# Contents

List of Tables  
List of Figures  
Preface  

1 Introduction to Polymers of Propylene  
1.1 Origins of Crystalline Polypropylene  
1.2 Basic Description of Polypropylene  
1.3 Types and Nomenclature of Polypropylene  
1.4 Molecular Weight of Polypropylene  
1.5 Transition Metal Catalysts for Propylene Polymerization  
1.6 Questions  
References  

2 Polymer Characterization  
2.1 Introduction  
2.2 Polymer Tacticity  
2.2.1 Introduction  
2.2.2 Measurement of Polymer Microtacticity by $^{13}$C NMR  
2.2.3 Total Isotactic Index  
2.2.4 Total Xylene Insolubles  
2.3 Molecular Weight and Molecular Weight Distribution  
2.3.1 Introduction  
2.3.2 Gel Permeation Chromatography  
2.3.3 Intrinsic Viscosity  
2.3.4 Melt Flow Rate
CONTENTS

2.4 Polymer Bulk Density 48
  2.4.1 Introduction 48
  2.4.2 Measurement Method 50
2.5 Particle Size Distribution and Morphology 50
  2.5.1 Introduction 50
  2.5.2 Measurement Method 52
2.6 Questions 54
 References 55

3 Ziegler-Natta Catalysts 59
  3.1 A Brief History of Ziegler-Natta Catalysts 59
  3.2 Definitions and Nomenclature 61
  3.3 Characteristics of Ziegler-Natta Catalysts 63
  3.4 Early Commercial Ziegler-Natta Catalysts 65
  3.5 Supported Ziegler-Natta Catalysts 67
  3.6 Prepolymerized Ziegler-Natta Catalysts 68
  3.7 Mechanism of Ziegler-Natta Polymerization 69
  3.8 Questions and Exercises 73
 References 73

4 Propylene Polymerization Catalysts 75
  4.1 Introduction 75
  4.2 Zero Generation Ziegler-Natta Catalysts 77
  4.3 First Generation ZN Catalysts 79
  4.4 Second Generation ZN Catalysts 82
  4.5 Third Generation ZN Catalysts 84
  4.6 Fourth Generation ZN Catalysts 86
  4.7 Fifth Generation ZN Catalysts 89
  4.8 ZN Catalysts for Atactic Polypropylene 92
  4.9 Metallocenes and Other Single Site Catalysts 93
  4.10 Cocatalysts for ZN Catalysts 94
  4.11 Kinetics and ZN Catalyst Productivity 99
  4.12 Concluding Remarks 102
  4.13 Questions 102
 References 105

5 Aluminum Alkyls in Ziegler-Natta Catalysts 111
  5.1 Organometallic Compounds 111
5.2 Characteristics of Aluminum Alkyls
   5.2.1 Basic Physical and Chemical Properties  116
   5.2.2 Hydride Content  116
   5.2.3 Other $R_3$Al Impurities  116
   5.2.4 Analysis of Aluminum Alkyls  117
   5.2.5 Impurities Resulting from Exposure to Minute Concentrations of Water and Oxygen  118
   5.2.6 Assays of Aluminum Alkyls  118
   5.2.7 Reactivity with Organic Substrates  118
   5.2.8 Reactivity with $\text{CO}_2$ and CO  119
   5.2.9 Distillation  119
   5.2.10 Association of Aluminum Alkyls  119
   5.2.11 Storage Stability  120
   5.2.12 Thermal Stability  121

5.3 Production of Aluminum Alkyls  122
5.4 Reducing Agent for the Transition Metal  125
5.5 Alkylating Agent for Creation of Active Centers  127
5.6 Scavenger of Catalyst Poisons  128
5.7 Chain Transfer Agent  129
5.8 Safety and Handling of Aluminum Alkyls  129
5.9 Questions  130
References  131

