

Contents

Preface	V
Preface to the German Edition	IX
1 PVC Stabilizers	1
1.1 The Production of Polyvinyl Chloride (PVC)	1
1.2 Thermal Degradation of PVC	5
1.3 One-Packs	7
1.4 Heat Stabilizers for PVC	8
1.4.1 Metal-Free Base Stabilizers	9
1.4.2 Metal Soaps as Base Stabilizers	14
1.4.3 Tin Stabilizers	19
1.4.4 Lead Stabilizers	24
1.4.5 Rare Earth Stabilizers	28
1.5 Costabilizers for PVC	29
1.5.1 Inorganic Costabilizers	29
1.5.2 Antioxidants	33
1.5.3 β -Diketones and Derivatives	36
1.5.4 Epoxy Compounds	40
1.5.5 Organic Phosphites	41
1.5.6 Polyols	43
1.5.7 Perchlorates	46
1.6 Guide Formulations	46
1.6.1 Additives for PVC Products in Contact with Drinking Water and Foodstuffs	46
1.6.2 Individual Guide Formulations	46
1.6.2.1 Guide Formulations for Pipes	47
1.6.2.2 Guide Formulations for Profiles	51
1.6.2.3 Guide Formulations for Sheets	53
1.6.2.4 Guide Formulations for Rigid Films	56
1.6.2.5 Guide Formulations for Cables	58

1.6.2.6	Guide Formulations for Flexible PVC Applications	62
1.7	Test Methods	67
1.7.1	Mixing	68
1.7.2	Dispersibility	69
1.7.3	Production of Rolled Sheets	70
1.7.4	Rheology	70
1.7.5	Degree of Gelation	73
1.7.6	Softening Temperature	75
1.7.7	Thermostability	75
1.7.7.1	Static Thermostability	76
1.7.7.2	Dynamic Thermostability	78
1.7.8	Light Stability	81
1.7.9	Color	84
1.7.10	Gloss	86
1.7.11	Electrical Volume Resistance and Capacitance	86
1.7.12	Fogging	87
1.7.13	Plate-Out	88
1.7.14	Shore Hardness	88
1.7.15	Impact Strength	89
1.8	Trends and Tendencies	92
1.8.1	PVC Producers, Production Capacities, and PVC Consumption	92
1.8.2	Lead Substitution: The Voluntary Commitment of the European PVC Industry and Other National Regulations	93
1.8.3	Recycling of PVC Products	94
1.8.4	Wood-PVC Composites	96
1.9	Analysis of Some Technical Problems with PVC Processing and Suggestions for Solutions	98
1.9.1	Plate-Out	98
1.9.2	Photo Effects	98
1.9.3	Extrusion Troubleshooting Guide	99
1.10	Stabilizer Producers	104
	References	108
2	Additional PVC Additives	115
2.1	Lubricants	115
2.1.1	Introduction	115
2.1.2	Lubricants: Chemistry and Mechanisms of Action	118
2.1.3	Methods to Characterize and Test Lubricants	134
2.1.4	Lubricant Producers	135
2.2	Functional Fillers	136
2.2.1	Introduction	136

2.2.2	Fillers: Chemistry and Effects	137
2.2.3	Methods to Characterize and Test Functional Fillers	160
2.2.4	Filler Producers	162
2.3	Plasticizers	164
2.3.1	Introduction	164
2.3.2	Plasticizers: Chemistry and Mechanisms of Action	166
2.3.3	Methods to Characterize and Test Plasticizers	184
2.3.4	Plasticizer Producers	185
2.4	Titanium Dioxide	187
2.4.1	Introduction	187
2.4.2	Titanium Dioxide: Chemistry and Mechanisms of Action	188
2.4.3	Methods to Characterize and Test Titanium Dioxides	198
2.4.4	Titanium Dioxide Producers	199
2.5	Processing Aids and Impact Modifiers	200
2.5.1	Introduction	200
2.5.2	The Chemistry and Effects of Processing Aids and Impact Modifiers	200
2.5.2.1	Processing Aids or Flow Modifiers	200
2.5.2.2	Impact Modifiers	204
2.5.3	Methods to Characterize and Test Processing Aids and Impact Modifiers	219
2.5.3.1	Flow Modifiers and Processing Aids	220
2.5.3.2	Impact Modifiers	221
2.5.4	Producers of Processing Aids and Impact Modifiers	224
	References	227
3	Uncharted Territory in PVC Processing: Plate-Out	233
3.1	Literature Review of Plate-Out	233
3.2	Plate-Out in the Venting Unit	237
3.3	Plate-Out in the Tooling and Adapter	240
3.3.1	Typical Compositions of Plate-Out from the Tooling	240
3.3.2	Laboratory Experiments	241
3.3.2.1	Introduction	241
3.3.2.2	The Influence of Moisture	242
3.3.2.3	The Influence of the Mixing Process	245
3.3.2.4	The Influence of Tooling Quality	247
3.3.2.5	The Influences of Mass Temperature, Mass Pressure and Extrusion Torque, Chalk, Titanium Dioxide, and Modifiers	247
3.3.2.5.1	Analysis of the Raw Data by Software (ECHIP)	249
3.3.2.5.2	The Influence of Extrusion Parameters	250

