

FORM 1

11408/88

COMMONWEALTH OF AUSTRALIA

PATENTS ACT 1952

598094

APPLICATION FOR A STANDARD PATENT

I\We,

BIP CHEMICALS LIMITED

APPLICATION ACCEPTED AND AMENDMENTS

ALLOWED

29-3-90

of

20 ST MARY'S PARSONAGE
MANCHESTER M3 2NL
ENGLAND

hereby apply for the grant of a standard patent for an
invention entitled:

POLYAMIDE COMPOSITIONS

which is described in the accompanying complete specification

Details of basic application(s):

Number of basic application	Name of Convention country in which basic application was filed	Date of basic application
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8703161

GB

11 FEB 87

My/our address for service is care of CLEMENT HACK & CO., Patent
Attorneys, 601 St. Kilda Road, Melbourne 3004, Victoria,
Australia.

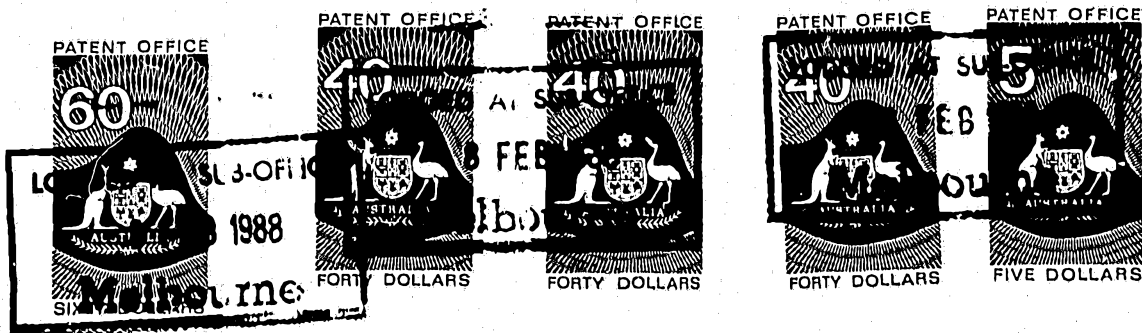
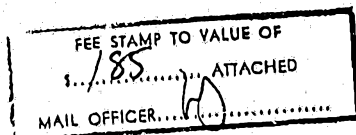
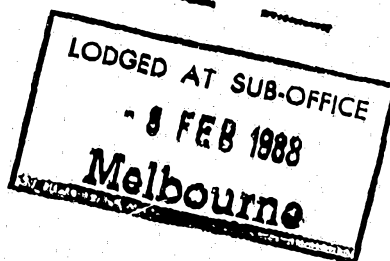
DATED this 08th day of February 1988

BIP CHEMICALS LIMITED

CLEMENT HACK & CO.

[Signature]

TO: The Commissioner of Patents.



AUSTRALIAPatents Act 1952DECLARATION IN SUPPORT OF A CONVENTION OR NON-CONVENTION
APPLICATION FOR A PATENT OR PATENT OF ADDITIONName(s) of
Applicant(s)In support of the application made by _____
BIP CHEMICALS LIMITED

Title

for a patent for an invention entitled _____
Polyamide compositionsName(s) and
Address(es)I/We, Robert Franklin Hadfield
of Bowdon House, Ashburton Road West,
Trafford Park, Manchester M17 1RA, ENGLANDPerson(s)
making
Declaration

do solemnly and sincerely declare as follows:-

1. I am/we are the applicant(s) for the patent, or
am/are authorised by the abovementioned applicant
to make this declaration on its behalf.
2. The basic application(s) as defined by Section 141
of the Act was/were made in the following country
or countries on the following date(s) by the
following applicant(s) namely:-
in United Kingdom on 11 February 1987
by BIP Chemicals Limited
in _____ on _____ 19____
by _____

3. The said basic application(s) was/were the first
application(s) made in a Convention country in respect
of the invention the subject of the application.
4. The actual inventor(s) of the said invention is/are
Richard Stuart Williams of
201 Pennine Road, Bromsgrove, Worcestershire, England

5. The facts upon which the applicant(s) is/are entitled
to make this application are as follows:-
By virtue of an Assignment dated 2 February 1987

Country, filing
date and name
of Applicant(s)
for the or
each basic
applicationName(s) and
Address(es)
of the or
each actual
inventorSee reverse
side of this
form for
guidance in
completing
this partDECLARED at Manchester, this 29th day of January 1988
ENGLAND

for BIP CHEMICALS LIMITED

Robert F HadfieldRobert Franklin Hadfield,
Authorised Signatory

This form may be completed and filed after the filing of a patent application but the form must not be signed until after it has been completely filled in as indicated by the marginal notes. The place and date of signing must be filled in. Company stamps or seals should not be used.

