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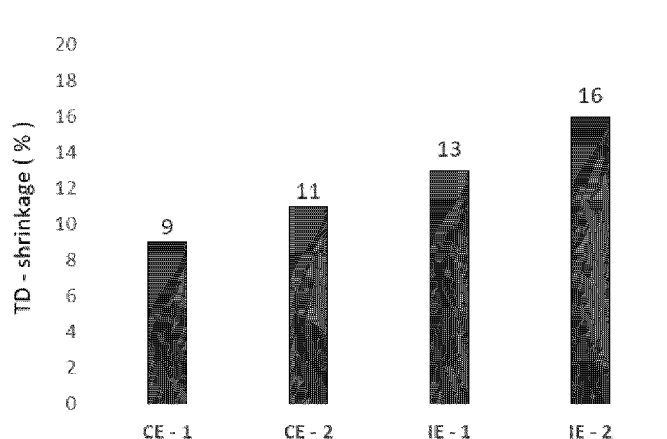


Figure 1

(57) Abstract: The present invention relates to a multilayer collation shrink film, comprising at least three layers, wherein core layer (B) comprises at least (B1) recycled LDPE having a strain hardening factor of from 1.5 to 5.0 when measured at 180°C, at a strain rate of 3.0 s⁻¹ and a Hencky strain of 2.5 in an amount of at least 50 wt%, based on the total weight of the core layer (B), and (B2) a specific linear copolymer of ethylene. The invention further refers to a method for manufacturing this multilayer film and its use in the field of secondary packaging.



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Multilayer collation shrink film

The present invention relates to a multilayer collation shrink film, comprising at least three layers, wherein core layer (B) comprises at least (B1) recycled LDPE having a strain hardening factor of from 1.5 to 5.0 when measured at 180°C, at a strain rate of 3.0 s⁻¹ and a Hencky strain of 2.5 in an amount of at least 50 wt%, based on the total weight of the core layer (B), and (B2) a specific linear copolymer of ethylene. The invention further refers to a method for manufacturing this multilayer film and its use in the field of secondary packaging.

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Technical background

Nowadays, the attempt of using polymers obtained from waste materials for the manufacturing of new products is of increasing interest and importance for ecological reasons and for reducing costs. Due to the growing environmental problems caused by plastics, the focus today is on the recycling of these plastics.

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Secondary packagings, like collation shrink films, do not require a food approval and a large amount of recycled material is resulting from flexible applications. Due to the original material design the best use of this material would be in a flexible application. Therefore, secondary packagings are a perfect fit application for using recycled plastics. Nevertheless, the use of recycled materials is limited due to their lower performances. However, multilayer collation shrink films comprising recycled plastics are also known in the prior art.

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WO 91/17886 A1 relates to the use of multilayer heat shrinkable film for advantageous high shrinkage but low shrinkage force is combined with the use of recycle scrap of such film to provide a multilayer heat shrinkable film retaining these advantageous properties. Exemplary of the film is a core of a blend of certain linear low density polyethylene with certain highly branched low density polyethylene sandwiched between two relatively thin outer layers of propylene/ethylene copolymer, with the core also containing recycle scrap of the multilayer film.

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DE 20 2018 101 226 U1 refers to a packaging for bottles or cans with the following components; 1) an outer packaging for at least partially repackaging bottles or cans

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consisting of a heat-shrinkable plastic film and 2) a carrying handle fastened to the outer packaging with a carrying handle additional component, wherein all components of the packaging consist of at least one recyclable plastic and wherein the carrying handle additional component consists of a printable plastic and has an
5 imprint.

In most of the multilayer collation shrink films the use of more than 25 % of recycled material is not possible without significant deterioration of the mechanical properties. Inhomogeneities originating from contaminants from the original use, collection and recycling of flexible materials increase the risk for hole formation in an oven, for
10 example a shrink oven. LDPE is the most sensitive material for hole formation due to inhomogeneities.

Based on this it was one objective of the present invention to provide a multilayer collation shrink film allowing the use of bigger amounts of recycled LDPE with low
15 or no hole formation. It was another objective of the present invention that the multilayer collation shrink film shows very good mechanical properties without increasing the film thickness. Furthermore, it was the objective of the present invention that the multilayer collation shrink film has good optical properties, a good shrink behaviour and good puncture resistance and good sealing properties.

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Summary of the invention

The present invention relates to a multilayer collation shrink film comprising an inner surface layer (A), a core layer (B) and an outer layer (C), wherein core layer (B) is sandwiched between inner surface layer (A) and outer layer (C) and core layer
25 (B) comprises the following components:

(B1) a recycled LDPE having a strain hardening factor of from 1.5 to 5.0, preferably from 1.8 to 4.5 when measured at 180°C, at a strain rate of 3.0 s⁻¹ and a Hencky strain of 2.5; and

(B2) a linear copolymer of ethylene comprising at least one comonomer selected
30 from alpha-olefins having from 4 to 10 carbon atoms and having a weight

average molecular weight M_w of from 150 to 400 kg/mol, preferably from 160 to 350 kg/mol, and a polydispersity index being the ratio of M_w/M_n , of from 15 to 35, preferably from 17 to 32, determined by Gel Permeation Chromatography (GPC) according to ISO 16014-4:2003 and ASTM D 6474-12, preferably being multimodal, more preferably being bimodal;

5 wherein the recycled LDPE (B1) has a lower density and a higher melt flow rate MFR_2 than the linear copolymer of ethylene (B2), and the recycled LDPE (B1) is present in the core layer (B) in an amount of more than 50 wt%, such as from 55 to 95 wt%, preferably from 60 to 90 wt%, most preferably

10 from 65 to 85 wt%, based on the total weight of the core layer (B).

The present invention further relates to a method for manufacturing the multilayer collation shrink film as described above or below, characterized in that the film is manufactured by a one-step blown film coextrusion process.

15

Still further, the present invention relates to the use of the multilayer collation shrink film as described above or below for secondary packaging, preferably for bottles and cans, more preferably for bottles and cans in the field of household products, food, healthcare products and beverage products.

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Definitions:

In the gist of the present invention the term “multimodal” can mean multimodal with respect to molecular weight distribution and includes also therefore bimodal polymers. However, as explained in the detailed description of the components, the

25 components can also be multimodal with respect to other properties, like the MFR and/or the density.

Usually, a polymer composition, comprising at least two polyethylene fractions, which have been produced under different polymerisation conditions resulting in

30 different (weight average) molecular weights and molecular weight distributions for

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the fractions, is referred to as “multimodal”. The prefix “multi” relates to the number of different polymer fractions present in the polymer. Thus, for example, the term multimodal polymer includes so called “bimodal” polymers consisting of two fractions. The form of the molecular weight distribution curve, i.e. the appearance of the graph of the polymer weight fraction as a function of its molecular weight, of a multimodal polymer, e.g. LLDPE, will show two or more maxima or at least be distinctly broadened in comparison with the curves for the individual fractions.

Ideally, the molecular weight distribution curve for multimodal polymers of the invention will show two distinct maxima. For example, if a polymer is produced in a sequential multistage process, utilising reactors coupled in series and using different conditions in each reactor, the polymer fractions produced in the different reactors will each have their own molecular weight distribution and weight average molecular weight. When the molecular weight distribution curve of such a polymer is recorded, the individual curves from these fractions are superimposed into the molecular weight distribution curve for the total resulting polymer product, usually yielding a curve with two or more distinct maxima.

In any multimodal polymer, there is by definition a lower molecular weight component (LMW) and a higher molecular weight component (HMW). The LMW component has a lower molecular weight than the higher molecular weight component. This difference is preferably at least 5000 g/mol.

In the sense of the present invention it is preferred that all olefins are alpha olefins.

The meaning of low density polyethylene (LDPE) is well known and documented in the literature. Although the term LDPE is an abbreviation for low density polyethylene, the term is understood not to limit the density range, but covers the LDPE-like HP polyethylenes, which are produced by free-radical polymerization in a high-pressure process, with low, medium and higher densities. The term LDPE

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describes and distinguishes only the nature of HP polyethylene with typical features, such as different branching architecture, compared to the polyethylene produced in the presence of an olefin polymerization catalyst. Moreover, said low density polyethylene (LDPE) homopolymer, may be unsaturated.

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In the gist of the present invention “collation shrink films” are films that are wrapped around an object to be packaged and shrunk to keep the units within the object together. The most common use of these films is in the packaging of multiple containers (items), such as bottles or cans which might contain food, beverages and so on. The collation shrink film is wrapped around a number of the containers, perhaps a 6-pack of drinks or 24-pack of food cans optionally held in a cardboard tray or pad and shrunk around the containers. The wrapping process typically involves a shrink oven or shrink tunnel in which the film and object covered by the film is briefly heated to cause the collation shrink wrapping to occur. The plastic film then collapses around the multiple containers and holds the units in place.

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For the purposes of the present description and of the subsequent claims, the term “recycled LDPE” is used to indicate that the material is recovered from post-consumer waste and/or post-industrial waste. Namely, post-consumer waste refers to objects having completed at least a first use cycle (or life cycle), i.e. having already served their first purpose; while industrial waste refers to the manufacturing scrap which does normally not reach a consumer. In the gist of the present invention “recycled LDPE” may also comprise up to 30 wt.-%, preferably up to 25 wt.-%, more preferably up to 20 wt.-% and even more preferably up to 10 wt.-% based on the overall weight of the accordant recycled LDPE of other components like for example LLDPE, MDPE, HDPE and/or additives, filler and colour masterbatches. Respectively, the term “virgin” denotes the newly produced materials and/or objects prior to first use and not being recycled. In case that the origin of the polymer is not explicitly mentioned the polymer is a “virgin” polymer.

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The “density” of the materials described in the present description and claims means the density determined according to ISO 1183.

5 The “melt flow rate” (= MFR) of the polymers described in the present description and claims means the MFR determined according to ISO 1133.

The “melting temperature” of the polymers described in the present description and claims may be measured with a TA Instrument Q200 differential scanning calorimetry (DSC) on 5 to 7 mg samples. DSC is run according to ISO 11357 / part 3
10 /method C2 in a heat / cool / heat cycle with a scan rate of 10 °C/min in the temperature range of 25 to +225°C. Crystallization temperature (T_c) and crystallization enthalpy (H_{cryst}) are determined from the cooling step, while melting temperature (T_m) and heat of fusion (H_{fusion}) are determined from the second heating step. The crystallinity is calculated from the heat of fusion by assuming an H_{fusion} -
15 value of 209 J/g for a fully crystalline polypropylene (see Brandrup, J., Immergut, E. H., Eds. Polymer Handbook, 3rd ed. Wiley, New York, 1989; Chapter 3).

The “weight average molecular weight M_w ” and the “number average molecular weight M_n ” described in the present description and claims may be measured by Gel
20 Permeation Chromatography (GPC) according to ISO 16014-4:2003 and ASTM D 6474-12.

Where the term "comprising" is used in the present description and claims, it does not exclude other non-specified elements of major or minor functional importance.
25 For the purposes of the present invention, the term "consisting of" is considered to be a preferred embodiment of the term "comprising of". If hereinafter a group is defined to comprise at least a certain number of embodiments, this is also to be understood to disclose a group, which preferably consists only of these embodiments.

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Whenever the terms "including" or "having" are used, these terms are meant to be equivalent to "comprising" as defined above.

Where an indefinite or definite article is used when referring to a singular noun, e.g. "a", "an" or "the", this includes a plural of that noun unless something else is specifically stated.

Detailed description

Core layer (B)

10 Core layer (B) comprises a recycled LDPE (B1) and a linear copolymer of ethylene and one comonomer selected from alpha-olefins having from 4 to 10 carbon atoms (B2).

The recycled LDPE (B1) is present in core layer (B) in an amount of more than 50
15 wt%, such as 55 to 95 wt%, preferably from 60 to 90 wt%, most preferably from 65 to 85 wt%, based on the total weight amount of core layer (B).

It is preferred that the linear copolymer of ethylene (B2) is present in core layer (B) in an amount of less than 50 wt%, such as from 5 to 45 wt%, preferably from 10 to
20 40 wt%, most preferably from 15 to 35 wt%, based on the total weight amount of core layer (B).

The core layer (B) can comprise additional polymeric components, which are different from the recycled LDPE (B1) and the linear copolymer of ethylene (B2).

25 These additional polymeric components are preferably ethylene based polymers. The additional polymeric components, if present, are preferably present in an amount of up to 25 wt.-%, more preferably up to 20 wt.-%, still more preferably up to 10 wt.-%.

The composition forming the layer (B) can further comprise additives and/or
30 admixtures.

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Additives are preferably selected from the group consisting of slip agents, UV-stabiliser, antioxidants, nucleating agents and mixtures thereof, preferably these additives are contained in an the range from 0 to 5000 ppm, preferably in the range from 10 to 5000 ppm and more preferably in the range from 500 to 3000 ppm based
5 on the overall weight of the layer (B).

