

Contents

Preface	V
Contents	VII
1. Compounds	1
1.1. Formulations and compounding calculations	1
1.1.1. Kinds of compounding formulations	1
1.1.2. Batch mixing	1
1.1.3. Calculation of the density of a compound	2
1.2. Compounding	3
1.2.1. Mixing volumes	3
1.2.2. Fill factor of a mixer	4
1.2.3. Mixing process	5
1.2.4. Mixing work	6
1.3. Compound processing	6
1.3.1. Calculation of the contraction of moulded articles	6
1.3.2. Calculation of the contraction of extruded articles	8
1.3.3. Calculation of moulded extrudate swell	9
1.4. Blowing agents	9
1.4.1. Amount of blowing agents for gas-filled hollow articles	9
1.4.2. Organic blowing agents	10
1.4.3. Calculation of the volume increase of blown articles	11
1.5. Eutectic composition for liquid-curing-systems (LC)	11
1.6. Stress relaxation of uncured rubber compounds	11
1.7. Surface tension of uncured and cured rubber compounds	12
1.7.1. Determination of contact angle ϕ	12
1.7.2. Determination of the surface tension σ_s of solids	13
1.8. Statistical experimental design	14
1.8.1. Plans of first order	14
1.8.2. Second order orthogonal central composite plans	15
1.8.3. Optimization methods	17
References Section 1	18
2. Vulcanizates	20
2.1. Stress-strain behavior of vulcanizates	20
2.1.1. Small deformations	20
2.1.2. Larger deformations	20
2.1.3. Mullins effect	21
2.2. Correlation between different vulcanizate properties in the temperature range ≥ 20 °C	22

2.2.1.	Calculation of the relaxation modulus	22
2.2.2.	Calculation estimation of storage modulus, loss modulus, and loss factor	22
2.2.3.	Correlations of different physico-mechanical parameters	24
	References Section 2	25
3.	Polymers	26
3.1.	Types of rubber	26
3.1.1.	Abbreviations	26
3.1.2.	Additional names	27
3.2.	Thermoplastic Elastomers (TPE)	27
3.2.1.	Types of TPE	28
3.2.1.1.	Styrene Block Copolymers (SBS/SEBS)	28
3.2.1.2.	Thermoplastic Olefins (TPO)	28
3.2.1.3.	Thermoplastic Polyurethanes (TPU)	28
3.2.1.4.	Thermoplastic Polyester / Copolyester (TP-AE)	28
3.2.1.5.	Polyether/Polyamide Block Copolymer (PEBA)	28
3.2.2.	Trade names of TPE's	29
3.2.3.	Basic parameter and application of several TPE types	30
3.3.	Criteria for the application of rubber types	30
3.3.1.	Guide lines for different application areas	30
3.3.2.	Temperature ranges for practical application	31
3.3.3.	Use of rubber types specially for tire treads	34
3.4.	Glass transition temperature T_g	34
3.4.1.	Determination of the glass transition temperature from the storage modulus-temperature function	34
3.4.2.	Glass transition temperature of different general purpose elastomers	
3.4.3.	Time-temperature superposition principle	36
3.5.	Microstructure	37
3.5.1.	Microstructure of different types of rubber	37
3.5.2.	Correlation between microstructure and vulcanizate properties	38
3.6.	Natural Rubber	40
3.6.1.	Physical and chemical characteristics of Natural Rubber	40
3.6.2.	Types of SMR (Standard Malaysian Rubber) Specification (October 1991)	40
3.6.3.	Test compound for NR	41
3.6.4.	Crystallization of natural rubber	42
3.6.5.	Mastication	42
3.7.	Permeability	45
3.7.1.	Permeation of gases	45
3.7.2.	Temperature dependence of the permeation coefficient	47
3.7.3.	General parameters influencing permeability	48
3.7.4.	Solubility of gases in polymers	48
3.8.	Solubility of sulfur in rubber	49