3.3.2.5.3	The Influence of Chalk.....	252
3.3.2.5.4	The Influence of Titanium Dioxide.....	254
3.3.2.5.5	The Influence of Impact Modifiers.....	257
3.3.2.5.6	The Influence of CPE Modifiers.....	259
3.3.2.6	The Influence of Lubricants and Metal Soaps.....	261
3.3.2.6.1	The Influence of Polyethylene Waxes.....	261
3.3.2.6.2	The Influence of Calcium Stearate.....	265
3.3.2.6.3	The Influence of Oxidized Polyethylene Waxes.....	267
3.3.3	Summary for Plate-Out in Tooling and Adapter.....	270
3.4	Plate-Out in the Calibration.....	271
3.4.1	Typical Compositions of Calibration Plate-Out.....	272
3.4.2	Possible Mechanisms for the Formation of Plate-Out in the Calibration.....	272
3.4.3	Investigations of Plate-Out Formation in the Calibration.....	274
3.5	Troubleshooting Guide for the Prevention of Plate-Out.....	278
	References.....	279
4	Uncharted Territory in the Use of PVC Products: Photo Effects.....	281
4.1	Literature Review of Photochemical Degradation of PVC Products.....	281
4.1.1	Photochemical Degradation of PVC.....	281
4.1.2	Degradation of PVC Phthalate Plasticizers During Weathering.....	288
4.2	Photobluing.....	289
4.2.1	Fundamental Experiments.....	289
4.2.2	Results and Discussion.....	290
4.2.2.1	Reproducibility and the Comparison of Xeno Test and Outdoor Weathering.....	290
4.2.2.2	Influence of the PVC Stabilizer.....	291
4.2.2.3	Influence of the Stabilizer Producer.....	293
4.2.2.4	Influence of PVC, Chalk, and the Processing Conditions.....	294
4.2.2.5	Influence of Modifiers and White Pigment.....	295
4.2.2.6	Influence of the Lattice Structure of Titanium Dioxide.....	296
4.2.2.7	Influence of the Titanium Dioxide Coating.....	296
4.2.2.8	Influence of Titanium Dioxide Levels.....	298
4.2.2.9	Influence of Oxygen.....	298
4.2.3	Conclusions and Summary for Photobluing.....	299
4.2.4	Outlook.....	300
4.3	Photopinking.....	300
4.4	Photograying.....	303
4.4.1	True Photograying.....	303
4.4.2	Apparent Photograying.....	304
4.5	Environmental Influences on the Weathering of Plastic Windows.....	307

4.5.1	Introduction.....	307
4.5.2	Rust Film	308
4.5.3	Soot.....	311
4.5.4	Pollen.....	312
4.5.5	Simulation of Environmental Effects	312
4.5.5.1	The Samples	313
4.5.5.2	A Simulation Method: The Bandol Wheel	321
4.5.5.3	Irradiation Trials without Contaminants.....	322
4.5.5.4	Irradiation Trials with Rust Film WJ 364 as Contaminant	324
4.5.5.5	Irradiation Trials with Soot WJ 365 as Contaminant.....	328
4.5.5.6	Irradiation Trials with Pollen as Contaminant.....	330
4.5.5.7	Summary of Bandol Wheel Experiments and Conclusions	334
4.5.6	Investigations by Xeno Test.....	335
4.5.7	Restoration.....	338
4.5.8	What Has Changed for Window Profiles in the Last 20 Years: A Review.....	339
4.6	Chalk as Filler in u-PVC Products: New Insights into Influences on Weathering Behavior	344
4.6.1	Formation of Calcium Oxalate	345
4.6.1.1	Calcium Oxalate and Oxalic Acid: Influence on Artificial Weathering.....	345
4.6.1.2	Calcium Oxalate: A Product Resulting from Weathering of Plastic Window Frames?	346
4.6.1.3	Summary of Findings Regarding Oxalate Formation.....	349
4.6.2	Influence of Trace Elements in Chalk on Weathering	349
4.6.2.1	Directed Contamination by Trace Elements	349
4.6.2.2	Results of Artificial Weathering with Xeno Test	352
4.6.2.3	Summary of Investigations into the Influence of Trace Elements in Chalks on Weathering of PVC Profiles.....	352
4.6.3	Calcium Carbonate as Filler and the Chalking of PVC Pipes	355
4.6.3.1	Materials and Methods	356
4.6.3.2	Influence on Appearance	357
4.6.3.3	Results of Outdoor Weathering.....	359
4.6.3.3.1	Observations for the Test Series Started in February 2007	360
4.6.3.3.2	Observations for the Test Series Started in June 2007	361
4.6.3.4	Conclusion and Summary	362
	References	363

5	PVC and Sustainability	369
5.1	A Changing World	369
5.2	From Business to Business	370
5.3	From Business to Society	372
5.4	Chemicals in a Changing World	375
5.5	The Relevance for PVC	376
5.6	PVC in the Scientific Assessment	377
5.7	The Engagement of the European PVC Industry for Sustainable Development	380
5.8	The Sustainability Challenges Resulting from the TNS Framework	384
5.9	Biodiversity–The Sixth Challenge?	386
5.10	Schedule For a Sustainable Future	387
5.11	Do We Accept the Challenges?	392
5.12	Synergistic Progress with Vinyl 2010 and VinylPlus	393
5.13	Innovation by Progress	394
5.14	Further Advantages of Proactivity for a Sustainable Development	397
5.15	The Pedigree for PVC	400
5.16	Sustainability Without Myths	406
5.17	PVC and the Future	407
	References	408
	About the Author	411
	Subject Index	413