

Contents

I. INTRODUCTION

- | | |
|--|-----------|
| 1. Ceramic Processing and Ceramic Products | 3 |
| 1.1 A Brief History of Ceramic Technology | 3 |
| 1.2 Industrial Ceramic Processing | 12 |
| 1.3 Science in Ceramic Processing | 12 |
| Summary | 15 |
| Suggested Reading | 15 |
| Problems | 16 |
| | |
| 2. Surface Chemistry | 17 |
| 2.1 The Atomic Structure of the Surface Differs from That in the Interior of the Particle | 17 |
| 2.2 Surface Energy Causes a Pressure Difference across a Curved Surface | 19 |
| 2.3 Weak Van der Waals Forces or Chemical Bonding Causes Solid Surfaces to Adsorb Molecules from Gases and Liquid Solutions | 20 |
| 2.4 The Wetting and Spreading of a Liquid on a Solid Surface Depends on Short-Range Molecular Forces That Can Be Significantly Modified by a Monolayer Coating | 22 |
| 2.5 Wetting May Cause Compressive Forces between Particles and Liquid Migration | 23 |
| 2.6 Weak Intermolecular Forces Can Cause the Adherence of Molecules on a Surface and the Agglomeration of Small Particles | 25 |

| | |
|-------------------|----|
| Summary | 26 |
| Suggested Reading | 26 |
| Problems | 26 |

II. CERAMIC RAW MATERIALS

| | |
|---|-----------|
| 3. Common Raw Materials | 31 |
| 3.1 Crude Materials | 31 |
| 3.2 Industrial Minerals | 32 |
| 3.3 Industrial Inorganic Chemicals | 36 |
| Summary | 44 |
| Suggested Reading | 44 |
| Problems | 45 |
| 4. Special Inorganic Chemicals | 47 |
| 4.1 Powders from Chemical Solution Techniques | 47 |
| 4.2 Powders from Vapor Phase Reactions | 54 |
| 4.3 Other Techniques | 55 |
| Summary | 56 |
| Suggested Reading | 56 |
| Problems | 57 |

III. MATERIAL CHARACTERIZATION

| | |
|---|-----------|
| 5. Characteristics and Specifications of Ceramic Materials | 61 |
| 5.1 Particles, Powders, Colloids, and Agglomerates | 61 |
| 5.2 Raw-Material Specifications | 62 |
| Summary | 66 |
| Suggested Reading | 67 |
| Problems | 67 |
| 6. Chemical and Phase Composition | 68 |
| 6.1 Bulk Chemical Analysis | 68 |
| 6.2 Phase Analysis | 73 |
| 6.3 Surface Analysis | 75 |
| 6.4 Thermochemical and Thermophysical Analyses | 76 |
| Summary | 80 |

| | |
|--|------------|
| Suggested Reading | 80 |
| Problems | 81 |
| 7. Particle Size and Shape | 82 |
| 7.1 Analysis Techniques | 83 |
| 7.2 Selecting a Technique | 91 |
| 7.3 Presentation of Particle Size Data | 94 |
| 7.4 Calculating a Mean Particle Size | 96 |
| 7.5 Particle Size Distribution Functions | 98 |
| Summary | 101 |
| Suggested Reading | 102 |
| Problems | 103 |
| 8. Density, Pore Structure, and Specific Surface Area | 105 |
| 8.1 Density | 105 |
| 8.2 Porosity and Pore Structure | 110 |
| 8.3 Specific Surface Area | 113 |
| Summary | 117 |
| Suggested Reading | 117 |
| Problems | 118 |
| | |
| IV. PROCESSING ADDITIVES | |
| | |
| 9. Liquids and Wetting Agents | 123 |
| 9.1 Water | 123 |
| 9.2 Organic Liquids | 126 |
| 9.3 Polar Liquids Near Oxide Surfaces | 127 |
| 9.4 Surfactants | 128 |
| Summary | 130 |
| Suggested Reading | 131 |
| Problems | 131 |
| | |
| 10. Deflocculants and Coagulants | 132 |
| 10.1 Particle Charging in Liquid Suspensions | 132 |
| 10.2 Development of an Electrical Double Layer | 139 |
| 10.3 Electrokinetic Properties | 141 |
| 10.4 Deflocculation and the Stability of Suspensions | 143 |
| 10.5 Coagulation and Flocculation | 146 |

| | |
|-------------------|-----|
| Summary | 149 |
| Suggested Reading | 149 |
| Problems | 150 |