Admixtures are preferably selected from the group consisting of pigments, fillers, antiblocking agents and mixtures thereof, preferably these additives are contained in an the range from 0 to 5 wt.-%, preferably in the range from 0 to 3 wt.-%, more preferably in the range from 0 to 2 wt.-% and most preferably from 0 to 1 wt.-%
10 based on the overall weight of the layer (B).

In one embodiment the polymeric components of core layer (B) consists of the recycled LDPE (B1) and the copolymer of ethylene (B2).

In said embodiment, the recycled LDPE (B1), the linear copolymer of ethylene (B2)
15 and the optional additives and admixtures add up to 100 wt.-% of the total weight of the core layer (B).

Recycled LDPE (B1)

The recycled LDPE (B1) preferably originates from post consumer waste or post
20 industrial waste, preferably from post consumer waste.

The recycled LDPE (B1) can comprise up to 20 wt.-% of constituents originating from the first use. Type and amount of these constituents influence the physical properties of recycled LDPE (B1). The properties given below refer to the main
25 component.

The recycled LDPE (B1) preferably has a density of from 915 to 935 kg/m³, more preferably of 917 to 932 kg/m³, most preferably of 920 to 930 kg/m³.

Further, the recycled LDPE (B1) preferably has a melt flow rate MFR_2 of 0.1 to 2.0 g/10 min, more preferably of 0.3 to 1.7 g/10 min, most preferably of 0.5 to 1.5 g/10 min.

- 5 Still further, the recycled LDPE (B1) preferably has a tensile modulus of from 200 to 450 MPa, preferably from 225 to 425 MPa, most preferably from 250 to 400 MPa.

Further, the recycled LDPE (B1) preferably has a tensile stress at yield of from 6.0 to 15.0 MPa, more preferably from 7.5 to 12.5 MPa, most preferably from 9.0 to 11.5
10 MPa.

Still further, the recycled LDPE (B1) preferably has a tensile strain at break of from 350 to 1200 %, more preferably from 375 to 1100 %, most preferably from 400 to 1000 %.

15

Additionally, the recycled LDPE (B1) preferably has a flexural modulus of from 200 to 500 MPa, more preferably from 225 to 475 MPa, most preferably from 250 to 450 MPa.

- 20 Further, the recycled LDPE (B1) preferably has a Charpy notched impact strength at 23°C of from 40 to 120 kJ/m², more preferably from 45 to 110 kJ/m², most preferably from 50 to 100 kJ/m².

Still further, the recycled LDPE (B1) preferably has a Charpy notched impact
25 strength at -20°C of from 5.0 to 20.0 kJ/m², more preferably from 6.0 to 18.0 kJ/m², most preferably from 7.0 to 16.0 kJ/m².

The recycled LDPE (B1) has a strain hardening factor of from 1.5 to 5.0, more preferably from 1.8 to 4.5, when measured at 180°C, at a strain rate of 3.0 s⁻¹ and a
30 Hencky strain of 2.5.

The recycled LDPE (B1) according to the present invention is characterized by a polymer structure being mainly responsible for the benefits of the present invention, particularly by the nature of long chain branching (LCB) which may be expressed by the Strain Hardening Factor being defined as

$$SHF = \frac{\eta_E^+(t, \dot{\epsilon})}{\eta_{LVE}^+(t)} = \frac{\eta_E^+(t, \dot{\epsilon})}{3\eta^+(t)}$$

wherein

$\eta_E^+(t, \dot{\epsilon})$ is the uniaxial extensional viscosity; and

$\eta_{LVE}^+(t)$, the Linear Viscoelastic Envelope (LVE), is three times the time dependent shear viscosity $\eta^+(t)$ in the linear range of deformation. The determination of the

Linear Viscoelastic Envelope in extension, $\eta_{LVE}^+(t)$, is based on IRIS Rheo Hub 2008 requiring the calculation of the discrete relaxation time spectrum from the storage and loss modulus data (G' , $G''(\omega)$). Details about the method can be found in the experimental part. The strain hardening factor mainly reflects the degree of “dispersion” (heterogeneity) of the branches relative to the polymer backbone.

Secondarily the strain hardening factor also provides information about the branching degree.

The recycled LDPE (B1) according to the present invention preferably has a strain hardening factor (SHF) of 1.5 to 5.0, preferably 1.8 to 4.5 when measured at a strain rate of 3.0 s^{-1} and a Hencky strain of 2.5.

Moreover, the recycled LDPE (B1) according to the present invention preferably has a strain hardening factor (SHF) of 3.6 to 8.0, preferably of 3.7 to 7.5, more preferably of 3.8 to 7.0, and most preferably 3.9 to 6.5 when measured at a strain rate of 1.0 s^{-1} and a Hencky strain of 2.0.

It should be understood that the preferred strain hardening factors (SHF) as

mentioned above can be present individually but also can be present in combination.

It has surprisingly been found that a recycled LDPE having a strain hardening factor in the claimed range is especially suitable for the objective of the present invention, namely to provide to provide a multilayer collation shrink film allowing the use of

bigger amounts of recycled LDPE with low or no hole formation and showing a beneficial balance of properties of very good mechanical properties without increasing the film thickness together with good optical properties, a good shrink behaviour and good puncture resistance and good sealing properties.

5

Recycled LDPE's meeting the requirements of the recycled LDPE (B1) as described above or below are known and can be bought from suppliers such as Suzhou Jinhui Technology or Plaspulp.

10 Linear copolymer of ethylene (B2)

The linear copolymer of ethylene (B2) is a copolymer of ethylene and at least one comonomer selected from alpha-olefins having from 4 to 10 carbon atoms.

The at least one comonomer is preferably selected from 1-butene, 1-hexene or 1-octene, more preferably from 1-butene or 1-hexene.

15 The linear copolymer of ethylene (B2) can comprise one or more, such as from one to five, preferably one, two or three, more preferably one or two different comonomer(s) selected from alpha-olefins having from 4 to 10 carbon atoms. "Different" in this context means that the alpha-olefins differ in their amount of carbon atoms.

20 It is preferred that the linear copolymer of ethylene (B2) is a copolymer of ethylene with one comonomer selected from alpha-olefins having from 4 to 10 carbon atoms. The term 'a copolymer of ethylene with one comonomer selected from alpha-olefins having from 4 to 10 carbon atoms' indicates that the copolymer of ethylene (B2) contains only units derivable from ethylene and one comonomer selected from alpha-
25 olefins having from 4 to 10 carbon atoms, preferably from 1-butene, 1-hexene or 1-octene, more preferably from 1-butene or 1-hexene.

The linear copolymer of ethylene (B2) preferably has a total comonomer content of from 0.1 to 15.0 wt.-%, more preferably from 0.15 to 12.5 wt.-%, still more
30 preferably from 0.2 to 10.0 wt.-%.

In one embodiment the linear copolymer of ethylene (B2) is a copolymer of ethylene and 1-butene comonomer units, wherein the 1-butene comonomer units are the only comonomer units present in the linear copolymer of ethylene (B2). In said
5 embodiment the the linear copolymer of ethylene (B2) preferably has a 1-butene content of from 0.1 to 10.0 wt.-%, more preferably from 0.15 to 9.0 wt.-%, still more preferably from 0.2 to 8.0 wt.-%, based on the total weight of the linear copolymer of ethylene (B2).

10 In one embodiment the linear copolymer of ethylene (B2) is a copolymer of ethylene and 1-hexene comonomer units, wherein the 1-hexene comonomer units are the only comonomer units present in the linear copolymer of ethylene (B2). In said embodiment, the linear copolymer of ethylene (B2) preferably has a 1-hexene content of from 0.1 to 15.0 wt.-%, more preferably from 0.15 to 12.5 wt.-%, still
15 more preferably from 0.2 to 10.0 wt.-%, based on the total weight of the linear copolymer of ethylene (B2).

The linear copolymer of ethylene (B2) can be unimodal in regard to the comonomer distribution. This means that the comonomer selected from alpha-olefins having from
20 4 to 10 carbon atoms, such as 1-butene or 1-hexene are uniformly distributed in the copolymer of ethylene (B2).

The linear copolymer of ethylene (B2) can be multimodal in regard to the comonomer distribution.

25 This means that the linear copolymer of ethylene (B2) comprises components with different comonomer content.

The linear copolymer of ethylene (B2) in one embodiment can comprise an ethylene homopolymer component and a copolymer of ethylene and one comonomer selected from alpha-olefins having from 4 to 10 carbon atoms, such as 1-butene or 1-hexene,
30 component.

The linear copolymer of ethylene (B2) in another embodiment can comprise two copolymers of ethylene and one comonomer selected from alpha-olefins having from 4 to 10 carbon atoms, such as 1-butene or 1-hexene, components with different comonomer content.

5

“Linear” in this context means that the copolymer of ethylene (B2) does not comprise any long chain branches. Thus, the linear copolymer of ethylene (B2) is not a LDPE, which has been polymerized in a high pressure process by radical polymerization as known in the art. Instead the linear copolymer of ethylene (B2) is usually produced in a low pressure process in the presence of a polymerization catalyst.

10

The linear copolymer of ethylene (B2) has a weight average molecular weight M_w of from 150 to 400 kg/mol, preferably from 160 to 350 kg/mol.

15

Further, the linear copolymer of ethylene (B2) preferably has a number average molecular weight M_n of from 8 to 12 kg/mol, most preferably from 8.5 to 11 kg/mol.

The linear copolymer of ethylene (B2) has a polydispersity index, being the ratio of M_w/M_n , of from 15 to 35, preferably from 17 to 32.

20

It is preferred that the linear copolymer of ethylene (B2) is multimodal, more preferably bimodal.

In view of its rather broad molecular weight distribution as indicated in the polydispersity index the linear copolymer of ethylene (B2) preferably is multimodal, more preferably bimodal with respect to molecular weight distribution.

25

The recycled LDPE (B1) has a higher melt flow rate MFR_2 than the linear copolymer of ethylene (B2).

The linear copolymer of ethylene (B2) preferably has a melt flow rate MFR_2 of from 0.10 to 0.50 g/10 min, more preferably of 0.10 to 0.40 g/10 min, most preferably of 0.12 to 0.30 g/10 min.

- 5 Further, the linear copolymer of ethylene (B2) preferably has a melt flow rate MFR_5 of 0.40 to 1.00 g/10 min, preferably of 0.45 to 0.90 g/10 min, most preferably of 0.50 to 0.80 g/10 min.

- 10 Still further, the linear copolymer of ethylene (B2) preferably has a melt flow rate MFR_{21} of 8.0 to 22.0 g/10 min, more preferably of 10.0 to 20.0 g/10 min, most preferably of 11.0 to 19.0 g/10 min.

- 15 Furthermore, the linear copolymer of ethylene (B2) preferably has a flow rate ratio $FRR_{21/2}$, being the ratio of MFR_{21}/MFR_2 , of from 60 to 150, preferably from 70 to 140, most preferably from 80 to 120.

- 20 Additionally, the linear copolymer of ethylene (B2) preferably has a flow rate ratio $FRR_{21/5}$, being the ratio of MFR_{21}/MFR_5 , of from 20 to 32, preferably from 22 to 30, most preferably from 23 to 28.

The recycled LDPE (B1) has a lower density than the linear copolymer of ethylene (B2).

- 25 The linear copolymer of ethylene (B2) preferably has a density of from 930 to 945 kg/m^3 , preferably of 932 to 942 kg/m^3 , most preferably of 933 to 940 kg/m^3 . Thus, the linear copolymer of ethylene (B2) usually qualifies as medium density copolymer of ethylene.

- 30 The linear copolymer of ethylene (B2) preferably has a melting temperature T_m of from 120 to 140°C, more preferably from 122 to 138°C, most preferably from 125 to

135°C, determined by differential scanning calorimetry (DSC) analysis according to ISO 11357 / part 3 / method C2 in a heat / cool /heat cycle with a scan rate of 10°C/min in the temperature range of 25 to +225°C.

- 5 It is preferred that the linear copolymer of ethylene (B2) has a strain hardening factor of less than 1.2, preferably less than 1.1, most preferably from 0.98 to 1.02 when measured at 180°C, at a strain rate of 3.0 s⁻¹ and a Hencky strain of 2.5.

10 It has surprisingly been found that by carefully selecting the linear copolymer of ethylene (B2) together with the recycled LDPE in core layer (B) the objective of the present invention can be met, namely to provide to provide a multilayer collation shrink film allowing the use of bigger amounts of recycled LDPE with low or no hole formation and showing a beneficial balance of properties of very good mechanical properties without increasing the film thickness together with good
15 optical properties, a good shrink behaviour and good puncture resistance and good sealing properties.

Linear copolymers of ethylene meeting the requirements of the copolymer of ethylene (B2) as described above or below are known and can be bought from
20 suppliers such as Borouge or Borealis. One suitable copolymer of ethylene is commercially available as Borstar® FB1350.

