

Contents

Face to the Second Edition

Preface to the First Edition

Acknowledgements

xi

Chemistry and Basic Intermediates	
Introduction	
Basic Chemistry	
Basic Structure of a Polyurethane Elastomer	
Synthesis of Basic Urethane Building Blocks	
Isocyanates	
Storage Life and Reactions of Isocyanates with Themselves—Dimers (Uretidinediones)	15
Uretidiones	19
Polyols	19
Polyesters	21
Polyethers	24
Chain Extenders and Crosslinking Agents	27
Catalysts	27
2. Polyurethane Elastomer Chemistry	29
Liquid Processing Routes	29
Meltable Elastomer Synthesis	30
Thermoplastic Linear Urethane Elastomers	34
Concept of Equivalent Weights	36
Concept of the Complete Urethane Chemical System	38
Polyol Quantization by Chemical Analysis	40
Other Isocyanate Analytical Terms	42
Other Useful Terms	43
Example Calculation for a Typical Polyurethane Elastomer Synthesis	45
Blends	46
Calculation of Isocyanate Proportions for a Water Blow Foam System	48
Effect of Flexible to Rigid Segment on Urethane Properties	50

CONTENTS

3. Property-Structure Relationships in Polyurethanes	
Introduction	
Flexible Segments	
Polyethers	
Polycaprolactones	
Rigid Segments	
Aliphatic <i>Versus</i> Aromatic Diisocyanates	
Aliphatic Diisocyanates and Transparency	
Effect of Diisocyanate Structure on the Relative Thermal Stability of Polyurethane Elastomers	
Chain Extension of Unsymmetrical Diisocyanates	
Glycols	
Chain Extension of Symmetrical Diisocyanates with Diols	
Synthesis	
Even Molar Ratio Effects	
Influence of the Diol Structure on Thermal Stability of the PU Elastomer: Molar Ratios 1:2:1	
Loss Tangent Values and Chain Extender Composition	
Uneven Molar Ratio Effects with Respect to the Diisocyanate	
Comparison of the Thermal Stability Effects of a Diamine with Diols (as Chain Extenders) in Polyurethane Elastomers (Molar Ratio 1:3:2)	
Differential Scanning Calorimetry (DSC) as a Means of Predicting Thermal Stability (Molar Ratio 1:2:1)	
DSC Studies and the Molar Ratio 1:2.6:1	
DSC as a Means of Predicting the Relative Thermal Stability of a Diamine (Polacure) with Diol Chain Extenders	
Contribution of Crosslinks to Properties	
Crosslinking and Thermal Stability in Polyurethane Elastomers	
Synthesis Technique	
In-Situ Isocyanate and Isocyanurate Crosslinking	
PU Elastomer Compositions	
Influence of % Free NCO on the Properties of the PU Elastomer at Room Temperature	
Strength Properties at Elevated Temperature	
Dynamic Mechanical Thermal Analysis (DMTA)	
Thermal Equilibrium Properties	
Low Temperature Stiffening and Glass Transition Temperature (T_g)	
Hazards	
Thermal Stability and Crosslink Structure in PUs	
Structure in Polyurethane Elastomers	
Continued Crystal Growth	
Plasticization	
4. Reaction Rates, Catalysis and Surfactant	
Reaction Rates	
Diisocyanates	
Polyols	
Temperature	

Catalysis	113
Acid Catalysis and Prepolymer Stability (Shelf Life)	113
Shelf Life Stability of Prepolymers	113
Base Catalysis	115
Additional Comments on RIM Catalysis	
Tertiary Amines	117
Organometallic and Other Metal Compounds	118
Catalyst Combinations	120
Surfactants (Surface Active Agents)	120
Ionic Surfactants	120
Non-ionic Surfactants	120
5. Liquid Polyurethane Elastomer Systems.	122
Stable Prepolymer Systems	124
Simple Hand Casting Procedure	125
Chain Extenders	127
Processing of TDI Prepolymers	129
Processing Variables	131
Type of Curative	132
Reaction Temperature	134
Other Representative Polymer Systems	135
Unstable Prepolymer System	152
Water Crosslinked Millable Vulkollan for Compression Moulding	158
Cellular Polyurethane Elastomers	158
Vulkollan System	158
Cellular Urethanes from Stable Prepolymers	159
Solvents	160
Compression Moulding of Cast Elastomers	161
Spray Application of Urethane Elastomers	163
Note on Water Content of Polypols of Urethane Elastomers.	164
Alternative Chain Extenders to MOCA	165
3,3'-Dimethyl-4,4'-diaminodicyclohexylmethane	166
Diols as Chain Extenders	167
Synthesis and Properties of Polyurethane Elastomers Based on Aromatic <i>Versus</i> Aliphatic Diisocyanates	169
CHDI Prepolymer Synthesis and Chain Extension.	169
PPDI Prepolymer Synthesis and Chain Extension	171
6. Reaction Injection Moulding (Liquid Injection Moulding)	174
The Process	178
RIM Formulation	179
Water	181
Physical Properties of RIM Urethane Systems	182
RIM Machine Design	182
Energy Requirements of RIM.	186
Mechanism of Impingement Mixing	187
Mould Design	187
Transition Zone	189

