  $C_{20}$  aryl groups are more preferably phenyl groups, optionally substituted with 1 or 2  $C_1$  to  $C_{10}$  alkyl groups as defined above.

**[0035]** By " $\sigma$ -ligand" is meant throughout the invention a group bonded to the transition metal (M) via a sigma bond.

**[0036]** Further, the ligands "X" are preferably independently selected from the group consisting of hydrogen, halogen,

C<sub>1</sub> to C<sub>20</sub> alkyl, C<sub>1</sub> to C<sub>20</sub> alkoxy, C<sub>2</sub> to C<sub>20</sub> alkenyl, C<sub>2</sub> to C<sub>20</sub> alkynyl, C<sub>3</sub> to C<sub>12</sub> cycloalkyl, C<sub>6</sub> to C<sub>20</sub> aryl, C<sub>6</sub> to C<sub>20</sub> aryloxy, C<sub>7</sub> to C<sub>20</sub> arylalkyl, C<sub>7</sub> to C<sub>20</sub> arylalkenyl, -SR", -PR"<sub>3</sub>, -SiR"<sub>3</sub>, -OSiR"<sub>3</sub> and -NR"<sub>2</sub>, wherein each R" is independently hydrogen, C<sub>1</sub> to C<sub>20</sub> alkyl, C<sub>2</sub> to C<sub>20</sub> alkenyl, C<sub>2</sub> to C<sub>20</sub> alkynyl, C<sub>3</sub> to C<sub>12</sub> cycloalkyl or C<sub>6</sub> to C<sub>20</sub> aryl.

**[0037]** More preferably "X" ligands are selected from halogen, C<sub>1</sub> to C<sub>6</sub> alkyl, C<sub>5</sub> to C<sub>6</sub> cycloalkyl, C<sub>1</sub> to C<sub>6</sub> alkoxy, phenyl and benzyl groups.

**[0038]** The bridging group "R" may be a divalent bridge, preferably selected from -R'<sub>2</sub>C-, -R'<sub>2</sub>C-CR'<sub>2</sub>-, -R'<sub>2</sub>Si-, -R'<sub>2</sub>Si-Si R'<sub>2</sub>-, -R'<sub>2</sub>Ge-, wherein each R' is independently a hydrogen atom, C<sub>1</sub> to C<sub>20</sub> alkyl, C<sub>2</sub> to C<sub>10</sub> cycloalkyl, tri(C<sub>1</sub> to C<sub>20</sub> alkyl)silyl, C<sub>6</sub> to C<sub>20</sub> aryl, C<sub>7</sub> to C<sub>20</sub> arylalkyl and C<sub>7</sub> to C<sub>20</sub> to alkylaryl.

**[0039]** More preferably the bridging group "R" is a divalent bridge selected from -R'<sub>2</sub>C-, -R'<sub>2</sub>Si-, wherein each R' is independently a hydrogen atom, C<sub>1</sub> to C<sub>20</sub> alkyl, C<sub>2</sub> to C<sub>10</sub> cycloalkyl, C<sub>6</sub> to C<sub>20</sub> aryl, C<sub>7</sub> to C<sub>20</sub> arylalkyl and C<sub>7</sub> to C<sub>20</sub> alkylaryl.

**[0040]** Another subgroup of the organometallic compounds (C) of formula (I) is known as non-metallocenes wherein the transition metal (M), preferably a Group 4 to 6 transition metal, suitably Ti, Zr or Hf, has a coordination ligand other than a cyclopentadienyl ligand. The term "non-metallocene" used herein means compounds, which bear no cyclopentadienyl ligands or fused derivatives thereof, but one or more non-cyclopentadienyl η-, or σ-, mono-, bi- or multidentate ligand. Such ligands can be chosen e.g. from the groups (b) and (c) as defined above and described e.g. in WO 01/70395, WO 97/10248, WO 99/41290, and WO 99/10353), and further in V. C. Gibson et al., in Angew. Chem. Int. Ed., engl., vol 38, 1999, pp 428 447.

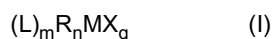
**[0041]** However, the organometallic compound (C) of the present invention is preferably a metallocene as defined above.

**[0042]** Metallocenes are described in numerous patents. In the following just a few examples are listed; EP 260 130, WO 97/28170, WO 98/46616, WO 98/49208, WO 98/040331, WO 99/12981, WO 99/19335, WO 98/56831, WO 00/34341, WO00/148034, EP 423 101, EP 537 130, WO2002/02576, WO2005/105863, WO 2006097497, WO2007/116034, WO2007/107448, WO2009/027075, WO2009/054832, WO 2012/001052 and EP 2532687. Further, metallocenes are described widely in academic and scientific articles.

**[0043]** In the following the essential features of the present invention are described in more detail.

**[0044]** The present invention is directed at a process for the preparation of a solid catalyst system (CS) comprising the steps of

- (i) preparing a liquid clathrate (LC) comprising a mixing step of an aluminoxane (A), an aromatic compound (AC) and an organo-silicon compound (OS), wherein the mol-ratio between the organo-silicon compound (OS) and aluminum (Al) of the aluminoxane (A) [(OS)/(A1)] is below 0.1,
- (ii) mixing said liquid clathrate (LC) with an organometallic compound (C) obtaining a liquid mixture (MI), said organometallic compound (C) is of formula (I)



wherein

- "M" is a transition metal (M) of group 3 to 10 of the Periodic Table (IUPAC 2007),
- each "X" is independently a monoanionic ligand, such as σ-ligand,
- each "L" is independently an organic ligand which coordinates to the transition metal (M),
- "R" is a bridging group linking said organic ligands (L),
- "m" is 2 or 3, preferably 2,
- "n" is 0, 1 or 2, preferably 1,
- "q" is 1, 2 or 3, preferably 2,
- m+q is equal to the valency of the transition metal (M),

- (iii) precipitating the solid catalyst system (CS) by adding a saturated aliphatic compound to said liquid mixture (MI)
- (iv) optionally recovering particles to obtain the solid catalyst system (CS).

**[0045]** According to the invention first step (step (i)) is followed by the second step (step (ii)). In other words, a liquid mixture (MI) is produced by preparing a liquid clathrate (LC) and subsequently mixing said liquid clathrate (LC) with an organometallic compound (C). Accordingly the liquid clathrate (LC) is not treated any further before being mixed with an organometallic compound (C). Further it is preferred that the liquid clathrate (LC) is a solution according to the definition of this invention. By "not treated" is meant that no such actions are carried, which might change either the physical or chemical composition of the liquid clathrate (LC) of step (i). However, e.g. washing or storing, where no such changes happen is possible between the steps (i) and (ii), if needed.

**[0046]** According to the invention step (ii) is followed by step (iii). In other words, in step (ii) a liquid mixture (MI) is produced and said liquid mixture (MI) is then in step (iii) precipitated. Accordingly the requirement that step (iii) must subsequently follow step (ii) may allow the storage of the liquid mixture (MI), but does not encompass embodiments in which the liquid mixture (MI) is further treated in a way that any physical or chemical changes occur in the liquid mixture (MI). Further it is preferred that the liquid mixture (MI) itself is homogenous, i.e. is a solution according to the definition of the invention.

**[0047]** The term "mixture" throughout the present application indicates that two or more substances are present.

**[0048]** The term "solution" throughout the present application indicates that two or more substances are homogeneously mixed, e.g. is not a two phase system.

**[0049]** An "emulsion" according to this invention is a mixture of two liquid substances. One substance, the dispersed phase, is dispersed in the other substance, the continuous phase, as droplets.

**[0050]** The term "liquid" according to this invention indicates that a compound (including a liquid) is liquid by normal pressure (1 atm) at room temperature, e.g. 20 to 30 °C.

**[0051]** A "liquid clathrate" is according to this invention a liquid which comprises, preferably consists of, a lattice (L), i.e. the reaction product of aluminosilane (A) the organo-silicon compound (OS) and a guest (G) enclosed therein. Liquid clathrates are as such well known and for instance described by Atwood, Jerry L. Dep. Chem., Univ. Alabama, Tuscaloosa, AL, USA. Editor(s): Robinson, Gregory Heagward.; Coord. Chem. Alum. (1993), p.197-32. Publisher: VCH, New York, N. Y CODEN: 59ECAI Conference; General Review written in English. CAN 119:117290; John D. Holbrey, "Liquid clathrate formation in ionic liquid-aromatic mixtures", Chem. Commun., 2003, pages 476 to 477, and Scott K. Spear, Encyclopedia of Supramolecular Chemistry, 2001, pages 804 to 807. Accordingly the "liquid clathrate (LC)" is preferably a liquid in which the lattice (L) constitutes the superstructure wherein the guest (G) is embedded. Preferably the guest (G) stabilizes said superstructure. The guest (G) according to this invention is the aromatic compound (AC).

**[0052]** A benefit of the solid catalyst system (CS) of the present invention over the metallocene/MAO based catalysts of prior art is the low solubility in solvents, including solvents used in polymerisation. The liquid clathrate (LC) is more stable than traditional catalyst/co-catalyst structures and thus is less soluble in common media for olefin polymerisation.

**[0053]** Thus one essential aspect of the invention is that the solid catalyst system (CS) is obtained by the use of a liquid clathrate (LC).

**[0054]** The liquid clathrate (LC) of the present invention comprises

(a) a lattice (L) being the reaction product of

(a1) aluminosilane (A) and

(a2) an organo-silicon compound (OS) being effective to form with the aluminosilane (A) the lattice (L).

**[0055]** The lattice (L) is formed in presence of an aromatic compound (AC).

**[0056]** In the following the individual reactants are defined in more detail.

**[0057]** As stated above for the formation of the lattice (L) of the liquid clathrate (LC) an organo-silicon compound (OS) is necessary which reacts with the aluminosilane (A). The lattice is formed by reacting an organo-silicon compound (OS) with aluminosilane (A) in presence of an aromatic compound (AC). It is preferred that the organo-silicon compound (OS) doesn't comprise halogens, in particular doesn't comprise fluorine.