(12) PATENT ABRIDGMENT (11) Document No. AU-B-11408/88
(19) AUSTRALIAN PATENT OFFICE (10) Acceptance No. 598094

(54) Title
POLYAMIDE COMPOSITIONS

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(56) Prior Art Documents
AU 11209/88 C08K 13/04 C08L 77/02 77/06
EP 0092776

(57) Claim

1. A polyamide moulding composition free from halogenated fire retardants and antimony trioxide comprising a thermoplastic polyamide in an amount of at least 40 per cent by weight of the composition, a flame retardant comprising red phosphorus, said red phosphorus making up 5 to 15 per cent by weight of the composition, magnesium carbonate in an amount of 5 to 50 per cent by weight of the composition, and optionally reinforcing fibres in an amount of 5 to 40 per cent by weight of the composition, the total amount of said flame retardant and said magnesium carbonate being not more than 55 per cent by weight of the composition and the amount of red phosphorus and magnesium carbonate being such that:

$$3P + C > 30$$

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where P is per cent by weight of red phosphorus in the total composition and C is per cent by weight of magnesium carbonate in the total composition.

AUSTRALIA

PATENTS ACT 1952

COMPLETE SPECIFICATION

(ORIGINAL)

FOR OFFICE USE

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Form 10

Short Title:

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Lodged:

Complete Specification-Lodged:
Accepted:
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Priority:

Related Art:

This document contains the
amendments made under
Section 49 and is correct for
printing.

TO BE COMPLETED BY APPLICANT

Name of Applicant: BIP CHEMICALS LIMITED

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Australia.

Complete Specification for the invention entitled:
POLYAMIDE COMPOSITIONS

The following statement is a full description of this invention
including the best method of performing it known to me:-

Polyamide Compositions

This invention relates to polyamide compositions, and more particularly to such compositions which contain flame retardants.

In moulding compositions of polyamides such as nylon 6 and nylon 66 flame retardants are widely used materials and various types are known. For Example brominated or chlorinated compounds may be used, particularly in conjunction with a synergist such as antimony trioxide. These materials, however, lower the electrical tracking resistance of the resulting composition, this being a particularly acute problem in glass-filled systems. Red phosphorus may be employed to obtain a higher tracking resistance with flame retardancy but the tracking resistance is still not as good as desirable particularly in glass filled systems.

We have now found a combination of additives through the use of which high tracking resistance may be attained in combination with good flame retardancy.

According to the invention a polyamide moulding free from halogenated fire retardants and antimony trioxide composition, comprises a thermoplastic polyamide in the amount of at least 40 per cent by weight of the composition, a flame retardant, ^{comprising} ~~consisting essentially of~~ red phosphorus, said red phosphorus making up 5 to 15 per cent by weight of the composition, and magnesium carbonate in an amount of 5 to 50 per cent by weight of the composition, and optionally reinforcing fibres in an amount of 5 to 40 per cent by weight of the composition, the total amount of said flame retardant and said magnesium carbonate being not more than 55 per cent by weight of the composition and the amount of red phosphorus and magnesium carbonate being such that

$$3P + C \geq 30$$

where P is per cent by weight of red phosphorus in the total composition and C is per cent by weight of magnesium carbonate in the total composition.

The thermoplastic polyamide is preferably an injection mouldable polymer with a melting point above 180°C for example, nylon 6 or nylon 66.

The flame retardant has red phosphorus as its essential ingredient but the red phosphorus is preferably treated in order to reduce its handling difficulties, since red phosphorus alone can be very dangerous in handling. Thus



the red phosphorus may be carried in a polymeric carrier, and/or may be encapsulated with a suitable substance such as a polymer or resin.

