

CONTENTS

Preface	xxv
1. Foreword-Overview: Wood–Plastic Composites	1
WPC: Pricing Restrictions, 11	
WPC: Brands and Manufacturers, 15	
Flexural Strength, 15	
Flexural Modulus and Deflection, 17	
Deck Boards, 17	
Stair Treads, 18	
Thermal Expansion–Contraction, 20	
Shrinkage, 22	
Slip Resistance, 24	
Water Absorption, Swell, and Buckling, 26	
Microbial Degradation, 29	
Termite Resistance, 33	
Flammability, 35	
Oxidation and Crumbling, 36	
Photooxidation and Fading, 40	
Wood–Plastic Composites—Products, Trends, Market Size and Dynamics, and Unsolved (or Partially Solved) Problems, 42	
WPC Products, 42	
The Public View: Perception, 43	

- WPC Market Size and Dynamics, 44
- Competition on the WPC Market, 45
- Unsolved (or Only Partially Solved) R & D Problems, 48

References, 49

2. Composition of Wood–Plastic Composite Deck Boards: Thermoplastics

50

Introduction, 50

Polyethylene, 51

- Low-Density Polyethylene (LDPE), 54

- Medium-Density Polyethylene (MDPE), 55

- High-Density Polyethylene (HDPE), 55

Polypropylene, 56

Polyvinyl Chloride, 58

Acrylonitrile–Butadiene–Styrene Copolymer (ABS), 61

Nylon 6 and Other Polyamides, 62

Conclusion, 64

Addendum: ASTM Tests Covering Definitions of Technical Terms and Their Contractions Used in Plastic Industry and Specifications of Plastics, 67

- ASTM D 883 “Standard Terminology Relating to Plastics”, 67

- ASTM D 1600 “Standard Terminology for Abbreviated Terms Relating to Plastics”, 68

- ASTM D 1784 “Standard Specifications for Rigid Poly(Vinyl Chloride) (PVC) Compounds and Chlorinated Poly(Vinyl Chloride) (CPVC) Compounds”, 68

- ASTM D 1972 “Standard Practice for Generic Marking of Plastic Products”, 69

- ASTM D 4066 “Standard Classification System for Nylon Injection and Extrusion Materials (PA)”, 69

- ASTM D 4101 “Standard Specification for Polypropylene Injection and Extrusion Materials”, 70

- ASTM D 4216 “Standard Specification for Rigid Poly(Vinyl Chloride) (PVC) and Related PVC and Chlorinated Poly(Vinyl Chloride) (CPVC) Building Products Compounds”, 70

- ASTM D 4396 “Standard Specification for Rigid Poly(Vinyl Chloride) (PVC) and Chlorinated Poly(Vinyl Chloride) (CPVC) Compounds for Plastic Pipe and Fittings Used in Nonpressure Applications”, 70

- ASTM D 4673 “Standard Classification System for Acrylonitrile–Butadiene–Styrene (ABS) Plastics and Alloys Molding and Extrusion Materials”, 70

- ASTM D 4976 “Standard Specification for Polyethylene Plastics Molding and Extrusion Materials”, 71

- ASTM D 5203 "Standard Specification for Polyethylene Plastics Molding and Extrusion Materials from Recycled Postconsumer (HDPE) Sources", 72
- ASTM D 6263 "Standard Specification for Extruded Rods and Bars Made from Rigid Poly(Vinyl Chloride) (PVC) and Chlorinated Poly(Vinyl Chloride) (CPVC)", 72
- ASTM D 6779 "Standard Classification System for Polyamide Molding and Extrusion Materials (PA)", 73

References, 73

3. Composition of Wood–Plastic Composites: Cellulose and Lignocellulose Fillers

75

Introduction, 75

A Brief History of Cellulose Fillers in WPC in U.S. Patents, 78

Beginning of WPC: Thermosetting Materials, 79

Cellulose as a Reinforcing Ingredient in Thermoplastic Compositions, 80

Improving Mechanical and Other Properties of WPC, 83

Improving the Compatibility of the Filler with the Polymeric Matrix: Coupling Agents, 84

