Modifiers for Wood Plastic Composites (WPC)
Background

Wood Plastic Composites (WPC) belong to a group of natural fiber-reinforced compounds in which wood fibers (or wood flour) are used as reinforcing fillers in amounts generally ranging from 50 to 80%. A number of other natural fibers can be used for comparable applications, for example, hemp, flax, sisal, and coconut fibers. However, wood fibers are used most frequently on a volume basis. Polymeric materials such as polyethylene (PE), polypropylene (PP) and PVC are used as binders.

Advantages
WPC products are generally more expensive to produce than conventional wood materials, but have a number of advantages. Alongside much simpler forming and the variety of diversified shapes, they are more durable due to their better weather resistance. Because of their high wood content, WPC are significantly more attractive, both on a cost and technical basis, than products made of pure plastic. They are frequently used as a replacement for tropical timber on account of their longevity, thereby contributing to the preservation of ecologically important tropical forests.

Applications
Wood plastic composite materials are used wherever wood has traditionally been employed. First and foremost, WPC is employed as a flooring material (decking) mainly outdoors, but also indoors. WPC is also used as railing, privacy fencing, exterior wall cladding, furniture and much more.

Manufacture
WPC profiles, which are produced in a single or two-stage extrusion process, are the most commonly manufactured form of WPC (figure 1).

Single-stage Extrusion: This is a so-called direct extrusion process. The mixing of the wood fibers with the plastic granules (compounding) and the extrusion of the profile are performed in one step. Usually conical, counter-rotating double screw extruders are employed that are able to thoroughly mix the wood and plastic and generate the pressure required for extruding the specified profile.

Two-stage Extrusion: In this method, compounding and extrusion of the profile occur in two separate processes. In this case, the compound can be prepared using different types of extruders. Most often parallel, co-rotating double screw extruders are used. Planetary gear extruders for the particularly gentle preparation of highly filled compounds and heating/cooling mixer combinations are also used. Other mixing methods are pellet mills and special grinding methods in which the wood and the plastic are ground at the melting point range of the plastic. The profile is then usually produced using single-screw extruders.

If a WPC is manufactured according to the two-stage extrusion compounding process described above, it must not necessarily be extruded, but can also be further processed using other methods. Injection molding is mentioned here in particular because it is a technique that allows the manufacture of complex shapes. Other possibilities include rotational molding and the plate press method. In principle, WPC compounds can be processed by almost all conventional techniques used in plastics engineering. The limiting factor is usually the flow properties of the WPC, which are primarily determined by the wood content.
SCONA Modifiers in WPC

In figure 2, E-modulus and Charpy impact strength values are used to illustrate the dependence of the mechanical properties of a wood flour-filled polypropylene WPC on wood content. With increasing wood content, E-modulus values increase but impact strength decreases. Whereas an increase in the E-modulus is desirable, a reduction in the impact strength is certainly not.

Through the use of SCONA coupling agents, which significantly enhance the bonding of wood fibers with the polymer matrix, mechanical properties such as bending strength and impact strength of the composite material are also greatly improved (figure 3).

Furthermore, the ability to withstand higher temperatures and surface quality are enhanced. SCONA modifiers also reduce water uptake considerably, which results in improved dimensional stability. The latter is a very important factor for outdoor applications, such as decking boards.

Chemistry of the Modifiers
SCONA modifiers are always non-polar base polymers that are functionalized with diverse monomers in a grafting process (figure 4). The modifiers used in WPC are maleic anhydride-modified polypropylene and polyethylene.

All SCONA products are grafted using a patented solid-phase process, whereas the standard procedure is to graft the polymers with the monomers in the melt. In solid-phase grafting, a greater degree of functionalization is achieved, resulting in a lower required concentration of modifier in the compound. The content of volatile organic compounds (VOC) is extremely low in products manufactured using this method. Moreover, the low process
temperature causes less damage to the base polymer and the resulting higher molecular weight is reflected in the improved mechanical properties of the compound.

More details on the technology of the SCONA modifiers are presented in brochure TP-TI 2 “Technology of the SCONA Plastic Modifiers”.

The technology also offers the possibility to graft in a two-stage process. A conventional solid-phase grafting takes place in the first stage and is followed by a melt grafting in the second stage (figure 5). Even greater degrees of grafting can be achieved by means of this combination.

“SCONA TP…” products are SCONA modifiers that are manufactured by the solid-phase process only. “SCONA TS…” products are modifiers that are manufactured by the combined process.

Mechanism of Action
The maleic acid anhydride groups of the modifier react with the OH groups of the wood fibers to produce a chemically stable compound (figure 6). As a result, the fibers are optimally incorporated into the polymer matrix, which significantly improves the mechanical properties and increases the weather resistance of the compound.
Applications in Polypropylene
For polypropylene-based WPC, we recommend SCONA TPPP 8112 FA as the coupling agent. Figure 7 clearly shows how the mechanical properties and water uptake of a WPC is affected by the method used to manufacture the coupling agent. The values obtained using SCONA TPPP 8112 FA are uniformly better than those from a coupling agent produced by melt grafting. The values with the greatest differences are printed in red.


