

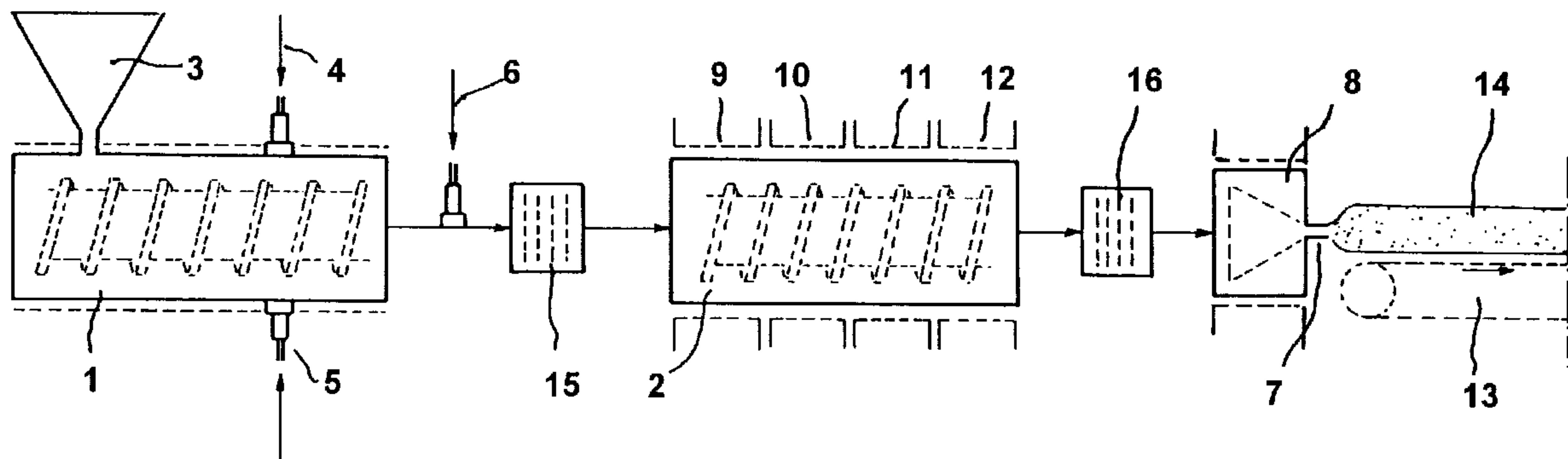


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(54) Titre : PROCEDE ET INSTALLATION POUR PRODUIRE DES MOUSSES, ET BLOCS ET PLAQUES DE MOUSSE
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(54) Title: PROCESS AND APPARATUS FOR PRODUCING FOAM



(57) **Abrégé/Abstract:**

The present invention relates to a process and apparatus for producing polystyrene foam, as well as to foam blocks and boards (such as plates and panels) produced therewith. CO₂ is used as the blowing agent, and a first and second control agents are injected into the melt, the first control agent being designed to dissolve and cool the melt and consisting of ethanol, while the second control agent is only designed to cool the melt and consists of H₂O₂, the injected amount of ethanol being just sufficient for achieving the highest possible dissolution of CO₂ in the melt and the injected amount of H₂O₂ being such that the foaming produced by ethanol is minimised. The related apparatus comprises arrangements for conditioning and feeding the blowing agent and control agents into the melt. The blocks and boards exhibit dimensional stability and good self-extinction features.



Abstract:

The present invention relates to a process and apparatus for producing polystyrene foam, as well as to foam blocks and boards (such as plates and panels) produced therewith. CO₂ is used as the blowing agent, and a first and second control agents are injected into the melt, the first control agent being designed to dissolve and cool the melt and consisting of ethanol, while the second control agent is only designed to cool the melt and consists of H₂O₂, the injected amount of ethanol being just sufficient for achieving the highest possible dissolution of CO₂ in the melt and the injected amount of H₂O₂ being such that the foaming produced by ethanol is minimised. The related apparatus comprises arrangements for conditioning and feeding the blowing agent and control agents into the melt. The blocks and boards exhibit dimensional stability and good self-extinction features.

PROCESS AND APPARATUS FOR PRODUCING FOAM

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The invention relates to a process and an apparatus for producing polystyrene foam, as well as to foam blocks and boards (such as plates and panels) produced therewith.

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Of particular relevance in this technical field are GB-A-1,220,053 and GB-A-1,230,992 of Imperial Chemical Industries Limited (ICI). Prior to the date of application of said British patents, foaming tests of synthetic resins using substantially inert inorganic gases, especially CO₂, had already been carried out. These tests did not give the desired results, at least not for
15 foam thicknesses of more than a few mm, owing mainly to the low solubility of CO₂ in the polymeric mixture or melt to be foamed, which made it necessary to operate at high pressures throughout the process (resulting in higher costs), giving rise to high temperatures, with the result that the temperature of the melt at the time of the final extrusion to the atmosphere (below, "final
20 extrusion") is too high to allow the foam features to be controlled properly; moreover, the polymeric mixture may be subject to thermal degradation. As a result, a foam of very high density is obtained, and foam boards of commercial grade can only be achieved for thicknesses in the order of a few mm, since it is not possible to incorporate in the melt the amount of CO₂
25 necessary for obtaining greater thicknesses.

