

**DEVELOPMENT OF IRRADIATED NATURAL
RUBBER(NR)/ETHYLENE-PROPYLENE-DIENE
TERPOLYMER(EPDM) BASED COMPOSITE
MATERIALS FOR OUTDOOR APPLICATIONS**

by

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award of the Degree of Master of Philosophy in Chemistry on
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DECLARATION BY THE CANDIDATE

The work described in this thesis was carried out by me under the supervision of Dr. Laleen Karunanayake, Senior Lecturer, Department of Chemistry, Faculty of Applied Science, University of Sri Jayewardenepura, and a report on this has not been submitted in whole or in part to any other university or institution for another Degree/Diploma.



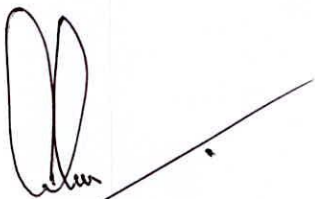
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TABLE OF CONTENTS

Table of Contents	i
List of Tables	vii
List of Figures	ix
List of Abbreviations	xiv
List of Symbols	xix
Acknowledgement	xx
Abstract	xxii
CHAPTER 1: INTRODUCTION	1
1.1 General introduction	1
1.2 Advantages/reasons for blending	1
1.3 Classification of polymer blends	2
1.3.1 Plastic-plastic blends	4
1.3.2 Plastic-elastomer blends	4
1.3.3 Elastomer-elastomer blends	6
1.3.3.1 Natural rubber/synthetic rubber blends	6
1.3.3.2 Synthetic rubber/synthetic rubber blends	8
1.4 Polymer composites	9
1.4.1 Filler	10
1.4.2 Characteristics of carbon black	12
1.4.2.1 Particle size	12
1.4.2.2 Structure	13
1.4.2.3 Physical nature of particle surface	13
1.4.2.4 Chemical nature of particle surface	15
1.4.2.5 Particle porosity	15
1.4.3 Filler reinforcement in elastomer blends	15
1.5 Vulcanization of polymers	17

1.5.1	Sulphur vulcanization	17
1.5.2	Peroxide vulcanization	21
1.5.3	Other non-sulphur vulcanization methods	23
1.5.3.1	Sulphur donor systems	23
1.5.3.2	Resin vulcanization	23
1.5.3.3	Radiation vulcanization	23
1.5.3.3.(i)	Irradiation and irradiation sources	26
1.6	Applications of irradiation in the polymer industry	32
1.7	Objectives of the study	36
CHAPTER 2: LITERATURE REVIEW		37
2.1	Thermodynamics of polymer blends	37
2.2	Polymer miscibility/immiscibility and compatibility	40
2.2.1	Miscibility versus compatibility	40
2.3	Present state of polymer blends/composites	46
2.4	NR/EPDM blends	50
2.4.1	EPDM	50
2.4.2	NR	53
2.4.3	Advantages and disadvantages of NR/EPDM blends	54
2.4.4	Improving the properties of NR/EPDM blends and composites	56
2.5	Irradiation processing of polymers	60
2.5.1	Radiation vulcanized natural rubber latex (RVNRL)	61
2.5.2	Radiation vulcanized plastics or thermoplastics	63
2.5.3	Radiation vulcanized thermoplastic elastomers	64
2.6	Radiation effect on various types of elastomers	64
2.7	Irradiation modification of NR/EPDM blends or composites	69
CHAPTER 3: MATERIALS AND EXPERIMENTAL PROCEDURES		71
3.1	Materials	71
3.1.1	Natural rubber	71
3.1.2	EPDM rubber	72