Plastics Beyond HDPE in Wood–Plastic Composite Materials, 87

Cellulose–Polyolefin Composite Pellets, 89

Foamed Wood–Plastic Composites Materials, 90

Biodegradable Wood–Plastic Composites, 91

General Properties of Lignocellulosic Fiber as Fillers, 92

Chemical Composition, 92

Detrimental Effects of Lignin, 95

Detrimental Effects of Hemicellulosics: Steam Explosion, 96

Aspect Ratio, 97

Density (Specific Gravity), 98

Particle Size, 99

Particle Shape, 99

Particle Size Distribution, 100

Particle Surface Area, 100

Moisture Content, the Ability to Absorb Water, 100

The Ability of Filler to Absorb Oil, 101

Flammability, 101

Effect on Mechanical Properties of the Composite Material, 101

Effect on Fading and Durability of Plastics and Composites, 103

Effect on Hot Melt Viscosity, 104

Effect on Mold Shrinkage, 105

Wood Fiber, 105

Wood Flour, 105

Sawdust, 106

Rice Hulls, 106

VOC from Rice Hulls, 108

Long Natural Fiber, 110

Papermaking Sludge, 111

Biodac[®], 112

VOC from Biodac[®], 112

Rice Hulls and Biodac[®] as Antioxidants in WPC, 114

References, 115

4. Composition of Wood–Plastic Composites: Mineral Fillers

123

Introduction, 123

General Properties of Mineral Fillers, 125

Chemical Composition, 125

Aspect Ratio, 125

Density (Specific Gravity), 125

Particle Size, 126

Particle Shape, 127

Particle Size Distribution, 128

Particle Surface Area, 128

Moisture Content: The Ability to Absorb Water, 128

The Ability to Absorb Oil, 129

Flame Retardant Properties, 129

Effect on Mechanical Properties of the Composite Material, 129

Effect on Hot Melt Viscosity, 131

Effect on Mold Shrinkage, 131

Thermal Properties, 132

Color: Optical Properties, 132

Effect on Fading and Durability of Plastics and Composites, 132

Health and Safety, 133

Fillers, 133

Calcium Carbonate (CaCO_3), 133

Talc, 137

Biodac[®] (a Blend of Cellulose and Mineral Fillers), 141

Silica (SiO_2), 145

Kaolin Clay ($\text{Al}_2\text{O}_3 \cdot 2\text{SiO}_2 \cdot 2\text{H}_2\text{O}$), 146

Mica, 146

Wollastonite (CaSiO_3), 147

Glass Fibers, 147

Fly Ash, 148
Carbon Black, 154
Nanofillers and Nanocomposites, 154

Conclusions, 156
References, 159

5. Composition of Wood–Plastic Composites: Coupling Agents 161

Introduction, 161
Why Such a Task?, 162
A Brief Overview of the Chapter, 163
Maleated Polyolefins (Polybond, Integrate, Fusabond, Epolene, Exxelor, Orevac, Lotader, Scona, and Unnamed Series), 165
Organosilanes (Dow Corning Z-6020, Momentive A-172 and Others), 171
Metablen™ A3000 (Acrylic-Modified Polytetrafluoroethylene, PTFE), 173
Other Coupling Agents, 174
Effect of Coupling Agents on Mechanical Properties of Wood-Plastic Composites: Experimental Data, 174
Mechanisms of Crosslinking, Coupling and/or Compatibilizing Effects, 180
 Spectroscopic Studies, 180
 Rheological Studies, 186
 Kinetic Studies, 188
 Other Considerations, 189
Effect of Coupling Agents on WPC Properties: A Summary, 191
 Effect on Flexural and Tensile Modulus, 192
 Effect on Flexural and Tensile Strength, 193
 Effect on Water Absorption, 194
Lubricants, Compatible and not Compatible with Coupling Agent, 194
References, 199