**[0058]** The preferred organo-silicon compound (OS) which is effective to form the lattice (L) with the aluminosilane (A) can be selected from the group of hydrocarbyloxysilanes of the formula  $R_3Si-O[-SiR_2-O]_n-SiR_3$  or  $Si-[O-R]_4$  wherein each R is, independently, a hydrocarbyl group having up to 20 carbon atoms (e.g. linear or branched alkyl, cycloalkyl, aryl, aralkyl, alkylaryl) and n is 0 to 3; and hydrocarbylpolysiloxanes having from 2 to 8 silicon atoms in the molecule and which are separated from each other by an oxygen atom such that there is a linear, branched or cyclic backbone of alternating Si and oxygen atoms, with the remainder of the four valence bonds of each of the silicon atoms individually satisfied by a univalent hydrocarbyl group, R, as just defined. Preferably the hydrocarbyl groups, R, are methyl, ethyl and phenyl. Examples of such organo-silicon compounds (OS) include tetramethoxysilane, tetraethoxysilane, tetraphenoxysilane, methoxytrimethylsilane, ethoxytrimethylsilane, hexamethyldisiloxane, hexaethyldisiloxane, hexaphenyldisiloxane, tetramethyldiphenyldisiloxane, dimethyltetraphenyldisiloxane, hexamethylcyclotrisiloxane, octamethylcyclotetrasiloxane, octaphenylcyclotetrasiloxane, octamethyltrisiloxane, decamethyltetrasiloxane, dodecamethylpentasiloxane and tetradecamethylhexasiloxane, 1,3,3,5-tetramethyl-1,1,5,5-tetraphenyldisiloxane, 1,1,1,5,5,5-hexamethyl-3,3-diphenyltrisiloxane, and 1,1,1,3,5,5,5-heptamethyl-3-phenyltrisiloxane.

**[0059]** Preferably the organo-silicon compound (OS) is selected from the group consisting of octamethyltrisiloxane, decamethyltetrasiloxane, octamethylcyclotetrasiloxane, methoxytrimethylsilane, tetraethoxysilane and 1,1,1,3,5,5,5-heptamethyl-3-phenyltrisiloxane. Preferably the organo-silicon compound (OS) is octamethyltrisiloxane.

**[0060]** The aluminosilane (A) can be any conventional aluminosilane as is known in the art.

**[0061]** Aluminosilanes are commercially available or can be prepared according to prior art literature for example by

the hydrolysis of aluminium alkyls either by direct water addition or by treatment with salt hydrates. There are a variety of methods for preparing aluminosiloxane and modified aluminosiloxanes, examples of which are described in US 4,665,208, US 4,952,540, US 5,091,352, US 5,206,199, US 5,204,419, US 4,874,734, US 4,924,018, US 4,908,463, US 4,968,827, US 5,308,815, US 5,329,032, US 5,248,801, US 5,235,081, US 5,157,137, US 5,103,031, US 5,391,793, US 5,391,529, US 5,693,838, US 5,731,253, US 5,731,451, US 5,744,656, EP-A-0 561 476, EP-B1-0 279 586, EP-A-0 594-218, and WO 94/10180.

**[0062]** Aluminosiloxanes are also called aluminosiloxanes.

**[0063]** Preferably, C<sub>1</sub> to C<sub>10</sub>-alkylaluminosiloxanes, particularly methylaluminosiloxane or modified methylaluminosiloxane, isobutylaluminosiloxane, e.g. TIBAO (tetraisobutylaluminosiloxane) or HIBAO (hexaisobutylaluminosiloxane) are used. More preferably the aluminosiloxane (A) is methylaluminosiloxane (MAO). MAO is commercially available as 5 to 40 wt% solution in toluene.

**[0064]** A rapid catalytic activity depletion of the catalyst systems obtained by the precipitation technology could be observed at high concentrations of organo-silicon compounds (OS). The reason for this depletion, without being bound by theory, is the activity decreasing effect of the organo-silicon compounds (OS) due to its Lewis-acidity. It has now surprisingly been found that catalyst systems with high catalytic activity can be obtained in an efficient manner when the liquid clathrate (LC) is prepared from a composition comprising a specific ratio of aluminum (Al) from the aluminosiloxane (A) and the organo-silicon compounds (OS).

**[0065]** Preferably the mol ratio between the organo-silicon compound (OS) and aluminum (Al) of the aluminosiloxane (A) [(OS)/(Al)] is equal or below 0.1, preferably in the range of 0.02 to 0.08, more preferably 0.02 to 0.07, most preferably 0.03 to 0.06, like 0.03 to 0.05. The mol-ratio is determined from the compounds provided in step (i) and relates to the starting concentrations as provided in step (i) of the process described.

**[0066]** The aromatic compound (AC) can be any aromatic compound suitable as host for the reaction of the organo-silicon compound (OS) with aluminosiloxane (A) from which the lattice (L) of the liquid clathrate (LC) is formed. The aromatic compound (AC) is preferably a liquid. Accordingly it is appreciated that the aromatic compound (AC) is an aromatic hydrocarbon solvent, such as for example toluene, benzene, xylenes, ethylbenzene, cumene, mesitylene or cymene. More preferably the aromatic compound (AC) is toluene. - The liquid clathrate (LC) is obtainable by, preferably obtained by,

(I) providing a mixture of an organo-silicon compound (OS), aluminosiloxane (A) and an aromatic compound (AC)

(II) obtaining a two phase system comprising an aromatic compound (AC) rich phase, and a liquid clathrate (LC) rich phase,

(III) separating the aromatic compound (AC) rich phase from the liquid clathrate (LC) rich phase.

**[0067]** It is preferred that the process from which the liquid clathrate (LC) is obtainable comprises formation of two stable immiscible organic layers, which remain intact such that the aromatic compound (AC) rich phase can be separated from the liquid clathrate (LC) rich phase.

**[0068]** The reaction is performed preferably under stirring and under inert atmosphere of for example N<sub>2</sub> or Argon at temperatures between -20 to 70 °C, preferably between -10 to 60 °C, more preferably between 0 to 50 °C, even more preferably between 10 to 40 °C, for example 20 to 30 °C. A person skilled in the art can easily determine experimentally a suitable temperature for any of the organo-silicon compound (OS).

**[0069]** Preferably aluminosiloxane (A) in an aromatic compound (AC) is added to the organo silicon compound (OS). However, it is appreciated that also the organo silicon compound (OS) could be added to aluminosiloxane (A) in an aromatic compound (AC). Furthermore, it is appreciated that also the organo silicon compound (OS) could be provided as a solution in an aromatic compound (AC), in this case aluminosiloxane doesn't necessarily have to be provided in an aromatic compound (AC).

**[0070]** In an embodiment the aromatic compound (AC) rich phase constitutes the upper layer and the lower layer constitutes the liquid clathrate (LC) rich phase.

**[0071]** The upper phase is discarded and the lower liquid clathrate (LC) rich phase, i.e. the liquid clathrate (LC) solution, is optionally washed before further use. The liquid clathrate (LC) phase, i.e. the liquid clathrate (LC), is preferably washed once or up to 5 times, preferably once to three times, with a (liquid) hydrocarbon compound, preferably with the aromatic compound (AC) used for its preparation, like toluene.

**[0072]** The starting concentration of aluminosiloxane (A) in the aromatic compound (AC), like toluene, usually ranges from 5 to 40 wt.-% solution.

**[0073]** Phase separation into the two phase system may occur immediately, i.e. by mixing organo-silicon compound (OS), aluminosiloxane (A) and the aromatic compound (AC), or may commence after a few hours, like 4 hours, or after one or more days, like after one to three days. Separation can be improved if the mixture is cooled down to -20°C, if needed. Most often the phase separation occurs immediately. E.g. by using 5 to 40 wt.-% methylaluminosiloxane (MAO) solution in toluene separation occurs immediately. However, phase separation time is dependent on the used aromatic compound (AC) and aluminosiloxane (A) concentrations therein as well type and amount of organo-silicon compound (OS).

**[0074]** Accordingly the reaction is characterized by the formation of a two phase system comprising two stable immis-

cible organic layers, which remain intact such that the upper layer, preferably the aromatic compound (AC) rich phase, can be separated from the lower phase, preferably the liquid clathrate (LC) layer, i.e. the liquid clathrate (LC).

**[0075]** For further processing the liquid clathrate (LC) phase, i.e. the liquid clathrate (LC) solution, is separated from the upper solvent layer by conventional separation techniques, for example by decantation, siphoning or draining.

**[0076]** Optionally the separated liquid clathrate (LC) phase can be washed before further use. Preferably the liquid clathrate phase (LC) is washed once or up to 5 times, preferably once to three times, with the aromatic compound (AC) used for its preparation.

**[0077]** The liquid clathrate (LC) as such is used in step (ii) and not for instance the liquid clathrate (LC) together with the upper phase formed during the preparation of the liquid clathrate (LC), i.e. the liquid clathrate (LC) solution.

**[0078]** In step (ii) the liquid clathrate (LC) is mixed with an organometallic compound (C) and a liquid mixture (MI) is obtained, from which the solid catalyst system (CS) can be precipitated (in step (iii)). Preferably the liquid mixture (MI) obtained is a solution. Solution, as defined earlier in this application, indicates that two or more substances are homogeneously mixed, e.g. it is not a two phase system.

**[0079]** The liquid clathrate (LC) is preferably reacted under stirring, with the organometallic compound (C), under inert atmosphere of for example N<sub>2</sub> or Argon at temperatures between -20 to 70 °C, preferably between -10 to 60 °C, more preferably between 0 to 50 °C, even more preferably between 10 to 40 °C, for example 20 to 30 °C, to obtain the liquid mixture (MI) being a solution. A person skilled in the art can easily determine experimentally a suitable temperature for any liquid clathrate (LC) and the organometallic compound (C).

**[0080]** According to the present invention it has been found that not only the mol-ratio of aluminum (Al) from the aluminosilicate (A) to the organo-silicon compounds (OS) has a strong influence on the catalytic activity of the catalyst system (CS) obtainable, but also the mol-ratio between aluminum (Al) of the aluminosilicate (A) and transition metal (M) of the organometallic compound (C). Accordingly it is preferred that the mol-ratio between aluminum (Al) of the aluminosilicate (A) and transition metal (M) of the organometallic compound (C)  $[(Al)/(M)]$  is  $\leq 600$ , more preferred  $\leq 500$ , like below 450. Furthermore, it is preferred that the mol-ratio between aluminum (Al) of the aluminosilicate (A) and transition metal (M) of the organometallic compound (C)  $[(Al)/(M)]$  is  $\geq 50$ , more preferred  $\geq 100$ , even more preferred  $\geq 150$ . In other words it is preferred that the mol-ratio between aluminum (Al) of the aluminosilicate (A) and transition metal (M) of the organometallic compound (C)  $[(Al)/(M)]$  is in a range from 50 to 600, preferably in a range from 100 to 500, like 150 to 450.

**[0081]** The mol-ratio is determined from the compounds provided in steps (i) and (ii) and relates to the starting concentrations as provided in steps (i) and (ii) of the process described.

**[0082]** Furthermore, it is preferred that essentially on the same level mol-ratio determined from the compounds provided in step (ii) is also present in the catalyst system (CS) obtained from the inventive process.

**[0083]** As is commonly known the catalytic activity of the catalyst system (CS) is normally higher with lower mol-ratio between aluminum (Al) of the aluminosilicate (A) and transition metal (M) of the organometallic compound (C)  $[(Al)/(M)]$ .