3.1.3	Activators	73
3.1.4	Filler and oil	73
3.1.5	Acrylates	73
3.1.6	Antioxidants	76
3.1.7	Curing ingredients	78
3.2	Methodologies	78
3.3	Development of a mixing sequence	79
3.3.1	Mixing sequence 1 (FBL method): Full loading of CB into NR/ EPDM preblend	79
3.3.2	Mixing sequence 2 (FEP method): Full loading of CB into EPDM phase	79
3.3.3	Mixing sequence 3 (FNR method): Full loading of CB into NR phase	79
3.3.4	Mixing sequence 4 (HNE method): Half CB loading into NR phase and half CB loading into EPDM phase	80
3.4	Formulations	80
3.5	Selection of filler type and filler loading	81
3.6	Selection of EPDM rubber grades	86
3.7	Ingredient mixing	87
3.8	Measurement of cure characteristics	88
3.9	Moulding	88
3.10	Irradiation	88
3.11	Tensile properties	89
3.12	Tear strength	90
3.13	Hardness	90
3.14	Abrasion weight loss	91
3.15	Fourier transform infrared (FTIR) spectroscopy	91
3.16	Thermal or accelerated ageing	91
3.16.1	Short-term (single day) ageing	91
3.16.2	Long-term (twenty five days) ageing	92

3.17	Carbon black dispersion	92
CHAPTER 4:	RESULTS AND DISCUSSION	93
4.1	Preliminary studies	93
4.2	The effect of mixing sequence on the performance of NR/EPDM/CB (70/30/30) composites	93
4.2.1	Cure characteristics	94
4.2.2	Physical and mechanical properties	98
4.2.2.1	Tensile properties	98
4.2.2.2	Tear strength	104
4.2.2.3	Hardness	106
4.2.2.4	Abrasion weight loss	107
4.3	The effect of filler loading and filler type on the performance of NR/EPDM/CB (70/30/30) composites	109
4.3.1	Cure characteristics	109
4.3.2	Physical and mechanical properties	112
4.3.2.1	Tensile properties	112
4.3.2.2	Tear strength	118
4.3.2.3	Hardness	119
4.3.2.4	Abrasion volume loss	120
4.4	The effect of irradiation dose on the performance of NR/EPDM/CB (70/30/30) composites	122
4.4.1	Physical and mechanical properties	122
4.4.1.1	Tensile properties	122
4.4.1.2	Tear strength	128
4.4.1.3	Hardness	129
4.4.1.4	Abrasion volume loss	130
4.4.2	Mathematical models to estimate the mechanical properties of NR/EPDM/CB (70/30/30) composites	131
4.5	The effect of sensitizer type on the performance of NR/EPDM/CB (70/30/30) composites	135
4.5.1	Physical and mechanical properties	135
4.5.1.1	Tensile properties	135

4.5.1.2	Tear strength	143
4.5.1.3	Hardness	143
4.5.1.4	Abrasion weight loss	144
4.6	The effect of sensitizer concentration on the performance of NR/EPDM/CB (70/30/30) composites	146
4.6.1	Physical and mechanical properties	146
4.6.1.1	Tensile properties	146
4.6.1.2	Tear strength	151
4.6.1.3	Hardness	152
4.6.1.4	Abrasion weight loss	153
4.7	The effect of antioxidant type on the performance of NR/EPDM/CB (70/30/30) composites	155
4.7.1	Physical and mechanical properties	155
4.7.2	Retention of Physical and mechanical properties	159
4.7.2.1	Retention of tensile properties	159
4.7.2.2	Retention of hardness	163
4.7.2.3	Retention of abrasion weight loss	163
4.8	The effect of EPDM rubber grade on the performance of NR/EPDM/CB (70/30/30) composites	166
4.9	Hypothetical model for the vulcanizate structure of partially sulphur cured and gamma irradiated NR/EPDM/CB (70/30/30) composites	168
CHAPTER 5: CONCLUSIONS		170
CHAPTER 6: SUGGESTIONS FOR FURTHER WORK		173
REFERENCES		175
APPENDICES		189
Appendix I	Rheoproperties with different mixing sequences	189
Appendix II	Rheoproperties with carbon black loading (N330)	190
Appendix III	Regression analysis graphs	191
Appendix IV	FTIR spectrum of NR	194
Appendix V	FTIR spectrum of EPDM rubber	195