11. Flocculants, Binders, and Bonds 152

| | |
|--|-----|
| 11.1 Binder Compositions | 153 |
| 11.2 Clay Binders | 154 |
| 11.3 Molecular Binders | 155 |
| 11.4 Dissolving and Admixing Binders | 159 |
| 11.5 Molecular Weight and Binder Grade | 159 |
| 11.6 Gelation | 161 |
| 11.7 General Effect of Binders | 163 |
| 11.8 Polymer Resins | 165 |
| 11.9 Reaction Bonds | 166 |
| 11.10 Hydraulic Cements | 168 |
| Summary | 171 |
| Suggested Reading | 172 |
| Problems | 172 |

12. Plasticizers, Foaming and Antifoaming Agents, Lubricants, and Preservatives 174

| | |
|-------------------------------------|-----|
| 12.1 Plasticizers | 174 |
| 12.2 Foaming and Antifoaming Agents | 179 |
| 12.3 Lubricants | 180 |
| 12.4 Preservatives | 181 |
| Summary | 181 |
| Suggested Reading | 181 |
| Problems | 182 |

V. PARTICLE MECHANICS AND RHEOLOGY

13. Particle Packing Characteristics 185

| | |
|---|-----|
| 13.1 Characteristics of Packings of Uniform Spheres | 186 |
| 13.2 Packing in Interstices Among Coarser Particles | 188 |
| 13.3 Packing of Continuous Size Distributions | 191 |
| 13.4 Hindered Packing | 195 |
| Summary | 197 |
| Suggested Reading | 197 |
| Problems | 198 |

| | |
|---|------------|
| 14. Consistency, Particle Mechanics, and Deformation Behavior | 200 |
| 14.1 Change in Consistency on Admixing a Liquid | 200 |
| 14.2 Concept of Effective Stress | 202 |
| 14.3 Particle Interactions | 203 |
| 14.4 Interparticle Friction | 204 |
| 14.5 Lubrication | 206 |
| 14.6 Average Stresses in a Powder Mass | 208 |
| 14.7 Shear Resistance of Granular Materials and Powders | 209 |
| 14.8 Stress-Strain Behavior During Compression | 212 |
| 14.9 Strength of Agglomerates | 215 |
| 14.10 Shear Resistance of Nearly Saturated Powders and Plastic Bodies | 218 |
| Summary | 223 |
| Suggested Reading | 224 |
| Problems | 224 |
| 15. Rheological Behavior of Slurries and Pastes | 227 |
| 15.1 Effective Stress and Shear Resistance in a Saturated System | 227 |
| 15.2 Rheological Properties | 229 |
| 15.3 Determination of Viscosity | 231 |
| 15.4 Viscosity of Liquids | 236 |
| 15.5 Viscosity of Binder Solutions | 237 |
| 15.6 Viscosity of Suspensions of Dispersed Colloidal Particles | 239 |
| 15.7 Viscosity of Slurries of Dispersed Powders and Powder-Colloid Mixtures | 242 |
| 15.8 Rheology of Coagulated Systems | 244 |
| 15.9 Rheology of Suspensions and Slurries Containing Binders | 247 |
| Summary | 249 |
| Suggested Reading | 250 |
| Problems | 250 |
| VI. BENEFICIATION PROCESS | |
| 16. Comminution | 255 |
| 16.1 Comminution Equipment | 255 |
| 16.2 Loading and Fracture of Particles | 260 |

- 16.3 Milling Performance 265
- 16.4 Milling Practice 268
- 16.5 Particle Size Distributions 270
- 16.6 Milling Efficiency 272
 - Summary 274
 - Suggested Reading 274
 - Problems 275

17. Batching and Mixing 277

- 17.1 Bulk Solids Transport and Batching 277
- 17.2 Mixing and Mixedness 280
- 17.3 Mixing Mechanisms 285
- 17.4 Mixing Equipment and Practice 286
- 17.5 Mixing Performance 292
 - Summary 295
 - Suggested Reading 295
 - Problems 296

