

CONTENTS

POLYPROPYLENE

| | |
|-----------------------------------------------------------------|-----------|
| PHYSICAL AND MECHANICAL PROPERTIES OF POLYPROPYLENE | 1 |
| Classification of polypropylene | 1 |
| Crystallinity of polypropylene | 3 |
| Molecular weight and impact resistance | 5 |
| Processability | 7 |
| Injection moulding of polypropylene | 10 |
| Mechanical properties of injection moulding grade polypropylene | 12 |
| Low temperature brittleness | 12 |
| Oxidation and ageing resistance | 15 |
| Miscellaneous properties | 15 |
| Abrasion resistance | 15 |
| Resistance to solvents | 16 |
| Electrical properties | 17 |
| Conclusion | 17 |
| | |
| THE MOULDING CHARACTERISTICS OF POLYPROPYLENE | 19 |
| General considerations | 19 |
| Flow behaviour | 20 |
| Melt flow index | 20 |
| Spiral flow | 23 |
| High shear viscometry | 24 |
| Specific volume and heat content | 25 |
| Mould shrinkage | 27 |
| Crystalline structure | 28 |
| Moulding procedures | 28 |
| Injection unit | 28 |
| Moulds | 29 |
| Machine settings | 29 |
| Conclusions | 30 |
| | |
| DISCUSSION ON POLYPROPYLENE | 31 |

MATERIAL DEVELOPMENTS

| | |
|---------------------------------------------------------------------------------|-----------|
| SOME NEW EPOXIED RESIN SYSTEMS AND THEIR PROPERTIES | 37 |
| Epoxide resins | 37 |
| Physical properties of EP.201 | 38 |
| Methods of hardening EP.201 | 39 |
| Properties obtained with EP.201 | 39 |
| Amine hardeners | 40 |
| Flexibilizers for epoxide resins | 43 |
| Methods of using modified amines as flexibilizers for epoxide resins systems | 44 |
| Applications of modified amine flexibilizers | 47 |
| | |
| CROSSLINKING OF THERMOPLASTICS AFTER FABRICATION | 49 |
| Scope of present work | 50 |
| Comparative features of processing in irradiation and chemical cures | 52 |
| Summary of observations | 55 |
| Polythene | 55 |
| Secondary cellulose acetate | 56 |
| Polyvinyl chloride (p.v.c.) | 59 |
| | |
| SOME THERORETICAL AND EXPERIMENTAL ASPECTS OF BLOCK AND GRAFT COPOLYMERS | 63 |
| Part I | |
| Methods of preparation | 68 |
| Block copolymers | 68 |
| Initiation by primary macroradicals | 68 |
| Ionic initiation | 69 |
| Initiation by primary macromolecules containing labile end groups | 69 |
| Transfer method | 71 |
| Free radicals produced by chain scission | 71 |
| Coupling of preformed polymers | 72 |
| Graft copolymers | 72 |
| Transfer process | 72 |
| Reactive side groups | 73 |
| Copolymerization with unsaturated polymer | 74 |
| Photochemical methods | 74 |
| High energy radiation grafting | 75 |

| | |
|----------------------------------------------------------------|------------|
| Part II | |
| Theoretical considerations | 77 |
| Fundamental equations | 77 |
| The duofunctional initiator | 78 |
| Other application of Equation 2 | 80 |
| Comparison of block yields using various monomers | 80 |
| Discussion of Y'd values | 84 |
| Synthesis of initiators of type I ₁ RI ₂ | 84 |
| Calculated block yields using "Bismac" | 86 |
| Thermal initiation | 88 |
| Transfer to initiation | 88 |
| Transfer to dear polymer | 88 |
| Experimental data | 89 |
| | |
| DISCUSSION ON MATERIAL DEVELOPMENTS | 95 |
| | |
| RECENT DEVELOPMENTS IN GLASS REINFORCED PLASTICS | |
| | |
| THE PROGRESS OF GLASS REINFORCED PLASTIC IN THE BENELUX | |
| COUNTRIES | 97 |
| Basic materials and resins | 97 |
| Reinforcing materials | 98 |
| Manufacturing methods | 98 |
| Hand lay-up | 98 |
| Vacuum bag technique | 101 |
| Preforming | 102 |
| Continuous moulding | 102 |
| Dough moulding | 102 |
| | |
| PROGRESS IN GERMANY | 103 |
| | |
| PROGRESS IN THE UNITED KINGDOM | 111 |
| Development in materials | 111 |
| Resins | 111 |
| Catalyst systems | 113 |
| Glass fibre | 115 |
| Moulding techniques | 115 |
| Contact moulding | 115 |
| Roof sheeting | 116 |
| Dough moulding and pre-impregnation | 117 |