6. Density (Specific Gravity) of Wood-Plastic Composites and Its Effect on WPC Properties 202

Introduction, 202
Effect of Density (Specific Gravity) of WPC, 205
 Effect on Flexural Strength and Modulus, 205
 Effect on Oxidation and Degradation, 205
 Effect on Flammability, Ignition, Flame Spread, 208
 Effect on Moisture Content and Water Absorption, 209
 Effect on Microbial Contamination/Degradation, 210
 The Effect on Shrinkage, 211
 The Effect on the Coefficient of Friction (The Slip Coefficient), 211

Density of Cross-Sectional Areas of Hollow Profiles of GeoDeck WPC Boards,	212
Densities and Weight of Some Commercial Wood–Plastic Deck Boards,	215
Determination of Density of Wood–Plastic Composites Using a Sink/Float Method,	216
ASTM Tests Recommended for Determination of the Specific Gravity (Density),	218
ASTM D 6111 “Standard Test Method for Bulk Density and Specific Gravity of Plastic Lumber and Shapes by Displacement”,	218
ASTM D 792 “Standard Test Method for Density and Specific Gravity (Relative Density) of Plastics by Displacement”,	219
ASTM D 1505 “Standard Test Method for Density of Plastics by the Density-Gradient Technique”,	220
ASTM D 1622 “Standard Test Method for Apparent Density of Rigid Cellular Plastics”,	222
ASTM D 1895 “Standard Test Methods for Apparent Density, Bulk Factor, and Pourability of Plastic Materials”,	223
References,	224

7. **Flexural Strength (MOR) and Flexural Modulus (MOE) of Composite Materials and Profiles** 225

Introduction,	225
Basic Definitions and Equations,	225
Moment of Inertia,	228
Bending Moment,	231
ASTM Recommendations,	234
ASTM D 790, “Standard Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials”,	234
ASTM D 6109, “Standard Test Methods for Flexural Properties of Unreinforced and Reinforced Plastic Lumbers”,	238
ASTM D 6272, “Standard Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials by Four-Point Bending”,	241
Flexural Strength of Composite Deck Boards,	244
English Units and SI Units,	244
Center Point Load, or Concentrated Load (3-pt Load),	244
Third-Point Load (4-pt. Load, or 1/3-Span Load),	247
Flexural Strength of Composite Deck Boards,	248
Flexural Strength of Materials Versus Profiles,	251
Flexural Strength for the Same Material but for Different Profiles,	252

- Comparison of Center-Point Load and Third-Point Load, 252
- Quarter-Point Load (4-pt Load, 1/4-Point Load), 253
- Uniformly Distributed Load, 255
- Effect of Temperature on Flexural Strength of Composite Materials, 256
- Effect of Commercial HDPE Materials on Flexural Strength of Composite Deck Boards, 257
- Effect of Density (Specific Gravity) of Composite Materials on Flexural Strength, 258
- Flexural Strength of Neat HDPE and Other Plastics, and Comparisons with that for WPCs, 258
- Effect of Plastic Content on Flexural Strength of Composite Materials, 259
- A Deck Board Used as a Stair Tread, 259
- Flexural Modulus of Composite Deck Boards, 264
 - Center-Point Load, or Concentrated Load (3-pt Load), 264
 - Third-Point Load (4-pt. Load, or 1/3-Span Load), 265
 - Flexural Modulus of Composite Deck Boards, 266
 - Flexural Modulus of Materials Versus Profiles, 267
 - Flexural Modulus for the Same Material but for Different Profiles: Solid and Hollow Deck Boards, 267
 - Comparison of Center-Point Load and Third-Point Load, 270
 - Quarter-Point Load (4-pt Load, 1/4-Point Load), 270
 - Uniformly Distributed Load, 272
 - Snow on a Deck, 272
 - Strength, 272
 - Deflection, 273
 - Effect of Temperature on Flexural Modulus of Composite Materials, 274
 - Effect of Commercial HDPE on Flexural Modulus of Composite Deck Boards, 275
 - Effect of Density (Specific Gravity) on Flexural Modulus, 276
 - Effect of Plastic Content on Flexural Modulus of Composite Materials, 276
- Flexural Modulus of Neat HDPE and Other Plastics and Comparisons with that for WPCs, 278
- A Deck Board Used as a Stair Tread: A Critical Role of Flexural Modulus, 280
- Deflection of Composite Materials: Case Studies, 281
 - Deflection and Bending Moment of a Soundwall Under Windloads, 281
 - Deflection of a Fence Board, 287
 - Deflection of WPC Joists, 288
 - Deflection of a Deck Under a Hot Tub, 289