Catalysis	113
Acid Catalysis and Prepolymer Stability (Shelf Life)	113
Shelf Life Stability of Prepolymers	113
Base Catalysis	115
Additional Comments on RIM Catalysis	117
Tertiary Amines	117
Organometallic and Other Metal Compounds	118
Catalyst Combinations	120
Surfactants (Surface Active Agents)	120
Ionic Surfactants	120
Non-ionic Surfactants	120
Liquid Polyurethane Elastomer Systems	122
Stable Prepolymer Systems	124
Simple Hand Casting Procedure	125
Chain Extenders	127
Processing of TDI Prepolymers	129
Processing Variables	131
Type of Curative	132
Reaction Temperature	134
Other Representative Polymer Systems	135
Unstable Prepolymer System	152
Water Crosslinked Millable Vulkollan for Compression Moulding	158
Cellular Polyurethane Elastomers	158
Vulkollan System	158
Cellular Urethanes from Stable Prepolymers	159
Solvents	160
Compression Moulding of Cast Elastomers	161
Spray Application of Urethane Elastomers	163
Note on Water Content of Polyols of Urethane Elastomers	164
Alternative Chain Extenders to MOCA	165
3,3'-Dimethyl-4,4'-diaminodicyclohexylmethane	166
Diols as Chain Extenders	167
Synthesis and Properties of Polyurethane Elastomers Based on Aromatic <i>Versus</i> Aliphatic Diisocyanates	169
CHDI Prepolymer Synthesis and Chain Extension	169
PPDI Prepolymer Synthesis and Chain Extension	171
6. Reaction Injection Moulding (Liquid Injection Moulding)	174
The Process	178
RIM Formulation	179
Water	181
Physical Properties of RIM Urethane Systems	182
RIM Machine Design	182
Energy Requirements of RIM	186
Mechanism of Impingement Mixing	187
Mould Design	187
Transition Zone	188

Moulding	
Ribs and Radius	
Runners	
Mould Sealing	
Processing Economics	
Reinforced Reaction Injection Moulding Machinery	
Dispersion of Fibre Reinforcement	
7. Millable Polyurethane Elastomers	
Sulphur Vulcanized Grades	
Millable Polyether Polyurethane Elastomers	
Plasticization	
Filler Reinforcement	
Isocyanate-Cured Urethane Rubber	
Peroxide-Cured Polyurethane Elastomers	
Cure Temperature	
Effect of Fillers	
Combined Peroxide and Diisocyanate Cures	
8. Polyurethane Adhesives	
Reasons for Adhesive Properties of Polyurethane and Diisocyanate-Based	
Adhesives	
Isocyanate Reactivity	
Self Polymerization	
Surface Wetting Properties	
Polarity	
Graded Physical Properties	
Reaction with Unreactive Surfaces	
Reasons for the Apparent Universal Applications of Polyurethanes as	
Adhesives	
Methods of Using Isocyanates as Adhesives	
As an Isocyanate Primer	
By In-Situ Polyurethane Polymerization	
As Polyurethane Elastomer Without or With Added Polyisocyanates	
Thermoplastic Polyurethane Elastomer Types	
Elastomer Gum Types	
Blocked Di- or Polyisocyanate Adhesives	
Aqueous Dispersions of Polyurethanes	
Film and Tape Polyurethane Adhesives	
Powdered Polyurethane	
Stabilization of Adhesives	
9. Thermoplastic (Linear Polyurethane Elastomers)	
Partially Crosslinked Thermoplastic Polyurethanes	
Synthesis of Thermoplastic Polyurethane	
Preparation	
Notes on Large-Scale Production Synthesis Procedures	
Processing of Thermoplastic Polyurethanes	