| | |
|-------------------------------|-----|
| Performance of final moulding | 118 |
| The use of mineral fillers | 118 |
| Degree of cure | 119 |
| Conclusion | 120 |

PROGRESS IN THE **123**

| | |
|------------------------------------------------|-----|
| New resin technology | 124 |
| Reinforcements | 126 |
| Finishes | 127 |
| Dough moulding | 128 |
| Spray moulding | 128 |
| Technical organization for reinforced plastics | 129 |

DISCUSSION ON RECENT DEVELOPMENTS IN GLASS REINFORCED PLASTICS **131**

EXPANDED PLASTICS

U.S. DEVELOPMENTS IN FOAMED PLASTICS AND IN PARTICULAR FOAMED

| | |
|------------------------------------------------|------------|
| SMOKES | 139 |
| Explanation of foamed plastics | 139 |
| Commercial developments | 140 |
| Development of foamed plastics smokes | 144 |
| Applications of foamed plastics smoke | 146 |
| Seeding of rain clouds | 146 |
| Crop-warming clouds | 146 |
| Prevention of evaporation | 146 |
| Artificial snow, fog and smoke | 147 |
| Carrier for insecticides | 147 |
| Reflection of communication radio waves | 147 |
| Outer space tracers for rockets and satellites | 147 |
| Decontamination of the atmosphere | 147 |
| Other uses | 147 |

BULK DENSITY AND PHYSICAL PROPERTIES OF EXPANDED POLYSTYRENE **149**

| | |
|----------------------------------------------------|-----|
| Preparation of the foamed polystyrene | 149 |
| Preparation of specimens | 150 |
| General physical properties | 150 |
| Thermal conductivity | 153 |
| Deformation of foamed polystyrene | 155 |
| Deformation under impact loading | 155 |
| Deformations under static load | 161 |
| Tensile and impact strengths of foamed polystyrene | 165 |
| Summary | 166 |

DISCUSSION ON EXPANDED PLASTICS **168**

EXTRUSION

EXTRUSION STUDIES ON THERMOPLASTICS **173**

| | |
|--------------------------------|-----|
| Description of the extruder | 174 |
| Experimental procedures | 176 |
| Assessment of results | 179 |
| Effect of temperature | 179 |
| Power considerations | 180 |
| Flow through the die | 183 |
| Mechanical properties | 186 |
| Screw temperature measurements | 186 |
| General conclusions | 186 |
| Polymer temperature | 186 |
| Effect of liner temperature | 186 |
| Energy balances | 188 |
| Viscosity studies | 188 |
| Appendix | 189 |

THE EXTRUSION OF ACRYLICS **191**

| | |
|------------------------------------------------|-----|
| Polymethyl methacrylate for extrusion | 191 |
| Extrusion behaviour of polymethyl methacrylate | 192 |
| Extrusion equipment for acrylics | 194 |
| Barrel | 194 |
| Screw | 203 |
| Vented extruders | 204 |
| Dies and finishing gear | 205 |
| Extrusion and rods | 205 |
| Tubes and rods | 205 |
| Profiles | 207 |
| Sections post-formed from tube dies | 208 |
| Trough sections light fittings | 208 |
| Rain water gutter section | 209 |
| Extruded acrylic sheet | 210 |

DISCUSSION ON EXTRUSION **214**