In the present invention the magnesium carbonate is used as a powdered solid material which may be in an uncoated or coated grade. It has various forms, pure magnesium carbonate (magnesite), hydrated magnesium carbonate, basic magnesium carbonate, all of which may be used, and we have also found that the mineral dolomite may be used. Dolomite contains magnesium carbonate in a mixed salt, magnesium calcium carbonate, and as will be shown in the Examples it has an effect similar to pure magnesium carbonate, although slightly more may have to be used for a given performance. Similarly basic magnesium carbonate is substantially equivalent, weight-for-weight, to pure magnesium carbonate. For magnesium carbonate that is merely in hydrate form, an amount is used which corresponds to the content of $MgCO_3$ in it.

We have found that the addition of the magnesium carbonate has a noticeably beneficial effect on the electrical tracking resistance of the flame retarded composition, and on the erosion resistance of the composition during the test for electrical tracking resistance. In general, by using both the red phosphorus and the magnesium carbonate it is possible to attain a composition which has both a high tracking resistance and a low flammability eg a VO flammability rating. In general if the



- 3A -

higher loadings of red phosphorus flame retardant are used, less magnesium carbonate is needed to attain a good tracking resistance with good flammability rating. _____

9
2
4



If low loadings of red phosphorus are used a good tracking resistance is obtainable with low loading of the magnesium carbonate but to obtain a good flammability rating as well the loading of magnesium carbonate needs to be increased.

We have found that with the lower loadings of phosphorus a small addition of Magnesium Carbonate has a beneficial effect on the electrical tracking resistance but a detrimental effect on flammability rating. However, increasing the amount of magnesium carbonate will ultimately restore a good flammability rating. The formula $3P + C \gg 30$ reflects the fact that the amount of red phosphorus needed for a given effect on flammability rating is much less than that of magnesium carbonate.

Preferably reinforcing fibres are included in the composition, the particularly preferred reinforcement being chopped glass fibres, and preferably the amount of such fibres in the composition is in the range 15 to 35 per cent by weight of the composition. Other types of fibres may be used however, for example inorganic fibres such as ceramic fibres, wollastonite, and organic heat resistant fibres such as aramid fibres.

Other fire retarding agents may also be included in the compositions of this invention provided that they do not have a detrimental effect on the electrical tracking

resistance of the composition. Thus halogenated fire retardants or antimony trioxide are not to be used.

If desired other ingredients may also be added to the compositions of this invention, such as pigments, stabilisers, lubricants, mineral fillers, etc, as is usual in a moulding composition.

The invention will now be described in more detail by means of examples.

Examples

In the following examples all the compositions were made by first blending the ingredients together, then feeding the mixture through a Werner and Pfleiderer ZSK30 extruder under the following conditions.

For Nylon 66 280°C barrel temperatures

For Nylon 6 250°C barrel temperatures

The screw speed used was 300-350 rpm but adjusted where 10 necessary to maintain a reasonable torque. Feed rate was adjusted to give a torque reading between 60 and 95%.

Test mouldings were made from each composition using standard injection moulding techniques and the samples so

made were tested for electrical tracking resistance and flammability.

Electrical Tracking Resistance

The test equipment used is that of the Comparative Tracking Index test of the European Standard (DIN 53480). An aqueous solution containing 0.1% NH_4Cl and 0.5% surfactant (Nansa HS 85/S ex Albright and Wilson) was dropped at 30 second intervals on to the surface of the mouldings between two electrodes carrying the applied voltage (up to 600 volts). Platinum electrodes were used, with trips at 0.5 amps and 2 secs.

Results are expressed in the tables below for each applied voltage as "failures" at a stated number of drops, or "passes" at 100 drops total. The erosion of the sample is measured as the weight loss in grammes after the application of 100 drops of solution.

Flammability Testing

The method used was the standard Underwriters Laboratories test method UL94. V0 means that the specimens burnt for less than 10s after removal of flame, that the total burn time for ten applications of the flame on five specimens was less than 50 seconds. In addition no flaming drops are

permitted. In V1 classification no specimen burns for longer than 30 seconds after the application of the flame and the total burning time for 10 specimens is less than 250 seconds. No flaming drops are permitted. The same criteria apply in V2 classification except that some flaming drops are permitted.

In addition to these classifications, the average burning time for each application of flame was calculated and the occurrence of non-flaming drops was noted (10 specimens).

Examples 1 to 3

A series of compositions of nylon 66 was prepared using as flame retardant granules of encapsulated red phosphorus, the latter being masterbatched in a polyamide carrier (70% by weight of red phosphorus). Powdered uncoated pure magnesium carbonate (magnesite) was used and the glass fibres were grade R23D from Owens Corning Fibreglass, chop length 4.5mm.