18. Particle Separation, Concentration, and Washing Processes 298

- 18.1 Particle Sizing 298
- 18.2 Filtration and Washing Processes 302
- 18.3 Other Particle Concentration Processes 310
 - Summary 311
 - Suggested Reading 311
 - Problems 311

19. Granulation 313

- 19.1 Direct Granulation 313
- 19.2 Spray-Drying 317
 - Summary 324
 - Suggested Reading 324
 - Problems 325

VII. FORMING PROCESSES

20. Pressing 329

- 20.1 Process Variables In Dry-Pressing 329
- 20.2 Powder Flow and Die Filling 333

| | | |
|------------|---|------------|
| 20.3 | Compaction Behavior | 336 |
| 20.4 | Ejection and Transfer | 342 |
| 20.5 | Die Wall Effects | 345 |
| 20.6 | Control of Compact Defects | 348 |
| 20.7 | Isostatic Compaction | 349 |
| 20.8 | Combination Pressing | 351 |
| 20.9 | Roll Pressing | 351 |
| | Summary | 352 |
| | Suggested Reading | 352 |
| | Problems | 353 |
| 21. | Plastic-Forming Processes | 355 |
| 21.1 | Equipment and Material Variables in Extrusion | 356 |
| 21.2 | Extrusion Mechanics | 360 |
| 21.3 | Control of Extrusion Defects | 368 |
| 21.4 | Plastic Transfer Pressing and Jigging | 371 |
| 21.5 | Injection Molding | 373 |
| | Summary | 376 |
| | Suggested Reading | 377 |
| | Problems | 378 |
| 22. | Casting Processes | 380 |
| 22.1 | Slip-Casting in a Permeable Mold | 381 |
| 22.2 | Slip-Casting Mechanics and Behavior | 386 |
| 22.3 | Nontraditional Casting | 393 |
| 22.4 | Control of Cast Defects | 395 |
| 22.5 | Tape Casting | 395 |
| 22.6 | Casting of Monosize, Spherical Colloids | 399 |
| | Summary | 400 |
| | Suggested Reading | 400 |
| | Problems | 401 |
| 23. | Molecular Polymerization Forming | 403 |
| 23.1 | Sol-Gel Processing | 403 |
| 23.2 | Chemical Vapor Deposition | 405 |
| | Summary | 407 |
| | Suggested Reading | 407 |
| | Problems | 407 |

VIII. DRYING, SURFACE PROCESSING, AND FIRING

| | |
|---|------------|
| 24. Drying | 411 |
| 24.1 Drying Systems | 411 |
| 24.2 Mechanisms in Drying | 413 |
| 24.3 The Drying Process | 415 |
| 24.4 Drying Shrinkage and Defects | 417 |
| 24.5 Modes of Drying | 420 |
| Summary | 423 |
| Suggested Reading | 423 |
| Problems | 424 |
| | |
| 25. Shaping, Surface Finishing, Film Printing, and Glazing Processes | 426 |
| 25.1 Trimming, Smoothing, and Grinding | 426 |
| 25.2 Blanking, Punching, and Laminating | 429 |
| 25.3 Printing Processes | 429 |
| 25.4 Coating Processes | 434 |
| Summary | 438 |
| Suggested Reading | 438 |
| Problems | 439 |
| | |
| 26. Firing Processes | 440 |
| 26.1 Firing Systems | 440 |
| 26.2 Presintering Processes | 445 |
| 26.3 Solid-State Sintering | 449 |
| 26.4 Sintering of Glass Particles | 461 |
| 26.5 Sintering in the Presence of a Small Amount of a Wetting Liquid | 463 |
| 26.6 Sintering of Whiteware Bodies (Vitrification) | 464 |
| 26.7 Sintering of Glazes and Glassy Thick Films | 466 |
| 26.8 Cooling | 469 |
| 26.9 Hot Pressing | 470 |
| Summary | 471 |
| Suggested Reading | 472 |
| Problems | 473 |

| | | |
|-------------------|---|------------|
| APPENDIX 1 | Aperture Size of U.S. Standard Sieves | 475 |
| APPENDIX 2 | Density of Ceramic Materials | 476 |
| APPENDIX 3 | Viscosity and Density Values of Water and Air | 478 |
| APPENDIX 4 | Conversion from Metric to English/American Units | 479 |
| INDEX | | 481 |