Contents

Preface xv
Editors Biographies xix

Part I Nanocomposites: Structure and Properties 1

Chapter 1 Carbon Nanotube-Reinforced Polymers: a State of the Art Review 3
1 Introduction 3
2 General Problems in Nanocomposite Technology 4
3 Experimental 6
3.1 Manufacturing of Multiple-Wall Carbon Nanotubes 6
3.2 Treatment of Carbon Nanotubes 7
3.3 Matrix Polymers 7
3.4 Electron Microscopy 7
3.5 Dynamic-Mechanical Thermal Analysis 8
4 Results 8
4.1 Comparison of the Multiple-Wall Carbon Nanotubes Studied 8
4.2 Purification 10
4.3 CNT/Epoxy Composites: Dispersion, Matrix Bonding, and Functionalization 11
4.3.1 Dispersion 11
4.3.2 Nanotube-Matrix Interaction 13
4.3.3 Functionalization 13
4.4 Microscopy 15
4.4.1 Matrix Bonding to the Nanotubes 15
4.4.2 Crack Bridging and Telescopic Pull-Outs 16
4.5 Thermal and Mechanical Properties 17
4.6 Electrical Properties 18
5 Conclusions 21
6 Acknowledgements 21
7 References 22

Chapter 2 Application of Non-Layered Nanoparticles in Polymer Modification 25
1 Introduction 25
2 Surface Treatment and Compounding 27
2.1 Raw Materials 27
2.2 Pregrafting of the Nanoparticles by Irradiation 27
2.3 Characterization of the Irradiation Products 28
2.4 Preparation of PP-Based Nanocomposites and Their Characterization 28
2.5 Preparation of Epoxy-Based Nanocomposites and Their Characterization 29
3 Thermoplastic Systems 29
3.1 Effect of Irradiation Grafting Polymerization on the Nanoparticles 29
3.2 Tensile Properties 30
3.3 Fractography 35
4 Thermosetting Systems 36
4.1 Interfacial Interactions in the Composites 36
4.2 Curing Behavior 38
4.3 Friction and Wear Performance 38
5 Conclusions 42
6 Acknowledgements 43
7 References 43

Chapter 3 Reinforcement of Thermosetting Polymers by the Incorporation of Micro- and Nanoparticles 45
1 Introduction 45
2 Manufacturing of Thermosetting Nanocomposites 47
3 Properties of Nanocomposites 50
3.1 Stress-Strain Behavior 50
3.2 Impact Behavior 54
3.3 Stiffness-Impact Energy Relationship 55
3.4 Dynamic Mechanical Properties 56
3.5 Wear Performance 57
4 Acknowledgements 60
5 References 60

Chapter 4 Polyimides Reinforced by a Sol-Gel Derived Organosilicon Nanophase: Synthesis and Structure-Property Relationships 63
1 Nanocomposites Based on Flexible-Chain Polymers 63
2 Nanocomposites Based on Semi-Rigid Chain Polymers (Polyimides) 66

2.1 *In Situ* Generation of an Organosilicon Nanophase 67
2.2 Structural Characterization 68
2.3 Water Uptake 69
2.4 Thermomechanical Performance 70
2.5 Dielectric Properties 72
3 Conclusions 73
4 Acknowledgements 74
5 References 74

Chapter 5 Layered Silicate/Rubber Nanocomposites *via* Latex and Solution Intercalations 77
1 Concept of Nanoreinforcement 77
2 Production of Rubber/Clay Nanocomposites 78
2.1 Latex Intercalation 79
2.1.1 Nanocomposites from Rubber Latex 79
2.1.2 Nanocomposites from Latex Blends 81
2.1.3 Radiation-Vulcanized NR Latex 84
2.2 Solvent-Assisted Intercalation 87
3 Future Issues 88
4 Acknowledgements 88
5 References 89

Chapter 6 Property Improvements of an Epoxy Resin by Nanosilica Particle Reinforcement 91
1 Introduction and State of the Art 91
2 Preparation and Characterization Techniques 94
2.1 Basic Material Components 94
2.2 Preparation of Nanosilica-Filled Epoxy Composites 94
2.3 Structural and Mechanical Analysis 95
2.3.1 Microstructure 95
2.3.2 Viscosity Studies of the Unfilled and Filled Resin 95
2.3.3 Mechanical Properties 95
2.3.4 Tribological Properties 96
2.3.5 Failure Analysis 96
3 Microstructural and Rheological Details 96
3.1 Particle Distribution 96
3.2 Viscosity 98
4 Mechanical Properties 99
4.1 Three-Point Bending 99
4.2 Microhardness 99
4.3 Fracture Toughness 101
4.4 Tribological Properties 101
5 Conclusions 103