In Table I below the formulations are given in parts by weight.

TABLE I

<u>Example No.</u>	1	2	3
Nylon 66	62.10	57.10	42.10
Glass Fibre	25.0	25.0	25.0
Flame Retardant (70% Red P)	12.90	12.90	12.90
Magnesium Carbonate	-	5.0	20.0

NB The above loading of flame retardant corresponds to 9% by weight of red phosphorus in the total composition.

Test samples were moulded from each composition and the results of electrical tracking resistance tests on each are given below in Table II.

TABLE II

<u>Example No.</u>	1	2	3
600 volts	NT	NT	P>60
500 volts	F/4	F/16	P>60
400 volts	F/15	P>100	P>100

F = fail P = pass

In this Table in each Example the level of flame retardant corresponds to 9% by weight red phosphorus in the total composition. It can be seen that an improved electrical tracking resistance has been obtained in the compositions containing the magnesium carbonate.

Test samples were also subjected to flammability testing by the Underwriters Laboratories UL94 test method and the results obtained are shown below in Table III.

TABLE III

<u>Example No.</u>	1	2	3
UL94 test rating			
Class 3mm	V0	V0	V0
1.5mm	V0	V0	V0
Burn Time (sec)			
3mm	0	0.5	0.3
1.5mm	0.5	0.8	1.4
Dripping	3NF at 1.5mm*	2NF at 1.5mm	None

* NF = non-flaming

Here it can be seen that the V0 flammability ratings have

been retained with the higher tracking resistance in Examples 2 and 3.

Examples 4 to 7

A further series of compositions of nylon 66 was prepared using the same ingredients as in Examples 1 to 3. In this series the loading of flame retardant corresponds to 5% by weight red phosphorus in the composition, and in one Example (Example 7) the nylon 66 is blended with a minor proportion of nylon 6. The formulations are given in Table IV in parts by weight.

TABLE IV

<u>Example No</u>	4	5	6	7
Nylon 66	67.90	57.90	47.90	37.90
Nylon 6	-	-	-	10.
Glass Fibre	25.0	25.0	25.0	25.0
Flame Retardant (70% Red P)	7.10	7.10	7.10	7.10
Magnesium Carbonate	-	10.0	20.0	20.0

Test samples were moulded from each composition and the results of electrical tracking resistance tests on each are given below in Table V.

TABLE V

<u>Example No</u>	4	5	6	7
600 volts	NT	F/8	NT	Fail
500 volts	F/8	P>60	P>100	P>70
E (g)*			0.037	
400 volts	P>100	P>60	P>100	P>60
E (g) *	0.282		0.013	

F = fail P = pass *E = Erosion from sample passing test, measured in grammes.

In this Table it can be seen that an improved electrical tracking resistance has been obtained in the compositions containing the magnesium carbonate, and in the blend composition (Example 7) the electrical tracking resistance remains better than that in Example 4 despite the presence of the nylon 6.

Test samples were also subjected to flammability testing by the Underwriters Laboratories UL94 test method and the results obtained are shown below in Table VI.

TABLE VI

<u>Example No</u>	4	5	6	7
UL94 test rating				
Class 3mm	VO	Fail	VO	VO
1.5mm	V1	V2	VO	V2
Burn Time (sec)				
3mm	0.7	-	1.9	-
1.5mm	2.8	-	1.8	-
Dripping	3NF at	-	None	-
	1.5mm			

* NF = non-flaming

Here it can be seen that the flammability rating has been decreased by the lower loading of Magnesium Carbonate in Example 5. However VO ratings have been regained with the higher tracking resistance in Examples 6 and 7.

Examples 8 to 11

A series of nylon 6 compositions was prepared using other ingredients as used in the previous examples. The formulations are given in parts by weight in Table VII.

TABLE VII

<u>Example No</u>	8	9	10	11
Nylon 6	62.1	57.1	67.9	47.9
Glass Fibres	25.0	25.0	25.0	25.0
Flame Retardant				
(70% Red P)	12.9	12.9	7.1	7.1
Magnesium Carbonate	-	5.0	-	20.0

NB 12.9 parts of flame retardant corresponds to 9% by weight red phosphorus and 7.1 parts of flame retardant corresponds to 5% by weight red phosphorus.