Said documents GB-A-1,220,053 and GB-A-1,230,992 established, toward the end of the 1960s, the general basis for producing specific synthetic resin foams, including those of polystyrene. Particularly, GB-A-1,220,053 describes "*a process for the production of foamed thermoplastic*

polymers in which the pressure is released from a pressurised homogeneous mixture of the molten thermoplastic polymer and a blowing agent system, said system comprising a first blowing agent which is completely miscible with the molten thermoplastic polymer at the said pressure and which is a solvent
5 for said thermoplastic polymer under the conditions of temperature and pressure of the homogeneous mixture and a second different blowing agent which has a solubility of at least 0.01% by weight in the thermoplastic polymer and a critical temperature less than the temperature of the homogeneous mixture at the point when said pressure is released, said first
10 blowing agent having a boiling point 10°C or more below said temperature of the mixture" (claim 1). Moreover, it clearly states that the process can be applied to the foaming of "polystyrene" (page 1, col. 2, line 53), that "the first and the second blowing agents are selected so that they are inert with respect to the thermoplastic polymer under the pressure and temperature
15 conditions of the pressure vessel" (page 2, col. 1, lines 40-44), that "the most suitable substances for use as the first blowing agent are liquids whose boiling points at atmospheric pressure are greater than room temperature" (page 2, col. 2, lines 69-72), that "ethanol" can be used as the first blowing agent (page 2, col. 2, line 83), that it was found that "carbon dioxide" (page 3,
20 col. 1, line 17) is a substance which can be used as the second blowing agent, that it is preferable to use "as much of the second gaseous blowing agent (CO₂) as possible", but stating that this amount of CO₂ is usually less than 10% by weight (page 3, col. 1, lines 29-34), and suggesting that, in fact, the foaming produced by the first blowing agent (for example, ethanol) alone
25 may give rise to a small number of very large bubbles or cells, which is detrimental to the commercial value of the product (page 3, column 1, lines 10-14).

In the years following the filing date of said ICI patents, manufacturers tended more and more towards using halocarbon blowing

agents (also foreseen in said British patents), either alone or in various mixtures. However, for environmental reasons, since the 1980s, attempts have been made to decrease the use of halocarbon blowing agents and everything points to the increased use of CO₂ as the main blowing agent.

5 From among the patent documents reflecting these trends, the following may be mentioned: WO 93/22371, EP-A-0 318 846, EP-A-0 411 923, EP-A-0 464 581, EP-A-0 597 375, DE 39 43 265 A1, US 5,158,986, US 5,244,927, US 5,250,577 and US 5,269,987, some of them also involving the use of ethanol as "blowing agent".

10 Relevant apparatuses are known from EP-A-0 528 536 and US-A-4 436 679.

As may be gathered from said patent documents of ICI, it would be ideal to work with a single blowing agent, namely CO₂. However, its low solubility in the polymer and the other drawbacks referred to above make it
15 necessary to use CO₂ in conjunction with other different agents which mitigate these drawbacks. Any agent other than CO₂ capable of passing from the liquid state to the vapour state at a temperature slightly below that of the polymer melt at the moment of the final extrusion will inevitably have, to a greater or lesser extent, a foaming effect, and in that sense such an agent
20 can qualify as a "blowing agent", as is done, for example, in said patent documents of ICI when referring to the "*first blowing agent*". However, especially when the agents employed jointly with CO₂ are lower alcohols, the foaming effects (inevitably) produced are in general undesirable, owing to the fact that they tend to give irregular bubbles or cells of which large-sized
25 and/or open ones predominate, rather than cells with the desired features produced by using the proper blowing agent, i.e. CO₂. For this reason, agents other than CO₂ will not be referred to in the present specification as "blowing agents" but as "control agents" since, rather than being used for foaming, they are used for enabling the foaming produced

basically by the proper blowing agent (CO₂) to proceed adequately.

The present inventors have confirmed through experiments that ethanol acts as a solvent for polystyrene, thereby reducing the viscosity of the melt, making it possible to work at lower pressures along the entire
5 production line, including the final extrusion head, while using the same amount of CO₂ incorporated in the melt. A decrease in the viscosity also results in a decrease in both the internal friction of the melt and its friction with the mechanical components it makes contact with and, as a result of this, in a decrease in the temperature of the melt, which is of special
10 importance near the die of the final extrusion head. The present inventors have also confirmed through experiments the beneficial effects of ethanol, by virtue of absorbing heat from the melt when the foaming occurs.

However, the experiments carried out by the present inventors using ethanol as control agent for the foaming, mainly produced by CO₂,
15 have also revealed its drawbacks, which chiefly consist of the fact that the foams obtained using ethanol take a considerable amount of time to reach the final value of some of their physical properties which are considered critical, such as their high-temperature dimensional stability, compression strength, and behaviour towards fire or self-extinction capacity, and that (as
20 already stated) ethanol tends to produce foaming with large and open cells.

It is an object of the present invention to obviate or mitigate the problems associated with conventional processes.

The inventors have found that where ethanol is used as control agent for the foaming produced by CO₂ the best foam features are obtained if
25 the minimum amount of ethanol is added, just sufficient to give to the melt the proper viscosity for absorbing the highest possible amount of CO₂, and to keep the foaming produced by ethanol at the minimum possible amount.

Moreover, the inventors have found that this reduction in the amount of ethanol used would by itself have the potential drawback of
30 making it difficult to achieve the required decrease in temperature, since one

of the effects of ethanol is to act as coolant of the melt. In order to avoid this drawback, the inventors propose the use of a second control agent consisting of H_2O_2 which is added to the melt subsequent to the addition of ethanol.