Inner surface layer (A)

Inner surface layer (A) preferably comprises a multimodal copolymer of ethylene
25 with at least one comonomer selected from alpha-olefins having from 4 to 10 carbon atoms (A1) and a LDPE (A2).

It is preferred that the multimodal copolymer of ethylene (A1) is present in the inner surface layer (A) in an amount of 15 to 90 wt%, preferably from 18 to 85 wt%, most

preferably from 20 to 82 wt%, based on the total weight amount of inner surface layer (A).

5 It is further preferred that the LDPE (A2) is present in the inner surface layer (A) in an amount of 10 to 85 wt%, preferably from 15 to 82 wt%, most preferably from 18 to 80 wt%, based on the total weight amount of inner surface layer (A).

The inner surface layer (A) can comprise additional polymeric components, which are different from the multimodal copolymer of ethylene (A1) and the LDPE (A2).
10 These additional polymeric components are preferably ethylene based polymers. The additional polymeric components, if present, are preferably present in an amount of up to 20 wt.-%, more preferably up to 10 wt.-%.

The composition forming the inner surface layer (A) can further comprise additives
15 and/or admixtures.

Additives are preferably selected from the group consisting of slip agents, UV-stabiliser, antioxidants, nucleating agents and mixtures thereof, preferably these additives are contained in an the range from 0 to 5000 ppm, preferably in the range from 10 to 5000 ppm and more preferably in the range from 500 to 3000 ppm based
20 on the overall weight of the inner surface layer (A).

Admixtures are preferably selected from the group consisting of pigments, fillers, antiblocking agents and mixtures thereof, preferably these additives are contained in an the range from 0 to 5 wt.-%, preferably in the range from 0 to 3 wt.-%, more preferably in the range from 0 to 2 wt.-% and most preferably from 0 to 1 wt.-%
25 based on the overall weight of the inner surface layer (A).

In a preferred embodiment the polymeric components of inner surface layer (A) consists of the multimodal copolymer of ethylene (A1) and the LDPE (A2).

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In said embodiment the weight ratio of the multimodal copolymer of ethylene (A1) and the LDPE (A2) (A1 : A2) is preferably in the range of from 15 : 85 to 90 : 10, more preferably from 18 : 82 to 85 : 15, most preferably from 20 : 80 to 82 : 18.

Further, in said embodiment, the multimodal copolymer of ethylene (A1), the LDPE (A2) and the optional additives and admixtures add up to 100 wt.-% of the total weight of the inner surface layer (A).

Outer Layer (C)

Outer layer (C) preferably comprises a multimodal copolymer of ethylene with at least one comonomer selected from alpha-olefins having from 4 to 10 carbon atoms (C1) and a LDPE (C2).

It is preferred that the multimodal copolymer of ethylene (C1) is present in the outer layer (C) in an amount of 15 to 90 wt%, preferably from 18 to 85 wt%, most preferably from 20 to 82 wt%, based on the total weight amount of the outer layer (C).

It is further preferred that the LDPE (C2) is present in the outer layer (C) in an amount of 10 to 85 wt%, preferably from 15 to 82 wt%, most preferably from 18 to 80 wt%, based on the total weight amount of the outer layer (C).

The outer layer (C) can comprise additional polymeric components which are different from the multimodal copolymer of ethylene (C1) and the LDPE (C2). These additional polymeric components are preferably ethylene based polymers. The additional polymeric components, if present, are preferably present in an amount of up to 20 wt.-%, more preferably up to 10 wt.-%.

The composition forming the outer layer (C) can further comprise additives and/or admixtures.

Additives are preferably selected from the group consisting of slip agents, UV-stabiliser, antioxidants, nucleating agents and mixtures thereof, preferably these additives are contained in an the range from 0 to 5000 ppm, preferably in the range from 10 to 5000 ppm and more preferably in the range from 500 to 3000 ppm based
5 on the overall weight of the outer layer (C).

Admixtures are preferably selected from the group consisting of pigments, fillers, antiblocking agents and mixtures thereof, preferably these additives are contained in an the range from 0 to 5 wt.-%, preferably in the range from 0 to 3 wt.-%, more preferably in the range from 0 to 2 wt.-% and most preferably from 0 to 1 wt.-%
10 based on the overall weight of the outer layer (C).

In a preferred embodiment the polymeric components of the outer layer (C) consists of the multimodal copolymer of ethylene (C1) and the LDPE (C2).

In said embodiment the weight ratio of the multimodal copolymer of ethylene (C1) and the LDPE (C2) (C1 : C2) is preferably in the range of from 15 : 85 to 90 : 10,
15 more preferably from 18 : 82 to 85 : 15, most preferably from 20 : 80 to 82 : 18.

Further, in said embodiment, the multimodal copolymer of ethylene (C1), the LDPE (C2) and the optional additives and admixtures add up to 100 wt.-% of the total weight of the outer layer (C).
20

In one embodiment the compositions of the inner surface layer (A) and the outer layer (C) can be different from each other.

In said embodiment at least one of the components (A1) and (C1) or (A2) and (C2) differ in at least one property.

25 It is, however, preferred that the properties of components (A1) and (C1) and the properties of components (A2) and (C2) are independently in the same range as defined below.

30 It is however preferred that the compositions of the inner surface layer (A) and the outer layer (C) are the same. This means that components (A1) and (C1) are the same

and components (A2) and (C2) are the same. Further, all components of the inner surface layer (A) and the outer layer (C) are present in the same amount.

Multimodal copolymer of ethylene (A1) and/or multimodal copolymer of ethylene

5 (C1)

The following properties preferably independently apply to components (A1) and (C1):

10 The multimodal copolymer of ethylene preferably is a copolymer of ethylene with at least one comonomer selected from alpha-olefins having from 4 to 10 carbon atoms. The at least one comonomer is preferably selected from 1-butene, 1-hexene and/or 1-octene, more preferably from 1-butene and/or 1-hexene.

15 In a preferred embodiment the multimodal copolymer of ethylene is a terpolymer of ethylene with two comonomers selected from alpha-olefins having from 4 to 10 carbon atoms.

The two comonomer is preferably selected from 1-butene, 1-hexene and 1-octene, more preferably from 1-butene and 1-hexene.

20 The term 'a terpolymer of ethylene with two comonomers selected from alpha-olefins having from 4 to 10 carbon atoms' indicates that the multimodal copolymer of ethylene (A1) contains only units derivable from ethylene and two comonomers selected from alpha-olefins having from 4 to 10 carbon atoms, preferably from 1-butene, 1-hexene and 1-octene, more preferably from 1-butene and 1-hexene.

25 The multimodal copolymer of ethylene preferably has a total comonomer content, i.e. the content of comonomer units derived from 1-butene and/or 1-hexene, of from 1.0 to 15.0 wt.-%, preferably from 1.5 to 12.5 wt.-%, still more preferably from 2.0 to 10.0 wt.-%.

In one embodiment multimodal copolymer of ethylene comprises 1-butene comonomer units. In said embodiment the multimodal copolymer of ethylene preferably has a 1-butene content of from 0.1 to 5.0 wt.-%, more preferably from 0.2 to 3.5 wt.-%, still more preferably from 0.3 to 2.0 wt.-%, based on the total weight of the multimodal copolymer of ethylene.

In one embodiment multimodal copolymer of ethylene comprises 1-hexene comonomer units. In said embodiment, the multimodal copolymer of ethylene preferably has a 1-hexene content of from 2.0 to 15.0 wt.-%, more preferably from 2.5 to 12.5 wt.-%, still more preferably from 3.0 to 10.0 wt.-%, based on the total weight of the multimodal copolymer of ethylene.

The multimodal copolymer of ethylene can be multimodal in regard to the comonomer distribution.

This means that the multimodal copolymer of ethylene comprises components with different comonomer content.

When being a copolymer of ethylene and one comonomer selected from alpha-olefins having from 4 to 10 carbon atoms, such as 1-butene or 1-hexene, the multimodal copolymer of ethylene in one embodiment can comprise an ethylene homopolymer component and a copolymer of ethylene and one comonomer selected from alpha-olefins having from 4 to 10 carbon atoms, such as 1-butene or 1-hexene, component.

When being a copolymer of ethylene and one comonomer selected from alpha-olefins having from 4 to 10 carbon atoms, such as 1-butene or 1-hexene, the multimodal copolymer of ethylene in another embodiment can comprise two copolymers of ethylene and one comonomer selected from alpha-olefins having from 4 to 10 carbon atoms, such as 1-butene or 1-hexene, components with different comonomer content.

When being a terpolymer of ethylene and two comonomers selected from alpha-olefins having from 4 to 10 carbon atoms, such as 1-butene and 1-hexene, the

multimodal copolymer of ethylene in one embodiment can comprise an ethylene homopolymer component, a copolymer of ethylene and one comonomer selected from alpha-olefins having from 4 to 10 carbon atoms, such as 1-butene, component and a copolymer of ethylene and another comonomer selected from alpha-olefins
5 having from 4 to 10 carbon atoms, such as 1-hexene, component.

When being a terpolymer of ethylene and two comonomers selected from alpha-olefins having from 4 to 10 carbon atoms, such as 1-butene and 1-hexene, the multimodal copolymer of ethylene in another embodiment can comprise an ethylene homopolymer component and a terpolymer of ethylene and two comonomers
10 selected from alpha-olefins having from 4 to 10 carbon atoms, such as 1-butene and 1-hexene, component.

When being a terpolymer of ethylene and two comonomers selected from alpha-olefins having from 4 to 10 carbon atoms, such as 1-butene and 1-hexene, the multimodal copolymer of ethylene in yet another embodiment can comprise a
15 copolymer of ethylene and one comonomer selected from alpha-olefins having from 4 to 10 carbon atoms, such as 1-butene, component and a copolymer of ethylene and another comonomer selected from alpha-olefins having from 4 to 10 carbon atoms, such as 1-hexene, component.

20 In a preferred embodiment, the multimodal copolymer of ethylene is a terpolymer of ethylene with two comonomers selected from 1-butene and 1-hexene having a 1-butene content of from 0.1 to 5.0 wt.-%, preferably from 0.2 to 3.5 wt.-%, still more preferably from 0.3 to 2.0 wt.-% and a 1-hexene content of from 2.0 to 14.9 wt.-%, more preferably from 2.5 to 12.3 wt.-%, still more preferably from 3.0 to 9.7 wt.-%,
25 based on the total weight of the multimodal copolymer of ethylene.

The multimodal copolymer of ethylene preferably has a density of 920 to 940 kg/m³, more preferably of 922 to 937 kg/m³, most preferably of 925 to 935 kg/m³.

The multimodal copolymer of ethylene preferably is a linear low density
30 polyethylene (LLDPE).

The multimodal copolymer of ethylene preferably has a melt flow rate MFR₂ of 0.5 to 2.0 g/10 min, more preferably 0.7 to 1.8 g/10 min, most preferably 1.0 to 1.6 g/10 min.

5

The multimodal copolymer of ethylene preferably has a melting temperature T_m of from 115 to 135°C, more preferably from 118 to 130°C, most preferably from 120 to 128 °C, determined by differential scanning calorimetry (DSC) analysis according to ISO 11357 / part 3 / method C2 in a heat / cool /heat cycle with a scan rate of

10 10°C/min in the temperature range of 25 to +225°C.

Further, the multimodal copolymer of ethylene preferably has a ratio of weight average molecular weight to number average molecular weight Mw/Mn of from 2.0 to 6.0, preferably from 2.5 to 5.5, more preferably from 3.0 to 5.0, determined by Gel
15 Permeation Chromatography (GPC) according to ISO 16014-4:2003 and ASTM D 6474-12.

The multimodal copolymer of ethylene is preferably obtainable by polymerization in the presence of a single site catalyst system. The single site catalyst system
20 preferably comprises catalytically active metallocene compound or complex combined with a cocatalyst. The metallocene compound or complex is referred herein also as organometallic compound (C).

The organometallic compound (C) comprises a transition metal (M) of Group 3 to 10
25 of the Periodic Table (IUPAC 2007) or of an actinide or lanthanide.

The term "an organometallic compound (C)" in accordance with the present invention includes any metallocene compound of a transition metal which bears at least one organic (coordination) ligand and exhibits the catalytic activity alone or
30 together with a cocatalyst. The transition metal compounds are well known in the art

and preferably covers compounds of metals from Group 3 to 10, e.g. Group 3 to 7, or 3 to 6, such as Group 4 to 6 of the Periodic Table, (IUPAC 2007), as well lanthanides or actinides.

5 In an embodiment the organometallic compound (C) has the following formula (I):



wherein

“M” is a transition metal (M) transition metal (M) of Group 3 to 10 of the Periodic Table (IUPAC 2007),

10 each “X” is independently a monoanionic ligand, such as a o -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,

15 “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).

“M” is preferably selected from the group consisting of zirconium (Zr), hafnium
20 (Hf), or titanium (Ti), more preferably selected from the group consisting of zirconium (Zr) and hafnium (Hf).