Deflection of a Hollow Deck Board Filled with Hot Water, 290
 Deflection and Creep of Composite Deck Boards, 291

Guardrail Systems, 302

Composite (and PVC) Railing Systems for Which ICC-ES Reports were
 Issued Until November 2006, 307

Combined Flexural and Shear Strength: a “Shotgun” Test, 311

Mathematical Modeling of WPCs and the Real World, 312

Verification of the Mathematical Model with Actual Conventional
 and Modified Composite Boards, 315

Weight, 315

Flexural Strength, 317

Flexural Modulus, 317

Impact Resistance, 317

References, 318

8. Compressive and Tensile Strength and Modulus of Composite Profiles

319

Introduction, 319

Basic Definitions and Equations, 320

ASTM Recommendations, 320

ASTM D 638, “Standard Test Methods for Tensile Properties
 of Plastics”, 320

ASTM D 5083 “Test Methods for Tensile Properties of Reinforced
 Thermosetting Plastics Using Straight-Sided Specimens”, 323

ASTM D 695, “Standard Test Method for Compressive Properties of Rigid
 Plastics”, 324

ASTM D 6108, “Standard Test Methods for Compressive Properties of
 Unreinforced and Reinforced Plastic Lumbers”, 325

Tensile Strength of Composite Materials, 326

Compressive Strength of Composite Materials: Examples, 328

Tensile Modulus of Elasticity of Composite Materials, 329

Compressive Modulus of Composite Materials, 331

References, 332

9. Linear Shrinkage of Extruded Wood–Plastic Composites

333

Introduction, 333

Origin of Shrinkage, 333

Size of Shrinkage, 336

Effect of Density (Specific Gravity) of WPC on Its Shrinkage, 337

Effect of Extrusion Regime on Shrinkage, 338

Annealing of Composite Boards, 338

Warranty Claims: Geodeck Composite Deckboards, 340
Examples of Composite Boards Shrinkage on a Deck, 345
References, 355

10. Temperature Driven Expansion–Contraction of Composite Deck Boards: Linear Coefficient of Thermal Expansion–Contraction 356

Introduction, 356
Linear Coefficient of Expansion–Contraction, 357
Some Reservations in Applicability of Coefficients of Expansion–Contraction, 358
ASTM Tests Recommended for Determination of the Linear Coefficient of Thermal Expansion–Contraction, 359
 ASTM D 696 “Standard Test Method for Coefficient of Linear Thermal Expansion of Plastics Between –30°C and 30°C with a Vitreous Silica Dilatometer”, 359
 ASTM D 6341 “Standard Test Method for Determination of the Linear Coefficient of Thermal Expansion of Plastic Lumber and Plastic Lumber Shapes Between –30 and 140°F (–34.4 and 60°C)”, 361
 ASTM E 228 “Standard Test Method for Linear Thermal Expansion of Solid Materials with a Vitreous Silica Dilatometer”, (Withdrawn), 361
Linear Coefficient of Thermal Expansion–Contraction for Wood–Plastic Composites. Effect of Fillers and Coupling Agents, 362
References, 368