**[0084]** In the present invention it has been found that clathrating agent has a clear impact on catalyst activity.

**[0085]** Still in a more preferred embodiment the organometallic compound (C) used in the invention is of formula (II)



wherein

"M" is zirconium (Zr) or hafnium (Hf),

each "X" is independently selected from halogen, C<sub>1</sub> to C<sub>6</sub> alkyl, C<sub>5</sub> to C<sub>6</sub> cycloalkyl, C<sub>1</sub> to C<sub>6</sub> alkoxy, phenyl and benzyl groups,

each "L" is independently a cyclopentadienyl, indenyl, tetrahydroindenyl, fluorenyl, which can be independently substituted or unsubstituted, preferably at least one organic ligand (L), preferably both organic ligands (L), comprise one or more substituents independently selected from C<sub>1</sub> to C<sub>20</sub> hydrocarbyl or silyl groups, which optionally contain one or more heteroatoms selected from groups 14 to 16 (IUPAC 2007) and/or are optionally substituted by halogen atom(s),

"R" is a divalent bridge selected from -R'<sub>2</sub>C-, -R'<sub>2</sub>Si-, wherein each R' is independently a hydrogen atom, C<sub>1</sub> to C<sub>20</sub> alkyl, C<sub>2</sub> to C<sub>10</sub> cycloalkyl, C<sub>6</sub> to C<sub>20</sub> aryl, C<sub>7</sub> to C<sub>20</sub> arylalkyl or C<sub>7</sub> to C<sub>20</sub> alkylaryl.

**[0086]** In the step (iii) the solid catalyst system (CS) is precipitated by adding a saturated aliphatic compound to the liquid mixture (MI) obtained from step (ii).

**[0087]** The precipitation is performed preferably under stirring and under inert atmosphere of for example N<sub>2</sub> or Argon at temperatures between 10 and 40 °C, preferably between 15 and 35 °C and more preferably between 20 and 30 °C.

**[0088]** Although the use of ambient temperatures is most convenient, i.e. from 10 to 30 °C, some compounds require elevated or lower temperatures. A person skilled in the art can easily determine experimentally a suitable temperature

depending on the type of aromatic compound used in the process.

**[0089]** The solid catalyst system (CS) is obtainable in a convenient and sustainable manner. The liquid mixture (MI), e.g. the liquid mixture (MI) being a solution, enables a person skilled in the art to accomplish precipitation with solvents in step (iii), which are convenient with respect to economic and ecologic considerations. Such solvents include saturated aliphatic compounds.

**[0090]** Accordingly in the instant process precipitation in step (iii) is accomplished by removing the aromatic compound (AC) from the liquid mixture of liquid clathrate (LC) and organometallic compound. The removal can be effected by different techniques.

**[0091]** According to the invention the precipitation in step (iii) is accomplished by adding a saturated aliphatic compound to the liquid mixture (MI) which causes a dilution effect for the aromatic compound (AC) leading to the precipitation of the catalyst system (CS).

**[0092]** It is a finding of the present invention that saturated aliphatic compounds can be employed in the process described for precipitating the catalyst system (CS) from the liquid mixture (MI). Preferably the aliphatic compound is selected from the group consisting of C<sub>1</sub> to C<sub>20</sub> alkanes, C<sub>4</sub> to C<sub>12</sub> cycloalkanes and combinations thereof, preferably C<sub>3</sub> to C<sub>12</sub> alkanes, like C<sub>5</sub> to C<sub>10</sub> alkanes. More preferably the aliphatic compound is selected from the group consisting of n-pentane, n-hexane, n-heptane, n-octane, and mixtures thereof. Even more preferably the aliphatic compound is n-pentane.

**[0093]** In a preferred embodiment the aromatic compound (AC) is toluene and/or the saturated aliphatic compound is selected from the group consisting of n-pentane, n-hexane, n-heptane, n-octane, and mixtures thereof. It is particularly preferred that the aromatic compound (AC) is toluene and the saturated aliphatic compound is n-pentane.

**[0094]** Further the saturated aliphatic compound, preferably n-pentane, is also inert in relation to the compounds of the solid catalyst system to be produced. The term "inert in relation to the compounds" means herein that the aliphatic compound, preferably the n-pentane, is chemically inert, i.e. undergoes no chemical reaction with the solid catalyst system (CS) and the compounds provided besides the aromatic compound (AC) for preparing the catalyst system (CS), i.e. the organo-silicon compound (OS) and the aluminosilane (A).

**[0095]** The addition of the saturated aliphatic compound to the liquid mixture (MI) can be accomplished as known in the art, for instance by pouring the saturated aliphatic compound into the liquid mixture (MI). Typically after addition the obtained mixture is agitated (stirred) to facilitate the formation of the solid catalyst system (CS) particles. No specific temperature is needed. Precipitation can be accomplished in a broad temperature range, like 2 to 80 °C. Optimal temperature is dependent on the individual components employed. The optimal precipitating temperature can vary e.g. from below 10 to above 50 °C. Very good results are achievable at temperatures between 10 and 40 °C, or between 15 and 35 °C, like 20 to 30 °C.

**[0096]** Alternatively the liquid mixture (MI) is introduced very fast into the saturated aliphatic compound, like spray-technology. This way of forming the solid catalyst system (CS) particles has the advantage that very spherical particles are obtained compared to simple pouring technique.

**[0097]** Optionally the process of the present invention comprises a fourth step (step (iv)), which is recovering the particles of the solid catalyst system (CS). In other words particles of the solid catalyst system (CS) which is obtained by the precipitation step (iii) may be separated and recovered by any procedure known in the art. For example, the solid catalyst particles in the suspension may be filtered. Other commonly known methods for isolating are decanting, centrifuging and flotation. The particles of solid catalyst system (CS) may then be optionally washed and/or dried to remove any solvent residuals present in the particles. The washing and/or drying of the catalyst particles may be carried out in any manner conventional in the art.

**[0098]** Furthermore, each of the steps, i.e. steps (i) to (iv), is preferably accomplished at a temperature in the range of 10 to 30 °C, preferably in the range of 20 to 30 °C.

**[0099]** The instant process leads to a solid catalyst system (CS), in particular to solid catalyst system (CS) without any need of using external support material. In other words a process is described wherein the solid catalyst system (CS) is unsupported, i.e. during the process no carrier material is added.

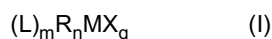
**[0100]** From the process described a solid catalyst system (CS) can be obtained.

**[0101]** In other words the present invention is also directed at a solid catalyst system (CS) as described in the process of the invention.

**[0102]** In a preferred embodiment the invention is also directed at a solid catalyst system (CS) comprising the reaction product of

(a) a liquid clathrate (LC) obtained by mixing an aluminosilane (A), an aromatic compound (AC) and an organo-silicon compound (OS), wherein the mol-ratio between the organo-silicon compound (OS) and aluminum (Al) of the aluminosilane (A) [(OS)/(Al)] is below 0.1 and

(b) an organometallic compound (C), said organometallic compound (C) is of formula (I)



wherein

"M" is a transition metal (M) of Group 3 to 10 of the Periodic Table (IUPAC 2007),  
 each "X" is independently a monoanionic ligand, such as  $\sigma$ -ligand,  
 each "L" is independently an organic ligand which coordinates to the transition metal (M),  
 "R" is a bridging group linking said organic ligands (L),  
 "m" is 1 or 2 or 3, preferably 2,  
 "n" is 0, 1 or 2, preferably 1,  
 "q" is 1, 2 or 3, preferably 2,  
 m+q is equal to the valency of the transition metal (M).

**[0103]** In a more preferred embodiment the invention is also directed at a solid catalyst system (CS) comprising the reaction product of

(a) a liquid clathrate (LC) obtained by mixing an aluminoxane (A), an aromatic compound (AC) and an organo-silicon compound (OS), wherein the mol-ratio between the organo-silicon compound (OS) and aluminum (Al) of the aluminoxane (A) [(OS)/(Al)] is below 0.08 and  
 (b) an organometallic compound (C) of formula (II)



wherein

"M" is zirconium (Zr) or hafnium (Hf),  
 each "X" is independently selected from halogen,  $C_1$  to  $C_6$  alkyl,  $C_5$  to  $C_6$  cycloalkyl,  $C_1$  to  $C_6$  alkoxy, phenyl and benzyl groups,  
 each "L" is independently a cyclopentadienyl, indenyl, tetrahydroindenyl, fluorenyl, which can be independently substituted or unsubstituted, preferably at least one organic ligand (L), preferably both organic ligands (L), comprise one or more substituents independently selected from  $C_1$  to  $C_{20}$  hydrocarbyl or silyl groups, which optionally contain one or more heteroatoms selected from groups 14 to 16 and/or are optionally substituted by halogen atom(s),  
 "R" is a divalent bridge selected from  $-R'_2C-$ ,  $-R'_2Si-$ , wherein each R' is independently a hydrogen atom,  $C_1$  to  $C_{20}$  alkyl,  $C_2$  to  $C_{10}$  cycloalkyl.

**[0104]** All preferred embodiments of reactants as disclosed above are valid to the preparation of catalyst system as well to catalyst system as such.

**[0105]** Furthermore, a solid catalyst system (CS) is preferred, wherein said solid catalyst system (CS) is obtained by mixing said liquid clathrate (LC) with the organometallic compound (C) obtaining a liquid mixture (MI), wherein further the solid catalyst system (CS) is precipitated from said liquid mixture (MI) by adding a saturated aliphatic compound to said liquid mixture (MI).

**[0106]** In an embodiment a solid catalyst system (CS) is preferred, wherein mol-ratio between the aluminum (Al) of the aluminoxane (A) and the transition metal (M) of the organometallic compound (C) [(Al)/(M)] is  $\leq 600$ , more preferred  $\leq 500$ , even more preferred  $\leq 450$ . Furthermore, it is preferred that the mol-ratio between aluminum (Al) of the aluminoxane (A) and transition metal (M) of the organometallic compound (C) [(Al)/(M)] is  $\geq 50$ , more preferred  $\geq 100$ , even more preferred  $\geq 150$ . In other words it is preferred that the mol-ratio between aluminum (Al) of the aluminoxane (A) and transition metal (M) of the organometallic compound (C) [(Al)/(M)] is in a range from 50 to 600, preferably in a range from 100 to 600, like 120 to 500.