Appendix VI	FTIR spectrum of polyethylene glycol 400 diacrylate (A-400)	196
Appendix VII	FTIR Spectrum of NR/EPDM/CB (70/30/30) composites without A-400	197
Appendix VIII	FTIR spectrum of NR/EPDM/CB (70/30/30) composites with A-400	198
Appendix IX	Peak assignments in FTIR spectra of irradiated samples	199
Appendix X	Publication list	200

LIST OF TABLES

Table 1.1:	CV, Semi-EV and EV vulcanization systems (Datta , 2002)	19
Table 1.2:	Vulcanizate structures and properties (Datta , 2002)	19
Table 2.1:	Some applications of EPDM (Easterbrook and Allen , 1987)	52
Table 2.2:	Some important properties of EPDM (Suryanarayan , 1995)	53
Table 3.1:	Technical specifications of NR	71
Table 3.2:	The characteristics of EPDM used in this study	72
Table 3.3:	Material properties of CB (Sirisinha and Prayoonchatphan , 2001)	73
Table 3.4:	The characteristics of MFAs	75
Table 3.5	Formula used to study the effects of mixing sequences	81
Table 3.6:	Formulations of the carbon black-filled elastomer composites	82
Table 3.7:	Recipes used to produce irradiation crosslinked NR/EPDM/CB (70/30/30) composites with different acrylates	83
Table 3.8:	Recipes used to study the effect of the sensitizer concentrations	84
Table 3.9:	Recipes used to produce irradiation crosslinked NR/EPDM/CB (70/30/30) composites with different antioxidants	85
Table 3.10:	Selected EPDM rubber grades to produce irradiation crosslinked NR/EPDM/CB (70/30/30) composites	86
Table 3.11:	Recipes used to produce irradiation crosslinked NR/EPDM/CB (70/30/30) composites with different grades of EPDM rubber	87
Table 4.1:	Cure characteristics of NR/EPDM/CB (70/30/30) composites prepared using different mixing sequences	96
Table 4.2:	The effect of ageing on physico-mechanical properties of NR/EPDM/CB (70/30/30) composites with mixing	102

sequences

Table 4.3:	Linear mathematical models for mechanical properties of NR/EPDM/CB (70/30/30) composites as a function of radiation dose	132
Table 4.4:	A comparison of measured and predicted values of mechanical properties	133
Table 4.5:	The mechanical properties of NR/EPDM/CB (70/30/30) composites irradiated in the presence of different antioxidants	155
Table 4.6:	The mechanical properties of NR/EPDM/CB (70/30/30) composites with different antioxidants as a function of ageing period	157
Table 4.7:	The mechanical properties of NR/EPDM/CB (70/30/30) composites with different EPDM grades at unaged and aged states	166

LIST OF FIGURES

Figure 1.1:	A simple classification of rubbery thermoplastics (Coran , 1988)	5
Figure 1.2:	Particle characteristics of fillers (Ferrigno , 1987)	11
Figure 1.3:	Filler primary particles, aggregates and agglomerates (Sekutowski , 1992)	14
Figure 1.4:	Overall mechanism of accelerated sulphur vulcanization (Chapman and Porter , 1988)	18
Figure 1.5:	Structural features of vulcanizate network (Chapman and Porter , 1988)	20
Figure 1.6:	Vulcanizate properties as a function of the extent of vulcanization (Coran , 1994)	20
Figure 1.7:	The typical depth-dose distribution of EB in water (Ratnam , 2001)	28
Figure 1.8:	Radiation decay scheme of Co-60 (Makuuchi , 2003)	29
Figure 1.9:	The decrease in activity of Co-60 with time (Makuuchi , 2003)	29
Figure 1.10:	Attenuation of γ -ray dose in water (Makuuchi , 2003)	30
Figure 1.11:	The flow chart of dosimetric methods (Ivanov , 1992).	31
Figure 2.1:	Schematic phase diagrams for binary blends showing LCST and UCST behaviour (Bonner and Hope , 1993).	38
Figure 2.2:	Blend physical properties as a function of composition	39
Figure 2.3:	Interrelations in polymer blend nomenclature (Utracki , 1990)	41
Figure 2.4:	Microstructure of polymer and alloy (Lyngaae-Jørgensen , 1993)	43
Figure 2.5:	Schematic representation of temperature dependence of storage shear modulus for polymer A and polymer B (solid lines) and their 50:50 mixture (broken line). Case (1) : A and B are miscible, Case (2) : A and B are immiscible, Case (3) : the miscibility is limited to low concentrations of A in B and B in A, Case (4) : blend with fine dispersion	44