11. Slip Resistance and Coefficient of Friction of Composite Deck Boards 369

Introduction, 369
 Definitions, 369
 Explanations and Some Examples, 371
Slip Resistance of Plastics, 371
Slip Resistance of Wood Decks, 373
Slip Resistance of Wood–Plastic Composite Decks, 373
ASTM Tests Recommended for Determining Static Coefficient of Friction, 376
 ASTM D 2047 “Standard Test Method for Static Coefficient of Friction of Polish-Coated Floor Surfaces as Measured by the James Machine”, 376
 ASTM F 1679 “Standard Test Method for Using a Variable Incidence Tribometer (VIT)”, 376
 ASTM D 2394 “Standard Method for Simulated Service Testing of Wood and Wood-Base Finish Flooring”, 377
Slip Resistance Using an Inclined-Plane Method, 378

- Effect of Formulation of Composite Deck Boards on Slip Resistances: Slip Enhancers, 381
- References, 382

12. Water Absorption by Composite Materials and Related Effects 383

- Introduction, 383
- “Near-Surface” Versus “Into the Bulk” Distribution of Absorbed Water in Composite Materials, 384
- Effect of Mineral Fillers on Water Absorption, 385
- Swelling (Dimensional Instability), Pressure Development, and Buckling, 386
- Short- and Long-Term Water Absorption, 396
- ASTM Recommendations, 399
 - ASTM D 570, “Standard Test Methods for Water Absorption of Plastics”, 399
 - ASTM D 1037, “Standard Test Method for Evaluating Properties of Wood-Based Fiber and Particle Panel Materials”, 400
 - ASTM D 2842 “Test Methods for Water Absorption of Rigid Cellular Plastics”, 402
 - ASTM D 6662 “Standard Specification for Polyolefin-Based Plastic Lumber Decking Boards” 402
 - ASTM D 7032 “Standard Specification for Establishing Performance Ratings for Wood–Plastic Composite Deck Boards and Guardrail Systems (Guards or Handrails)”, 402
- Effect of Cellulose Content in Composite Materials on Water Absorption, 403
- Effect of Board Density (Specific Gravity) on Water Absorption, 403
- Moisture Content of Wood and Wood–Plastic Composites, 405
- Effect of Water Absorption on Flexural Strength and Modulus, 406
- Freeze–Thaw Resistance, 407
 - Effect of Board Density on Freeze–Thaw Resistance — A Case Study, 407
 - Effect of Board Density and Weathering on Freeze–Thaw Resistance—A Case Study, 408
 - Effect of Multiple Freeze–Thaw Cycles, 409
- Comparison of Water Absorption of Some Composite Deck Boards Available in the Market, 409
- References, 411

13. Microbial Degradation of Wood–Plastic Composite Materials and “Black Spots” on the Surface: Mold Resistance 412

- Introduction, 412
 - Microbial Effects on Wood–Plastic Composites, 412

- Mold and Spores, 413
- Moisture and Ventilation: Critical Moisture Content, 413
- Wood Decay Fungi, 414
- Biocides and “Mold Resistance”, 415

Preservatives for Wood Lumber, 416

- CCA, 416
- ACQ, 417
- PCP (The U.S. EPA Data), 417
- Creosote (The U.S. EDA Data), 417

Microorganisms Active in Degradation and Staining of Composite Materials, 418

- Molds, 418
- Black Mold, 424
- Black Algae, 426
- Case Study 1: Staining with a Microbial Pigment, 427
- Case Study 2: Deck as a Mold Incubator, 428
- Case Study 3: Black Mold due to Low Density of a Composite Material and High Moisture, 429

Microbial Infestation of Wood–Plastic Composite Materials, 430

- Requirements for Microbial Growth on Wood and Wood–Plastic Composites, 430

Sensitivity and Resistance of Composite Materials to Microbial Degradation: Examples, 431

ASTM Tests for Microbial Growth and Degradation of Wood–Plastic Composites, 434

- ASTM D 1413 “Standard Test Method for Wood Preservatives by Laboratory Soil-Block Cultures”, 434

- Examples: Wood, 436

- Examples: Wood–Plastic Composites, 436

- ASTM D 2017 “Standard Method of Accelerated Laboratory Test of Natural Decay Resistance of Woods” (Discontinued), 438