**[0107]** The present invention is also directed at a solid catalyst system (CS) prepared according to above process, wherein the organo-silicon compound (OS) is preferably selected from the group consisting of octamethyltrisiloxane, decamethyltetrasiloxane, octamethylcyclotetrasiloxane, methoxytrimethylsilane, tetraethoxysilane, tetramethoxysilane, tetraphenoxysilane, ethoxytrimethylsilane, hexamethyldisiloxane, hexaethyldisiloxane, hexaphenyldisiloxane, tetramethyldiphenyldisiloxane, dimethyltetraphenyldisiloxane, hexamethylcyclotrisiloxane, octaphenylcyclotetrasiloxane, dodecamethylpentasiloxane and tetradecamethylhexasiloxane, 1,3,3,5-tetramethyl-1,1,5,5-tetraphenyltrisiloxane, 1,1,1,5,5,5-hexamethyl-3,3-diphenyltrisiloxane, 1,1,1,3,5,5,5-heptamethyl-3-phenyltrisiloxane; and/or the aromatic compound (AC) is toluene; and/or the saturated aliphatic compound is selected from the group consisting of n-pentane, n-hexane, n-

heptane, n-octane, and mixtures thereof.

**[0108]** Preferred is a solid catalyst system (CS), wherein the liquid mixture (MI) is homogeneous; and the solid catalyst system (CS) is unsupported, i.e. during the process no carrier material is added.

**[0109]** Thus, the present invention is also directed at the use of a solid catalyst system (CS) for the preparation of a polymer, like polyethylene and /or polypropylene.

**[0110]** Furthermore, the present invention is also directed at the preparation of a polymer, like a polypropylene or polyethylene, by polymerising monomer units, like propylene and/or ethylene in the presence of a solid catalyst system (CS) as defined above.

**[0111]** Finally, the present invention is also directed at the preparation of a polymer, like a polypropylene, comprising the steps of preparing a solid catalyst system (CS) according to the process described, using said solid catalyst system (CS) in a polymerisation process, thereby obtaining the polymer, like the polypropylene.

**[0112]** Polymerisation of olefins, like propylene and ethylene optionally with other comonomers, like C<sub>2</sub> to C<sub>8</sub>, e.g. ethylene, butylenes or hexene, can be carried out in one or more polymerisation steps comprising solution, slurry/liquid and gas phase polymerisation or any combination thereof. Polymerisation configuration can comprise one or more polymerisation reactors or combination of reactors.

## FIGURES

**[0113]**

**Fig. 1:** Catalyst activity of Polymerisation examples 2, 4 and 5 (Catalyst Examples 2, 5 and 6, resp.) obtained by precipitation with pentane as a function of  $[(Al)/(Zr)]$  compared to catalyst activity of Comparative Example 1 obtained by precipitation in silicon oil as a function of mol ratio  $[(Al)/(Zr)]$ .

**Fig. 2:** Catalyst activity of Polymerisation examples P3, P2 and P1 (Catalyst Examples 4, 2 and 1, resp) obtained by precipitation with pentane as a function of mol ratio  $[(OS)/(Al)]$ .

## EXAMPLES

The following definitions of terms and determination methods apply for the above general description of the invention as well as to the below examples, unless otherwise defined.

### 1. Measuring Methods:

**[0115]** **MFR<sub>2</sub> (230 °C)** is measured according to ISO 1133 (230 °C, 2.16 kg load) for polypropylene.

**[0116]** **MFR<sub>2</sub> (190 °C)** is measured according to ISO 1133 (190 °C, 2.16 kg load) for polyethylene.

### ICP analysis

The elemental analysis of a catalyst was performed by taking a solid sample of mass, M, cooling over dry ice. Samples were diluted up to a known volume, V, by dissolving in nitric acid (HNO<sub>3</sub>, 65 %, 5 % of V) and freshly deionised (DI) water (5 % of V). The solution was then diluted with DI water up to the final volume, V, and left to stabilise for two hours.

The analysis was run at room temperature using a Thermo Elemental iCAP 6300 Inductively Coupled Plasma - Optical Emission Spectrometer (ICP-OES) which was calibrated using a blank (a solution of 5 % HNO<sub>3</sub>, 3 % HF in DI water), and 6 standards of 0.5 ppm, 1 ppm, 10 ppm, 50 ppm, 100 ppm and 300 ppm of Al, with 0.5 ppm, 1 ppm, 5 ppm, 20 ppm, 50 ppm and 100 ppm of Hf and Zr in solutions of 5 % HNO<sub>3</sub>, 3 % HF in DI water.

Immediately before analysis the calibration is 'resloped' using the blank and 100 ppm Al, 50 ppm Hf, Zr standard, a quality control sample (20 ppm Al, 5 ppm Hf, Zr in a solution of 5 % HNO<sub>3</sub>, 3 % HF in DI water) is run to confirm the reslope. The QC sample is also run after every 5<sup>th</sup> sample and at the end of a scheduled analysis set.

The content of hafnium was monitored using the 282.022 nm and 339.980 nm lines and the content for zirconium using 339.198 nm line. The content of aluminium was monitored via the 167.079 nm line, when Al concentration in ICP sample was between 0-10 ppm (calibrated only to 100 ppm) and via the 396.152 nm line for Al concentrations above 10 ppm.

The reported values are an average of three successive aliquots taken from the same sample and are related back to the original catalyst by inputting the original mass of sample and the dilution volume into the software.

**Molecular weight averages, molecular weight distribution (Mn, Mw, Mz, MWD)**

**[0122]** Molecular weight averages (Mz, Mw and Mn), Molecular weight distribution (MWD) and its broadness, described by polydispersity index, PDI= Mw/Mn (wherein Mn is the number average molecular weight and Mw is the weight average molecular weight) were determined by Gel Permeation Chromatography (GPC) according to ISO 16014-1:2003, ISO 16014-2:2003, ISO 16014-4:2003 and ASTM D 6474-12 using the following formulas:

$$M_n = \frac{\sum_{i=1}^N A_i}{\sum_{i=1}^N (A_i/M_i)} \quad (1)$$

$$M_w = \frac{\sum_{i=1}^N (A_i \times M_i)}{\sum_{i=1}^N A_i} \quad (2)$$

$$M_z = \frac{\sum_{i=1}^N (A_i \times M_i^2)}{\sum_{i=1}^N (A_i/M_i)} \quad (3)$$

**[0123]** For a constant elution volume interval  $\Delta V_i$ , where  $A_i$  and  $M_i$  are the chromatographic peak slice area and polyolefin molecular weight (MW), respectively associated with the elution volume,  $V_i$ , where N is equal to the number of data points obtained from the chromatogram between the integration limits.

**[0124]** A high temperature GPC instrument, equipped with either infrared (IR) detector (IR4 or IR5 from PolymerChar (Valencia, Spain) or differential refractometer (RI) from Agilent Technologies, equipped with 3 x Agilent-PLgel Olexis and 1x Agilent-PLgel Olexis Guard columns was used. As the solvent and mobile phase 1,2,4-trichlorobenzene (TCB) stabilized with 250 mg/L 2,6-Di tert butyl-4-methyl-phenol) was used. The chromatographic system was operated at 160 °C and at a constant flow rate of 1 mL/min. 200 µL of sample solution was injected per analysis. Data collection was performed using either Agilent Cirrus software version 3.3 or PolymerChar GPC-IR control software.

**[0125]** The column set was calibrated using universal calibration (according to ISO 16014-2:2003) with 19 narrow MWD polystyrene (PS) standards in the range of 0.5 kg/mol to 11 500 kg/mol. The PS standards were dissolved at room temperature over several hours. The conversion of the polystyrene peak molecular weight to polyolefin molecular weights is accomplished by using the Mark Houwink equation and the following Mark Houwink constants:

$$\begin{aligned} K_{PS} &= 19 \times 10^{-3} \text{ mL/g}, & p_{PS} &= 0.655 \\ K_{PE} &= 39 \times 10^{-3} \text{ mL/g}, & p_{PE} &= 0.725 \\ K_{PP} &= 19 \times 10^{-3} \text{ mL/g}, & p_{PP} &= 0.725 \end{aligned}$$

**[0126]** A third order polynomial fit was used to fit the calibration data.

**[0127]** All samples were prepared in the concentration range of 0.5 to 1.0 mg/ml and dissolved at 160 °C for 2.5 hours for polypropylene or 3 hours for polyethylene under continuous gentle shaking.

**Catalyst productivity**

**[0128]** The catalyst productivity is defined as the amount of polymer in kilograms obtained per gram solid catalytic component used (kg polymer / g catalyst).

**Catalyst activity**

**[0129]** The catalyst activity is defined as the amount of polymer in kilograms obtained per gram solid catalytic component and polymerisation time (kg polymer/g catalyst x time)

**2. Chemicals:****Methylaluminoxane (MAO)**

[0130] MAO was purchased from Chemtura as 30 wt-% solution in toluene.

[0131] **Octamethyltrisiloxane (OMTS)** was purchased from Aldrich (Octamethyltrisiloxane Mw 236,53 g/mol, CAS 107-51-7) and distilled from  $\text{CaH}_2$ .

[0132] **1,3,3,5-tetramethyl-1,1,5,5-tetraphenyltrisiloxane (OS2)**, CAS 3982-82-9

**Triisobutylaluminium (TIBA)**

[0133] TIBA was purchased from Crompton (TIBA, CAS 100-99-2).

**Triethylaluminium (TEA)**

[0134] TEA was purchased from Crompton. (TEA CAS 97-93-8)

**Hydrogen**

[0135] Hydrogen was purchased from AGA and purified according to standard methods before use.

**Ethylene, propylene and hexene**

[0136] Ethylene, propylene and hexene were provided from Borealis in polymerisation grade and purified according to standard methods.

**Pentane**

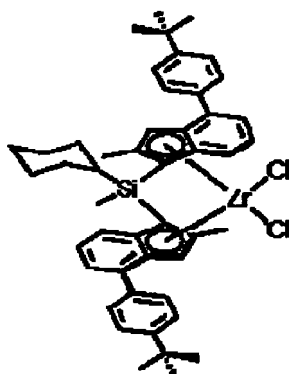
[0137] Pentane was degassed by sparging argon for 30 min and stored over molecular sieves.

**Toluene**

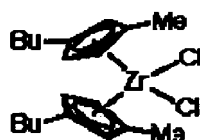
[0138] Toluene was purified according to the standard purification method.

**Metallocene A**

[0139] *rac*-methyl(cyclohexyl)silanediy-*bis*[(2-methyl-4-(4-*tert*-butylphenyl)indenyl)]zirconium dichloride (CAS no 888227-55-2, WO2006/060544) purchased from commercial source,

**Metallocene B**

[0140] Dichloro-*bis*[(1-butyl-3-methyl)cyclopentadienyl]zirconium, CAS no 151840-68-5



### 3. Preparation-of the catalyst system (CS)

#### Example 1

[0141] All chemicals were handled and the steps were performed under inert gas atmosphere ( $N_2$  or Ar gas)

#### Preparation of liquid clathrate

[0142] 10.3 mmol MAO (30 wt % in toluene) was added to 1.03 mmol OMTS (mol-ratio between OMTS and aluminum (Al) of the aluminoxane (A)  $[OMTS/(Al)] = 0.1$ ). The solution was stirred for 12 h at room temperature (20 to 25 °C). Stirring was stopped and separation of the solution into two phases was clearly seen. The upper phase (toluene) was removed and the lower phase (clathrate). The lower phase (clathrate) was washed twice by adding 1 mL toluene for each washing step and lower phase was isolated.