Tests for electrical tracking resistance and flammability rating were carried out on samples moulded from each composition and the results are given below in Table VIII.

TABLE VIII

<u>Example No</u>	8	9	10	11
Electrical tracking resistance				
250 volts	P>80	NT	NT	NT
300 volts	Fail	NT	P>100	NT
350 volts	NT	P>60	Fail	NT
400 volts	NT	Fail	Fail	P>60
500 volts	NT	NT	NT	Fail
UL94 test				
3mm class	V0	V0	Fail	V0
1.5mm class	V2	NT	V2	NT

It can be seen that the addition of magnesium carbonate in these formulations has again made a considerable improvement to electrical tracking resistance.

Examples 12 to 16

A series of nylon 66 compositions was prepared to investigate using powdered dolomite or powdered calcium carbonate as synergist instead of the pure magnesium carbonate used in previous examples. Other ingredients were as before.

The formulations are given in parts by weight in Table IX.

TABLE IX

<u>Example No</u>	12	13	14	15
Nylon 66	57.1	47.9	57.1	47.9
Glass fibres	25.0	25.0	25.0	25.0
Flame Retardant (70% Red P)	12.90	7.10	12.90	7.10
Dolomite	5.0	20.0	-	-
Calcium Carbonate	-	-	5.0	20.0

Again, 12.9 parts of flame retardant corresponds to 9% by weight red phosphorus and 7.10 parts to 5% by weight red phosphorus in the total composition.

Samples moulded from these compositions were tested briefly for electrical tracking resistance and flammability rating and the results are given below in Table X.

TABLE X

<u>Example No</u>	12	13	14	15
350 volts	NT	NT	P>100	NT
400 volts	P>60	NT	F/22	P>100
500 volts	Fail	P>60	NT	F/5
600 volts	NT	Fail	NT	NT
UL94 test				
3mm class	V0	V1	V0	Fail
1.5mm class	V1	V1	V0	-

Examples 12 and 14 compare with Example 1 and Examples 13 and 15 compare with Example 4.

Examples 12 and 13 demonstrate that dolomite has effects on electrical tracking resistance and flammability rating which are similar to those of pure magnesium carbonate but it can be seen from Examples 14 and 15 that the effects of calcium carbonate on electrical tracking resistance are no more than a dilution effects.

THE CLAIMS DEFINING THE INVENTION ARE AS FOLLOWS:

1. A polyamide moulding composition free from halogenated fire retardants and antimony trioxide comprising a thermoplastic polyamide in an amount of at least 40 per cent by weight of the composition, a flame retardant comprising red phosphorus, said red phosphorus making up 5 to 15 per cent by weight of the composition, magnesium carbonate in an amount of 5 to 50 per cent by weight of the composition, and optionally reinforcing fibres in an amount of 5 to 40 per cent by weight of the composition, the total amount of said flame retardant and said magnesium carbonate being not more than 55 per cent by weight of the composition and the amount of red phosphorus and magnesium carbonate being such that:

$$3P + C > 30$$

where P is per cent by weight of red phosphorus in the total composition and C is per cent by weight of magnesium carbonate in the total composition.

2. A polyamide moulding composition according to claim 1 in which the thermoplastic polyamide is an injection mouldable polymer with a melting point above 180°C.

3. A polyamide moulding composition according to claim 1 or 2 in which the thermoplastic polyamide is nylon 6 or nylon 66.

4. A polyamide moulding composition according to any preceding claim which includes chopped glass fibres as reinforcing fibres.



5. A polyamide moulding composition according to any preceding claim which includes as reinforcing fibres one or more of ceramic fibres, wollastonite, and aramid fibres.

6. A polyamide moulding composition according to any preceding
5 claim which includes an amount of reinforcing fibres in the range 15 to 35 per cent by weight of the composition.

7. A polyamide moulding composition according to any preceding claim in which the magnesium carbonate is incorporated in the form of magnesite.

8. A polyamide composition according to any one of claims 1 to
10 6 in which the magnesium carbonate is incorporated as dolomite.

9. A polyamide moulding composition substantially as described in any Example 2 or Example 6.

10. A polyamide moulding composition substantially as described
15 in Example 3, 7, 9, 11, 12 and 13.

DATED this 21st day of March, 1990

BIP CHEMICALS LTD.
By Their Patent Attorneys

20 GRIFFITH HACK & CO.
Fellows Institute of Patent
Attorneys of Australia