- ASTM E 2180 “Standard Test Method for Determining the Activity of Incorporated Antimicrobial Agent(s) in Polymeric or Hydrophobic Materials”, 438

- ASTM G 21 “Standard Practice for Determining Resistance of Synthetic Polymeric Materials to Fungi”, 439

Effects of Formulation on Sensitivity and Resistance of Wood–Plastic Composites to Microbial Degradation, 440

Biocides Used (Actually or Under Consideration) in Wood–Plastic Composites, 440

- Zinc Borate, (e.g., Borogard [U.S. Borax], Fiberguard [Royce International]), 440
- Barium Metaborate, Busan, 444
- Folpet, Fungitrol 11, Intercede TMP (carboximide), 444
- Chlorothalonil (tetrachloroisophthalonitrile), Nuocide 960, 449
- OBPA, Intercede ABF (10,10'-Oxybisphenoxyarsine), Vinizene BP 5-5, 449
- IPBC, Polyphase®, Troy®, Intercede IBF (2-iodo-2-propynyl-*n*-butylcarbamate, 3-iodo-2-propynyl-*n*-butylcarbamate), 451
- OIT, DCOIT, Octhilinone, Micro-Chek, Intercede OBF (2-*n*-Octyl-4-isothiazolin-3-one), 451
- Zinc Pyrithione, Zinc Omadine, Intercede ZNP, Zinc Derivative of Mercaptopyridine 1-oxide, 452
- Thiabendazole, Irgaguard F3000, 2-(4-Thiazolyl)-1*H*-benzimidazole, 4-(2-Benzimidazolyl)thiazole, Thiabendazole, MK-360, TBZ, 453

Biocides: Accelerated Laboratory Data and the Real World, 453
References, 459

14. Flammability and Fire Rating of Wood-Plastic Composites 461

- Introduction, 461
- Flammability of Wood, 462
- Ignition of Composite Materials, 463
- Flame Spread Indexes and Fire Rating of Composite Materials, 464
- Effect of Mineral Fillers on Flammability, 467
- Smoke and Toxic Gases, and Smoke Development Index, 467
- Flame Retardants for Plastics and Composite Materials, 468
 - Flame Retardants in Plastics, 471
 - Restrictions or Prohibitions of Some Brominated Flame Retardants, 471
 - Chlorine-Containing Flame Retardants, 472
 - ATH (Aluminum Trihydrate) and MDH (Magnesium Hydroxide), 473
 - ATH Dehydration: A Quantitative Approach, 474
 - Flame Retardants with Wood-Plastic Composites, 476
 - Nanoparticles as Flame Retardants, 476
- ASTM Recommendations, 477
 - ASTM D 635 "Standard Test Method for Rate of Burning and/or Extent and Time of Burning of Plastics in a Horizontal Position", 478
 - ASTM D 1929 "Standard Test Method for Determining Ignition Temperature of Plastics", 478
 - ASTM E 84, "Standard Test Method for Surface Burning Characteristics of Building Materials", 480
 - ASTM E 1354 "Standard Test Method for Heat and Visible Smoke Release Rates for Materials and Products Using an Oxygen Consumption Calorimeter", 482

- E 162 “Standard Test Method for Surface Flammability of Materials Using a Radiant Heat Energy Source”, 483
- E 662 “Standard Test Method for Specific Optical Density of Smoke Generated by Solid Materials”, 484

Fire Performance of Composite Decks and Deck Boards, 485

References, 491

15. Thermo- and Photooxidative Degradation and Lifetime of Composite Building Materials 493

Introduction. Lifetime of Plastics and Plastic-based Composites: Examples, 493

Thermooxidation, Photooxidation, Oxidative Degradation, and Product Crumbling and Failure, 496