“X” is preferably a halogen, most preferably Cl.

Most preferably the organometallic compound (C) is a metallocene complex which
25 comprises a transition metal compound, as defined above, which contains a cyclopentadienyl, indenyl or fluorenyl ligand as the substituent “L”. Further, the ligands “L” may have substituents, such as alkyl groups, aryl groups, arylalkyl groups, alkylaryl groups, silyl groups, siloxy groups, alkoxy groups or other heteroatom groups or the like. Suitable metallocene catalysts are known in the art
30 and are disclosed, among others, in WO-A-95/12622, WO-A-96/32423, WO-A-

97/28170, WO-A-98/32776, WO-A-99/61489, WO-A-03/010208, WO-A-03/051934, WO-A-03/051514, WO-A-2004/085499, EP-A-1752462 and EP-A-1739103.

- 5 Most preferred the metallocene catalyst, which means the catalytically active metallocene complex, as defined above, is used together With a cocatalyst, which is also known as an activator. Suitable activators are metal alkyl compounds and especially aluminium alkyl compounds known in the art. Especially suitable activators used with metallocene catalysts are alkylaluminium oxy-compounds, such as methylaluminumoxane (MAO), tetraisobutylalumoxane (TIBAO) or
10 hexaisobutylalumoxane (HIBAO).

The multimodal copolymer of ethylene may be produced in any suitable polymerization process known in the art, which comprise at least one polymerization
15 stage, where polymerization is typically carried out in solution, slurry, bulk or gas phase. Preferably the multimodal copolymer of ethylene is produced in a multistage polymerization process comprising at least two polymerization zones.

A first ethylene polymer component is preferably produced in a first polymerization zone and a second ethylene polymer component is preferably produced in a second
20 polymerization zone. The first polymerization zone and the second polymerization zone may be connected in any order, i.e. the first polymerization zone may precede the second polymerization zone, or the second polymerization zone may precede the first polymerization zone or, alternatively, polymerization zones may be connected in parallel. However, it is preferred to operate the polymerization zones in cascaded
25 mode. The polymerization zones may operate in slurry, solution, or gas phase conditions or their combinations.

Suitable processes comprising cascaded slurry and gas phase polymerization stages are disclosed, among others, in WO-A-92/12182 and WO-A-96/18662.

It is often preferred to remove the reactants of the preceding polymerization stage from the polymer before introducing it into the subsequent polymerization stage. This is preferably done when transferring the polymer from one polymerization stage to another.

5

The catalyst may be transferred into the polymerization zone by any means known in the art. For example, it is possible to suspend the catalyst in a diluent and maintain it as homogeneous slurry, to mix the catalyst with a viscous mixture of grease and oil and feed the resultant paste into the polymerization zone or to let the catalyst settle and introduce portions of thus obtained catalyst mud into the polymerization zone.

10

The polymerization in the first polymerization zone is preferably conducted in slurry. Then the polymer particles formed in the polymerization, together with the catalyst fragmented and dispersed within the particles, are suspended in the fluid hydrocarbon. The slurry is agitated to enable the transfer of reactants from the fluid into the particles.

15

The polymerization usually takes place in an inert diluent, typically a hydrocarbon diluent such as methane, ethane, propane, n-butane, isobutane, pentanes, hexanes, heptanes, octanes etc., or their mixtures. Preferably the diluent is a low-boiling hydrocarbon having from 1 to 4 carbon atoms or a mixture of such hydrocarbons and preferred diluent is propane.

20

The ethylene content in the fluid phase of the slurry may be from 2 to about 50 % by mol, preferably from about 2 to about 20 % by mol and in particular from about 3 to about 12 % by mol.

25

The temperature in the slurry polymerization is typically from 50 to 115°C, preferably from 60 to 110°C and in particular from 70 to 100°C. The pressure is from 1 to 150 bar, preferably from 10 to 100 bar.

The slurry polymerization may be conducted in any known reactor used for slurry polymerization.

30

Such reactors include a continuous stirred tank reactor and a loop reactor. It is especially preferred to conduct the polymerization in loop reactor. In such reactors

the slurry is circulated with a high velocity along a closed pipe by using a circulation pump. Loop reactors are generally known in the art and examples are given, for instance, in US-A-4582816, US-A-3405109, US-A-3324093, EP-A-479186 and US-A-5391654.

- 5 It is sometimes advantageous to conduct the slurry polymerization above the critical temperature and pressure of the fluid mixture. Such operation is described in US-A-5391654. In such operation the temperature is typically from 80 to 110°C, preferably from 85 to 105°C and the pressure is from 30 to 150 bar, preferably from 50 to 100 bar.
- 10 The slurry may be withdrawn from the reactor either continuously or intermittently. A preferred way of intermittent withdrawal is the use of settling legs where slurry is allowed to concentrate before withdrawing a batch of the concentrated slurry from the reactor. The continuous withdrawal is advantageously combined with a suitable concentration method, e.g. as disclosed in EP-A-1310295 and EP-A-1591460.
- 15 Hydrogen may be fed into the reactor to control the molecular weight of the polymer as known in the art. Furthermore, one or more comonomers selected from alpha-olefins having from 4 to 10 carbon atoms, such as 1-butene and/or 1-hexene, can be added into the reactor e.g. to control the density of the polymer product. The actual amount of such hydrogen and comonomer feeds depends on the catalyst that is used
- 20 and the desired melt index (or molecular weight) and density (or comonomer content) of the resulting polymer.

- The polymerization in the second polymerization zone is preferably conducted in gas phase, preferably in a fluidized bed reactor, in a fast fluidized bed reactor or in a
- 25 settled bed reactor or in any combination of these. The polymerization in the second polymerization zone is more preferably conducted in a fluidized bed gas phase reactor, wherein ethylene is polymerized together with one or more comonomers selected from alpha-olefins having from 4 to 10 carbon atoms, such as 1-butene and/or 1-hexene, in the presence of a polymerization catalyst and, preferably in the
- 30 presence of the reaction mixture from the first polymerization zone in an upwards

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moving gas stream. The reactor typically contains a fluidized bed comprising the growing polymer particles containing the active catalyst located above a fluidization grid.

5 The polymer bed is fluidized with the help of the fluidization gas comprising the olefin monomer, eventual comonomer(s), eventual chain growth controllers or chain transfer agents, such as hydrogen, and eventual inert gas. The fluidization gas is introduced into an inlet chamber at the bottom of the reactor. One or more of the above-mentioned components may be continuously added into the fluidization gas to compensate for losses caused, amongst others, by reaction or product withdrawal.

10 The fluidization gas passes through the fluidized bed. The superficial velocity of the fluidization gas must be higher than minimum fluidization velocity of the particles contained in the fluidized bed, as otherwise no fluidization would occur. On the other hand, the velocity of the gas should be lower than the onset velocity of pneumatic transport, as otherwise the whole bed would be entrained with the fluidization gas.

15 When the fluidization gas is contacted with the bed containing the active catalyst the reactive components of the gas, such as monomers and chain transfer agents, react in the presence of the catalyst to produce the polymer product. At the same time the gas is heated by the reaction heat.

The unreacted fluidization gas is removed from the top of the reactor and cooled in a
20 heat exchanger to remove the heat of reaction. The gas is cooled to a temperature which is lower than that of the bed to prevent the bed from heating because of the reaction. It is possible to cool the gas to a temperature where a part of it condenses. When the liquid droplets enter the reaction zone they are vaporised.

The vaporisation heat then contributes to the removal of the reaction heat. This kind
25 of operation is called condensed mode and variations of it are disclosed, among others, in WO-A-2007/025640, USA-4543399, EP-A-699213 and WO-A-94/25495. It is also possible to add condensing agents into the recycle gas stream, as disclosed in EP-A-696293. The condensing agents are non-polymerizable components, such as n-pentane, isopentane, n-butane or isobutane, which are at least partially condensed
30 in the cooler.

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The gas is then compressed and recycled into the inlet chamber of the reactor. Prior to the entry into the reactor fresh reactants are introduced into the fluidization gas stream to compensate for the losses caused by the reaction and product withdrawal. It is generally known to analyze the composition of the fluidization gas and introduce
5 the gas components to keep the composition constant. The actual composition is determined by the desired properties of the product and the catalyst used in the polymerization.

The catalyst may be introduced into the reactor in various ways, either continuously
10 or intermittently. Where the gas phase reactor is a part of a reactor cascade the catalyst is usually dispersed within the polymer particles from the preceding polymerization stage. The polymer particles may be introduced into the gas phase reactor as disclosed in EP-A-1415999 and WO-A-00/26258. Especially if the preceding reactor is a slurry reactor it is advantageous to feed the slurry directly into
15 the fluidized bed of the gas phase reactor as disclosed in EP-A-887379, EP-A-887380, EP-A-887381 and EP-A-991684.

The polymeric product may be withdrawn from the gas phase reactor either continuously or intermittently. Combinations of these methods may also be used.
20 Continuous withdrawal is disclosed, among others, in WO-A-00/29452. Intermittent withdrawal is disclosed, among others, in US-A-4621952, EP-A-188125, EP-A-250169 and EP-A-579426.

Also antistatic agent(s), such as water, ketones, aldehydes and alcohols, may be introduced into the gas phase reactor if needed. The reactor may also include a
25 mechanical agitator to further facilitate mixing within the fluidized bed.

Typically the fluidized bed polymerization reactor is operated at a temperature within the range of from 50 to 100°C, preferably from 65 to 90°C. The pressure is suitably from 10 to 40 bar, preferably from 15 to 30 bar.

The polymerization of the first ethylene polymer component and second ethylene polymer component in the first and second polymerization zones may be preceded by a prepolymerization step. The purpose of the prepolymerization is to polymerize a small amount of polymer onto the catalyst at a low temperature and/or a low monomer concentration. By prepolymerization it is possible to improve the performance of the catalyst in slurry and/or modify the properties of the final polymer.

The prepolymerization step may be conducted in slurry or in gas phase. Preferably prepolymerization is conducted in slurry, preferably in a loop reactor. The prepolymerization is then preferably conducted in an inert diluent, preferably the diluent is a low-boiling hydrocarbon having from 1 to 4 carbon atoms or a mixture of such hydrocarbons.

The temperature in the prepolymerization step is typically from 0 to 90°C, preferably from 20 to 80°C and more preferably from 25 to 70°C.

The pressure is not critical and is typically from 1 to 150 bar, preferably from 10 to 100 bar.

The catalyst components are preferably all introduced to the prepolymerization step. Preferably the reaction product of the prepolymerization step is then introduced to the first polymerization zone.

The multimodal copolymer of ethylene obtained from the multistage process can be is extruded and pelletized and then blended with the LDPE (A2) or LDPE (C2) in pellet form.

The multimodal copolymer of ethylene obtained from the multistage process can also be blended with the LDPE (A2) or LDPE (C2) in powder form.

The multimodal copolymer of ethylene is preferably a virgin polymer.

- 30 -

LDPE (A2) and LDPE (C2)

The following properties preferably independently apply to components (A2) and (C2):

- 5 Preferably the LDPE has a density of from 915 to 935 kg/m³, preferably of 917 to 932 kg/m³, most preferably of 920 to 930 kg/m³.

It is further preferred that the LDPE has a melt flow rate MFR₂ of 0.1 to 2.0 g/10 min, preferably of 0.2 to 1.5 g/10 min, most preferably of 0.3 to 1.2 g/10 min.

10

The LDPE preferably comprises virgin LDPE, recycled LDPE or mixtures of virgin LDPE and recycled LDPE.

In a first embodiment, the LDPE consists of virgin LDPE.

In a second embodiment, the LDPE consists of recycled LDPE.

- 15 In a third embodiment, the LDPE consists of a mixture of virgin LDPE and recycled LDPE.

In said third embodiment the weight ratio of virgin LDPE to recycled LDPE in the mixture is preferably in the range of 5:1 to 1:2, more preferably of 4:1 to 1:1, most preferably from 3:1 to 2:1.

20

Virgin LDPE is preferably an ethylene homopolymer.

Recycled LDPEs preferably are the same as described above for recycled LDPE (B1).

25

Virgin LDPEs meeting the requirements of the LDPE as described above or below are known and can be bought from suppliers such as Borouge or Borealis.

Recycled LDPEs meeting the requirements of the LDPE as described above or below are known and can be bought from suppliers such as Suzhou Jinhui Technology or

30

Plaspulp.

Collation shrink film

The multilayer collation shrink film of the present invention comprises the inner surface layer (A), the core layer (B) and the outer layer (C). Thereby, core layer (B) is sandwiched between inner surface layer (A) and outer layer (C).

- 5 It is preferred that the multilayer collation shrink film comprises up to seven layers, preferably up to five layers, most preferably consists of three layers.