(compatibilized) (**Utracki**, 1990)

Figure 2.6:	Plausible mechanism of TMPTMA promoted crosslinking of EPDM (Chowdhury and Banerji , 2005)	67
Figure 2.7:	Plausible mechanism of side reactions of TMPTMA at high concentrations (Chowdhury and Banerji , 2005)	68
Figure 3.1:	Natural rubber (<i>cis</i> -1,4-Polyisoprene)	71
Figure 3.2:	Ethylene-propylene-diene terpolymer rubber	72
Figure 3.3:	Chemical structures of acrylates used in the study	74
Figure 3.4:	Chemical structures of anti-oxidants used in the study	77
Figure 3.5:	A schematic diagram of tensile strength specimen (ASTM D 412)	89
Figure 3.6:	A schematic diagram of hardness test specimen (d=38 mm and t=12 mm)	90
Figure 4.1:	Rheographs of the samples prepared according to different mixing sequences	94
Figure 4.2:	Tensile strength of NR/EPDM/CB (70/30/30) composites prepared using different mixing sequences	99
Figure 4.3:	Elongation at break of NR/EPDM/CB (70/30/30) composites prepared using different mixing sequences	99
Figure 4.4:	M 100 of NR/EPDM/CB (70/30/30) composites prepared using different mixing sequences	103
Figure 4.5:	M 300 of NR/EPDM/CB (70/30/30) composites prepared using different mixing sequences	104
Figure 4.6:	Tear strength of NR/EPDM/CB (70/30/30) composites prepared using different mixing sequences	105
Figure 4.7:	Hardness of NR/EPDM/CB (70/30/30) composites prepared using different mixing sequences	106
Figure 4.8:	DIN abrasion volume loss of NR/EPDM/CB (70/30/30) composites prepared with different mixing sequences	107
Figure 4.9:	Rheographs of NR/EPDM/CB (70/30/30) composites with different CB (N 330) loading	109

Figure 4.10:	The effect of carbon black loading on the cure time (t_{90}) of NR/EPDM (70/30) blend loaded with different types of carbon blacks	110
Figure 4.11:	The effect of carbon black content on the tensile strength of NR/EPDM (70/30) blend loaded with different carbon black types	112
Figure 4.12:	The effect of carbon black particle size on the tensile strength of NR/EPDM (70/30) blend loaded with different carbon black types	113
Figure 4.13:	Variation of dispersion with different filler types (a-c) (magnification 30X)	115
Figure 4.14:	The effect of carbon black content on the M 100 of NR/EPDM (70/30) blend loaded with different carbon black types	116
Figure 4.15:	The effect of carbon black content on the M 300 of NR/EPDM (70/30) blend loaded with different carbon black types	116
Figure 4.16:	The effect of carbon black content on the E_b of NR/EPDM (70/30) blend loaded with different carbon black types	117
Figure 4.17:	The effect of carbon black content on the tear strength of NR/EPDM (70/30) blend loaded with different carbon black types	118
Figure 4.18:	The effect of carbon black content on the hardness of NR/EPDM (70/30) blend loaded with different carbon black types	119
Figure 4.19:	The effect of carbon black content on the abrasion volume loss of NR/EPDM (70/30) blend loaded with different carbon black types	121
Figure 4.20:	The effect of irradiation dose on tensile strength of NR/EPDM/CB (70/30/30) composites	122
Figure 4.21:	The effect of irradiation dose on E_b of NR/EPDM/CB (70/30/30) composites	126
Figure 4.22:	The effect of irradiation dose on stress at 300% elongation of NR/EPDM/CB (70/30/30) composites	127
Figure 4.23:	The effect of irradiation dose on tear strength of	129