6 Acknowledgements 104
7 References 104

Part II Special Characterization Methods and Modeling 107

Chapter 7 Micro-Scratch Testing and Finite Element Simulation of Wear Mechanisms of Polymer Composites 109
1 Introduction 109
2 Micro-Scratch Testing 110
3 The Representative Wear Mechanisms 113
4 Wear Considerations by Finite Element Contact Analysis 114
4.1 Finite Element Macro/Micro-Contact Models 115
4.2 Normal Fiber Orientation 116
4.3 Parallel Fiber Orientation 118
4.4 Anti-Parallel Fiber Orientation 120
5 Finite Element Simulation of the Fiber/Matrix Debonding 121
5.1 Debonding Model and Interface Elements 122
5.1.1 Interface Elements 122
5.1.2 Conditions of Debonding 123
5.1.3 Unloading Considerations 125
5.1.4 The Debonding Algorithm 125
5.2 Calculations for N-Oriented Carbon Fibers in a PEEK Matrix 126
6 Conclusions 129
7 Acknowledgements 130
8 References 130

Chapter 8 Determination of the Interface Strength of Polymer-Polymer Joints by a Curved Interface Tensile Test 133
1 Introduction 133
2 Curved Interface Tensile Test 136
3 Stress Calculation by Finite-Element Analysis 137
3.1 Flat Interface 138
3.2 Curved Interface 138
4 Experimental Observations 140
4.1 Materials and Specimen Preparation 140
4.2 Tensile Tests and Strain Estimation 142
4.3 Determination of the Adhesion Strength 144
5 Conclusions and Outlook 145
6 References 146

Chapter 9 Manufacturing and Characterization of Microfibrillar Reinforced Composites from Polymer Blends 149
1 Introduction 149
2 Materials, Processing, and Characterization Techniques 151
3 Structure and Properties of MFCs 153
3.1 Structure and Properties of MFCs Based on PET/PP Blends 153
3.1.1 Morphology 153
3.1.2 Mechanical Properties of the Drawn Blends After Processing 157
3.2 Structure and Properties of MFCs Based on LCP/PPE Blends 159
3.2.1 Morphology 159
3.2.2 Mechanical Properties of Injection Molded LCP/PPE Blends with MFC Structure 162
4 Conclusions 164
5 Acknowledgements 165
6 References 165

Chapter 10 Tribological Characteristics of Micro- and Nanoparticle Filled Polymer Composites 169
1 Introduction 169
2 Influence of Particle Size: from Micro- to Nanometer 170
3 Influence of the Nanoparticle Volume Content 171
4 Particle-Filled Polytetrafluoroethylene 174
5 Integration of Inorganic Particles With Traditional Fillers 175
5.1 Inorganic Particles and Other Fillers 175
5.2 Combinative Effect of Nanoparticles and Short Carbon Fibers 175
6 Conclusion 182
7 Acknowledgement 182
8 References 182

Part III Macrocomposites: Processing and Application 187

Chapter 11 Production of Thermoplastic Towpregs and Towpreg-Based Composites 189
1 Introduction 189
2 Raw Materials 190
3 Production of Towpregs 190
3.1 Process and Equipment Description 190

3.2 Relationships Between Final Properties and Processing Conditions 192
3.2.1 Parameters Affecting the Polymer Powder Deposition 192
3.2.2 Influence of the Processing Conditions on the Final Composite Properties 193
4 Production of Towpreg-Based Composites 194
4.1 Compression Molding 194
4.1.1 Process Description 194
4.1.2 Molding Conditions 194
4.2 Process Modeling 195
4.2.1 Isothermal Consolidation 196
4.2.2 Non-Isothermal Consolidation 197
4.2.3 Validation of the Consolidation Model 198
4.3 Pultrusion 200
4.3.1 Process Description 200
4.3.2 Processing Conditions 201
4.3.3 Process Modeling 201
4.4 Filament Winding 203
4.4.1 Process Description 203
4.4.2 Processing Conditions 203
4.4.3 Relationships Between Final Properties and Processing Conditions 204
4.5 Long Fiber-Reinforced Composite Stamping 206
4.5.1 Process Description 206
4.5.2 Processing Conditions 206
5 Composite Properties 206
5.1 Mechanical Properties of Continuous Fiber-Reinforced Composites 207
5.2 Mechanical Properties of Discontinuous Fiber-Reinforced Composites 207
6 Conclusions 211
7 Acknowledgements 211
8 References 212

Chapter 12 Manufacturing of Tailored Reinforcement for Liquid Composite Molding Processes 215
1 Introduction 215
2 Pre-selection of Sewing Thread 217
2.1 Selection Criteria 217
2.2 Polyester Thread in Global Preform Sewing 219
3 Tailored Reinforcements 220
4 Stitching Parameters and Their Influence on the Fiber-Reinforced Polymer Composites 221

4.1 Machine Parameters 221
4.1.1 Thread Tension 221
4.1.2 Presser Foot Pressure 223
4.2 Stitching Pattern 224
5 Quality Secured Preforming 225
5.1 Macro Preform Quality 225
5.2 Micro Preform Quality 225
5.3 Fiber Disturbance at Seams 226
6 Liquid Composite Molding Process for Net-Shape Preforms 227
6.1 Preform LCM Process Chain 227
6.2 Thermal Behavior of Seam in FRPC 228
7 Quality Management 228
8 Conclusions 231
9 Acknowledgements 231
10 References 231