5 The fact that H_2O_2 does not dissolve polystyrene and therefore does not modify its features has the effect that the physical properties of the foam are maintained or improved and that the foam can be obtained with greater thicknesses than when using ethanol alone as the control agent for controlling the foaming produced by CO_2 . The use of a much
10 smaller amount of ethanol enables the physical properties which are considered critical (dimensional stability, strength and self-extinction capacity) to be achieved more rapidly.

 Furthermore, the inventors have also found that the advantages of the invention are optimised if the polystyrene used to form the
15 polymeric mixture is a polystyrene having a molecular weight of less than about 150,000, a melt flow index of about 20 g/10 min (ISO 1133H) and a softening temperature VICAT VST B 50 (according to ISO 306 B 50) above 100°C. The main reason for using this low-molecular-weight polystyrene is to enable the process to be carried out at a lower viscosity
20 than the one usually encountered; this makes it possible to dissolve a larger amount of CO_2 in the melt, to decrease the amount of ethanol used and, most importantly, to keep low the increase in temperature inevitably produced by friction.

 Bearing in mind the foregoing, according to an aspect of the
25 present invention there is provided a process for producing polystyrene foam, the process comprising: plastifying a mixture of polystyrene with nucleating agents, plasticisers and additives at a pressure and temperature respectively above atmospheric pressure and room temperature to form a melt, injecting a blowing agent to produce the
30 desired foaming and only consisting of CO_2 into the melt so that the blowing agent is dissolved in the melt, and also injecting a first and a second control agents into the melt, the first control agent for dissolving and cooling the melt and consisting of ethanol, while the second control

agent is only for cooling the melt and consists of H_2O_2 , the injected amount of ethanol being such that it is just sufficient for achieving dissolution of CO_2 in the melt, and the injected amount of H_2O_2 being such that the foaming produced by ethanol is minimized, and suddenly
5 decompressing and cooling the melt to atmospheric pressure and room temperature, on being extruded through a final extrusion die.

According to an optional feature, the ethanol is injected into the immediate proximity of the injection point of CO_2 and the H_2O_2 is injected downstream from that point, when the injections of the blowing
10 agent and the ethanol have already partially cooled the melt.

According to another optional feature, immediately before the final extrusion, the melt to be extruded comprises 2.25-5% by weight of CO_2 , 0.3-3.0% by weight of ethanol and 0.2-1.7% by weight of H_2O_2 , the remainder being polystyrene and customary nucleating agents,
15 plasticisers and additives.

According to another optional feature, immediately before the final extrusion, the melt to be extruded comprises 3.0-4.0% by weight of CO_2 , 0.6-1.25% by weight of ethanol and 0.25-1% by weight of H_2O_2 , the remainder being polystyrene and customary nucleating agents,
20 plasticisers and additives.

According to another optional feature, the temperature and pressure profiles of the process are kept at decreasing temperature values in the range of 200 to 100°C and at decreasing pressure values in the range of 20 to 7.6 MPa (about 200 to 76 bar), respectively, CO_2
25 always being maintained under supercritical conditions until the final extrusion.

According to another optional feature, the polystyrene has a molecular weight of less than about 150,000, a melt flow index of about 20

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g/10 min (ISO 1133H) and a VICAT VST B 50 (according to ISO 306 B 50) softening temperature above 100° C.

According to another aspect, the invention provides an apparatus for producing polystyrene foam, the apparatus comprising a kneader-extruder
5 and a dynamic mixer arranged in series, the kneader-extruder comprises means for effecting initial plastifying of a mixture of polystyrene, nucleating agents, plasticisers and additives into a melt and injection of CO₂ and ethanol into the melt, and the dynamic mixer being provided with a cooling device and feeds the melt into an extrusion die, means for injection of H₂O₂ located
10 between the kneader-extruder and the dynamic mixer, a first static mixer and a second static mixer inserted respectively immediately downstream of the kneader-extruder and immediately downstream of the dynamic mixer, and the means for the injection of H₂O₂ being arranged between the kneader-extruder and the first static mixer.

15 According to another optional feature, the apparatus comprises, upstream from the kneader-extruder, a first tank for receiving CO₂ from an external source, the first tank being maintained under pressure and temperature conditions of the same range as those of the external source, a second tank for CO₂ in which this is maintained under a pressure of about 7
20 MPa (about 70 bar) and at ambient or room temperature, and an injection pump for pumping CO₂ from the second tank and injecting it into the kneader-extruder and capable of raising the pressure of CO₂ from about 7 MPa (about 70 bar) to about 30 MPa (about 300 bar).

25 According to another optional feature, the flow of CO₂ from the first tank to the second tank is effected by means of another pump, downstream of which a heating device is provided which raises the temperature of the CO₂ leaving the another pump to about ambient or room temperature.

According to another optional feature, the flow of CO₂ between the second tank and the injection pump passes through a cooling device which

lowers the temperature of CO₂ to prevent it from being overheated during the pumping operation.

According to another optional feature, the injection pump is a cooled one.