3.8.1.	<i>Solubility in different types of rubber</i>	49
3.8.2.	<i>Diffusion coefficient of sulfur in rubber</i>	50
3.8.3.	Migration of sulfur from different types of rubber	50
3.9.	Refraction index of rubbers	51
3.10.	Electrical properties of different rubber compounds (rubber content about 50 %)	51
3.11.	Properties of different rubbers in solvents	52
3.11.1.	Valuation methods of the swelling behaviour	52
3.11.2.	Effect of solvents on pure rubbers	53
3.11.3.	Chemical resistance of vulcanizates of different rubbers according to VDI 2537	55
3.11.4.	Cohesive energy density to assess the solubility of polymers ..	56
3.12.	Compression-set properties of different types of vulcanized rubber	57
References Section 3		59
4.	Carbon Black	54
4.1.	Grades of carbon black	54
4.1.1.	Grade nomenclature	54
4.1.2.	ASTM classification of carbon blacks	54
4.1.3.	Typical properties of commercial carbon black grades	55
4.1.4.	Determination of carbon black properties in rubber	56
4.2.	Correlations of filler concentration	57
4.2.1.	Loading c_0	57
4.2.2.	Volume fraction of filler in compounds	58
4.2.3.	Structure-volume equivalence	59
4.3.	Carbon black parameters	60
4.3.1.	Parameters according to WOLFF	60
4.3.2.	Parameters according to KRAUS et al.	61
4.4.	Determination of processing properties and degree of dispersion of carbon blacks	72
4.4.1.	Method according to Wolff	72
4.4.2.	Method according to Cotton	74
4.5.	Interaction between carbon black and rubber	75
4.5.1.	Bound rubber	75
4.5.2.	Functions of intercorrelations	76
4.6.	Thermal conductivity of carbon blacks	78
4.7.	Electrical properties of carbon blacks	79
References Section 4		80
5.	Plasticizers	82
5.1.	Characterization of mineral-oil-plasticizers	82
5.1.1.	Determination of the viscosity-density constant VDC	82
5.1.2.	Determination of the basic value B	83

5.1.3.	Viscosity table for converting centistokes into Engler grades and Sayboldt Universal Seconds (SUS)	83
5.1.4	Determination of hydrocarbon distribution in mineral oil plasticizers	
5.1.5.	Classification of mineral-oil plasticizers	85
5.1.6.	Calculation of the refraction intercept	85
5.2.	Application of mineral-oil plasticizers in different elastomers	85
5.3.	Diffusion coefficients of mineral-oil plasticizers in different elastomers	86
5.4.	Influence of different types of plasticizers on the glass transition temperature of polymers	86
5.4.1.	Mixing rule according to Leilich	86
5.4.2.	Calculation according to Bueche	86
5.5.	Determination of the compatibility of plasticizers with rubber	87
5.6.	Synthetic plasticizers	88
	References Section 5	88
6.	Rubber / Carbon Black / Plasticizer Systems	90
6.1.	Substitution of carbon black-grades at maintained hardness	90
6.1.1.	Replacement of carbon black grades on equal hardness level.	90
6.2.	Influence of carbon black and plasticizer on the abrasion resistance of tire tread compounds	91
6.3.	Influence of carbon black and plasticizer on 300% modulus, heat build-up and rebound resilience	92
6.3.1.	300% modulus	92
6.3.2.	Heat build-up (HBU)	93
6.3.3.	Correlations between 300% modulus and heat build-up	93
6.4.	Plasticity equivalent	95
6.4.1.	Plasticity changes caused by carbon black and mineral-oil plasticizer influence on the Mooney viscosity	95
6.4.2.	Equivalence correlation between carbon-black and mineral-oil plasticizer for constant Mooney viscosity or constant Defo hardness	96
	References Section 6	97
7.	Cure	98
7.1.	Curing systems	98
7.1.1.	Curing systems for GP-Rubbers	98
7.1.2.	Curing systems for EPDM-Rubber	98
7.1.3.	Curing systems for Butyl Rubber (IIR)	99
7.1.4.	Curing systems for halogenated Isobutylene-Isoprene Rubber (X-IIR)	100
7.1.5.	Curing systems for Butadiene Acrylonitrile Rubber (NBR)	101
7.1.6.	Curing system for HNBR	101
7.1.7.	Curing systems for Chloroprene Rubber (CR) (Mercaptan and XD-Modification)	102
7.1.8.	Curing systems for Polyurethane Rubber (AU,EU)	102
7.1.9.	Curing systems for Ethylene Acrylate Rubber (EAM) – VAMAC	103