Advantages of a Coupling Agent Manufactured by Solid Phase Grafting
WPC with 60 % Lignocel P Super (Wood Flour), 38 % Polypropylene, 2 % Modifier

<table>
<thead>
<tr>
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</thead>
<tbody>
<tr>
<td>SCONA TPPP 8112 FA</td>
<td>Dry 42.9</td>
<td>Dry 42.9</td>
<td>Dry 5,040</td>
<td>Dry 11.6</td>
<td>6.5</td>
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<tr>
<td></td>
<td>Wet 35.1</td>
<td>Wet 26.1</td>
<td>Wet 3,320</td>
<td>Wet 7.2</td>
<td>8.9</td>
</tr>
<tr>
<td>Melt Grafting</td>
<td>Dry 47.6</td>
<td>Dry 26.1</td>
<td>Dry 4,820</td>
<td>Wet 7.2</td>
<td>8.9</td>
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<tr>
<td></td>
<td>Wet 37</td>
<td>Wet 18.6</td>
<td>Wet 2,290</td>
<td>Wet 6.7</td>
<td></td>
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</tbody>
</table>

Source: Fraunhofer-Institut für Werkstoffmechanik in Halle, Germany

Comparison of Several Established Coupling Agents

Figure 8 shows some of the results and illustrates the very good performance of the SCONA product in comparison to several other established coupling agents.

Figure 9 very clearly shows again the importance of having the highest possible content of MAH in the coupling agent. The greater the degree of grafting, the less coupling agent is required for saturating the wood surface. Waxes allow significantly higher rates of grafting, but the lower molecular weight of waxes results in poorer mechanical properties.

MFR (230 °C, 2.16 kg): PP-1: 40 g/10 min. PP-2: 1.5 g/10 min

Source: IFA-Tulln Institut für Naturstofftechnik, Tulln, Austria

Effect of MAH Content

WPC with PP and 40 % Wood Flour

Source: Dissertation of Klaus Specht, University of Kassel, Germany, 2007
It is very important to adjust the dosage in an existing formulation when replacing a coupling agent with low MAH content for a product with a higher MAH content. Otherwise, the expected improvement in mechanical properties after the substitution may not materialize or may even result in a decline in the properties. Figure 10 illustrates this: a coupling agent with 0.74 % MAH was used at a concentration of 3 %. If the same amount of a coupling agent with 1.72 % MAH is used instead, the bending strengths of the product are almost identical. If the amount of the latter coupling agent is reduced to 2 %, the resulting product has improved mechanical properties.

The critical factor is always the MAH content in the composite. The optimum in this case lies between 0.03 and 0.04 % MAH.

The modifier with the greater degree of grafting attains this value at a concentration of as little as 2 %, while a much higher concentration (approx. 5 %) is logically needed for the modifier with lower MAH content. The exact values vary for each specific application and with the raw materials used. Thus, it is always advisable to determine the optimal concentration by testing a series of concentrations.

### Improvement in the Mechanical Properties through Coupling Agents

![Graph showing improvement in mechanical properties through coupling agents](image1)

**WPC with PP and 40 % Wood Flour**
- Coupling Agent with 1.72 % MAH (Solid Phase Grafting)
- Coupling Agent with 0.74 % MAH (Melt Grafting)

### Comparison of the effect of LLDPE- and HDPE-based Coupling Agents on Mechanical Strength

![Graph showing comparison of mechanical strength](image2)

**Applications in Polyethylene**

At the outset of developing WPC for wider applications in Europe, the focus was primarily on using polypropylene as the matrix material. In contrast, HDPE was the preferred matrix polymer in the USA mainly due to the wide availability of recycled HDPE from packaging material. In recent years, HDPE has also been increasingly used as matrix material in Europe in light of the better UV stability of polyethylene. However, because of the inherently lower strength and rigidity of HDPE, the use of coupling agents for improving these properties and of course, for reducing water uptake, is especially important.
Two very highly grafted SCONA modifiers that are produced through the combination of solid-phase grafting and melt grafting are extremely suitable for this application. The base polymer is either LLDPE or HDPE. Which product is used in a specific case is very dependent upon the mixing units available and the specific objectives of the respective customer (figures 11 and 12).

HDPE-based SCONA TSPE 2102 GAHD produces very good results in all systems with respect to improvement in mechanical properties and reduction of water uptake. LLDPE-based SCONA TSPE 1112 GALL is not recommended for use in mixing units that do not work the material so intensely, such as a conical counter-rotating extruder, due to the limited miscibility of HDPE and LLDPE. In units that are able to achieve a more thorough mixing, for example a parallel, co-rotating extruder, this coupling agent does produce somewhat lower strength values (due to the lower inherent strengths), yet attains extremely good values for the reduction of water uptake.

Comparison of the Effect of LLDPE-based and HDPE-based Coupling Agents on Water Uptake

Product Recommendations for WPC

<table>
<thead>
<tr>
<th>Coupling Agent for PP</th>
<th>Base Polymer</th>
<th>Grafting</th>
<th>MFR (190 °C, 2.16 kg)</th>
<th>MAH Content</th>
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</thead>
<tbody>
<tr>
<td>SCONA TPPP 8112 FA</td>
<td>PP</td>
<td>Solid-phase</td>
<td>&gt; 80 g/10 min.</td>
<td>1.4 %</td>
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</table>

<table>
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<tr>
<th>Coupling Agents for PE</th>
<th>Base Polymer</th>
<th>Grafting</th>
<th>MFR (190 °C, 5 kg)</th>
<th>MAH Content</th>
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</thead>
<tbody>
<tr>
<td>SCONA TSPE 1112 GALL</td>
<td>LLDPE</td>
<td>Solid Phase + Melt</td>
<td>&gt; 5 g/10 min.</td>
<td>2 %</td>
</tr>
<tr>
<td>SCONA TSPE 2102 GAHD</td>
<td>HDPE</td>
<td>Solid Phase + Melt</td>
<td>&gt; 5 g/10 min.</td>
<td>1.7 %</td>
</tr>
</tbody>
</table>
Products and Applications

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