5 According to another optional feature, the cooling of the injection pump is effected by cooling the pump head.

According to another optional feature, the process is carried out in an apparatus such as the one defined in the immediately preceding paragraphs and comprises the steps of:

- 10 a) plastifying into a melt a mixture of polystyrene with customary nucleating agents, plasticisers and additives in the kneader-extruder, the polystyrene having a molecular weight of less than about 150,000, a melt flow index of about 20 g/10 min (ISO 1133H) and a VICAT VST B 50 (according to ISO 306 B 50) softening temperature above 100 °C;
- 15 b) injecting into the melt, in the kneader-extruder, CO₂ on the one hand and ethanol on the other hand, at a pressure of about 20 MPa (about 200 bar);
- c) transferring the melt from the kneader-extruder to the first static mixer and injecting H₂O₂ into the melt between the kneader-extruder and the
20 first static mixer;
- d) homogenising the melt in the first static mixer;
- e) transferring the melt from the first static mixer to the dynamic mixer in which homogenisation is accompanied by a decrease in the temperature and the pressure to which the melt is subjected;
- 25 f) transferring the melt from the dynamic mixer to the second static mixer, in which the decrease in the temperature and the pressure to which the melt is subjected continues;
- g) transferring the melt from the second static mixer to the final extrusion head, in which the temperature and pressure are controlled so that they

remain close to about 100°C and 7.6 MPa (about 76 bar), respectively, the CO₂ always being maintained under supercritical conditions until the final extrusion;

the operative conditions being such

- 5 - that at the time of the final extrusion, the melt comprises 2.25-5% by weight of CO₂, 0.3-3.0% by weight of ethanol and 0.2-1.7% by weight of H₂O₂, the remainder being polystyrene and customary nucleating agents, plasticisers and additives,
- 10 - that the blocks or boards produced, 42 days after their production and after having been subjected to heating at 70°C for 2 days, have undergone a decrease in each of their linear dimensions (length, width and thickness) of less than 5% with regard to the original dimension, and
- 15 - that the test for determining the self-extinction coefficient, carried out on said blocks and boards one hour after they have been extruded, gives a flame height of less than 11 cm.

According to another aspect, the invention provides foam blocks and boards produced using the above mentioned process or apparatus, characterized in that 42 days after their production and after having been
20 subjected to heating at 70°C for 2 days they have undergone a decrease in each of their linear dimensions (length, width and thickness) of less than 5%, with regard to the original dimension.

According to another optional feature of the blocks and boards according to the invention, the test for determining the self-extinction
25 coefficient, carried out on said blocks and boards one hour after they have been extruded, gives a flame height of less than 11 cm.

Other features, objects and advantages will be apparent from the remainder of the description which follows after it has been read in conjunction with the attached drawings, in which:

Fig. 1 shows a schematic view of an apparatus in which the process according to the invention is carried out; and

Fig. 2 shows a schematic view of the CO₂ conditioning and feeding arrangements in the same apparatus.

5 Referring to Fig. 1, according to an embodiment of the present invention, the apparatus comprises a kneader-extruder 1 and a dynamic mixer 2, arranged in series or tandem.

The kneader-extruder 1 receives the initial charge of polystyrene and customary nucleating agents, plasticizers and additives, as shown
10 schematically by means of feed hopper 3, which feeds said initial charge or mixture into the kneader-extruder 1 which plastifies and homogenises it into a melt (in fact, the plastification and the homogenisation of melt proceed continuously through the apparatus until immediately before the final extrusion). The general structure of the kneader-extruder 1 is that of a
15 conventional plastifying apparatus and it is designed to work at pressures above 20 MPa (about 200 bar) and at temperatures above 225°C. In this embodiment of the invention, the kneader-extruder 1 is further equipped with injection devices 4 and 5, for CO₂ and ethanol, respectively, at temperatures near room temperature and at pressures in the order of 20 MPa (about 200
20 bar).

A device 6 for the injection of H₂O₂ at a temperature near room temperature and at a pressure above 20 MPa (about 200 bar) is provided between the kneader-extruder 1 and the dynamic mixer 2.

The purpose of the dynamic mixer 2 is to maintain the melt in the
25 best conditions for its final extrusion and foaming which will take place at the die outlet 7, provided at the outlet end of the final extrusion head 8. In the dynamic mixer 2, the dilution of the melt with ethanol and the dissolution of CO₂ in the melt are continued. Cooling of the melt by means of an exchanger-assisted cooling device, shown schematically by cooling steps 9,
30 10, 11 and 12, also takes place in said dynamic mixer 2.

Final extrusion head 8 and its die 7, as well as the conveyor 13 for discharging foam 14, do not form part of the invention and are therefore to be considered as being of the conventional type.

5 In the embodiment shown, a first static mixer 15 and a second static mixer 16, which serve to reinforce the homogenising action of the kneader-extruder 1 and dynamic mixer 2, are inserted immediately downstream of the kneader-extruder 1 and immediately downstream of the dynamic mixer 2, respectively.

10 In this kind of apparatus, it has been found advantageous to use the CO₂ conditioning and feeding arrangements of Fig. 2. These arrangements comprise a first tank 20 for receiving CO₂ from an external source 21 (the first tank 20 being maintained under pressure and temperature conditions of the same order as those of the external source 21), a second CO₂ tank 22 which is maintained under a pressure of about 7 MPa
15 (about 70 bar), and a pump 25 for the injection of CO₂, via device 4, into the kneader-extruder 1 and capable of raising the pressure of CO₂ from about 7 MPa (about 70 bar) to about 30 MPa (about 300 bar).