Preferably, the film further comprises additional layers such as a sub-inner surface layer (I1) and/or a sub-outer surface layer (O1), wherein the sub-inner surface layer (I1) is present between the inner surface layer (A) and the core layer (B), and the
10 sub-outer surface layer (O1) is present between the outer surface layer (C) and the core layer (B). Optionally, the film comprises more than one of any of the layers O1, B, I1, A or C for five layer film or seven layer films

For 3-layer films, it is preferred that inner surface layer (A) is in adherent contact with one surface of the core layer (B).

- 15 It is further preferred that the outer layer (C) is in adherent contact with the other surface of the core layer (B).

It is especially preferred that inner surface layer (A) and outer layer (C) are in adherent contact with each surface of core layer (B).

“In adherent contact” in this context means that there is no additional layer between
20 the core layer (B) and the inner surface layer (A) and/or the core layer (B) and the outer layer (C).

It is preferred that the inner surface layer (A) and the outer layer (C) consist of identical components and are most preferably the same.

In this context “being the same” means that the inner surface layer (A) and the outer
25 layer (C) consist not only of the same components (amount and chemical composition), but also have the same layer thickness, so that the multilayer film is symmetric.

The inner surface layer (A) of the multilayer collation shrink film preferably has a thickness in the range from 2 to 25 μm , more preferably from 3 to 23 μm and most preferably from 5 to 20 μm .

- 5 The core layer (B) of the multilayer collation shrink film preferably has a thickness in the range from 10 to 100 μm , more preferably from 15 to 80 μm and most preferably from 20 to 60 μm .

10 The outer layer (C) of the multilayer collation shrink film preferably has a thickness in the range from 2 to 25 μm , more preferably from 3 to 23 μm and most preferably from 5 to 20 μm .

15 The overall film thickness of the multilayer collation shrink film is preferably in the range from 15 to 100 μm , more preferably from 20 to 90 μm and most preferably from 25 to 80 μm .

20 The thickness of the core layer (B) in the multilayer collation shrink film is preferably in the range of from 40 to 70 %, more preferably from 44 to 66 %, most preferably from 48 to 62 %, based on the total thickness of the multilayer collation shrink film.

25 The thickness of the inner surface layer (A) in the multilayer collation shrink film is preferably in the range of from 10 to 30 %, more preferably from 15 to 28 %, most preferably from 19 to 26 %, based on the total thickness of the multilayer collation shrink film.

30 The thickness of the outer layer (C) in the multilayer collation shrink film is preferably in the range of from 10 to 30 %, more preferably from 15 to 28 %, most preferably from 19 to 26 %, based on the total thickness of the multilayer collation shrink film.

The total amount of recycled LDPE in the multilayer collation shrink film is preferably from 25 to 55 wt%, preferably from 27 to 53 wt%, most preferably from 30 to 50 wt%, based on the total weight of the multilayer collation shrink film.

- 5 The recycled LDPE is present in the core layer (B) and can also be present in the inner surface layer (A) and/or the outer layer (C) as described above and below.

The multilayer collation shrink film preferably has one or more or all of the following properties:

- 10
- a shrinkage in machine direction of from 60 to 85%, preferably from 65 to 82%, most preferably from 70 to 80%; and/or
 - a shrinkage in transverse direction of from 5 to 25%, preferably from 7 to 22%, most preferably from 9 to 20%; and/or
 - a haze of from 5.0 to 19.0%, preferably from 7.0 to 18.0%, most preferably from 8.0 to 17.0%; and/or
 - a gloss at 60° of from 70 to 130, preferably from 73 to 120, most preferably from 75 to 110; and/or
 - a tensile modulus in machine direction of from 225 to 600 MPa, preferably from 240 to 550 MPa, most preferably from 250 to 500 MPa; and/or
 - a tensile modulus in transverse direction of from 250 to 650 MPa, preferably from 265 to 600 MPa, most preferably from 275 to 550 MPa; and/or
 - a tensile stress at break in machine direction of from 12.0 to 40.0 MPa, preferably from 13.0 to 38.0 MPa, most preferably from 14.0 to 36.0 MPa; and/or
 - a tensile stress at break in transverse direction of from 15.0 to 40.0 MPa, preferably from 18.0 to 36.0 MPa, most preferably from 20.0 to 32.0 MPa; and/or
 - a puncture energy of from 0.8 to 3.0 J, preferably from 0.9 to 2.5 J, most preferably from 1.0 to 2.0 J; and/or
- 15
- 20
- 25

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- a sealing initiation temperature of from 100 to 125°C, preferably from 103 to 120°C, most preferably from 105 to 115°C.

Method for manufacturing the multilayer collation shrink film

5 The present invention further relates to a method for manufacturing the multilayer collation shrink film according to the present invention. According to one preferred embodiment the multilayer collation shrink film is manufactured by a one-step blown film coextrusion process.

10 Use of the multilayer collation shrink film

The multilayer collation shrink film according to the present invention can be used for secondary packaging, preferably for bottles and cans more preferably bottles and cans in the field of household products, food, healthcare products, beverage products and bottles.

15

The invention will now be described with reference to the following non-limiting examples.

Examples

20 1. **Determination methods**

Melt flow rate

The melt flow rate (MFR) is determined according to ISO 1133 and is indicated in g/10 min. The MFR is an indication of the flowability, and hence the processability, of the polymer. The higher the melt flow rate, the lower the viscosity of the polymer.

25 The MFR₂ of polyethylene at a temperature of 190 °C and a load of 2.16 kg.

The MFR₅ of polyethylene at a temperature of 190 °C and a load of 5 kg.

The MFR₂₁ of polyethylene at a temperature of 190 °C and a load of 21.6 kg.

30 The MFR₂ of the high molecular weight ethylene polymer component polymerized in the second polymerization reactor is calculated from the MFR₂ of the low molecular

- 35 -

weight ethylene polymer component polymerized in the first polymerization reactor and the MFR₂ of the base resin as follows:

$$\text{LogMFR}_{\text{final}} = \text{wt}\%_{\text{1st}} \times \text{LogMFR}_{\text{1st}} + \text{wt}\%_{\text{2nd}} \times \text{LogMFR}_{\text{2nd}}$$

wherein

- 5 - “final” means “of the polyethylene resin”
- “1st” means “of the polymer component produced in the first reactor
- “2nd” means “of the polymer component produced in the second reactor.

The flow rate ratio FRR_{21/2}, is calculated as the ratio of MFR₂₁/MFR₂ and the flow
10 rate ratio FRR_{21/5}, is calculated as the ratio of MFR₂₁/MFR₅

Density

Density of the polymer was measured according to ISO 1183-1:2004 Method A on
compression moulded specimen prepared according to EN ISO 1872-2 (Feb 2007)
15 and is given in kg/m³.

Comonomer content

¹³C-NMR spectra were recorded on Bruker 400 MHz spectrometer at 130 °C from
samples dissolved in 1, 2, 4-trichlorobenzene/benzene-d₆ (90/10 w/w). Conversion
20 between %wt and %mol can be carried out by calculation.

DSC Analysis

Melting temperature T_m and Crystallization temperature T_c were measured
with a TA Instrument Q2000 differential scanning calorimetry (DSC) on 5 to 7 mg
25 samples. DSC is run according to ISO 11357 / part 3 /method C2 in a heat / cool /
heat cycle with a scan rate of 10 °C/min in the temperature range of 25 to +225°C.
Crystallization temperature was determined from the cooling step, while melting
temperature (T_m) and melting enthalpy (H_m) are determined from the second
heating step.

30

GPC**(1) GPC conventional method**

Unless otherwise indicated, the GPC conventional method is used for the measurement of ethylene polymers – except for LDPE.

- 5 Molecular weight averages (M_z , M_w and M_n), molecular weight distribution (MWD) and its broadness, described by polydispersity index, $PDI = M_w/M_n$ (wherein M_n is the number average molecular weight and M_w is the weight average molecular weight) were generally determined by Gel Permeation Chromatography (GPC) according to ISO 16014-4:2003 and ASTM D 6474-12 using the following formulas:

$$10 \quad M_n = \frac{\sum_{i=1}^N A_i}{\sum_{i=1}^N (A_i/M_i)} \quad (1)$$

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

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

- For a constant elution volume interval ΔV_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.
- 15 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
- 20 Olexis Guard columns) was used. As 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 column temperature of 160 °C and detector at 160 °C and at a constant flow rate of 1 mL/min. 200 μ L of sample solution was injected per analysis. Data collection was performed using either Agilent Cirrus
- 25 software version 3.3 or PolymerChar GPC-IR control software.

The column set was calibrated using 19 narrow MWD polystyrene (PS) standards in the range of from 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:

$$K_{PS} = 19 \times 10^{-3} \text{ mL/g}, \quad \alpha_{PS} = 0.655$$

$$K_{PE} = 39 \times 10^{-3} \text{ mL/g}, \quad \alpha_{PE} = 0.725$$

5 A third order polynomial fit was used to fit the calibration data.

All samples were prepared in the concentration range of around 1 mg/ml and dissolved at 160 °C for 3 (three) hours for PE in fresh distilled TCB stabilized with 250 ppm BHT (butylated hydroxytoluene) under continuous gentle shaking with N₂ gas purging.

10

(2) GPC viscosity method

Molecular weight averages (M_z , M_w and M_n), molecular weight distribution (MWD) of LDPE is measured by GPC-viscosity method using universal calibration.

15 Molecular weight averages (M_w , M_n), Molecular weight distribution (MWD) and its broadness, described by polydispersity index, $PDI = M_w/M_n$ (wherein M_n is the number average molecular weight and M_w is the weight average molecular weight) were determined by Gel Permeation Chromatography (GPC) according to ISO 16014-4 2019. A PL 220 (Polymer Laboratories) GPC equipped with an IR4 infrared detector, an online four capillary bridge viscometer (PL-BV 400-HT) was used. 3x
20 Olexis and 1x Olexis Guard columns from Polymer Laboratories as stationary phase and 1,2,4-trichlorobenzene (TCB, stabilized with 250 mg/L 2,6-Di tert butyl-4-methyl-phenol) as mobile phase at 160 °C and at a constant flow rate of 1 mL/min was applied. 200 μ L of sample solution were injected per analysis. The corresponding detector constant of the viscometer as well as the inter-detector delay
25 volumes were determined with a narrow PS standard (MWD = 1.01) with a molar mass of 132900 g/mol and an intrinsic viscosity of 0.4789 dl/g. The detector constant of the IR4 detector was determined using NIST1475a with dn/dc of 0.094 cm³/g. The column set was calibrated using universal calibration (according to ISO 16014-2:2019) with at least 15 narrow MWD polystyrene (PS) standards in the range of 0.5
30 kg/mol to 11600 kg/mol. The corresponded intrinsic viscosities of the PS standards

were calculated from their corresponding concentration (IR4), online viscometer signals, and determined detector constants for polystyrene. For low molecular weight PS with a molar mass below 3000 g/mol the initial weight out concentration is used, due to end group effects in the IR detector.

- 5 The molecular weight of the sample (M_2) at each chromatographic slice using the universal calibration approach can be calculated by following correlation:

$$\log M_1[\eta_1] = V_R = \log M_2[\eta_2]$$

with: M_1 Molar mass of PS

η_1 intrinsic viscosity of the PS

- 10 M_2 Molar mass of sample

η_2 intrinsic viscosity of sample

V_R Retention volume

All data processing and calculation was performed using the Cirrus Multi-Offline SEC-Software Version 3.2 (Polymer Laboratories a Varian inc. Company).

- 15 All samples were prepared by dissolving 5.0 – 9.0 mg of polymer in 8 mL (at 160 °C) of stabilized TCB (same as mobile phase) 3 hours for PE at max. 160 °C under continuous gentle shaking.

Tensile properties

- 20 Tensile properties of molded specimens were determined on samples prepared from compression-moulded plaques having a sample thickness of 4 mm. Tensile modulus was determined according to ISO 527-2/1 A at 1 mm/min and 23°C. To determine tensile stress at yield, a speed of 50 mm/min was used.
- 25 Tensile modulus of films in machine direction (MD) and Tensile modulus of films in transverse direction (TD) were measured as 1% secant modulus with 5mm/min test speed and 50mm gauge length according to ASTM D882. Tensile stress at break of films were measured according to ISO 527-3 specimen Type 2 with 50mm gauge length and 500 mm/min test speed.

Charpy notched impact strength

The Charpy notched impact strength was measured according to ISO 179 1eA at 23 °C and -20 °C, using molded bar test specimens of 80x10x4 mm³ prepared by compression molding in accordance with ISO 294-1 or ISO 17855-2 using a melt
5 temperature of 200°C.

Flexural modulus

The flexural modulus was determined in 3 -point-bending according to ISO 178 on molded specimens of 80 x 10 x 4 mm³ prepared by compression molding in
10 accordance with ISO 294-1 or ISO 17855-2 using a melt temperature of 200°C.

Strain hardening factor

The Strain hardening factor (SHF) was determined at 180°C.