Factors Accelerating the Oxidative Degradation of Composites, 502

Density (Specific Gravity) of the Composite, 503

Temperature, 508

The Physical and the Chemical Structure of the Polymer, 514

History of Plastic (Virgin, Recycled), 516

The Type and Amount of Cellulose Fiber, 516

The Type and Amount of Mineral Fillers, 517

The Presence of Stress, 517

The Presence of Metal Catalysts, 522

The Presence of Moisture, 524

Antioxidants and Their Amounts, 526

Solar Radiation (UV Light), 531

Amount of Added Regrinds, If Any, 540

ASTM Recommendations, 541

ASTM Tests for Oxidative Induction Time, 541

ASTM D 3895 “Standard Test Method for Oxidative Induction Time of Polyolefins by Differential Scanning Calorimetry”, 541

ASTM D 5885 “Standard Test Method for Oxidative Induction Time of Polyolefin Geosynthetics by High-Pressure Differential Scanning Calorimetry”, 545

ASTM Tests for Determination of Phenolic Antioxidants in Plastics, 546

ASTM D 1996 “Standard Test Method for Determination of Phenolic Antioxidants and Erucamide Slip Additives in Low-Density Polyethylene Using Liquid Chromatography”, 547

ASTM D 5524 “Standard Test Method for Determination of Phenolic Antioxidants in High-Density Polyethylene Using Liquid Chromatography”, 548

ASTM D 5815 “Standard Test Method for Determination of Phenolic Antioxidants and Erucamide Slip Additives in Linear Low-Density Polyethylene Using Liquid Chromatography”, 548

- ASTM D 6042 “Standard Test Method for Determination of Phenolic Antioxidants and Erucamide Slip Additives in Polypropylene Homopolymer Formulations Using Liquid Chromatography”, 548
- ASTM D 6953 “Standard Test Method for Determination of Antioxidants and Erucamide Slip Additives in Polyethylene Using Liquid Chromatography”, 548
- ASTM D 3012 “Standard Test Method for Thermal-Oxidative Stability of Polypropylene Using a Specimen Rotator Within an Oven, 549
- ASTM D 5510 “Standard Practice for Heat Aging of Oxidatively Degradable Plastics”, 550

- Surface Temperature of Composite Decking and Railing Systems, 550
- Life Span of Zero-Antioxidant GeoDeck Decks in Various Areas of the United States, 556
- The OIT and Lifetime of Composite Deck Boards, 564
- Durability (in Terms of Oxidative Degradation) of Wood-Plastic Composite Deck Boards Available in the Current Market, 565
- Oxidative Degradation and Crumbling of GeoDeck Deck Boards: History of the Case and Correction of the Problem, 567
 - Density, Porosity, and Mechanical Properties of GeoDeck before the Problem had Emerged, 567
 - Emerging of the Problem, 569
 - Density (Specific Gravity) of GeoDeck Boards in Pre-October 2003, 569
 - Correction of the Crumbling Problem, 570
 - Antioxidant Level, 570
 - Density, 571
 - The OIT Procedure: Proxy of Lifetime at Accelerated Oxidation, 571
 - Accelerated (Artificial) Weathering, 572
 - Air-Flow Oven, 573

- Addendum: Test Method for Oxidative Induction Time of Filled Composite Materials by Differential Scanning Calorimetry, 574

Case Studies, 576

- GeoDeck Decks in Arizona, 576
- GeoDeck Decks in Massachusetts, 576

- GeoDeck Voluntary Recall, 581
- Problem GeoDeck Decks: Installation Time and Warranty Claims, 582
- References, 584

16. Photooxidation and Fading of Composite Building Materials 585

Introduction, 585

- How Fading is Measured, 586
- Fading: Some Introductory Definitions, 588

Accelerated and Natural Weathering of Wood-Plastic Composite Materials and a Correlation (or a Lack of It) Between Them: The Acceleration Factor, 590