20 Preferably, the flow of CO₂ from the first tank 20 to the second tank 22 is effected by means of another pump 23, downstream of which a heating device 24 is provided which raises the temperature of the CO₂ leaving the other pump 23 to about room temperature. The flow of CO₂ between the second tank 22 and injection pump 25 passes through a cooling device 26 which lowers the temperature of CO₂ to prevent it from being overheated during the pumping of CO₂ to kneader-extruder 1, via device 4. Injection
25 pump 25 is cooled by passing coolant through its head.

Examples

Example 1: Effect of using low-molecular-weight polystyrene in the foaming produced by CO₂, controlled only by ethanol

In all Experiments 1-6 indicated below, polystyrene foam is produced by extrusion in the apparatus described above. The foam obtained at the outlet of the lips of die 7 upon final extrusion of the melt is 630 mm in width and 60 mm in thickness.

5 In a first series of experiments (Experiments 1 and 2), a polymeric mixture based on conventional polystyrene of molecular weight (Mw) 200,000, melt flow index (MFI) 7.5 and VICAT 50 N (ISO 306 B 50) softening temperature 102 °C is introduced into the kneader-extruder 1 at a flow rate of 400 kg/h. The mixture includes 0.4% talc for regulating the cell size and 2.5%
10 of hexabromocyclododecane as fireproofing agent.

Once the polymeric mixture has been plastified into a melt, 3.0 pph (3.0 parts by weight for every 100 parts by weight of polymeric mixture) of the blowing agent CO₂ and 4.1 pph of ethanol as the only control agent are injected into the melt.

15 The foams produced are just acceptable.

 In a second series of experiments (Experiments 3 and 4), conventional polystyrene is replaced with polystyrene of molecular weight (Mw) 130,000 (size exclusion chromatography (SEC)), melt flow index (MFI) 200 °C-5kg (ISO 1133 H) 23 and VICAT 50 N (ISO 306 B 50) softening
20 temperature 101 °C.

It is noted that the pressures in the kneader-extruder 1 and the dynamic mixer 2 decrease but that the pressure in the final extrusion head 8 is maintained, as desired, above the critical pressure of CO₂.

 Compared with Experiments 1 and 2, the foams from Experiments
25 3 and 4 exhibit a more smooth and even extrusion skin over the entire surface which is of better quality, without any deterioration of the other technical features.

 In a third series of experiments (Experiments 5 and 6), the same low-molecular-weight polystyrene as in Experiments 3 and 4 of the second
30 series was used, and the amount of control agent (ethanol) was lowered to

3.1 pph. As can be seen from Table 1 (Experiments 5 and 6), the pressures increase and reach the same order of magnitude as those observed in Experiments 1 and 2. It should be noted that the extrusion reference temperature, taken at the final extrusion head 8, is of the same order of magnitude.

Under these new conditions (less amount of control agent), the same good foam features (including good extrusion skin quality) as those observed in the second series of experiments are obtained.

The results obtained in the experiments are summarised in Table 1.

10

Table 1

EXPERIMENT	CO ₂ pph	EtOH pph	P ₁ (MPa)	P ₂ (MPa)	P ₃ (MPa)	Ref. temp. °C.	Skin quality	Density
1	3.0	4.1	15.3	11.6	8.5	109	A	40.2
2	3.0	4.1	14.7	11.5	8.1	107	A	40.0
3	2.8	4.0	11.7	11.3	8.1	111	B	37.4
4	2.9	4.1	12.6	11.5	8.2	112	B	38.6
5	3.2	3.1	14.3	12.7	8.4	109	B	39.9
6	3.2	3.1	13.2	12.7	8.2	108	B	39.2

P₁ = pressure in the kneader-extruder 1.

P₂ = pressure in the dynamic mixer 2.

P₃ = pressure in the final extrusion head 8.

15 Ref. temp. = Extrusion reference temperature, taken at the final extrusion head.

Skin quality: A = Acceptable. Skin fairly even without holes.

B = Good. Even and smooth skin.

20 From the results given in Table 1, it can be deduced that the use of low-molecular-weight polystyrene gives foams of better quality than those obtained with conventional polystyrene, maintaining lower pressures (Experiments 3 and 4) in the kneader-extruder 1 (P₁), without lowering the

pressures (P_3) in the final extrusion head 8, which would be undesirable.

Example 2: Effect of using [CO₂ + ethanol] and [CO₂ + ethanol + H₂O₂]

5 All Experiments 7-13 given below were carried out under the same conditions as those described in the first paragraph of Example 1 above. The tested products have the thicknesses indicated in Table 2 below.

A first series of experiments (Experiments 7-10) was carried out using conventional polystyrene (Experiments 7 and 8) and low-molecular-weight polystyrene (Experiments 9 and 10), using ethanol as the only control
10 agent.

In a second series of experiments (Experiments 11-13), a mixture of polystyrene of molecular weight (Mw) 130,000 (SEC), melt flow index (MFI) 200° C-5kg (ISO 1133 H) 23 and VICAT 50 N (ISO 306 B 50) softening temperature 101 °C, 0.6% of talc for regulating the cell size and 2.5% of
15 hexabromocyclododecane as fireproofing agent is introduced into the kneader-extruder 1 at a flow rate of 450 kg/h.