15 The strain hardening factor is defined as

$$SHF = \frac{\eta_E^+(t, \dot{\epsilon})}{\eta_{LVE}^+(t)} = \frac{\eta_E^+(t, \dot{\epsilon})}{3\eta^+(t)}$$

wherein

$\eta_E^+(t, \dot{\epsilon})$ is the uniaxial extensional viscosity; and

20 $\eta_{LVE}^+(t)$, the Linear Viscoelastic Envelope (LVE), is three times the time dependent shear viscosity $\eta^+(t)$ in the linear range of deformation. The determination of the Linear Viscoelastic Envelope in extension, $\eta_{LVE}^+(t)$, is based on IRIS Rheo Hub 2008 requiring the calculation of the discrete relaxation time spectrum from the storage and loss modulus data (G' , $G''(\omega)$). The determination of the linear viscoelastic data
25 $G'(\omega)$, $G''(\omega)$ is obtained by frequency sweep measurements undertaken at 180°C, on a Anton Paar MCR 301 coupled with 25 mm parallel plates.

The underlying calculation principles used for the determination of the discrete relaxation spectrum are described in Baumgartel M. Winter H H, "Determination of

the discrete relaxation and retardation time spectra from dynamic mechanical data”, Rheol Acta 28:511519 (1989) which is incorporated by reference in its entirety. IRIS Rheo Hub 2008 expresses the relaxation time spectrum as a sum of N Maxwell modes

$$G(t) = G_e \cdot \sum_1^N g_i \cdot e^{-\frac{t}{\lambda_i}}$$

5

wherein g_i , and λ_i are material parameters and G_e is the equilibrium modulus.

The choice for the maximum number of modes, N used for determination of the discrete relaxation spectrum, is done by using the option “optimum” from IRIS RheoHub. The equilibrium modulus G_e was set at zero.

10 The non-linear fitting used to obtain $\eta_{LVE}^+(\mathbf{t})$ is performed on IRIS Rheo Hub 2008, using the Doi-Edwards model.

The uniaxial extensional viscosity $\eta_E^+(\mathbf{t}, \dot{\epsilon})$ is obtained from uniaxial extensional flow measurements, conducted on an Anton Paar MCR 501 coupled with the Sentmanat extensional fixture. The temperature for the uniaxial extensional flow

15 measurements was set at 180°C, applying extension rates $d\epsilon/dt$ ranging from 0.3 s⁻¹ to 10 s⁻¹, and covering a range of Hencky strain

$$\epsilon = (I - I_0)/I_0,$$

with I_0 , being the original and I the actual sample fixation length, from 0.3 to 3.0.

Particularly care was taken for the preparation of the samples for extensional flow.

20 The samples were prepared by compression moulding at 180°C followed by controlled cooling to room temperature (forced water or air cooling were not used). This procedure allowed obtaining well shaped samples free of residual stresses. The sample was left for some minutes at the testing temperature to ensure thermal stability (set temperature $\pm 0.1^\circ\text{C}$.), before carrying out the uniaxial extensional

25 measurements.

Film shrinkage

Determination of shrinkage was performed in oil according to ISO 14616 and/or ISO 11501.

60mm x 60mm film samples are placed in oil (Polydimethylsiloxan) at 160°C for 15
5 seconds. After this the samples are removed, and conditioned at room temperature for 1 hour. Finally the shrinkage, i.e. change in dimension is measured. Shrinkage values are calculated as:

$$\text{Shrinkage} = (L_o - L_m) * 100 / L_o$$

wherein L_o is the original length (i.e. 60 mm), and L_m is the length measured after
10 thermal exposure. If the measured value increases (e.g. in the TD direction), then shrinkage is negative.

Optical properties

Haze measured on three-layered collation shrink films, prepared as described in the
15 example section below according to ASTM D 1003.

Gloss is measured on three-layered collation shrink films, prepared as described in the example section below according to DIN 67530/ISO 2813 at an angle of 60°.

Gloss values are recorded and reported as gloss units (GU).

20 Puncture resistance

Protrusion Puncture Resistance testing is conducted according to ASTM D5748 on three-layered blown films with a thickness of 60 µm, prepared as described in the example section below. This test method determines the resistance of a film sample to the penetration of a probe with specific size of 19mm diameter pear-shaped TFE
25 fluorocarbon coated at a standard low rate, a single test velocity (250 mm/min).

Performed at standard conditions, the test method imparts a biaxial stress loading.

Cut the film specimens 150mmx150mm to fit into the jig and conditioning done at 23±2°C at 50±5% relative humidity.

The Puncture Resistance Energy (J) is the energy used until the probe breaks the test
30 specimen, both are measured using the high accuracy 500N loadcell and crosshead

position sensor.

Seal initiation temperature (SIT)

In principle, heat seal is formed by bonding two films (polymeric) in the way that
5 surfaces are pressed together into a close contact while being at least in partially
molten. This test method also covers the evaluation part after the heat seal process is
performed. The force required to separate a test strip of film containing the seal is
measured using UTM (also to identify the mode of specimen failure). Following the
ASTM F 2029; ASTM F 88 standard, a tested specimen with a preferred film
10 thickness of 30 microns where the sealed surfaces are selected. Samples should be
conditioned for at least 24hrs in the case of PE after sealing at $23\pm 2^{\circ}\text{C}$ and $50\pm 5\%$
relative humidity. For testing, a minimum of five specimens shall be used for each
seal temperature. The term “seal initiation temperature” (SIT) is specified as the
“heat seal initiation temperature at 5N” and it refers to the temperature at which a
15 seal is formed that will have a seal strength of 5N after cooling. The temperature at
which a heat seal forms immediately after the sealing operation (sealing time 1.0
seconds, sealing pressure 3 bar for less than 65 micron film and sealing time 1.5
seconds for 65 micron and above thickness), the strength of the heat seal being
measured at a specified time interval (at least 24 hrs after completion of the sealing
20 cycle and after the seal has cooled to ambient temperature and reached maximum
strength).

2. Materials used

- FB1350 bimodal ethylene/1-butene copolymer (MDPE) having a melt flow rate
25 MFR₂ of 0.15 g/10 min, MFR₅ of 0.60 g/10 min and a density of 935
kg/m³, commercially available from Borouge;
- FT5236 tubular LDPE having a melt flow rate MFR₂ of 0.75 g/10 min and a
density of 923 kg/m³, commercially available from Borouge; having slip
additives.

- FK2715 multimodal ethylene/1-butene/1-hexene terpolymer having a melt flow rate MFR₂ of 1.3 g/10 min and a density of 927 kg/m³, commercially available from Borouge;
- 3505MC Enable 3505MC; a metallocene catalyzed ethylene/1-hexene copolymer having a melt flow rate MFR₂ of 0.5 g/10 min and a density of 935 kg/m³, commercially available from ExxonMobil;
- 1327MD Exceed 1327MD; a metallocene catalyzed ethylene/1-hexene copolymer having a melt flow rate MFR₂ of 1.3 g/10 min and a density of 927 kg/m³, commercially available from ExxonMobil;
- 10 rLDPE1 PCR-LDPE(ML)-A; post-consumer waste LDPE (with a content of LDPE + LLDPE together >80 wt%) having a melt flow rate MFR₂ of 1.1 g/10 min and a density of 925 kg/m³, commercially available from Suzhou Jinhui Technology;

15 3. Properties of materials

rLDPE

The properties of rLDPE1 were measured on moulded specimen and are listed below in Table 1.

20 Table 1: Properties of rLDPE1

Properties	rLDPE1
Tensile modulus	309 MPa
Tensile stress at yield	10.6 MPa
Tensile strain at break	808 %
Flexural modulus	379 MPa
Charpy notched impact strength, 23°C	78.7 kJ/m ²
Charpy notched impact strength, -20°C	11.3 kJ/m ²

Strain hardening factor

The strain hardening factor (SHF) of rLDPE1, FT5236, FB1350, 3505MC and 1327MD was measured at 180°C, at a strain rate of 3.0 s⁻¹ and a Hencky strain of

2.5. The results of SHF are comparable for the grades having not much long chain-branching (all are less than 1.2 SHF when measured at 180°C, at a strain rate of 3.0 s⁻¹ and a Hencky strain of 2.5 as shown below in Table 2. The LDPE grades rLDPE1 and FT5236 show higher SHF due to long chain branching.

5

Table 2: Strain hardening factor

Material	SHF
rLDPE1	2.02
FT5236	2.90
FB1350	< 1.2
3505MC	< 1.2
1327MD	<1.2

Other properties:

Melt flow rates and GPC data from FK2715, FB1350, 3505MC and 1327MD were measured. The results are shown below in Table 3.

10

Table 3: Melt flow rates and GPC data

	FK2715	FB1350	3505MC	1327MD
MFR ₂ [g/10 min]	1.30	0.16	0.46	1.34
MFR ₅ [g/10 min]	3.40	0.67	1.79	3.26
MFR ₂₁ [g/10 min]	26	17	23.2	20.7
FRR _{21/2}	20	106	50	15.4
FRR _{21/5}	7.6	25.3	12.9	6.3
M _w [kg/mol]	107.7	224.3	103.4	105.5
M _n [kg/mol]	25.0	9.55	20.4	28.8
M _w /M _n	4.3	23.6	5.1	3.7

4. Collation shrink films

The films were produced on a commercial scale 3-layer extrusion blown film line (Polyrema) with three extruders (extruder temperature main zone setting 180 to 220°C, die diameter 180 mm, blow up ratio (BUR) 1:3, die gap 1.8 mm, with internal bubble cooling). The blown films made of polyethylene blends are described herein for each film layer. Any polyethylene blend used in the above described film layers can be produced by any suitable conventional multi-layer film extrusion line, preferably at a temperature of 150 to 230 °C, more preferably 160 to 225°C. Conventional blown film production techniques used in this regard, which in principle are known and available to the skilled person. Typically each film layers are coextruded at a temperature in the range of from 160 to 225 °C , die temperature in the range of 205 to 220 °C and cooled by blowing air at a temperature of 12 to 16 °C, to provide a frost line height of 1 to 2 times of the diameter of the die. Blown films were produced on a Polyrema (Reifenhauser blown film line with internal bubble cooling system) having an output of 150 kgs/hr.

The ABC films layer of comparative examples CE-1 and CE-2 and inventive examples IE-1 and IE-2 with a total thickness 60 to 70 µm were produced with a thickness distribution of the ABC films was 25%/50%/25%. The overall rLDPE content of the ABC films layer was about 37.5 wt%. Seal layer (C) is identical to inner surface layer (A) in thickness and composition. The compositions of the ABC films layers of the first approach are shown in Table 4 below.

Table 4: Collation shrink films (ABC film layers)

Samples	Inner surface Layer (A)	Core Layer (B)	Seal layer (C)
Thickness layer ratio	25%	50%	25%
CE-1	50 wt% FT5236 + 50 wt% 1327MD	75 wt% rLDPE1 + 25 wt% 3505MC	50 wt% FT5236 + 50 wt% 1327MD
CE-2	50 wt% FT5236 + 50 wt% 1327MD	75 wt% rLDPE1 + 25 wt% 1327MD	50 wt% FT5236 + 50 wt% 1327MD

IE-1	50 wt% FT5236 + 50 wt% FK2715	75 wt% rLDPE1 + 25 wt% FB1350	50 wt% FT5236 + 50 wt% FK2715
IE-2	60 wt% FT5236 + 40 wt% FK2715	75 wt% rLDPE1 + 25 wt% FB1350	60 wt% FT5236 + 40 wt% FK2715

The film shrinkage in transverse direction (TD) of films of examples IE-1, IE-2, CE-1 and CE-2 were measured and shown in Figure 1.

The films of IE-1 and IE-2 show a film shrinkage TD of 13 to 16%, whereas CE-1 and CE-2 show a film shrinkage TD of 9 to 11%.

All these film examples of IE-1, IE-2, CE-1 and CE-2 show a film shrinkage MD of 75 to 79%, which is comparable to each other.

The optical properties of examples IE-1, IE-2, CE-1 and CE-2 were measured and shown in Figure 2 (haze) and Figure 3 (gloss at 60°).

The films of IE-1 and IE-2 show a haze of 12.0 to 12.1%, whereas CE-1 and CE-2 show a haze of 17.7 to 19.7%.

The films of IE-1 and IE-2 show a gloss at 60° of 94 to 98GU, whereas CE-1 and CE-2 show a gloss at 60° of 86 to 90GU.

The tensile properties of examples IE-1, IE-2, CE-1 and CE-2 were measured and shown in Figure 4.

The films of IE-1 and IE-2 show a tensile modulus in machine direction (MD) of 274-295 MPa, whereas CE-1 and CE-2 show a tensile modulus in machine direction (MD) of 282-302 MPa.

The films of IE-1 and IE-2 show a tensile modulus in transverse direction (TD) of 289-311 MPa, whereas CE-1 and CE-2 show a tensile modulus in transverse direction (TD) of 309-355 MPa.