NR/EPDM/CB (70/30/30) composites

Figure 4.24:	The effect of irradiation dose on hardness of NR/EPDM/CB (70/30/30) composites	130
Figure 4.25:	The effect of irradiation dose on abrasion volume loss of NR/EPDM/CB (70/30/30) composites	131
Figure 4.26:	The effect of irradiation on the tensile strength of NR/EPDM/CB (70/30/30) composites sensitized with various multifunctional acrylates (MFAs)	136
Figure 4.27:	The effect of irradiation on elongation at break of NR/EPDM/CB (70/30/30) composites sensitized with various multifunctional acrylates (MFAs)	140
Figure 4.28:	The effect of irradiation on modulus at 100% elongation of NR/EPDM/CB (70/30/30) composites sensitized with various multifunctional acrylates (MFAs)	141
Figure 4.29:	The effect of irradiation on modulus at 300% elongation of NR/EPDM/CB (70/30/30) composites sensitized with various multifunctional acrylates (MFAs)	142
Figure 4.30:	The effect of irradiation on tear strength of NR/EPDM/CB (70/30/30) composites sensitized with various multifunctional acrylates (MFAs)	143
Figure 4.31:	The effect of irradiation on hardness of NR/EPDM/CB (70/30/30) composites sensitized with various multifunctional acrylates (MFAs)	144
Figure 4.32:	The effect of irradiation on DIN abrasion weight loss of NR/EPDM/CB (70/30/30) composites sensitized with various multifunctional acrylates (MFAs)	145
Figure 4.33:	The effect of A-400 concentration on tensile strength of NR/EPDM/CB (70/30/30) composites	148
Figure 4.34:	The effect of A-400 concentration on elongation at break of NR/EPDM/CB (70/30/30) composites	148
Figure 4.35:	The effect of A-400 concentration on stress at 100% elongation of NR/EPDM/CB (70/30/30) composites	150
Figure 4.36:	The effect of A-400 concentration on stress at 300% elongation of NR/EPDM/CB (70/30/30) composites	151

Figure 4.37:	The effect of A-400 concentration on tear strength of NR/EPDM/CB (70/30/30) composites	152
Figure 4.38:	The effect of A-400 concentration on hardness of NR/EPDM/CB (70/30/30) composites	153
Figure 4.39:	The effect of A-400 concentration on abrasion weight loss of NR/EPDM/CB (70/30/30) composites	154
Figure 4.40:	The effect of ageing time on tensile strength of NR/EPDM/CB (70/30/30) composites	159
Figure 4.41:	The effect of ageing time on elongation at break of NR/EPDM/CB (70/30/30) composites	161
Figure 4.42:	The effect of ageing time on stress at 100% elongation of NR/EPDM/CB (70/30/30) composites	162
Figure 4.43:	The effect of ageing time on stress at 300% elongation of NR/EPDM/CB (70/30/30) composites	162
Figure 4.44:	The effect of ageing time on hardness of NR/EPDM/CB (70/30/30) composites	163
Figure 4.45:	The effect of ageing time on DIN abrasion weight loss of NR/EPDM/CB (70/30/30) composites	164
Figure 4.46:	A hypothetical model for a sulphur cured and irradiated vulcanizate structure of a ternary composites of the elastomer/elastomer/filler composites	169
Scheme 1	Possible reaction mechanisms between NR, EPDM and NR and EPDM	124
Scheme 2	Possible crosslinking reaction mechanisms between NR, EPDM and NR and EPDM in the presence of a sensitizer	138