Once the polymeric mixture has been plastified into a melt, 3.5 pph (3.5 parts by weight for every 100 parts by weight of polymeric mixture) of the blowing agent CO₂, from 1 to 1.1 pph of ethanol and from 0.4 to 0.45 pph of
20 H₂O₂ are injected.

The extruded polystyrene foam obtained according to Experiments 11-13 exhibits an even extrusion skin of good quality with a percentage of closed cells above 95%. The self-extinction coefficient of the foam thus obtained is very more favourable than in the samples obtained using only
25 ethanol as the control agent (Experiments 7-10), as shown in Table 2 below. Likewise, they exhibit better dimensional stability when the foam is subjected to high temperatures.

Table 2

	7	8	9	10	11	12	13
Mw PS (1)	200.000	200.000	130.000	130.000	130.000	130.000	130.000
Thickness (mm)	40	50	40	50	50	40	40
CO ₂ pph	3.3	3.3	3.3	3.5	3.5	3.5	3.5
Ethanol pph	4.2	4.2	3.4	3.1	1.0	1.1	1.0
H ₂ O ₂ pph	0	0	0	0	0.45	0.4	0.4
P ₁ (MPa)	14.7	15.2	12.3	13.8	14.7	13.9	14.8
P ₂ (MPa)	13.4	13.4	10.2	11.3	15.0	11.9	12.0
P ₃ (MPa)	8.2	8.2	7.7	8.1	8.8	8.9	8.7
Ref. temp. (°C)	112	112	115	114	112	113	114
Density (kg/m ³)	38.2	38.8	41.0	41.2	38.4	36.4	36.8
% Closed cells (2)	95.7	95.0	96.1	97.5	98.4	96.4	96.6
Dimens. stabil. (3)							
Ext.	-6.8	-4.9	-6.6	2.0	-3.5	-4.1	-3
Trans.	-6.5	-7.0	-6.7	-10.3	-4.9	-2.4	-1.5
Th.	-6.7	-9.5	-3.8	-8.8	-2.3	-0.4	0
Self-ext. coef. (4)							
Flame height	16.5	18.0	15.0	15.0	9.0	8.0	10.0
Time	17.5	16.0	14.0	14.0	10.5	10.9	10.7

(1) = Molecular weight of polystyrene

(2) = Micromeritics apparatus

5 (3) = Dimensional stability measured after 30 days; the test specimens are subjected to 70°C for 2 days. Ext. = Direction of final extrusion; Trans. = Transverse direction; Th. = Direction of thickness

(4) = Self-extinction coefficient measured one hour after production.

In the test for determining the self-extinction coefficient, the
10 following protocol was used:

Number and size of the test specimens: 4 test specimens of size 90

mm x 190 mm were cut from the board to be tested. The thickness of the test specimen is that of the original board of up to 60 mm. The boards of more than 60 mm in thickness are cut to boards of 60 mm in thickness.

5 Test Procedure: The test specimen is attached to a support. A burner is used and its flame height is adjusted to 20 mm, the burner being moved in a horizontal direction until the flame is at a distance of 15 mm from the rear face of the test specimen. After 15 seconds, the burner is removed. This is followed by measuring the maximum height the flame
10 reaches (on the rear face of the test specimen) and the time it takes the flame to become extinguished, both before and after the burner is removed.

Example 3: Effect of feeding excess H_2O_2

15 A mixture of low-molecular-weight polystyrene and additives, as in Example 2 above, is fed into the apparatus (Experiments 11-13).

3.5 pph of the blowing agent, CO_2 , 1 pph of ethanol, as the first control agent, and 1 pph of H_2O_2 as the second control agent are injected.

Once the process has stabilised, the amount of H_2O_2 is steadily
20 increased. As soon as this amount reaches 3 pph, the process starts to destabilise. The pressure in the kneader-extruder 1 begins to vary widely between 10 and 15 MPa (about 100 and 150 bar). It is then noted that the current of the motor of the dynamic mixer 2 also varies. These variations indicate that the melt is not homogeneous because the blowing and control
25 agents are not being incorporated properly into the melt.

After adding H_2O_2 at 3 pph for 30 min., holes begin to appear on the foam surface caused by pockets of gas or unmixed control agents. The foam then becomes destabilised and its width varies constantly, and regions of hard material which has rapidly solidified begin to appear, possibly also due

to the pockets of gas or control agent.

The amount of H_2O_2 is lowered to 2,5 pph, and the process gradually stabilises.

5 **Example 4: Effect of omitting H_2O_2 and of feeding excess ethanol**

A mixture of low-molecular-weight polystyrene and additives, as in Example 3 above, is fed into the apparatus.

3.5 pph of the blowing agent CO_2 and 4.5 pph of the control agent ethanol are injected.

10 This melt is extruded through the lips of final extrusion die 7, giving a foam of 630 mm. The thickness of this foam at the outlet of the die gauge, measured with a slide calliper at 3 points along its width, is on average 51 mm. When the foam reaches the cutter conventionally placed downstream of die 7 (time elapsed 15 min.), the thickness is again measured over the entire
15 board width, giving an average value of 47 mm. Thus, the thickness has diminished by 4 mm.

The amount of ethanol is increased to 7 pph and that of CO_2 is decreased to 2.5 pph. The thickness is again measured at the outlet of the die gauge and when the foam reaches the cutter. Under these conditions, the
20 thickness has diminished by as much as 9 mm.