#### Preparation of the mixture liquid (MI)

[0143] 0.041 mmol of Metallocene A was added to the clathrate phase obtained from the preparation of the liquid clathrate. A solution with a mol-ratio between aluminum (Al) of the aluminoxane (A) and zirconium (Zr) of the Metallocene A of  $[(Al)/(M)] = 250$  was obtained. The solution was stirred for 2 h at room temperature (20 to 25 °C).

#### Precipitation of the catalyst system

[0144] Subsequently 4.0 mL pentane was added and the solution was stirred for 12 h at room temperature (20 to 25 °C). A solid precipitate was formed and the liquid was decanted. The residue of the liquid was removed with a pipette. The solid precipitate was washed twice by adding 3 mL pentane for each washing step and washing liquids were discarded. The solid was dried in vacuum at 0.03 mbar for 30 to 40 minutes. The solid was sieved through a 50  $\mu$ m sieve to yield 400 mg of the catalyst as a pink powder.

#### Example 2

[0145] Example 2 was prepared as described in Example 1 but instead of 1.03 mmol OMTS only 0.515 mmol OMTS (mol-ratio between OMTS and aluminum (Al) of the aluminoxane (A)  $[OMTS/(Al)] = 0.05$ ) was added. 390 mg of product were collected in the form of pink powder. ICP analysis showed 37.9 wt.-% Al and 0.61 wt.-% Zr content.

#### Example 3

[0146] Example 3 was prepared as described in Example 2 but instead of Metallocene A Metallocene B was added. 370 mg of product were collected in the form of yellowish powder. ICP analysis showed 35.1 wt.-% Al and 0.75 wt.-% Zr content.

#### Example 4

[0147] Example 4 was prepared as described in Example 1 but instead of 1.03 mmol OMTS only 0.206 mmol OMTS (mol-ratio between OMTS and aluminum (Al) of the aluminoxane (A)  $[OMTS/(Al)] = 0.02$ ) was added. 390 mg of product were collected in the form of pink powder. ICP analysis showed 36.3 wt.-% Al and 0.91 wt.-% Zr.

#### Example 5

[0148] Example 5 was prepared as described in Example 2 but the amount of metallocene was 0.0205 mmol, thus the mol-ratio between aluminum (Al) of the aluminoxane (A) and zirconium (Zr) of the Metallocene A was increased from  $[(Al)/(M)] = 250$  to  $[(Al)/(M)] = 500$  in the feed. 370 mg of product were collected in the form of pink powder. ICP analysis showed 31.9 wt.-% Al and 0.32 wt.-% Zr content.

**Example 6**

[0149] Example 6 was prepared as described in Example 2 but the amount of metallocene was only 0,0137 mmol, thus the mol-ratio between aluminum (Al) of the aluminosilane (A) and zirconium (Zr) of the Metallocene A was increased from  $[(Al)/(M)] = 250$  to  $[(Al)/(M)] = 750$  in the feed. 280 mg of product were collected in the form of pink powder. ICP analysis showed 37.2 wt.-% Al and 0.21 wt.-% Zr content

**Example 7**

[0150] Example 7 was prepared as described in Example 2 but instead of using OMTS (0.515 mmol) 0.515 mmol of 1,3,3,5-tetramethyl-1,1,5,5,-tetraphenyltrisiloxane (OS2) was used. In other words, an alternative organosilicon compound was used. 250 mg of product were collected in the form of pink powder. ICP analysis showed 35.4 wt.-% Al and 1.11 wt.-% Zr content.

**Comparative Example 1**

[0151] Comparative Example 1 is an catalyst system comprising Metallocene A, a mol-ratio between aluminum (Al) of the aluminosilane (A) and zirconium (Zr) of the Metallocene A of  $[(Al)/(M)] = 500$  and a mol-ratio between OMTS and aluminum (Al) of the aluminosilane (A)  $[OMTS/(Al)] = 0.05$ , which was prepared by the silicon oil route by the precipitation method according to the principles and examples 1 to 2 as described in EP 2 386 582.

**Comparative Example 2**

[0152] Catalyst was prepared by adding metallocene B to MAO in a mol-ratio between aluminum (Al) of the aluminosilane (A) and zirconium (Zr)  $[(Al)/(M)] = 250$  without using any chelating agent. Catalyst solution was precipitated with pentane according to the example 3. Due to high solubility of MAO-metallocene catalyst, only a trace amount of solid product were obtained, only 30 mg of the catalyst were isolated compared to the yield of 370 mg in example 3 run on the same scale. Thus, it was clear that catalyst preparation using precipitation method without any chelating agent does by no means make any sense.

**Comparative Example 3**

[0153] Catalyst was prepared according to the example 2 except for the fact that the upper layer has not been removed upon the formation of the liquid clathrate mixture, and metallocene A was added to a heterogeneous liquid-liquid mixture. After stirring for 12 hours, pentane was added and the work-up was carried out as in the Example 2. The catalyst was isolated in the form of pink powder (0.4 g). ICP analysis showed 37.4 wt.-% Al and 0.44 wt.-% Zr content.

**4. Preparation of polymers from the catalyst systems (CS)****Polypropylene**

[0154] A 5 liter stainless steel reactor was used for propylene polymerisations. 1100 g of liquid propylene (Borealis polymerisation grade) was fed to the reactor. 0.2 ml triethylaluminum was fed as a scavenger and 15 mmol hydrogen as chain transfer agent. Reactor temperature was set to 20 °C. Desired amount of catalyst (20 to 28 mg) was flushed into to the reactor in 5 ml PFC with nitrogen overpressure. After 5 minutes the reactor was heated to 70 °C in a period of about 15 minutes. The polymerisation is stopped after 60 minutes by venting the reactor and flushing with nitrogen before the polymer is collected.

[0155] The catalyst activity was calculated on the basis of the 60 minutes period according to the following formula:

$$\text{Catalyst Activity (kg/(g(cat)*h))} = \frac{\text{amount of polymer produced (kg)}}{\text{catalyst loading (g)} \times \text{polymerisation time (h)}}$$

**Polyethylene**

[0156] Polymerisation experiments were carried out in PPR (Parallel Pressure Reactor) which are stirred reactors each reactor having a volume of 21 mL. Reactor was conditioned by purging it with dry nitrogen for 6 hours at 80 °C. Pre-weighed disposable glass vials and disposable flat stirring paddles were fitted into the reactor. Reactor was then

closed and thoroughly flushed with propylene prior the experiment. 5  $\mu$ mol of freshly made TIBA solution (200  $\mu$ L of 25 mM solution in heptane) was added through a valve to all 48 reactors. Reactors were pressurised to 278 kPa (40 psi) with ethylene to ensure that all the individual reactors were maintaining pressure. Stirring speed was the set up to 800 rpm for all reactors and the temperature increased to 80 °C. Once the temperature was stable the reactors were pressurised to 434 kPa (63 psi) with ethylene. The reactor temperatures were maintained at 80 °C by computer control during the experiment. Catalyst slurries were made by mixing catalysts with dodecane so that concentration of the resulting slurry was 12.25 mg/mL. Vortexing of 1200 rpm was applied to ensure formation of homogeneous slurry. Once the reactor temperature was stabilized catalysts were added into the reactors through a valve. Pressure in the reactors was maintained at 434 kPa (63 psi) during the experiment. Polymerisations were continued for 60 minutes after which the reaction was terminated by addition of CO<sub>2</sub> (20%/80% of CO<sub>2</sub>/N<sub>2</sub> was used to pressurize the reactors to 2.9 MPa). Once cooled, the reactor was degassed and flushed repeatedly with nitrogen.

[0157] The catalyst activity was calculated on the basis of the 60 minutes period according to the following formula: Catalyst Activity (kg/(g(cat) h)) amount of polymer produced (kg)/catalyst loading (g) polymerisation time (h)

[0158] The catalyst activity was calculated on the basis of the 60 minutes period according to the following formula: Catalyst Activity (kg/(g(cat) h)) amount of polymer produced (kg)/catalyst loading (g) polymerisation time (h)

$$\text{Catalyst Activity (kg/(g(cat)*h))} = \frac{\text{amount of polymer produced (kg)}}{\text{catalyst loading (g)} \times \text{polymerisation time (h)}}$$

#### Polyethylene 1-Hexene Copolymer

[0159] The polymerisation was carried out in an autoclave reactor (2L) purchased from Buchi, equipped with a paddle stirrer and a continuous ethylene supply.

[0160] The reactor was purged with N<sub>2</sub> and filled with propane (900 ml) and 150 g ethene (Borealis polymerisation grade) and 25 mL 1-hexene (Borealis polymerisation grade). 1.5 ml of TIBA was fed as a scavenger in 5 mL of dry and degassed pentane. The temperature was raised to 60 °C and then the desired amount of catalyst was flushed into the reactor with nitrogen overpressure. The temperature was subsequently raised to 80 °C. The polymerisation is stopped after 60 minutes by venting the reactor and flushing with nitrogen before the polymer was collected.

[0161] The catalyst activity was calculated on the basis of the 60 minutes period according to the following formula:

$$\text{Catalyst Activity (kg/(g(cat)*h))} = \frac{\text{amount of polymer produced (kg)}}{\text{catalyst loading (g)} \times \text{polymerisation time (h)}}$$

#### 5. Determining the catalytic activity of the catalyst system (CS)

[0162]

**Table 1:** Polymerisation results of polypropylene

PE	CE	MC	[OMTS/(Al)]	Catalytic activity	MFR <sub>2</sub>
			[-]	[kg PP/g cat*h]	[g/10min]
P1	Ex. 1	A	0.10	4.1	3.7
P2	Ex. 2	A	0.05	24.6	3.6
P3	Ex. 4	A	0.02	27.2	2.9
P4	Ex. 5	A	0.05	14.6	3.7
P5	Ex. 6	A	0.05	5.3	N/A
P6	Ex 7	A	0.05*	54.1	4.7
CP1	Comp. Ex. 1	A	0.05	0.1	N/A

(continued)

PE	CE	MC	[OMTS/(Al)]	Catalytic activity	MFR <sub>2</sub>
			[-]	[kg PP/g cat*h]	[g/10min]
CP2	Comp. Ex. 3	A	0.05	1.6	N/A
*OS2 used instead of OMTS PE Polymerisation example CE Catalyst example MC Metallocene					

**Table 2:** Polymerisation results of polyethylene (homoPE), data from PPR

PE	CE	MC	[OMTS/(Al)]	Catalytic activity	Mw
			[-]	[kg PE/g cat*h]	[kg/mol]
P7	Ex. 1	A	0.1	6.0	572
P8	Ex. 2	A	0.05	6.4	441
P9	Ex. 3	B	0.05	1.3	231
PE Polymerisation example CE Catalyst example MC Metallocene					

**Table 3:** Polymerisation results of polyethylene/1-hexene copolymer

PE	CE	MC	Catalytic activity	MFR <sub>2</sub>	Hexene
			[kg PE/g cat*h]	[g/10min]	[wt.-%]
P10	Ex. 3	B	11.2	2.2	1.7
PE Polymerisation example CE Catalyst example MC Metallocene					

**[0163]** The examples provide that the catalytic activity in polymerisation process significantly exceeded the catalytic activity of solid unsupported catalyst systems obtained by the precipitation technology known from the state. Further, it has been shown that precipitation of catalyst without any clathrating agent does not lead to a solid catalyst in any reasonable yield.