Extrusion	250
Injection Moulding	251
Calendering	253
Hot-Melt Calendering	254
Film Lamination	255
Solution Applications	256
Reactive Coatings	256
100%-Solids Reactive Systems	257
Commercially Available TPUs	257
Comment About the Set Properties of TPUs	260
Microporous Thermoplastic Polyurethanes	260
Blends	263
Processing of Transparent Thermoplastic Polyurethane Elastomer by Injection Moulding	264
Thermoplastic Polyurethane Elastomers as Hydraulic Seal Materials	264
CHDI-Based Polyurethanes	267
Polyester TPUs	268
Mixed Aliphatic Diols as Chain Extenders (CHDM and BDO)	277
Polyether TPUs	277
Thermal Stability	278
Polycaprolactone/CHDI Polyurethanes	278
Polycaprolactone/PPDI Polyurethanes	278
Polyether/PPDI Polyurethanes	278
Polyether/CHDI Polyurethanes	279
Energy Absorption ($\tan \delta$)	279
Post-Cure Prediction Responses	279
Conclusions	279
10. Water Dispersions of Polyurethane Elastomers	281
Self-Emulsifying Latex	281
Emulsified Latex	282
Polyurethane Ionomers	284
Special Features of Water-Dispersed Polyurethane Elastomers	286
Anionic Dispersions	287
Cationic Dispersions	288
Practical Example for the Preparation of a Polyurethane Dispersion (Melt-Dispersion Technique)	290
11. Analysis and Characterization of Polyurethane Elastomers	292
Diisocyanates	292
Measurement of NCO Content	293
Total Chlorine: Principle of the ASTM Method D1638	295
Acidity	295
Hydrolyzable Chlorine	296
Isomer Ratio	297
Activity of Diisocyanate	297
Diisocyanates in the Atmosphere	298
Polyol Analysis	303

CONTENT

Hydroxyl Number	
Primary and Secondary Hydroxyl Groups	
Water Content	
Acid Number	
Measurement of pH (Apparent)	
Hydrolytic Stability	
Unsaturation	
Peroxide Content	
General Analytical Parameters for Polyols	
Infrared Spectroscopy Techniques	
Determination of Isomer Ratio of TDI by Infrared Spectroscopy	
Determination of Unreacted NCO Groups in a Polyurethane Elastomer	
An Additional Rapid Infrared Method for the Quantitative Analysis of NCO Present in a Polyurethane Elastomer	
Chromatography Techniques	
Gas-Liquid Chromatography	
Thin Layer Liquid Chromatography	
Thermal Analysis	
Identification of the Components in a Polyurethane	
Polyesters	
Polyethers	
Differentiation of Polymers Present in a Polyurethane	
General Analysis of Miscellaneous Elements in a Polyurethane Elastomer	
Colour Reactions for Polyurethane Identification	
References	
12. Special Types of Polyurethane Elastomers	
Hydroxy-Terminated Polybutadienes	
Process Oils and Plasticizers	
Low-Temperature Resistance	
Transparent Polyurethane Elastomers	
Amine-Terminated Polyols	
Fluorinated Polyols	
UV Light Curable PU Systems	
13. Properties and Applications	
Tensile Properties	
In Tension	
In Compression	
Load Deflection Properties	
Comparison of Physical Properties of Polyurethane Elastomers with Common Rubbers and Plastics	
Energy Absorption Properties	
Wear Resistance	
Friction Properties	
Environmental and Ageing Properties	
Light Resistance	
High Energy Radiation Effects	
Electrical Properties	

Applications	390
Current Types of PU Elastomer	391
Solid Tyres	392
Pneumatic Polyurethane Tyres	392
Microcellular Shoe Solings	395
Blends of TPU with other Thermoplastics	397
Rollers	397
Automotive Body Panels and Bumpers	398
Rain-Erosion Protection of Surfaces	398
Cold-Curing Elastomers	398
Low-Speed Tyre-Filling Compositions	398
Water Vapour Permeable PU Elastomers	399
Polyurethane Elastomers in Medicine	400
Millable Polyurethane Elastomers	403
Fillers for Cold-Cast Polyurethane	404
Plasticizers for Polyurethane Elastomers	405
Manufacturing Factors	405
Moulding	405
Shrinkage	405
Mould Lubricant	405
Mould Cleaning	406
Machining	406
14. Health Hazards and Precautions	407
Toluene Diisocyanate (TDI)	409
Diphenylmethane Diisocyanate (MDI)	409
1,5-Naphthalene Diisocyanate (NDI)	411
Toxicity Data for the Analogues Aromatic and Aliphatic Diisocyanates	411
General Toxicity Problems	413
Handling Isocyanates and Manufacture of Polyurethane Products	413
Skin Irritation	414
Protective Clothing	416
First Aid	416
Specific Hazards Associated with the Manufacturing Processes	417
Urethane Rubbers	417
Manufacture of Moulded Articles	417
Surface Coatings	418
Printing Inks	419
Adhesives	420
Isocyanate Monitoring and Detection	420
Analytical Monitoring Techniques	421
Alternative Method	423
Determination of TDI in Solvent Atmosphere	424
Diamines	425
Polyols and Glycols	425
Waste Disposal	426
<i>References and Bibliography</i>	<i>427</i>
<i>Index</i>	<i>429</i>