7.1.10.	Curing systems for fluorelastomers	103
7.1.11.	Application of peroxide cure	104
7.1.12.	Nitrosamine – free curing systems	105
7.2.	Vulcanisation kinetics	106
7.2.1.	Temperature coefficient TC	106
7.2.2.	Activation energy	107
7.2.3.	Cross linking reaction	107
7.3.	Determination of crosslink density	108
7.3.1.	Determination by means of stress-strain measurements on unfilled vulcanizates	108
7.3.2.	Determination of crosslink density of filled vulcanizates according to Eisele and Müller by using the Mullins effect.....	110
7.3.3.	Determination according to Flory and Rehner from equilibrium swelling of unfilled vulcanizates	110
7.3.4.	Determination of the Huggins interaction parameter χ	116
7.4.	Optimization of cure regimes	117
7.4.1.	Optimization methods	117
7.4.2.	Determination of the temperature window	117
7.4.3.	Determination of equivalent cure time t^*	119
7.5.	Pressure-temperature equivalents for saturated water vapor	124
7.6.	Reversion	125
7.6.1.	Kinetics of reversion	125
7.6.2.	Determination of characteristic values of reversion	126
7.6.3.	Correlation of 300% modulus and heat build-up in the reversion region	128
7.6.4.	Improvement of reversion resistance	130
7.7.	Application and effect of anti-scorching agents / retarder	131
	References Section 7	132
8.	Rubber to Metal Bonding	135
8.1.	Adhesion systems for rubber	135
8.2.	Pre-Treatment of ferrous and non-ferrous metal substrates	137
8.3.	Pre-treatment of plastic and cured rubber substrates	138
	References Section 8	139
9.	Aging	140
9.1.	Application of antidegradants (antioxidants)	140
9.1.1.	Effect of antioxidants in NR, IR, and SBR	140
9.1.2.	Migration of antioxidants in various rubbers	140
9.1.3.	Volatility of antioxidants	141
9.1.4.	Desactivation of antioxidants	141
9.2.	Calculations of ageing of NR compounds according to Barker	142
	References Section 9	144

10.	Characterising Properties of Raw Materials and Additives	145
10.1.	Rubbers (additionally see chapter 3)	145
10.1.1.	Code for SBR types	145
10.1.2.	Trade names of rubbers	146
10.1.2.1.	Acrylic Rubber ACM	146
10.1.2.2.	Butadiene Rubber BR	146
10.1.2.3.	Ethylene Acrylate Rubber EAM	147
10.1.3.4.	Butadiene Acrylonitrile Rubber NBR	147
10.2.1.5.	Hydrogenated Nitrile Rubber HNBR	148
10.1.2.6.	Isobutylene Isoprene Rubber IIR, BIIR, CIIR	148
10.1.2.7.	Chloroprene Rubber CR	148
10.1.2.8.	Epichlorhydrine Rubber CO/ECO	148
10.1.2.9.	Ethylene Propylene Rubber EPM, EPDM	149
10.1.2.10.	Ethylene Vinylacetate Rubber EVM	149
10.1.2.11.	Isoprene Rubber IR	149
10.1.2.12.	Styrene Butadiene Rubber SBR	150
10.1.2.13.	High styrene rubber market grades	150
10.1.2.14.	L-SBR grades	151
10.1.2.15.	Epichlorhydrine Rubber CO/ECO	151
10.1.2.16.	Fluoric Rubber FPM	151
10.1.2.17.	Polyurethane Rubber AU, EU	152
10.1.2.18.	Polysiloxane Rubber Q	152
10.1.3.	Density of rubbers	152
10.2.	Antioxidants, antidegradants [1] [2] [3] [12]	155
10.3.	Accelerators [1] [3] [11]	157
10.4.	Processing safety of peroxides	161
10.5.	Factices	161
10.5.1.	Trade names of factices	161
10.5.2.	Application for NR, IR, and SBR types	162
10.5.3.	Application for special rubbers	163
10.6.	Fatty acids	164
10.7.	Flame retardants	164
10.8.	Fillers	165
10.8.1.	Light fillers	165
10.8.2.	Carbon black	167
10.8.3.	Zinc oxide types	167
10.8.4.	Refractive indices of pigments [16]	167
10.8.5.	Water absorption of fillers [17]	168
10.9.	Resins [8]	168
10.9.1.	Adhesive resins	168
10.9.2.	Reinforcing resins	169
10.9.3.	Curing resins [18]	169
10.10.	Processing aids [19]	170

10.11.	Waxes and solid plasticizers	171
10.12.	Plasticizers	171
10.12.1.	Mineral oil plasticizers	171
10.12.2.	Selection of special synthetic plasticizers	172
10.13.	Peptizers	172
10.14.	Retarders	173
10.15.	Antiozonant waxes	174
10.16.	Sulfur	174
10.16.1.	Sulfur grades	174
10.16.2.	Sulphur donors	175
10.16.3.	Fire and explosion hazards with sulphur [10]	176
10.17.	Solvents	176
10.18.	Reclaims	178
10.19.	Densimetry	178
10.20.	Density of other auxiliary agents	179
	References Section 10	179
11.	Statistical Calculation Procedures	181
11.1.	Linear regression analysis	181
11.2.	Binominal distribution	182
11.3.	Poisson distribution	183
11.4.	Normal distribution	183
11.5.	t-distribution	185
	References Section 11	186
12.	Signs, Abbreviations and Sources on Toxicity of Chemicals	187
	References Section 12	188
13.	Appendix	189
13.1.	Physical units and their conversion	189
13.2.	Greek alphabet	194
14.	Index	195