The experiment is continued, feeding in no more of the blowing agent CO_2 and injecting only ethanol, at 9 pph. After 30 min., a change in the foam structure is observed. At a glance, the cell size is seen to be much larger than in all of the preceding experiments. The board thickness has
25 increased to 55 mm at the outlet of the die gauge. However, upon reaching the cutter (time elapsed 15 min.), the board has a thickness of 26 mm, on average. Thus, the thickness has diminished by 29 mm. Furthermore, when only ethanol is used as the blowing agent, the walls tend to collapse.

To those skilled in the art, it will be apparent that many

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modifications and variations are possible in the practice of the invention described, which are all within the scope defined by the claims given below.

The embodiments of the invention in which an exclusive property or privilege is claimed are defined as follows:

1. A process for producing polystyrene foam, said process comprising:
 plastifying a mixture of polystyrene with nucleating agents, plasticisers and additives at a pressure and temperature respectively above atmospheric pressure and room temperature to form a melt,
 injecting a blowing agent to produce the desired foaming and only consisting of CO₂ into the melt so that said blowing agent is dissolved in the melt, and
 also injecting a first and a second control agents into the melt, the first control agent for dissolving and cooling the melt and consisting of ethanol, while the second control agent is only for cooling the melt and consists of H₂O₂, the injected amount of ethanol being such that it is just sufficient for achieving dissolution of CO₂ in the melt, and the injected amount of H₂O₂ being such that the foaming produced by ethanol is minimized, and
 suddenly decompressing and cooling the melt to atmospheric pressure and room temperature, on being extruded through a final extrusion die.
2. The process according to claim 1, wherein the ethanol is injected into the immediate proximity of the injection point of CO₂ and the H₂O₂ is injected downstream from that point, when the injections of the blowing agent and the ethanol have already partially cooled the melt.
3. The process according to claim 1 or claim 2, wherein immediately before the final extrusion, the melt to be extruded comprises 2.25-5% by weight of CO₂, 0.3-3.0% by weight of ethanol and 0.2-1.7% by weight of H₂O₂ the remainder being polystyrene and nucleating agents, plasticisers and additives.

4. The process according to claim 3, wherein immediately before the final extrusion, the melt to be extruded comprises 3.0-4.0% by weight of CO₂, 0.6-1.25% by weight of ethanol and 0.25-1% by weight of H₂O₂, the remainder being polystyrene and nucleating agents, plasticisers and additives.
5. The process according to any one of claims 1 to 4, wherein temperature and pressure profiles of the process are continuously decreasing from injection points to the extrusion die, with temperature values in the range of 200 to 100° C. and pressure values in the range of 20 to 7.6 MPa, the CO₂ always being maintained under supercritical conditions until the final extrusion.
6. The process according to claim 3, wherein the polystyrene has a molecular weight of less than about 150,000, a melt flow index of 20 g/10 min according to the standard ISO 1133H and a Vicat Softening Temperature according to the standard ISO 306 B 50 above 100° C.
7. An apparatus for producing polystyrene foam, said apparatus comprising a kneader-extruder and a dynamic mixer arranged in series, the kneader-extruder comprises means for effecting initial plastifying of a mixture of polystyrene, nucleating agents, plasticisers and additives into a melt and injection of CO₂ and ethanol into the melt, and the dynamic mixer being provided with a cooling device and being operative to feed the melt into an extrusion die, means for injection of H₂O₂ located between the kneader-extruder and the dynamic mixer, a first static mixer and a second static mixer inserted respectively immediately downstream of the kneader-extruder and immediately downstream of the dynamic mixer, and the means for the injection of H₂O₂ being arranged between the kneader-extruder and the first static mixer.

8. The apparatus according to claim 7, wherein, upstream from the kneader-extruder is located a first tank for receiving CO₂ from an external source, the first tank is maintained under pressure and temperature conditions of the same range as those of the external source, a second tank for CO₂ maintained under a pressure of about 7 MPa and at room temperature, and an injecting pump for pumping CO₂ from the second tank and injecting CO₂ into the kneader-extruder and capable of raising the pressure of CO₂ from about 7 MPa to about 30 MPa.
9. The apparatus according to claim 8, wherein flow of CO₂ from the first tank to the second tank is effected by means of a transferring pump, downstream of which a heating device is provided which raises the temperature of the CO₂ leaving the transferring pump to about room temperature.
10. The apparatus according to claim 8, wherein flow of CO₂ between the second tank and the injection pump passes through a cooling device which lowers the temperature of CO₂ to prevent CO₂ from being above about room temperature during the pumping operation.
11. The apparatus according to claim 8, wherein the injecting pump is a cooled one.
12. The apparatus according to claim 11, wherein the cooling of the injecting pump is effected by cooling a pump head.
13. A process for producing polystyrene blocks or boards, said process comprising the steps of:
- a) plastifying into a melt a mixture of polystyrene with nucleating agents, plasticisers and additives in a kneader-extruder, the polystyrene having a molecular weight of less than about 150,000, a melt flow index of 20 g/10 min

according to the standard ISO 1133H and a Vicat Softening Temperature according to the standard ISO 306 B 50 above 100° C.;