LIST OF ABBREVIATIONS

R	Retention percentage
%wt	Weight percentage
γ -irradiation	Gamma-irradiation
1, 4 HD	1, 4 hexadiene
6PPD	N-(1,3-Dimethylbutyl)-N'-phenyl-p-phenylenediamine
A	Accelerator
A/S	Accelerator to Sulphur ratio
A-400	Poly(ethylene glycol) 400 diacrylate
A-600	Poly(ethylene glycol) 600 diacrylate
ABS	Acrylonitrile butadiene styrene terpolymer
ASTM	American standard test method
ATR	Attenuated total reflectance
BR	Butyl rubber
CB	Carbon black
CBS	N-cyclohexyl-2-benzothiazole sulphenamide
Co-60	Cobalt-60
CON	Control
conc.	Concentration
CR	Polychloroprene (neoprene)
Cs	Cesium
CV	Conventional vulcanization
CV 60	Constant viscosity-60
DBP	n-Dibutyl phthalate
DCP	Dicumyl peroxide
DCPD	Dicyclopentadiene
DIPDIS	Bis(diisopropyl)thiophosphoryl disulphide
DIPTOS	Diisopropyl thiophosphoryl-N-oxydiethylene sulfonamide
DMA	Dynamic mechanical analysis
dNm	Deci newton meter
Eb	Elongation at break
EB	Electron beam

EBM	Electron beam machine
EHA	2-Ethylhexyl acrylate
ENB	Ethylidene norbornene
ENR	Epoxidized natural rubber
EP	Engineering polymer
EPB	Engineering polymer blend
EPDM	Ethylene propylene diene terpolymer
EPDMSH	Mercapto-modified EPDM
EPDMTA	Thioacetate-modified EPDM
EPM	Ethylene propylene monomer
EPR	Ethylene propylene rubber
EPS1	NORDEL IP4640
EPS2	KELTAN 314
EPS3	KELTAN 512X50 (oil extended)
EV	Efficient vulcanization
EVA	Ethylene vinyl acetate
FBL	Full loading of CB into NR/EPDM blend
FEF	Fast extrusion furnace black
FEP	Full loading of CB into EPDM phase
Fig.	Figure
FNR	Full loading into NR phase
FTIR	Fourier transform infrared
GPF	General purpose furnace
Gy	Gray
HAF	High-abrasion furnace black
HNE	Half CB loading into NR phase and half CB loading into EPDM phase
IIR	Butyl rubber
IPN	Inter penetrating network
IRG	Irganox 1520 (4,6-bis (octylthiomethyl)-o-cresol)
ISAF	Intermediate super abrasion furnace
ISO	International standard organization

J/kg	Joule per kilogram
kGy	Kilogray
kGy/h	Kilogray per hour
LCST	Lower critical solution temperature
m	Meter
M 100	Modulus at 100% elongation
M 300	Modulus at 300% elongation
Max	Maximum
MeV	Mega electron volt
Min	Minimum
min	Minute
ML	Mooney unit (large rotor type)
MPa	Megapascal
MPB	Miscible polymer blend
MPR	Melt processable rubbers
NBR	Acrylonitrile-butadiene rubber
Ni-60	Nickel-60
nm	Nano meter
NR	Natural rubber
ODR	Oscillating disc rheometer
p MSAN	Poly (p-methylstyrene-co-acrylonitrile)
PA	Poly amide
PAs	Polymer alloys
PB	Polymer blend
PBEMA	Poly (2-bromoethyl methacrylate)
PBT	Poly (butylene terephthalate)
PC	Polycarbonate
PCL	Poly (ϵ -caprolactone)
PE	Polyethylene
PECH	Poly (epichlorohydrin)
PET	Poly (ethylene terephthalate)
phr	Parts per hundred parts of rubber

PMMA	Poly(methyl methacrylate)
P _o	Plasticity
PP	Polypropylene
PPO	Poly (2,6-dimethyl-1,4-phenylene ether)
PRI	Plasticity retention index
PS	Polystyrene
PVAc	Poly (vinyl acetate)
PVC	Poly(vinyl chloride)
PVME	Poly (vinyl methyl ether)
PαMS	Poly (pα-methyl styrene)
R-H	Rubber hydrocarbon
RLC	Ralox LC
RSS	Ribbed smoke sheet
R-Sx-R	Initial polysulphidic crosslinks
R-Sy-X	Rubber-bound intermediate
RVNRL	Radiation vulcanized natural rubber latex
S	Sulphur
S ₂ Cl ₂	Sulphur chloride
SAN	Poly (styrene-co-acrylonitrile)
SBR	Styrene butadiene rubber
SEV	Semi-efficient vulcanization
SI	Standard international
SO ₂	Sulphur dioxide
St. acid	Stearic acid
T6P	Blend of TMQ/6PPD(50/50)
<i>t</i> ₉₀	The time to achieve 90% cure
TETD	Tetraethylthiuram disulfide
TMM	Pentaerythritol triacrylate
TMPT	Trimethylolpropane triacrylate
TMQ	2,2,4-Trimethyl-1,2-dihydroquinoline
TMTD	Tetramethylthiuram disulfide
TOR	Trans-polyoctylene