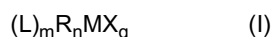
## Claims

1. Process for the preparation of a solid catalyst system (CS) comprising the steps of

- (i) preparing a liquid clathrate (LC) comprising a mixing of an aluminosilicate (A), an aromatic compound (AC) and an organo-silicon compound (OS), wherein the mol-ratio between the organo-silicon compound (OS) and aluminum (Al) of the aluminosilicate (A) [(OS)/(Al)] is equal or below 0.1,
- (ii) mixing said liquid clathrate (LC) with an organometallic compound (C) obtaining a liquid mixture (MI), wherein the liquid mixture (MI) is homogeneous,
- (iii) precipitating the solid catalyst system (CS) out of said liquid mixture (MI) by adding a saturated aliphatic compound to said liquid mixture (MI),
- (iv) optionally recovering particles of the solid catalyst system (CS),

wherein during the process no carrier material is added.

2. Process according to claim 1, wherein said organometallic compound (C) is of formula (I)



wherein

"M" is a transition metal (M) of group 3 to 10 of the Periodic Table (IUPAC 2007),  
 each "X" is independently a mono anionic ligand, like a  $\sigma$ -ligand,  
 each "L" is independently an organic ligand which coordinates to the transition metal "M",  
 "R" is a bridging group linking said organic ligands (L),  
 "m" is 1, 2 or 3, preferably 2,  
 "n" is 0, 1 or 2, preferably 1,  
 "q" is 1, 2 or 3, preferably 2,  
 m+q is equal to the valency of the transition metal (M).

3. Process according to claim 1 or 2, wherein the mol-ratio between the aluminum (Al) of the aluminosilane (A) and the transition metal (M) of the organometallic compound (C)  $[(Al)/(M)]$  is in the range of 50 to 600.

4. Process according to any one of the preceding claims, wherein the organo-silicon compound (OS) is selected from the group consisting of octamethyltrisiloxane, decamethyltetrasiloxane, octamethylcyclotetrasiloxane, methoxytri-methylsilane, tetraethoxysilane and 1,1,1,3,5,5,5-heptamethyl-3-phenyltrisiloxane.

5. Process according to any one of the preceding claims, wherein

(a) the aromatic compound (AC) is toluene;

and/or

(b) the saturated aliphatic compound is selected from the group consisting of n-pentane, n-hexane, n-heptane, n-octane, and mixtures thereof.

6. Process according to any one of the preceding claims, wherein

(a) step (i), i.e. the mixing of aluminosilane (A), an aromatic compound (AC) and an organo-silicon compound (OS), is accomplished at a temperature in the range of -20 to 70 °C, preferably in the range of 10 to 40 °C  
 (b) step (ii), i.e. the mixing of the liquid clathrate (LC) with an organometallic compound (C) is accomplished at a temperature in the range of 0 to 50 °C, preferably in the range of 20 to 30 °C.

7. Process according to any one of the preceding claims, wherein the organometallic compound (C) is formula (II)



wherein

"M" is zirconium (Zr) or hafnium (Hf),  
 each "X" is independently selected from halogen,  $C_1$  to  $C_6$  alkyl,  $C_5$  to  $C_6$  cycloalkyl,  $C_1$  to  $C_6$  alkoxy, phenyl and benzyl groups,  
 each "L" is independently a cyclopentadienyl, indenyl, tetrahydroindenyl, fluorenyl, which can be independently substituted or unsubstituted, preferably at least one organic ligand (L), preferably both organic ligands (L),  
 comprise one or more substituents independently selected from  $C_1$  to  $C_{20}$  hydrocarbyl or silyl groups, which optionally contain one or more heteroatoms selected from groups 14 to 16 and/or are optionally substituted by halogen atom(s),  
 "R" is a divalent bridge selected from  $-R'_2C-$ ,  $-R'_2Si-$ , wherein each R' is independently a hydrogen atom,  $C_1$  to  $C_{20}$  alkyl,  $C_2$  to  $C_{10}$  cycloalkyl.

8. Solid catalyst system (CS) comprising the reaction product of

(a) a liquid clathrate (LC) obtained by mixing an aluminosilane (A), an aromatic compound (AC) and an organo-

silicon compound (OS), wherein the mol-ratio between the organo-silicon compound (OS) and aluminum (Al) of the aluminosilicate (A) [(OS)/(Al)] is below 0.08, and  
 (b) an organometallic compound (C), said organometallic compound (C) is of formula (I)



wherein

"M" is a transition metal (M) of Group 3 to 10 of the Periodic Table (IUPAC 2007),  
 each "X" is independently a  $\sigma$ -ligand,  
 each "L" is independently an organic ligand which coordinates to the transition metal (M),  
 "R" is a bridging group linking said organic ligands (L),  
 "m" is 1, 2 or 3, preferably 2,  
 "n" is 0, 1 or 2, preferably 1,  
 "q" is 1, 2 or 3, preferably 2,  
 m+q is equal to the valency of the transition metal (M),

wherein said solid catalyst system (CS) is obtained by mixing said liquid clathrate (LC) with the organometallic compound (C) obtaining a liquid mixture (MI), wherein further the solid catalyst system (CS) is precipitated from said mixture (MI) by adding a saturated aliphatic compound to said mixture (MI), and wherein the mixture (MI) is homogeneous and the solid catalyst system (CS) is unsupported, i.e. during the process no carrier material is added.

9. Solid catalyst system (CS) according to claim 8, wherein the mol-ratio between the aluminum (Al) of the aluminosilicate (A) and the transition metal (M) of the organometallic compound (C) [(Al)/(M)] is equal or below 600, preferably in the range of 100 to equal or below 600.

10. Solid catalyst system (CS) according to claim 8 or 9, wherein

(a) the organo-silicon compound (OS) is selected from the group consisting of octamethyltrisiloxane, decamethyltetrasiloxane, octamethylcyclotetrasiloxane, methoxytrimethylsilane and tetraethoxysilane. and/or  
 (b) the aromatic compound (AC) is toluene;

and/or

(c) the saturated aliphatic compound is selected from the group consisting of n-pentane, n-hexane, n-heptane, n-octane, and mixtures thereof.

11. Solid catalyst system (CS) according to any one of the preceding claims 8 to 10, wherein the organometallic compound (C) is formula (II)



wherein

"M" is zirconium (Zr) or hafnium (Hf),  
 each "X" is independently selected from halogen,  $C_1$  to  $C_6$  alkyl,  $C_5$  to  $C_6$  cycloalkyl,  $C_1$  to  $C_6$  alkoxy, phenyl and benzyl groups,  
 each "L" is independently a cyclopentadienyl, indenyl, tetrahydroindenyl, fluorenyl, which can be independently substituted or unsubstituted, preferably at least one organic ligand (L), preferably both organic ligands (L),  
 comprise one or more substituents independently selected from  $C_1$  to  $C_{20}$  hydrocarbyl or silyl groups, which optionally contain one or more heteroatoms selected from groups 14 to 16 and/or are optionally substituted by halogen atom(s),  
 "R" is a divalent bridge selected from  $-R'_2C-$ ,  $-R'_2Si-$ , wherein each  $R'$  is independently a hydrogen atom,  $C_1$  to  $C_{20}$  alkyl,  $C_2$  to  $C_{10}$  cycloalkyl.

12. Use of a solid catalyst system (CS) as defined in any one of the claims 8 to 11 or a solid catalyst system (CS) obtained according to any one of the claims 1 to 7 for the preparation of a polymer, like a polypropylene or polyethylene or any copolymers thereof.

13. Process for the preparation of a polymer, like a polypropylene or polyethylene, by polymerising monomer units in the presence of a solid catalyst system (CS) as defined in any one of the claims 8 to 11.

14. Process according to claim 13, comprising the steps of

- (A) preparing a solid catalyst system (CS) according to the claims 1 to 7,  
(B) using said solid catalyst system (CS) in a polymerisation process thereby obtaining the polymer, like the polypropylene or polyethylene.

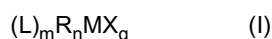
## Patentansprüche

1. Verfahren zur Herstellung eines festen Katalysator-Systems (CS), umfassend die Schritte von

- (i) Herstellen eines flüssigen Clathrats (LC), umfassend eine Mischung von einem Aluminoxan (A), einer aromatischen Verbindung (AC) und einer Organo-Silizium-Verbindung (OS), wobei das Mol-Verhältnis zwischen der Organo-Silizium-Verbindung (OS) und Aluminium (Al) des Aluminoxans (A) [(OS)/(A1)] gleich oder unter 0,1 ist,  
(ii) Vermischen des flüssigen Clathrats (LC) mit einer organo-metallischen Verbindung (C) unter Gewinnen eines Flüssigkeits-Gemisches (MI), wobei das Flüssigkeits-Gemisch (MI) homogen ist,  
(iii) Ausfällen des festen Katalysator-Systems (CS) aus dem Flüssigkeits-Gemisch (MI) durch Zusetzen einer gesättigten aliphatischen Verbindung zu dem Flüssigkeits-Gemisch (MI),  
(iv) gegebenenfalls Gewinnen der Teilchen des festen Katalysator-Systems (CS),

wobei während des Verfahrens kein Träger-Material zugesetzt wird.

2. Verfahren nach Anspruch 1, wobei die organo-metallische Verbindung (C) die Formel (I) aufweist



wobei

- "M" ein Übergangs-Metall (M) der Gruppe 3 bis 10 des Perioden-Systems (IUPAC 2007) ist,  
jedes "X" unabhängig ein mono-anionischer Ligand, wie ein  $\sigma$ -Ligand, ist,  
jedes "L" unabhängig ein organischer Ligand ist, der an das Übergangs-Metall "M" koordiniert,  
"R" eine Brücken-Gruppe ist, die die organischen Liganden (L) verbindet,  
"m" 1, 2 oder 3, vorzugsweise 2, ist,  
"n" 0, 1 oder 2, vorzugsweise 1, ist,  
"q" 1, 2 oder 3, vorzugsweise 2, ist,  
m+q gleich der Wertigkeit des Übergangs-Metalls (M) ist.