Fading of Commercial Wood-Plastic Composite Materials, 596

Fading of Composite Deck Boards Versus Their Crumbling Due to Oxidation, 600

Factors Accelerating or Slowing Down Fading of Composites, 601

Density (Specific Gravity) of the Composite, 601

Temperature, 602

UV Absorbers and Their Amounts, 602

Pigments and Their Amounts, 603

Antioxidants and Their Amounts, 605

History of Plastics (Virgin, Recycled), 605

Effect of Moisture in the Composite, 605

The Type and Amount of Cellulose Fiber, 606

Extruded Versus Injection-Molded Wood-Plastic Composite Materials, 606

ASTM Recommendations, 607

ASTM D 2565 "Standard Practice for Xenon-Arc Exposure of Plastics Intended for Outdoor Applications", 607

ASTM D 1435 "Standard Practice for Outdoor Weathering of Plastics", 608

ASTM D 4329 "Practice for Fluorescent UV Exposure of Plastics", 608

ASTM D 4364 "Practice for Performing Outdoor Accelerated Weathering Tests of Plastics Using Concentrated Sunlight", 609

ASTM D 4459 "Practice for Xenon-Arc Exposure of Plastics Intended for Indoor Applications", 609

ASTM D 5071 "Practice for Exposure of Photodegradable Plastics in a Xenon-Arc Apparatus", 610

ASTM D 5208 "Practice for Fluorescent Ultraviolet (UV) Exposure of Photodegradable Plastics", 610

ASTM D 5272 "Practice for Outdoor Exposure Testing of Photodegradable Plastics", 611

ASTM G 155 "Standard Practice for Operating Xenon-Arc Light Apparatus for Exposure of Nonmetallic Materials", 611

Addendum, 612

References, 616

17. Rheology and a Selection of Incoming Plastics for Composite Materials

617

Introduction: Rheology of Neat and Filled Plastics, Composite Materials, and Regrinds, 617

Basic Definitions and Equations, 618

Shear Rate, Shear Stress, Shear Viscosity, Dynamic Viscosity, Apparent Viscosity, Limiting Viscosity, 618

Shear-Thinning Effect and the Power Law Equation, 620

Volumetric Flow Rate and a Pressure Gradient Along the Capillary, 623

Wall Slip Phenomenon, 625

The Rabinowitsch Correction, 626

ASTM Recommendations in the Area of Capillary Rheometry, 627

ASTM D 1238-04, "Standard Test Method for Melt Flow Rates of Thermoplastics by Extrusion Plastometer", 628

ASTM D 3835-02, "Standard Test Method for Determination of Properties of Polymeric Materials by Means of a Capillary Rheometer", 629

ASTM D 5422-03, "Standard Test Method for Measurement of Properties of Thermoplastic Materials by Screw-Extrusion Capillary Rheometer", 630

ASTM Recommendations in the Area of Rotational Rheometry, 630

ASTM D 4440-01, "Standard Test Method for Plastics: Dynamic Mechanical Properties Melt Rheology", 631

ASTM D 4065-01, "Standard Practice for Plastics: Dynamic Mechanical Properties: Determination and Report of Procedures", 632

Common Observations, 633

Neat Plastics, 633

Molecular Weight of Polyethylenes and Viscosity of Their Hot Melts, 633

Effect of Temperature on Viscosity, 633

The Power-Law Index of Some Neat Plastics, 635

The Power-Law Index and Molecular Weight Distribution, 636

Composite Materials, 636

Rheology of Filled Plastics and Wood Plastic Composites, 636

Filler Increases the Dynamic Viscosity, 637

Viscosity and the Power-Law Index of Wood-Plastic Composites Materials, 638

Steady Shear Viscosity and Dynamic Viscosity Data, 639

Capillary Rheometer and an Extruder: Are They in Agreement?, 643

Extrudate Swell, 643

Almost Uncharted Areas of Composite and Plastic Rheology, 644

Effect of Particle Size of Filler on Rheology of Wood-Plastic Composites, 644

Effect of Coupling Agents, Lubricants, and Polymer Processing Additives, 645

Varying Plastic Sources—Which to Choose for Composite Materials?, 647

Rheology of Regrinds of Wood-Plastic Composites, 651

Melt Fracture of Plastics and Their Composites and Regrinds: Surface Tearing, 656

References, 670

Index

673