Chapter 13 Deconsolidation and Reconsolidation of Thermoplastic Composites During Processing 233
1 Introduction 233
2 Experimental Observations 235
2.1 Void Growth 235
2.2 Migration of Voids 236
2.3 Squeezed Flow of Resin During Reconsolidation 237
3 Mechanistic Model of the Void Growth 238
3.1 Discussion of the Mechanism 238
3.2 Void-Growth Model 241
3.3 Theoretical Predictions 244
4 Thermal/Mechanistic Models of Migration of Voids 246
4.1 Discussion of Mechanisms 246
4.2 Thermal Analysis 246
4.3 Void Closure 249
4.4 Squeezed Creep Flow of Resin 251
5 Conclusions 253
6 Acknowledgement 253
7 References 253

Chapter 14 Long Fiber-Reinforced Thermoplastic Composites in Automotive Applications 255
1 Introduction 255
2 Long Glass Fiber-Reinforced Polypropylene with Mineral Fillers 257
3 Long Fiber-Reinforced Polyamide 66 with Minimized Water Absorption 259

4 Long Fiber-Reinforced Thermoplastic Styrene Resins for Car Interior Applications 259
5 Conclusions 261
6 References 261

Part IV Mechanical Performance of Macrocomposites 263

Chapter 15 Deformation Mechanisms in Knitted Fabric Composites 265
1 Introduction 265
2 Knitted Fabrics 267
3 Material Characterization and Deformation Behavior 268
3.1 Raw Materials 268
3.2 Material Characterization 268
3.2.1 Tensile Testing 268
3.2.2 V-Bending 268
3.2.3 Dome Forming 269
3.2.4 Cup Forming 269
4 Experimental Results and Grid Strain Analysis 269
4.1 Tensile Testing 269
4.2 V-bending 270
4.3 Dome Forming 271
4.4 Cup Forming 273
5 Textile Composite Deformation Mechanisms 274
5.1 Prepreg Flow Mechanisms 274
5.2 Macro-Level Fabric Deformation Modes 274
5.3 Micro-Level Fabric Deformation Modes 275
5.4 Textile Fabric Force-Displacement Curve 276
5.5 Experimental Force-Displacement Curves 278
6 Modeling the Manufacture of the Reinforcement Architecture 278
6.1 Model Set-Up 279
6.2 Model Input: Knitting Machine Parameters 280
6.3 Model Input: Material Property Parameters 280
6.4 Model Input: Non-Physical Parameters 282
6.5 Simulating the Mechanics of the Knitting Process 283
7 Concluding Remarks 284
8 Acknowledgements 286
9 References 286

Chapter 16 Impact Damage in Composite Laminates 289
1 Introduction 289
2 Deformation and Energy Release Rate of Axisymmetric Plates with Multiple Delaminations 291

2.1 Axisymmetric Plate with Multiple Delaminations of the Same Size 291
2.2 A Delamination is Larger or Smaller than the Rest 293
2.3 Effect of geometrical nonlinearity 295
2.4 Finite Element Analysis 296
2.5 Some Derived Relationships 297
3 Effect of the Stacking Sequence 300
4 Simulation of Delamination Growth in Composite Laminates 304
5 Conclusion 305
6 References 306

Chapter 17 Discontinuous Basalt Fiber-Reinforced Hybrid Composites 309
1 Introduction 309
2 Basalt Fibers 310
2.1 Characteristics, Applications 310
2.2 Production and Properties of Melt-Blown Basalt Fibers 313
3 Hybrid Composites 314
3.1 Concept and Realization 314
3.2 Property Prediction 316
3.3 Applications 317
4 Thermoplastic Hybrid Composites 317
4.1 Polypropylene with Hybrid Reinforcement Containing Basalt Fibers 317
4.2 Basalt Fiber-Reinforced Polymer Blends 319
5 Thermoset Hybrid Composites 321
5.1 Basalt Fiber Mat-Reinforced Hybrid Thermosets 321
5.2 Hybrid Fiber Mat-Reinforced Hybrid Thermosets 323
6 Conclusions and Outlook 324
7 Acknowledgement 325
8 References 325

Chapter 18 Accelerated Testing Methodology for Polymer Composite Durability 329
1 Introduction 329
2 Prediction Procedure of Fatigue Strength 330
3 Some Experimental Details and Relationships Obtained 330
3.1 Experimental Procedure 330
3.2 Failure Mechanism 331
3.3 Master Curve for the CSR Strength 333
3.4 Master Curve for Creep Strength 334

3.5 Master Curve for the Fatigue Strength at Zero Stress Ratio 335
3.6 Prediction of Fatigue Strength for Arbitrary Stress Ratios 337
4 Applicability of the Prediction Method 338
5 Conclusion 339
6 References 340

Contributing Authors 343
List of Acknowledgements 357
Author Index 361
Subject Index 363