6 Single Site Catalysts and Cocatalysts  133
   6.1 Introduction  133
   6.2 The Structures of Metalloccenes and SSCs  134
   6.3 Non-Metalloocene Polymerization Catalysts  138
   6.4 Cocatalysts for SSCs  139
      6.4.1 Aluminoxanes  139
      6.4.2 Organoboron Cocatalysts  142
      6.4.3 Activated Supports  142
   6.5 Supports for SSCs  143
   6.6 Characteristics of mPP  145
   6.7 Selected Applications of mPP Resins  148
      6.7.1 Medical Applications  148
      6.7.2 Thin Wall Food Containers  149
      6.7.3 High Clarity Bottles for Personal Care  149
6.7.4 Waxes
6.7.5 New Resins from Hybrid Catalysts to Make Polypropylene Alloys
6.8 Metalloocene Synthesis
6.9 Syndiotactic Polypropylene
6.10 Commercial Reality and Concluding Remarks
6.11 Questions
References

7 Catalyst Manufacture
7.1 Introduction
7.2 Development of the Manufacturing Process
7.3 Chemistry of Catalyst Manufacture
7.4 Raw Materials Storage and Handling
7.5 Catalyst Preparation
7.6 Catalyst Drying
7.7 Catalyst Packaging
7.8 Recovery and Recycle of Spent Solvents
7.9 Prepolymerization at the Catalyst Manufacturing Plant
7.10 Plant Size
7.11 Site Safety
7.12 Quality Control and Specifications
7.13 Diagram of a Hypothetical Plant
7.14 Custom Manufacture
7.15 Brief Consideration of Metalloocene Catalyst Manufacture
7.16 Concluding Remarks
7.17 Questions
References

8 An Overview of Industrial Polypropylene Processes
8.1 Introduction
8.2 Slurry (Suspension) Processes
8.3 Bulk ("Liquid Pool") Process
8.4 "Loop Slurry" Process (Chevron Phillips Chemical)
8.5 Gas Phase Processes
8.6 Solution Process 194
8.7 Hybrid Processes 194
8.8 Kinetics and Reactivity Ratios 196
8.9 Emergency Stoppage of Polymerization 198
8.10 Questions 199
References 199

9 Laboratory Catalyst Synthesis 201
  9.1 Introduction 201
  9.2 General Synthesis Requirements 202
  9.3 Equipment Requirements 202
  9.4 Synthesis Schedule 207
  9.5 Handling TiCl₄ 208
  9.6 Handling Diethylaluminum Chloride 209
  9.7 Spent Liquids 209
  9.8 Synthetic Procedure for Fourth Generation Supported Catalyst 210
    9.8.1 Introduction 210
    9.8.2 Procedure 210
  9.9 Synthetic Procedure for Second Generation Precipitated TiCl₃ Catalyst 211
    9.9.1 Introduction 211
    9.9.2 Procedure 212
  9.10 Catalyst Analysis 213
  9.11 Questions 213
References 214

10 Polymerization Catalyst Testing 217
  10.1 Introduction 217
  10.2 Facility Requirements 219
  10.3 The Autoclave 221
  10.4 Key Equipment Items 224
  10.5 Raw Materials 225
  10.6 Polymerization Conditions 227
  10.7 Autoclave Preparation 228
  10.8 Polymerization Test Procedure 228
  10.9 Reproducibility 230
## CONTENTS

10.10 Testing Metallocene Catalysts 231  
10.11 Questions 232  
References 233

### 11 Downstream Aspects of Polypropylene 235  
11.1 Introduction 235  
11.2 Additives 236  
11.3 Fabrication Methods 242  
11.4 Biopolymers 244  
11.5 Environmental 248  
11.6 Questions 254  
References 255

### 12 Overview of Polypropylene Markets 257  
12.1 Introduction 257  
12.2 The Supply Chain for Polypropylene 258  
12.3 The Global Polypropylene Market 260  
12.4 Questions 266  
References 266

### 13 The Future of Polypropylene 269  
13.1 Introduction 269  
13.2 Key Growth Markets for Polypropylene 270  
13.3 Polypropylene and Free Markets 272  
13.4 Questions 277  
References 277

Appendix A 279

Appendix B 297

Appendix C 315

Index 317