3. Verfahren nach Anspruch 1 oder 2, wobei das Mol-Verhältnis zwischen dem Aluminium (Al) des Aluminoxans (A) und dem Übergangs-Metall (M) der organo-metallischen Verbindung (C) [(Al)/(M)] in dem Bereich von 50 bis 600 liegt.

4. Verfahren nach einem der vorangehenden Ansprüche, wobei die Organo-Silizium-Verbindung (OS) ausgewählt ist aus der Gruppe, bestehend aus Octamethyltrisiloxan, Decamethyltetrasiloxan, Octamethylcyclotetrasiloxan, Methoxytrimethylsilan, Tetraethoxysilan und 1,1,1,3,5,5,5-Heptamethyl-3-phenyltrisiloxan.

5. Verfahren nach einem der vorangehenden Ansprüche, wobei

- (a) die aromatische Verbindung (AC) Toluol ist; und/oder  
(b) die gesättigte aliphatische Verbindung ausgewählt ist aus der Gruppe, bestehend aus n-Pentan, n-Hexan, n-Heptan, n-Octan und Gemischen davon.

6. Verfahren nach einem der vorangehenden Ansprüche, wobei

- (a) Schritt (i), d.h. das Vermischen von Aluminoxan (A), einer aromatischen Verbindung (AC) und einer Organo-Silizium-Verbindung (OS), bei einer Temperatur in dem Bereich von -20 bis 70°C, vorzugsweise in dem Bereich

von 10 bis 40°C ausgeführt wird,

(b) Schritt (ii), d.h. das Vermischen des flüssigen Clathrats (LC) mit einer organo-metallischen Verbindung (C) bei einer Temperatur in dem Bereich von 0 bis 50°C, vorzugsweise in dem Bereich von 20 bis 30°C, ausgeführt wird.

7. Verfahren nach einem der vorangehenden Ansprüche, wobei die organo-metallische Verbindung (C) die Formel (II) aufweist



wobei

"M" Zirkonium (Zr) oder Hafnium (Hf) ist,

jedes "X" unabhängig ausgewählt ist aus Halogen, C<sub>1</sub> bis C<sub>6</sub> Alkyl-, C<sub>5</sub> bis C<sub>6</sub> Cycloalkyl-, C<sub>1</sub> bis C<sub>6</sub> Alkoxy-, Phenyl- und Benzyl-Gruppen,

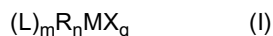
jedes "L" unabhängig ein Cyclopentadienyl, Indenyl, Tetrahydroindenyl, Fluorenyl ist, welches unabhängig substituiert oder unsubstituiert sein kann, vorzugsweise mindestens ein organischer Ligand (L), vorzugsweise beide organische Liganden (L), einen oder mehrere Substituenten umfassen, unabhängig ausgewählt aus C<sub>1</sub> bis C<sub>20</sub> Kohlenwasserstoff- oder Silyl-Gruppen,

welche gegebenenfalls ein oder mehrere Heteroatome enthalten, ausgewählt aus Gruppen 14 bis 16 und/oder gegebenenfalls mit Halogen-Atom(en) substituiert ist / sind, "R" eine zweiwertige Brücke ist, ausgewählt aus -R'<sub>2</sub>C-, -R'<sub>2</sub>Si-, wobei jedes R' unabhängig ein Wasserstoff-Atom, C<sub>1</sub> bis C<sub>20</sub> Alkyl, C<sub>2</sub> bis C<sub>10</sub> Cycloalkyl ist.

8. Festes Katalysator-System (CS), umfassend das Reaktionsprodukt von

(a) einem flüssigen Clathrat (LC), erhalten durch Vermischen eines Aluminoxans (A), einer aromatischen Verbindung (AC) und einer Organo-Silizium-Verbindung (OS), wobei das Mol-Verhältnis zwischen der Organo-Silizium-Verbindung (OS) und Aluminium (Al) des Aluminoxans (A) [(OS)/(Al)] unter 0,08 ist, und

(b) einer organo-metallischen Verbindung (C), wobei die organo-metallische Verbindung (C) die Formel (I) aufweist



wobei

"M" ein Übergangs-Metall (M) der Gruppe 3 bis 10 des Perioden-Systems (IUPAC 2007) ist,

jedes "X" unabhängig ein σ-Ligand ist,

jedes "L" unabhängig ein organischer Ligand ist, der an das Übergangs-Metall (M) koordiniert,

"R" eine Brücken-Gruppe ist, die die organischen Liganden (L) verbindet,

"m" 1, 2 oder 3, vorzugsweise 2, ist,

"n" 0, 1 oder 2, vorzugsweise 1, ist,

"q" 1, 2 oder 3, vorzugsweise 2, ist,

m+q gleich der Wertigkeit des Übergangs-Metalls (M) ist,

wobei das feste Katalysator-System (CS) durch Vermischen des flüssigen Clathrats (LC) mit der organo-metallischen Verbindung (C) unter Gewinnen eines Flüssigkeits-Gemisches (MI) erhalten wird, wobei weiterhin das feste Katalysator-System (CS) aus dem Gemisch (MI) durch Zusetzen einer gesättigten aliphatischen Verbindung zu dem Gemisch (MI) ausgefällt wird, und wobei das Gemisch (MI) homogen ist und das feste Katalysator-System (CS) ungetragen ist, d.h. während des Verfahrens kein Träger-Material zugesetzt wird.

9. Festes Katalysator-System (CS) nach Anspruch 8, wobei das Mol-Verhältnis zwischen dem Aluminium (Al) des Aluminoxans (A) und dem Übergangs-Metall (M) der organo-metallischen Verbindung (C) [(Al)/(M)] gleich oder unter 600, vorzugsweise in dem Bereich von 100 bis gleich oder unter 600, liegt.

10. Festes Katalysator-System (CS) nach Anspruch 8 oder 9, wobei

(a) die Organo-Silizium-Verbindung (OS) ausgewählt ist aus der Gruppe, bestehend aus Octamethyltrisiloxan, Decamethyltetrasiloxan, Octamethylcyclotetrasiloxan, Methoxytrimethylsilan und Tetraethoxysilan

und/oder

(b) die aromatische Verbindung (AC) Toluol ist;

5 und/oder

(c) die gesättigte aliphatische Verbindung ausgewählt ist aus der Gruppe, bestehend aus n-Pentan, n-Hexan, n-Heptan, n-Octan und Gemischen davon.

10 11. Festes Katalysator-System (CS) nach einem der vorangehenden Ansprüche 8 bis 10, wobei die organo-metallische Verbindung (C) die Formel (II) aufweist



15 wobei

"M" Zirkonium (Zr) oder Hafnium (Hf) ist,

jedes "X" unabhängig ausgewählt ist aus Halogen, C<sub>1</sub> bis C<sub>6</sub> Alkyl-, C<sub>5</sub> bis C<sub>6</sub> Cycloalkyl-, C<sub>1</sub> bis C<sub>6</sub> Alkoxy-, Phenyl- und Benzyl-Gruppen,

20 jedes "L" unabhängig ein Cyclopentadienyl, Indenyl, Tetrahydroindenyl, Fluorenyl ist, welches unabhängig substituiert oder unsubstituiert sein kann, vorzugsweise mindestens ein organischer Ligand (L), vorzugsweise beide organische Liganden (L), einen oder mehrere Substituenten umfassen, unabhängig ausgewählt aus C<sub>1</sub> bis C<sub>20</sub> Kohlenwasserstoff- oder Silyl-Gruppen, welche gegebenenfalls ein oder mehrere Heteroatome enthalten, ausgewählt aus Gruppen 14 bis 16 und/oder gegebenenfalls mit Halogen-Atom (en) substituiert sind,

25 "R" eine zweiwertige Brücke ist, ausgewählt aus -R'<sub>2</sub>C-, -R'<sub>2</sub>Si-, wobei jedes R' unabhängig ein Wasserstoff-Atom, C<sub>1</sub> bis C<sub>20</sub> Alkyl, C<sub>2</sub> bis C<sub>20</sub> Cycloalkyl ist.

30 12. Verwendung eines festen Katalysator-Systems (CS), wie in einem der Ansprüche 8 bis 11 definiert, oder eines festen Katalysator-Systems (CS), erhalten nach einem der Ansprüche 1 bis 7, zur Herstellung eines Polymers, wie ein Polypropylen oder Polyethylen oder beliebige Copolymere davon.

13. Verfahren zur Herstellung eines Polymers, wie ein Polypropylen oder Polyethylen, durch Polymerisieren von Monomer-Einheiten in Gegenwart eines festen Katalysator-Systems (CS), wie in einem der Ansprüche 8 bis 11 definiert.

35 14. Verfahren nach Anspruch 13, umfassend die Schritte von

(A) Herstellen eines festen Katalysator-Systems (CS) nach den Ansprüchen 1 bis 7,

(B) Verwendung des festen Katalysator-Systems (CS) in einem Polymerisations-Verfahren, wodurch das Polymer, wie das Polypropylen oder Polyethylen, erhalten wird.

40

## Revendications

45 1. Procédé pour la préparation d'un système de catalyseur solide (CS) comprenant les étapes consistant à

(i) préparer un clathrate liquide (LC) comprenant un mélange d'un aluminosilicate (A), d'un composé aromatique (AC) et d'un composé organique du silicium (OS), dans lequel le rapport molaire entre le composé organique du silicium (OS) et l'aluminium (Al) de l'aluminosilicate (A) [(OS)/(Al)] est égal ou inférieur à 0,1,

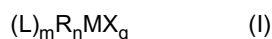
50 (ii) mélanger ledit clathrate liquide (LC) avec un composé organométallique (C), ce qui donne un mélange liquide (MI), lequel mélange liquide (MI) est homogène,

(iii) précipiter le système de catalyseur solide (CS) hors dudit mélange liquide (MI) par addition d'un composé aliphatique saturé audit mélange liquide (MI),

(iv) éventuellement récupérer des particules du système de catalyseur solide (CS),

55 dans lequel, durant le procédé, aucun matériau de support n'est ajouté.

2. Procédé selon la revendication 1, dans lequel ledit composé organométallique (C) répond à la formule (I)



dans laquelle

"M" est un métal de transition (M) des Groupes 3 à 10 du Tableau Périodique (IUPAC 2007),  
chaque "X" est indépendamment un ligand monoanionique, tel qu'un ligand  $\sigma$ ,  
chaque "L" est indépendamment un ligand organique qui se coordonne au métal de transition "M",  
"R" est un groupe pontant liant lesdits ligands organiques (L),  
"m" vaut 1, 2 ou 3, de préférence 2,  
"n" vaut 0, 1 ou 2, de préférence 1,  
"q" vaut 1, 2 ou 3, de préférence 2,  
la somme m+q est égale à la valence du métal de transition (M).