TPE	Thermoplastic elastomers
TPV	Thermoplastic vulcanisates
<i>T_s</i>	Tensile strength
TSR	Technically specified rubber
TZM	Blend of TMQ/ZMTI(50/50)
UCST	Upper critical solution temperature
UV	Ultra-violet
Vanox ZMTI	2H-Benzimidazole-2-thione,1,3-dihydro-4(or 5)-methyl-zinc salt
wt.	Weight
ZnO	Zinc oxide

LIST OF SYMBOLS

%	Percentage
μm	Micrometer
$^{\circ}\text{C}$	Degree centigrade
T	Temperature in Kelvin
T_g	Glass transition temperature
γ	Gamma
ΔG_{mix}	Gibbs free energy of mixing
ΔH_{mix}	Enthalpy of mixing
ΔS_{mix}	Entropy of mixing
Φ_1	Volume or weight fraction of relevant polymer
χ_{12}	Interaction coefficient

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DEVELOPMENT OF IRRADIATED NATURAL RUBBER(NR)/ETHYLENE-PROPYLENE-DIENE TERPOLYMER(EPDM) BASED COMPOSITE MATERIALS FOR OUTDOOR APPLICATIONS

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ABSTRACT

The effect of γ -irradiation on the natural rubber (NR)/ethylene propylene diene terpolymer (EPDM)/carbon black (CB) ternary composites was investigated. The effects of compounding conditions such as mixing sequence of component materials and compositional variables such as filler type and filler loading in preparation of NR/EPDM/CB ternary composites were studied first. The best conditions to develop materials for outdoor applications among the investigated conditions were established. NR:EPDM ratio was maintained at 70:30. These composites were then partially cured using sulphur as the crosslinking agent. Partially cured composites were subjected to irradiation using a γ -irradiation source. The effects of radiation dose on the mechanical properties of the composites were evaluated. The effectiveness of five different sensitizers (radiation crosslink promoters) on the irradiation crosslinking process of the composites was compared. The optimum concentration of the best sensitizer among the candidate sensitizers was also identified. The performance of five different antioxidant systems against the thermal degradation of these composites was also studied. This work was followed by the preparation of NR/EPDM/CB composites using three different grades of EPDM rubber and the evaluation of their mechanical properties upon irradiation. Based on the results, processing, compounding and irradiation conditions

were proposed to produce a new material for outdoor applications. Attempts were made to develop a hypothetical model to explain the vulcanizate structure of the composite.

Of the four mixing sequences studied, the Full loading of CB into the NR/EPDM preblend yielded reasonably good mechanical properties before ageing and the highest retention percentage of some important mechanical properties after ageing. As such this mixing sequence was selected for the preparation of composites. The experimental results also showed that CB N220 at 30 phr loading offered the overall best properties. It was found that efficient crosslinking of the composites was possible in the presence of polyethylene glycol 400 diacrylate, (A-400) at an optimum radiation dose of 80 kGy whereas an optimum dose of 100 kGy was required to get the equivalent improvement in properties of sensitizer free composites. It was also found that variation of tensile properties, tear strength and abrasion loss showed a linear relationship with the radiation dose up to the optimum dose and hence mathematical models were developed and validated within a 4% error. The optimum dose of the selected sensitizer was found to be 1phr

The composites containing a blend of TMQ:Vanox ZMTI possessed optimum mechanical properties when compared with the other antioxidant systems investigated. Among the EPDM grades used the composite prepared with oil extended grade exhibited the best long term ageing property. Finally, considering the effect of various ingredients on the performance of mechanical properties, a hypothetical model showing possible crosslinks that could have formed was proposed and presented at the end of this study.