

Table of content

Acknowledgement	4
Table of content	5
Abbreviations	8
Abstract	9
Zusammenfassung	10
Introduction	11
Definition of Wood Polymer Composites	11
Market situation	12
Polymers	13
Polypropylene	14
Wood and natural fibers	14
Wood	14
Anatomical structure	15
Chemical wood structure	16
Mechanical properties of softwood	17
Wood fibers	18
Natural fibers	18
Aspect ratio	19
Particle size and geometry	19
Reinforcement models	20
Property profile of Wood Polymer Composites	20
Influence of the process	21
Additives	22
Lubricant	23
Antioxidant	23
UV- stabilizer	24
Degradation mechanisms	24
Protecting strategies	25
Coupling agent	25
Silanes as coupling agents for inorganic materials	26
Processing	28
Production methods	30
Wood modification: general aspects	32
Thermally modified timber	33
Acetylation	33
Use of polymerizable chemicals	33
N-methylol compounds	34
Furfuryl alcohol	34
Other modification agents	35
Silanes – general aspects	35
Silanes as coupling agents for organic materials	36
Properties and problems of Wood Polymer Composites	36
Aim of thesis	37
Improvement of interfacial bonding between wood and polymer	38
Improvement of mechanical properties- Reinforcement effect by using wood particles	38
Improved dimensional stability and reduced water uptake	38
Improvement of the durability against basidiomycetes and soil fungi	38
Materials and Methods	39

Materials	39
Wood particles	39
Coupling agents	39
Polymer	40
Modification agents	40
Methods	43
Sample production	43
Impregnation	43
Drying and curing	43
Compounding	43
Injection molding (IM)	44
Compression molding (CM)	44
Samples and conditioning	45
Mechanical properties	45
EN 527 (1+2) – Plastics - Determination of tensile properties	45
ISO 178 – Determination of bending properties (Flexural properties of unreinforced and reinforced plastics and electrical insulating materials)	46
ISO 179-1 Plastics - Determination of Charpy impact properties Part 1: Non-instrumented impact test	47
Physical – technological properties	48
EN 84 – Wood preservative: Accelerated ageing tests of treated wood prior to biological testing – Leaching procedure (according to)	48
Extended exposure period water uptake test	48
DIN EN 1087 - Particleboard - Determination of moisture resistance - Boil test	48
Determination of subsidence rate	49
EN 12038 – Durability of wood, wood-based products, and wood-based panels: Method of testing for determining the resistance against wood-destroying basidiomycetes	49
Weathering performance	50
EN 927-3 Paints and varnishes: Coating materials and coating systems for exterior wood - Part 3: Natural weathering test	50
EN 927-6 Paints and varnishes: Coating materials and coating systems for exterior wood - Part 6: Exposure of wood coatings to artificial weathering using fluorescent UV lamps and water	50
General measurements	51
Analysis of wood particles	51
Determination of pH	53
Microscopy Investigations	53
Dynamic mechanical (thermal) analysis	53
X-ray tube based high resolution computer tomography (CT) scanning	53
Test matrices	54
Results	56
Mechanical properties	56
Mechanical properties of Wood Polymer Composites based on Arbocel [®] C100 particles	56
Mechanical properties of Wood Polymer Composites based on Arbocel [®] C320 particles	72
Mechanical properties of Wood Polymer Composites based on Lignocel [®] Type 9 particles	73
Physical – technological properties	80
EN 84 – Wood preservative: Accelerated ageing tests of treated wood prior to biological testing – Leaching procedure (according to)	80
Extended exposure period water uptake test	82
DIN EN 1087 - Particleboard - Determination of moisture resistance - Boil test	87
Boiling time 2 hours – [50x50x4 mm ³]	87
Boiling time 5 hours - [50x50x4 mm ³]	88

Boiling time 5hours - [100x50x4 mm ³]	89
EN 12038 Durability test	102
Durability test of solid Wood Polymer Composite samples	102
Durability test of treated wood particles	103
EN 927-3 Natural weathering	104
Water uptake	104
Color change	106
Determination of subsidence rate	91
Wood particles Arbocel [®] C100	91
Wood particles Arbocel [®] C320	92
Wood particles Lignocel [®] Type 9	93
Determination of pH value	95
Dynamic mechanical (thermal) analysis	97
Determination of wood particles geometry before and after processing	98
Microscopy	108
Optical microscopy	108
Scanning Electron Microscopy	108
X-ray tube based high resolution computer tomography (CT) scanning	111
Energy dispersive x-ray analysis (EDX)	113
Discussion	116
Improvement of interfacial bonding between wood and polymer	116
Improvement of mechanical properties - Reinforcement effect by using wood particles	118
Influence of wood particle geometry and strength	118
Influence of coupling agent	121
Influence of wood particle orientation	124
Improved reduced water uptake and dimensional stability	127
Durability against basidiomycetes	129
Weathering influence of Wood Polymer Composites	132
Literature	134
Standards	134
Literature	134
Glossary	155
Table of figures	158
Table of tables	163
Appendix	165
Appendix 1 - EN 84 – Wood preservative: Accelerated test	165
Appendix 2 – Long time water uptake	167
Appendix 3- DIN EN 1087 - Particleboard - Boil test	172
Appendix 4 - EN 927-3 Natural weathering	183
Appendix 5 - Dynamic Mechanical Analysis	187
Appendix 6 – Determination of wood particles geometry	189
Particle gallery	189
Curriculum vitae	191