3. Procédé selon la revendication 1 ou 2, dans lequel le rapport molaire entre l'aluminium (Al) de l'aluminoxane (A) et le métal de transition (M) du composé organométallique (C)  $[Al/(M)]$  est situé dans la plage allant de 50 à 600.

4. Procédé selon l'une quelconque des revendications précédentes, dans lequel le composé organique du silicium (OS) est choisi dans l'ensemble constitué par l'octaméthyltrisiloxane, le décaméthyltétrasiloxane, l'octaméthylcyclotétrasiloxane, le méthoxytriméthylsilane, le tétraéthoxysilane et le 1,1,1,3,5,5,5-heptaméthyl-3-phényltrisiloxane.

5. Procédé selon l'une quelconque des revendications précédentes, dans lequel

(a) le composé aromatique (AC) est le toluène ;

et/ou

(b) le composé aliphatique saturé est choisi dans l'ensemble constitué par le n-pentane, le n-hexane, le n-heptane, le n-octane, et leurs mélanges.

6. Procédé selon l'une quelconque des revendications précédentes, dans lequel

(a) l'étape (i), c'est-à-dire le mélange d'aluminoxane (A), d'un composé aromatique (AC) et d'un composé organique du silicium (OS), est effectuée à une température située dans la plage allant de -20 à 70°C, de préférence dans la plage allant de 10 à 40°C ;

(b) l'étape (ii), c'est-à-dire le mélange du clathrate liquide (LC) avec un composé organométallique (C), est effectuée à une température située dans la plage allant de 0 à 50°C, de préférence dans la plage allant de 20 à 30°C.

7. Procédé selon l'une quelconque des revendications précédentes, dans lequel le composé organométallique (C) répond à la formule (II)

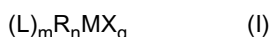


dans laquelle

"M" est le zirconium (Zr) ou le hafnium (Hf),  
chaque "X" est indépendamment choisi parmi les halogènes et les groupes alkyle en  $C_1$  à  $C_6$ , cycloalkyle en  $C_5$  à  $C_6$ , alcoxy en  $C_1$  à  $C_6$ , phényle et benzyle,  
chaque "L" est indépendamment un cyclopentadiényle, indényle, tétrahydroindényle, fluorényle, qui peut être indépendamment substitué ou non substitué, de préférence au moins un ligand organique (L), de préférence les deux ligands organiques (L), comprennent un ou plusieurs substituant(s) indépendamment choisi(s) parmi les groupes silyle et hydrocarbyle en  $C_1$  à  $C_{20}$ , contenant éventuellement un ou plusieurs hétéroatome(s) choisi(s) parmi les Groupes 14 à 16, et/ou sont éventuellement substitués par un ou plusieurs atome(s) d'halogène,  
"R" est un pont divalent choisi parmi  $-R'_2C-$ ,  $-R'_2Si-$ , où chaque  $R'$  est indépendamment un atome d'hydrogène, un alkyle en  $C_1$  à  $C_{20}$ , un cycloalkyle en  $C_2$  à  $C_{10}$ .

8. Système de catalyseur solide (CS) comprenant le produit de la réaction de

- (a) un clathrate liquide (LC) obtenu par mélange d'un aluminosilicate (A), d'un composé aromatique (AC) et d'un composé organique du silicium (OS), dans lequel le rapport molaire entre le composé organique du silicium (OS) et l'aluminium (Al) de l'aluminosilicate (A) [(OS)/(Al)] est inférieur à 0,08, et  
 (b) un composé organométallique (C), lequel composé organométallique (C) répond à la formule (I)



dans laquelle

- "M" est un métal de transition (M) des Groupes 3 à 10 du Tableau Périodique (IUPAC 2007),  
 chaque "X" est indépendamment un ligand  $\sigma$ ,  
 chaque "L" est indépendamment un ligand organique qui se coordonne au métal de transition "M",  
 "R" est un groupe pontant liant lesdits ligands organiques (L),  
 "m" vaut 1, 2 ou 3, de préférence 2,  
 "n" vaut 0, 1 ou 2, de préférence 1,  
 "q" vaut 1, 2 ou 3, de préférence 2,  
 la somme m+q est égale à la valence du métal de transition (M),  
 lequel système de catalyseur solide (CS) est obtenu par mélange dudit clathrate liquide (LC) avec le composé organométallique (C), ce qui donne un mélange liquide (MI), et  
 lequel système de catalyseur solide (CS) est en outre précipité à partir dudit mélange (MI) par addition d'un composé aliphatique saturé audit mélange (MI),  
 dans lequel le mélange (MI) est homogène et le système de catalyseur solide (CS) est non supporté, c'est-à-dire que, durant le procédé, aucun matériau de support n'est ajouté.

9. Système de catalyseur solide (CS) selon la revendication 8, dans lequel le rapport molaire entre l'aluminium (Al) de l'aluminosilicate (A) et le métal de transition (M) du composé organométallique (C) [(Al)/(M)] est égal ou inférieur à 600, de préférence situé dans la plage allant de 100 à 600 ou moins.

10. Système de catalyseur solide (CS) selon la revendication 8 ou 9, dans lequel

- (a) le composé organique du silicium (OS) est choisi dans l'ensemble constitué par l'octaméthyltrisiloxane, le décaméthyltétrasiloxane, l'octaméthylcyclotétrasiloxane, le méthoxytriméthylsilane et le tétraéthoxysilane,

et/ou

- (b) le composé aromatique (AC) est le toluène ;

et/ou

- (c) le composé aliphatique saturé est choisi dans l'ensemble constitué par le n-pentane, le n-hexane, le n-heptane, le n-octane, et leurs mélanges.

11. Système de catalyseur solide (CS) selon l'une quelconque des revendications 8 à 10, dans lequel le composé organométallique (C) répond à la formule (II)



dans laquelle

- "M" est le zirconium (Zr) ou le hafnium (Hf),  
 chaque "X" est indépendamment choisi parmi les halogènes et les groupes alkyle en C<sub>1</sub> à C<sub>6</sub>, cycloalkyle en C<sub>5</sub> à C<sub>6</sub>, alcoxy en C<sub>1</sub> à C<sub>6</sub>, phényle et benzyle,  
 chaque "L" est indépendamment un cyclopentadiényle, indényle, tétrahydroindényle, fluorényle, qui peut être indépendamment substitué ou non substitué, de préférence au moins un ligand organique (L), de préférence les deux ligands organiques (L), comprennent un ou plusieurs substituant(s) indépendamment choisi(s) parmi les groupes silyle et hydrocarbyle en C<sub>1</sub> à C<sub>20</sub>, contenant éventuellement un ou plusieurs hétéroatome(s) choisi(s) parmi les Groupes 14 à 16, et/ou sont éventuellement substitués par un ou plusieurs atome(s) d'halogène,

"R" est un pont divalent choisi parmi  $-R'_2C-$ ,  $-R'_2Si-$ , où chaque R' est indépendamment un atome d'hydrogène, un alkyle en  $C_1$  à  $C_{20}$ , un cycloalkyle en  $C_2$  à  $C_{10}$ .

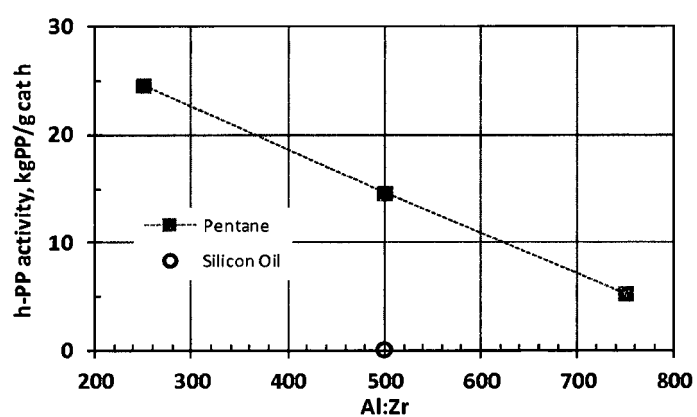
12. Utilisation d'un système de catalyseur solide (CS) tel que défini dans l'une quelconque des revendications 8 à 11 ou d'un système de catalyseur solide (CS) obtenu conformément à l'une quelconque des revendications 1 à 7 pour la préparation d'un polymère, tel qu'un polypropylène ou polyéthylène ou n'importe quels copolymères de ceux-ci.

13. Procédé pour la préparation d'un polymère, tel qu'un polypropylène ou polyéthylène, par polymérisation de motifs monomères en présence d'un système de catalyseur solide (CS) tel que défini dans l'une quelconque des revendications 8 à 11.

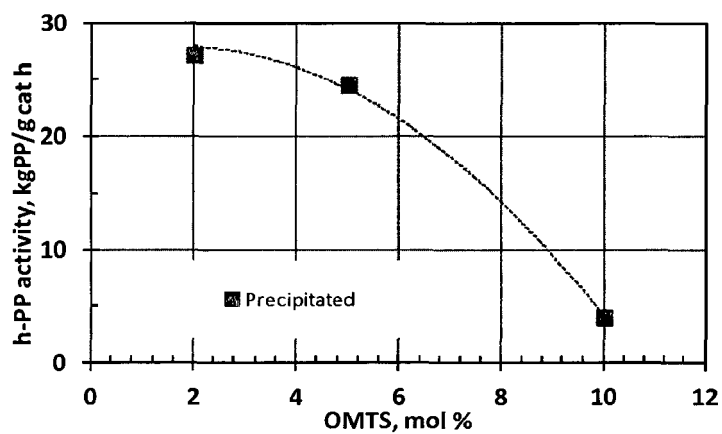
14. Procédé selon la revendication 13, comprenant les étapes consistant à

(A) préparer un système de catalyseur solide (CS) selon les revendications 1 à 7,

(B) utiliser ledit système de catalyseur solide (CS) dans un procédé de polymérisation, ce qui donne ainsi le polymère, tel que le polypropylène ou polyéthylène.



**Fig. 1:** Catalyst activity of polymerisation examples 2, 4 and 5 (Catalyst Examples 2, 5 and 6, resp.) obtained by precipitation with pentane as a function of  $[(Al)/(Zr)]$  compared to catalyst activity of Comparative Example 1 obtained by precipitation in silicon oil as a function of  $[(Al)/(Zr)]$ .



**Fig. 2:** Catalyst activity of polymerisation examples P3, P2 and P1 (CatalystExamples 4, 2 and 1, resp) obtained by precipitation with pentane as a function of  $[(OS)/(Al)]$ .

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