The films of IE-1 and IE-2 show a tensile stress at break in machine direction (MD) of 15.5 to 18.2 MPa, whereas CE-1 and CE-2 show a tensile stress at break in machine direction (MD) of 14.9 to 15.8 MPa.

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The films of IE-1 and IE-2 show a tensile stress at break in transverse direction (TD) of 22.8 to 23.1 MPa, whereas CE-1 and CE-2 show a tensile stress at break in transverse direction (TD) of 26.1 to 26.3 MPa.

- 5 The puncture energy and SIT of examples IE-1, IE-2, CE-1 and CE-2 were measured and shown in Figure 5.

The films of IE-1 and IE-2 show a puncture energy of 1.3 J, whereas CE-1 and CE-2 show a puncture energy of 0.9 to 1.2 J.

- The films of IE-1 and IE-2 show a SIT of 110.5 to 111.1°C, whereas CE-1 and CE-2
10 show a SIT of 110.0 to 110.6°C.

- The films according to the invention show an improved TD shrinkage, which is commonly acceptable in the market, comparable mechanical properties, and comparable SIT whereas the films according to the invention show improved haze
15 and comparable gloss and slightly increased puncture energy.

Thus, the films according to the invention show a good balance of properties of shrinkage, mechanical properties, puncture resistance, sealing properties and optical properties, which surprisingly is not impaired by the presence of recycled LDPE in amounts of up to 40 wt%.

20

Claims

1. A multilayer collation shrink film comprising an inner surface layer (A), a core layer (B) and an outer layer (C), wherein core layer (B) is sandwiched between inner surface layer (A) and outer layer (C) and core layer (B) comprises the following components:
 - (B1) a recycled LDPE having a strain hardening factor of from 1.5 to 5.0, preferably from 1.8 to 4.5, when measured at 180°C, at a strain rate of 3.0 s⁻¹ and a Hencky strain of 2.5; and
 - (B2) a linear copolymer of ethylene comprising at least one comonomer selected from alpha-olefins having from 4 to 10 carbon atoms and having a weight average molecular weight Mw of from 150 to 400 kg/mol, preferably from 160 to 350 kg/mol, and a polydispersity index, being the ratio of Mw/Mn, of from 15 to 35, preferably from 17 to 32, determined by Gel Permeation Chromatography (GPC) according to ISO 16014-4:2003 and ASTM D 6474-12, preferably being multimodal, more preferably being bimodal;wherein the recycled LDPE (B1) has a lower density and a higher melt flow rate MFR₂ than the linear copolymer of ethylene (B2), and the recycled LDPE (B1) is present in the core layer (B) in an amount of more than 50 wt%, such as from 55 to 95 wt%, preferably from 60 to 90 wt%, most preferably from 65 to 85 wt%, based on the total weight of the core layer (B).
2. The multilayer collation shrink film according to claim 1, wherein the linear copolymer of ethylene (B2) is present in the core layer (B) in an amount of less than 50 wt%, such as from 5 to 45 wt%, preferably from 10 to 40 wt%, more preferably from 15 to 35 wt%, based on the total weight of the core layer (B).
3. The multilayer collation shrink film according to claims 1 or 2, wherein the linear copolymer of ethylene (B2) is a copolymer of ethylene and 1-butene

comonomer units or a copolymer of ethylene and 1-hexene comonomer units, wherein the 1-butene comonomer units or the 1-hexene comonomer units are the only comonomer units present in the linear copolymer of ethylene (B2).

- 5 4. The multilayer collation shrink film according to any one of claims 1 to 3, wherein the linear copolymer of ethylene (B2) has one or more or all of the following properties:
- a density of from 930 to 945 kg/m³, preferably of 932 to 942 kg/m³, most preferably of 933 to 940 kg/m³, determined according to ISO 1183;
 - 10 • a melt flow rate MFR₂ of 0.10 to 0.50 g/10 min, preferably of 0.10 to 0.40 g/10 min, most preferably of 0.12 to 0.30 g/10 min, determined according to ISO 1133 at a temperature of 190°C and a load of 2.16 kg;
 - a melt flow rate MFR₅ of 0.40 to 1.00 g/10 min, preferably of 0.45 to 0.90 g/10 min, most preferably of 0.50 to 0.80 g/10 min, determined according to
15 ISO 1133 at a temperature of 190°C and a load of 5 kg;
 - a melt flow rate MFR₂₁ of 8.0 to 22.0 g/10 min, preferably of 10.0 to 20.0 g/10 min, most preferably of 11.0 to 19.0 g/10 min, determined according to ISO 1133 at a temperature of 190°C and a load of 21.6 kg;
 - a flow rate ratio FRR_{21/2}, being the ratio of MFR₂₁/MFR₂, of from 60 to 150,
20 preferably from 70 to 140, most preferably from 80 to 120;
 - a flow rate ratio FRR_{21/5}, being the ratio of MFR₂₁/MFR₅, of from 20 to 32, preferably from 22 to 30, most preferably from 23 to 28; and/or
 - a strain hardening factor of less than 1.2, preferably less than 1.1, most preferably from 0.98 to 1.02, when measured at 180°C, at a strain rate of 3.0
25 s⁻¹ and a Hencky strain of 2.5.
5. The multilayer collation shrink film according to any one of claims 1 to 4, wherein the recycled LDPE (B1) originates from post consumer waste or post industrial waste, preferably from post consumer waste.

- 50 -

6. The multilayer collation shrink film according to any one of claims 1 to 5, wherein the recycled LDPE (B1) has one or more or all of the following properties:
- 5 • a density of from 915 to 935 kg/m³, preferably of 917 to 932 kg/m³, most preferably of 920 to 930 kg/m³, determined according to ISO 1183;
 - a melt flow rate MFR₂ of 0.1 to 2.0 g/10 min, preferably of 0.3 to 1.7 g/10 min, most preferably of 0.5 to 1.5 g/10 min, determined according to ISO 1133 at a temperature of 190°C and a load of 2.16 kg;
 - 10 • a tensile modulus of from 200 to 450 MPa, preferably from 225 to 425 MPa, most preferably from 250 to 400 MPa, determined according to ISO 527-2/1 A;
 - a tensile stress at yield of from 6.0 to 15.0 MPa, preferably from 7.5 to 12.5 MPa, most preferably from 9.0 to 11.5 MPa, determined according to ISO 527-2/1 A;
 - 15 • a tensile strain at break of from 350 to 1200 %, preferably from 375 to 1100 %, most preferably from 400 to 1000 %, determined according to ISO 527-2/1 A;
 - a flexural modulus of from 200 to 500 MPa, preferably from 225 to 475 MPa, most preferably from 250 to 450 MPa, determined according to ISO 178;
 - 20 • a Charpy notched impact strength at 23°C of from 40 to 120 kJ/m², preferably from 45 to 110 kJ/m², most preferably from 50 to 100 kJ/m², determined according to ISO 179 1eA; and/or
 - 25 • a Charpy notched impact strength at -20°C of from 5.0 to 20.0 kJ/m², preferably from 6.0 to 18.0 kJ/m², most preferably from 7.0 to 16.0 kJ/m², determined according to ISO 179 1eA.

7. The multilayer collation shrink film according to any one of claims 1 to 6, wherein the both layers (A) and (C) are in adherent contact with each surface of core layer (B) and comprises up to seven layers, and preferably the multilayer film consists of the three layers (A), (B) and (C), preferably wherein the
- 5 thickness of core layer (B) in the multilayer collation shrink film is in the range of from 40 to 70 %, preferably from 44 to 66 %, most preferably from 48 to 62 %, and the thickness of layer (A) and layer (C) in the multilayer collation shrink film is independently in the range of from 10 to 30 %, preferably from 15 to 28 %, most preferably from 19 to 26 %, all based on the total thickness of the
- 10 multilayer collation shrink film.
8. The multilayer collation shrink film according to any one of claims 1 to 7, wherein layer (A) comprises the following components:
- (A1) a multimodal copolymer of ethylene with at least one comonomer selected
- 15 from alpha-olefins having from 4 to 10 carbon atoms, which multimodal polymer of ethylene has a density of 920 to 940 kg/m³, preferably of 922 to 937 kg/m³, most preferably of 925 to 935 kg/m³, determined according to ISO 1183, and a melt flow rate MFR₂ of 0.5 to 2.0 g/10 min, preferably 0.7 to 1.8 g/10 min, most preferably 1.0 to 1.6 g/10 min, determined
- 20 according to ISO 1133 at a temperature of 190°C and a load of 2.16 kg; and
- (A2) a LDPE; and
- layer (C) comprises the following components:
- (C1) a multimodal copolymer of ethylene with at least one comonomer selected
- 25 from alpha-olefins having from 4 to 10 carbon atoms, which multimodal polymer of ethylene has a density of 920 to 940 kg/m³, preferably of 922 to 937 kg/m³, most preferably of 925 to 935 kg/m³, determined according to ISO 1183, and a melt flow rate MFR₂ of 0.5 to 2.0 g/10 min, preferably 0.7 to 1.8 g/10 min, most preferably 1.0 to 1.6 g/10 min, determined

according to ISO 1133 at a temperature of 190°C and a load of 2.16 kg;
and

(C2) a LDPE.

- 5 9. The multilayer collation shrink film according to claim 8, wherein
the multimodal copolymer of ethylene (A1) is present in layer (A) in an amount
of 15 to 90 wt%, preferably from 18 to 85 wt%, most preferably from 20 to 82
wt% and
the LDPE (A2) is present in layer (A) in an amount of 10 to 85 wt%, preferably
10 from 15 to 82 wt%, most preferably from 18 to 80 wt%,
both based on the total weight amount of layer (A); and
the multimodal copolymer of ethylene (C1) is present in layer (C) in an amount
of 15 to 90 wt%, preferably from 18 to 85 wt%, most preferably from 20 to 82
wt% and
15 the LDPE (C2) is present in layer (C) in an amount of 10 to 85 wt%, preferably
from 15 to 82 wt%, most preferably from 18 to 80 wt%,
both based on the total weight amount of layer (C).
- 20 10. The multilayer collation shrink film according to claims 8 or 9, wherein the
LDPE (A2) and/or LDPE (C2) comprises virgin LDPE, recycled LDPE or
mixtures of virgin LDPE and recycled LDPE, wherein the weight ratio of virgin
LDPE to recycled LDPE in the mixture is preferably in the range of 5:1 to 1:2,
more preferably of 4:1 to 1:1, most preferably from 3:1 to 2:1, and/or the LDPE
(A2) and/or LDPE (C2) has a density of from 915 to 935 kg/m³, preferably of
25 917 to 932 kg/m³, most preferably of 920 to 930 kg/m³, determined according to
ISO 1183, and a melt flow rate MFR₂ of 0.1 to 2.0 g/10 min, preferably of 0.2 to
1.5 g/10 min, most preferably of 0.3 to 1.2 g/10 min, determined according to
ISO 1133 at a temperature of 190°C and a load of 2.16 kg.

11. The multilayer collation shrink film according to any one of claims 8 to 10, wherein the multimodal copolymer of ethylene (A1) and/or the multimodal copolymer of ethylene (C1) is a terpolymer of ethylene with two different comonomers selected from alpha-olefins having from 4 to 10 carbon atoms, preferably the multimodal copolymer of ethylene (A1) and/or the multimodal copolymer of ethylene (C1) is a terpolymer of ethylene, 1-butene comonomer units and 1-hexene comonomer units, wherein the 1-butene comonomer units and the 1-hexene comonomer units are the only comonomer units present in the multimodal copolymer of ethylene (A1) and/or the multimodal copolymer of ethylene (C1), more preferably the multimodal copolymer of ethylene (A1) and/or the multimodal copolymer of ethylene (C1) comprises a copolymer of ethylene and 1-butene comonomer units and a copolymer of ethylene and 1-hexene comonomer units.
12. The multilayer collation shrink film according to any one of claims 1 to 11 having one or more or all of the following properties:
- a shrinkage in machine direction of from 60 to 85%, preferably from 65 to 82%, most preferably from 70 to 80%, determined according to ISO 14616 and/or ISO 11501;
 - a shrinkage in transverse direction of from 5 to 25%, preferably from 7 to 22%, most preferably from 9 to 20%, determined according to ISO 14616 and/or ISO 11501;
 - a haze of from 5.0 to 19.0%, preferably from 7.0 to 18.0%, most preferably from 8.0 to 17.0%, determined according to ASTM D 1003;
 - a gloss at 60° of from 70 to 130, preferably from 73 to 120, most preferably from 75 to 110, determined according to DIN 67530/ISO 2813;
 - a tensile modulus in machine direction of from 225 to 600 MPa, preferably from 240 to 550 MPa, most preferably from 250 to 500 MPa, determined according to ASTM D 882;

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- a tensile modulus in transverse direction of from 250 to 650 MPa, preferably from 265 to 600 MPa, most preferably from 275 to 550 MPa, determined according to ASTM D 882;
 - a tensile stress at break in machine direction of from 12.0 to 40.0 MPa, preferably from 13.0 to 38.0 MPa, most preferably from 14.0 to 36.0 MPa, determined according to ISO 527-3;
 - a tensile stress at break in transverse direction of from 15.0 to 40.0 MPa, preferably from 18.0 to 36.0 MPa, most preferably from 20.0 to 32.0 MPa, determined according to ISO 527-3;
 - a puncture energy of from 0.8 to 3.0 J, preferably from 0.9 to 2.5 J, most preferably from 1.0 to 2.0 J, determined according to ASTM D 5748; and/or
 - a sealing initiation temperature of from 100 to 125°C, preferably from 103 to 120°C, most preferably from 105 to 115°C, determined according to ASTM F 2029, ASTM F 88.
13. The multilayer collation shrink film according to any one of claims 1 to 12, wherein the total amount of recycled LDPE in the multilayer collation shrink film is from 25 to 55 wt%, preferably from 27 to 53 wt%, most preferably from 30 to 50 wt%, based on the total weight of the multilayer collation shrink film.
14. A method for manufacturing the multilayer collation shrink film according to any one of claims 1 to 13, characterized in that the film is manufactured by a one-step blown film coextrusion process.
15. Use of the multilayer collation shrink film according to any one of claims 1 to 14 for secondary packaging, preferably for bottles and cans, more preferably for bottles and cans in the field of household products, food, healthcare products and beverage products.

