

Contents

Preface	ix
Foreword	xi
1 Introduction	1
1.1 What Is Rheology and How Is It Used in Quality Control?	1
1.2 Controlling Quality	1
1.2.1 Quality Systems – the ISO 9000 Series	2
1.2.2 ISO 9000 Registration Strategies	3
1.2.3 Technical Standards – ISO or ASTM?	6
1.2.4 Customer Verification	7
1.3 Why a Statistical Approach Is Necessary	8
2 Rheological Properties of Polymers	10
2.1 Introduction	10
2.2 Melt Viscosity	10
2.2.1 Dependence on Shear Rate and Temperature	12
2.2.2 Empirical Viscosity Models	13
2.2.3 Time-Temperature Superposition and the Temperature Master Curve	13
2.2.4 How Viscosity Is Related to Processability	14
2.3 Storage and Loss Moduli and the Complex Viscosity	14
2.3.1 Dynamic Mechanical Analysis	14
2.3.2 The Cox-Merz Rule	15
2.4 How Rheological Tests Reveal Polymer Structure and Composition	16
2.4.1 Molecular Weight from Zero Shear Viscosity	16
2.4.2 Molecular Weight from Intrinsic Viscosity	16
2.4.3 Viscosity Master Curve for Different Resins	18
2.4.4 Molecular Weight Distribution	18
2.4.4.1 The Discrete Spectrum and the Relaxation Spectrum Index	19
2.4.4.2 The Crossover Modulus	21
2.4.5 Long-Chain Branching	21
2.4.6 Filler Content	22
2.5 Extensional Flow Behavior	22
3 An Introduction to Quality Assurance	25
3.1 Basic Concepts	25
3.2 Events and Populations	26
3.3 Precision	26
3.4 Discovering Sources of Uncertainty	33
3.5 Accuracy and Bias	36
3.6 Statistics Tests	37
3.7 Sampling the Production Process	42

4	Control Basics	45
4.1	Statistical Control Charts	45
4.1.1	Building Control Charts	45
4.1.2	Interpreting Control Charts	52
4.1.3	Specialized Control Charts	54
4.1.4	Autocorrelation	55
4.2	Specification Limits	56
4.2.1	Process and Measurement Capability – C_p	56
4.2.2	Process Capability Indices – C_{pk} and C_{pm}	57
4.3	Improving the Process	59
4.3.1	A Case of Flow Activation Energy	59
4.3.2	Correlation	61
4.3.3	Simple Linear Regression	61
4.3.4	Regression Confidence Intervals	65
4.3.5	Multiple Linear Regression	67
4.3.6	Nonlinear Regression	68
5	Capillary Rheometers	71
5.1	Introduction	71
5.2	Determination of the Wall Shear Stress	71
5.3	Determination of the Wall Shear Rate and the Viscosity	74
5.4	The Entrance Pressure Drop and the Extensional Viscosity	75
5.5	Sources of Error in Capillary Rheometry	76
6	Rotational Rheometers	80
6.1	Introduction	80
6.2	Calculation of Dynamic Properties	82
6.3	Temperature Control	82
6.4	Establishing a Test Protocol	83
6.5	Sources of Error	86
7	Empirical Test Methods	88
7.1	Introduction	88
7.2	The Melt Index	88
7.3	The Melt Strength – An Indication of Extensibility	93
7.4	Extrudate Swell	94
7.5	Extrudate Distortion – Melt Fracture	95
7.6	Moldability Tests	96
7.7	Squeezing Flows	96
7.8	Torque Rheometers	97
7.9	The Mooney Viscometer	98
8	On-Line Rheometers for Process Control	102
8.1	Process Rheometers for Polymers	102
8.2	On-Line Rheometers	102
8.3	On-Line Determination of the Melt Index	105

8.4	On-Line Determination of Viscosity	106
8.4.1	Multipoint Measurements	106
8.4.2	Temperature Compensation.	107
9	Controlling the Measurement Process	109
9.1	Establishing a Test Protocol.	109
9.1.1	Reference Materials	109
9.1.2	Common Rheometric Sources of Uncertainty	111
9.1.3	Error Propagation.	113
9.1.4	Ruggedness Tests	117
9.1.5	Logical Control Charts.	120
9.1.6	Interlaboratory Studies.	122
9.2	Using the Test Protocol.	123
9.2.1	Sampling.	123
9.2.2	Data Integrity	123
Appendix A Companies Manufacturing Melt Rheometers and Testers.		125
Appendix B Statistical Software Producers		130
Nomenclature		132
Subject Index		136