- b) injecting into the melt, in the kneader-extruder, CO₂ and ethanol, at a pressure of about 20 MPa;
 - c) transferring the melt from the kneader-extruder to a first static mixer and injecting H₂O₂ into the melt between the kneader-extruder and the first static mixer;
 - d) homogenising the melt in the first static mixer;
 - e) transferring the melt from the first static mixer to a dynamic mixer, in which homogenisation is accompanied by a decrease in the temperature and the pressure to which the melt is subjected;
 - f) transferring the melt from the dynamic mixer to a second static mixer, in which the decrease in the temperature and the pressure to which the melt is subjected continues;
 - g) transferring the melt from the second static mixer to a final extrusion head, in which the temperature and pressure are controlled so that they remain about 100° C. and 7.6 MPa, respectively, the CO₂ always being maintained under supercritical conditions until the final extrusion,
- wherein at the time of the final extrusion, the melt comprises 2.25-5% by weight of CO₂, 0.3-3.0% by weight of ethanol and 0.2-1.7% by weight of H₂O₂, the remainder being polystyrene and nucleating agents, plasticisers and additives.

FIG. 1

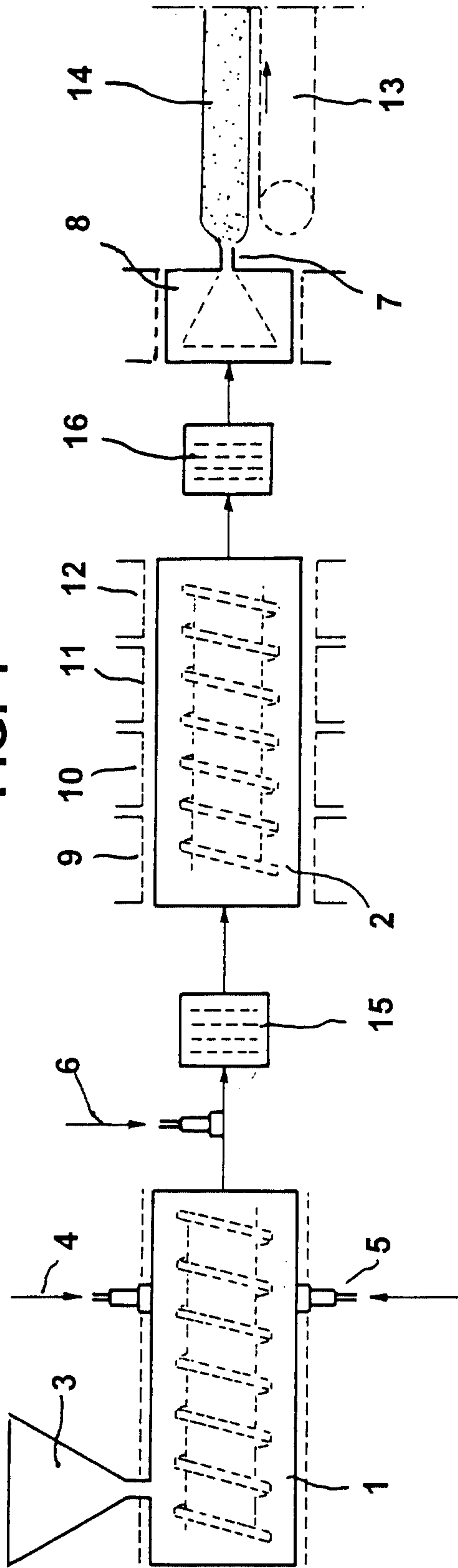
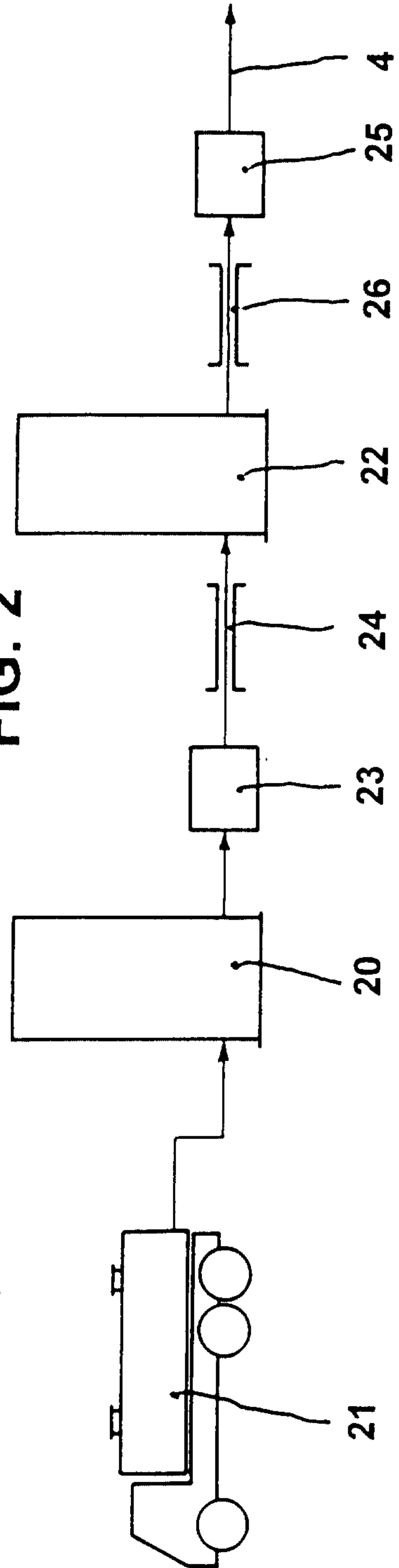


FIG. 2



Marks & Clerk