Figures

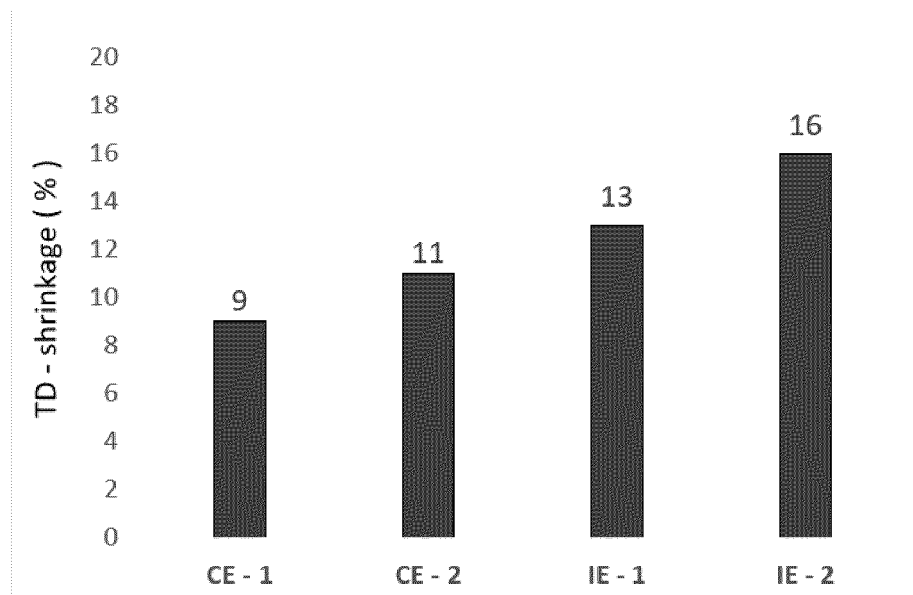


Figure 1

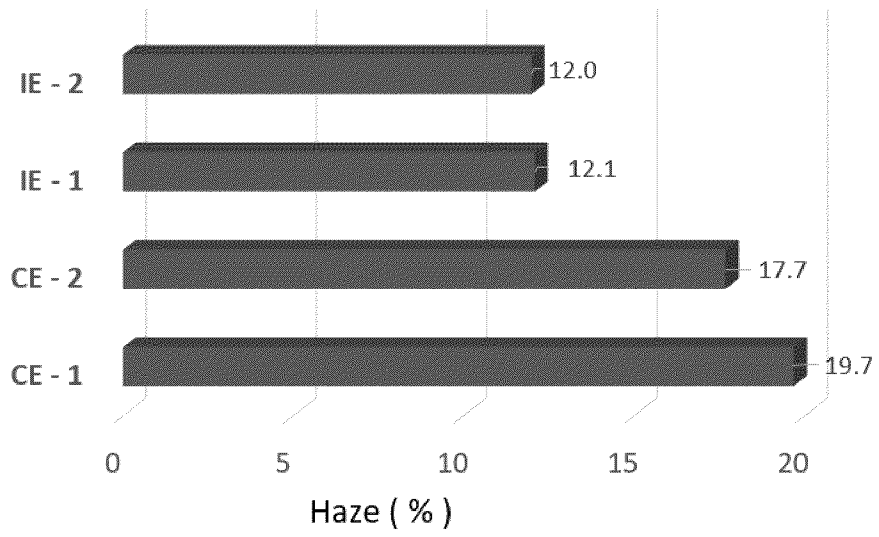


Figure 2

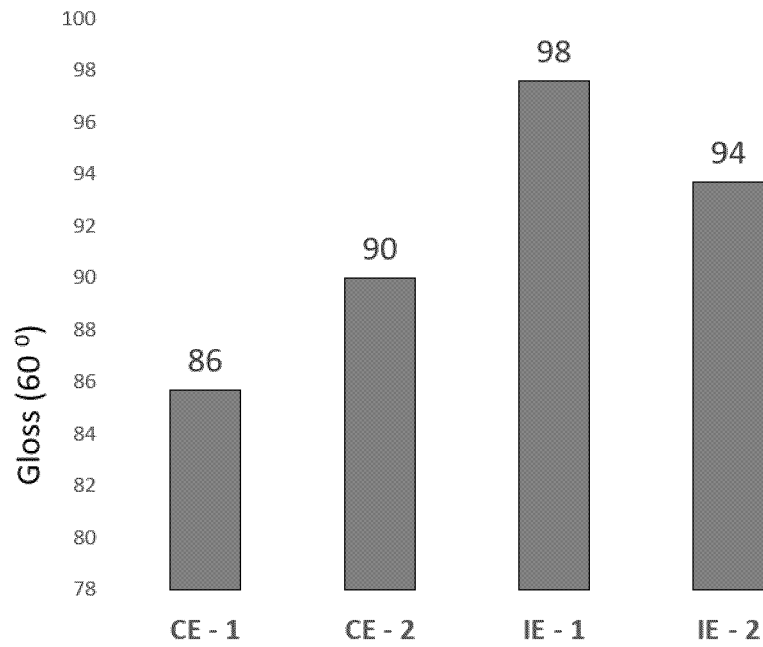


Figure 3

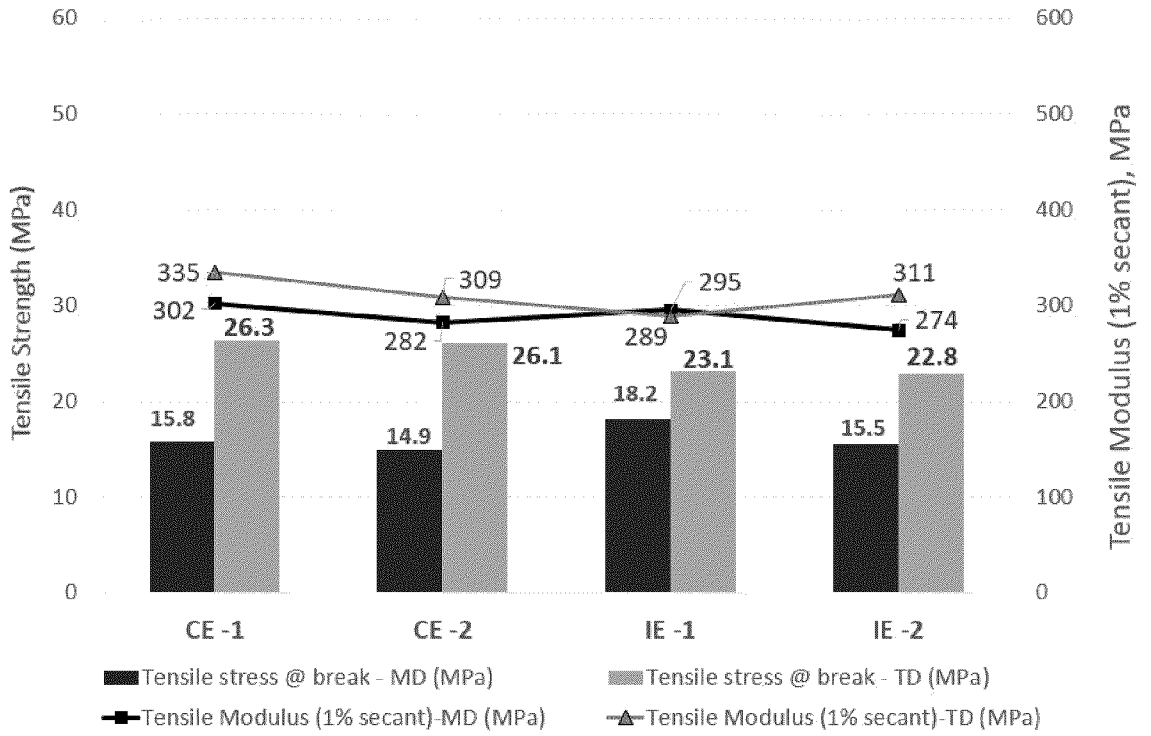


Figure 4

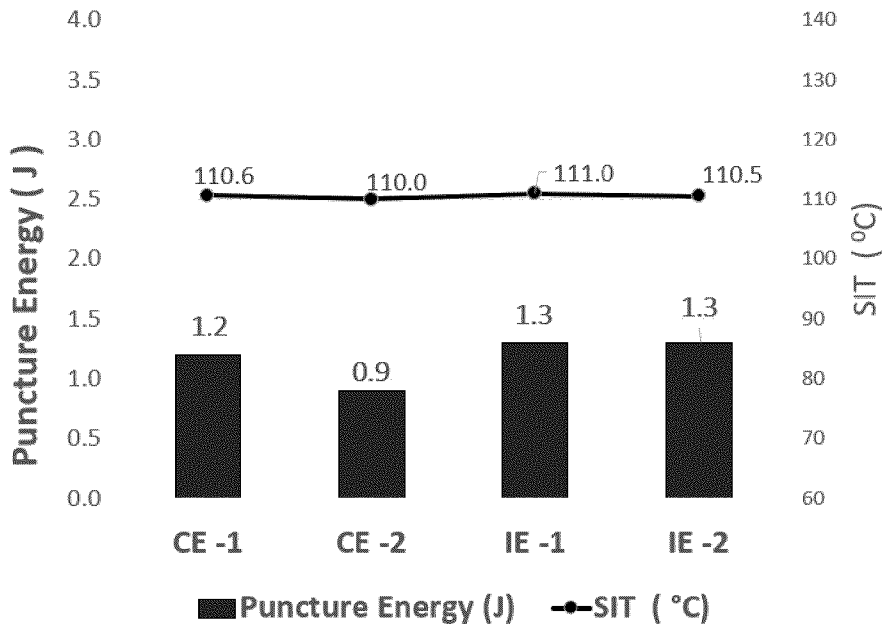


Figure 5

INTERNATIONAL SEARCH REPORT

International application No PCT/EP2023/086318
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A. CLASSIFICATION OF SUBJECT MATTER				
INV. B32B27/08	B32B27/30	B32B27/32		
		C08J5/18		
		B32B7/023		
		B32B7/028		
ADD.				
According to International Patent Classification (IPC) or to both national classification and IPC				
B. FIELDS SEARCHED				
Minimum documentation searched (classification system followed by classification symbols) B32B C08J				
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched				
Electronic data base consulted during the international search (name of data base and, where practicable, search terms used) EPO-Internal, WPI Data				
C. DOCUMENTS CONSIDERED TO BE RELEVANT				
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.		
X	WO 2020/207940 A1 (BOREALIS AG [AT]) 15 October 2020 (2020-10-15) the whole document -----	1-15		
A	WO 2022/258804 A1 (BOREALIS AG [AT]) 15 December 2022 (2022-12-15) abstract; claims 11-15 page 18, lines 6-9 -----	1-15		
A	WO 2015/179291 A1 (DU PONT [US]) 26 November 2015 (2015-11-26) abstract; claims 1-15 -----	1-15		
<input type="checkbox"/> Further documents are listed in the continuation of Box C. <input checked="" type="checkbox"/> See patent family annex.				
* Special categories of cited documents : <table style="width: 100%; border: none;"> <tr> <td style="width: 50%; border: none;"> "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier application or patent but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed </td> <td style="width: 50%; border: none;"> "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family </td> </tr> </table>			"A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier application or patent but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family
"A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier application or patent but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family			
Date of the actual completion of the international search 25 January 2024		Date of mailing of the international search report 02/02/2024		
Name and mailing address of the ISA/ European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Fax: (+31-70) 340-3016		Authorized officer Bergmans, Koen		

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/EP2023/086318

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