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(54) Title: HYBRID FOAM

(54) Bezeichnung: HYBRIDSCHAUM

(57) Abstract: The invention relates to highly elastic polyurethane foams which are suitable as functional materials having heat-insulating properties.

(57) Zusammenfassung: Die Erfindung betrifft hochelastische Polyurethanschäume, die sich als Funktionswerkstoffe mit wärmedämmenden Eigenschaften eignen.

## Hybrid foam

### Description

- 5 The invention relates to a hybrid foam based on a highly elastic thermoplastic polyurethane (TPU), a process for producing it and the use of the foam.

The use of soft, closed-celled and highly elastic functional materials based on chloroprene foams for the sports, shoe and clothing industry is known. Owing to an  
10 intrinsically good resilience in combination with the low density and closed-celled nature, such foams are used to a great extent in diving suits and surfing wetsuits, swimsuits and sea rescue wetsuits and also boots and other equipment in the marine sector. However, the production of chloroprene foams is complicated. In addition, chloroprene foams do not have a satisfactory light stability, for which reason they are  
15 preferably colored black, and have an only low tear strength and elongation at break.

Production of foams and polyurethane films based on TPU which have essentially closed pores is known. Thermoplastic polyurethane films which have essentially closed pores are known, for example, from DE 3810595 A1. They are produced by adding a  
20 blowing agent before production of the film and carrying out foaming by means of the blowing agent essentially only after formation of the thermoplastic polyurethane. The films obtained can be at least monoaxially stretched. EP 0 692 516 A1 discloses thermoplastic double foams in which a thermoplastic polyurethane is used as base composition, with at least two foaming processes which proceed separately from one  
25 another taking place, mainly by means of a chemical blowing agent and, in parallel thereto, by means of incorporated microballoons. WO 2005/026243 A1 discloses the use of expandable microspheres in the form of hollow microspheres comprising a thin polymer shell, with the spheres being filled with gas, generally with hydrocarbons, in expandable compositions based on TPU. To improve the mechanical properties of  
30 such systems, thermoplastic processing of a blend of a thermoplastic polyurethane with rubbers together with at least one blowing agent under conditions which lead to expansion of the blowing agent is known from WO 2005/026243 A1.

A disadvantage of the known foams is that their hardness and stiffness is frequently  
35 very high.

The present invention seeks to provide a foam which is highly elastic, has a high softness, preferably a matrix hardness in the Shore A range from 20 to 70, particularly preferably from 30 to 70, and preferably has a stress at 100% elongation of < 0.5 MPa and at 200% elongation of < 1 MPa, which is predominantly closed-celled and easy to produce and has improved resistance to visible and UV light.

According to a first aspect, the present invention seeks to provide a piece of clothing, comprising an elastic hybrid foam based on

- 10 a) at least one thermoplastic polyurethane (TPU),
- b) hollow polymer bodies M which are filled with blowing agents,
- c) optionally an additional physical or chemical blowing agent T,
- d) and optionally auxiliaries and additives,

wherein the hybrid foam is at least monoaxially stretched, and wherein the Shore A hardness of the TPU employed is less than 75.

According to a second aspect, the present invention seeks to provide a process for producing pieces of clothing which have an elastic hybrid foam, wherein thermoplastic polyurethane is mixed with hollow polymer bodies M filled with blowing agents and optionally chemical or physical blowing agent T and also optionally further auxiliaries and additives, the hollow polymer bodies M filled with blowing agents and the chemical or physical blowing agent T are made to expand and the resulting expanded hybrid material is at least monoaxially stretched and processed to produce the piece of clothing.

25 The invention provides an elastic hybrid foam based on

- a) at least one thermoplastic polyurethane (TPU),
- b) hollow polymer bodies M which are filled with blowing agents and have a diameter of preferably not more than 200  $\mu\text{m}$ , optionally
- c) at least one additional chemical and/or physical blowing agent T, and
- 30 d) auxiliaries and/or additives,

wherein the hybrid foam is at least monoaxially stretched, preferably from 100 to 500%, particularly preferably from 200 to 400%.

The term hybrid foam indicates that the stretched foam of the invention comprises a TPU together with a different polymer in the form of hollow polymer bodies, preferably based on polystyrene or polyacrylonitrile or copolymers based on polystyrene or  
5 polyacrylonitrile.

As thermoplastic polyurethanes, it is possible to use the customary and known compounds as are described, for example, in Kunststoffhandbuch, volume 7 "Polyurethane", Carl Hanser Verlag, Munich, Vienna, 3rd edition 1993, pages 455 to  
10 466.

Preference is given to using TPUs which have a melt index or MFR (melt flow rate; 190°C/3.8 kg; DIN EN 1133) of 1 - 350 g/10 min, preferably 20 - 150 g/10 min. However, the use of TPUs for expandable or expanded TPUs is not restricted to a particular MFR.  
15

For the purposes of the present invention, thermoplastic polyurethanes can be plasticizer-free and plasticizer-comprising TPUs, in particular those having a content of 0 - 70% by weight, preferably from 0 to 50% by weight, based on the weight of the mixture, of customary plasticizers. Possible plasticizers are the compounds known in general for this  
20 purpose, e.g. phthalates, citrates, for example esters of citric acid, e.g.

tributylacetyl citrate and benzoates.

The preparation of the TPUs is carried out by customary processes by reacting diisocyanates A) with compounds having at least two hydrogen atoms which are  
5 reacted toward isocyanate groups, preferably bifunctional alcohols, in particular polyols B) and chain extenders C).

As diisocyanates A), it is possible to use the customary aromatic, aliphatic and/or cycloaliphatic diisocyanates, preferably diphenylmethane diisocyanate (MDI), tolylene  
10 diisocyanate (TDI), trimethylene, tetramethylene, pentamethylene, hexamethylene, heptamethylene and/or octamethylene diisocyanate, 2-methylpentamethylene 1,5-diisocyanate, 2-ethylbutylene 1,4-diisocyanate, 1-isocyanato-3,3,5-trimethyl-5-isocyanatomethylcyclohexane (isophorone diisocyanate, IPDI), 1,4- and/or  
1,3-bis(isocyanatomethyl)cyclohexane (HMDI), cyclohexane 1,4-diisocyanate,  
15 1-methylcyclohexane 2,4- and/or 2,6-diisocyanate, dicyclohexylmethane 4,4'-, 2,4'- and/or 2,2'-diisocyanate, diphenylmethane diisocyanate (MDI) is particularly preferred.

As compounds B) which are reactive toward isocyanates, it is possible to use generally known polyhydroxyl compounds which have number average molecular weights of  
20 from 500 to 8000, preferably from 600 to 6000, in particular from 800 to 4000, and preferably have an average functionality of from 1.8 to 2.6, preferably from 1.9 to 2.2, in particular 2, polyesterols, polyetherols and/or polycarbonatediols are preferred.

Preferred polyester diols can be obtained by reacting ethanediol, butanediol or hexanediol as diol with adipic acid as dicarboxylic acid, with the diols being able to be  
25 used either individually or as a mixture. Preference is given to, for example, a weight ratio of butanediol to hexanediol of 2 : 1 or a weight ratio of butanediol to ethanediol of 1 : 1. Preference is also given to polyether polyol having a number average molecular weight of from 750 to 2500 g/mol, preferably from 1000 to 2000 g/mol. Particular  
30 preference is given to polytetrahydrofuran having a number average molecular weight of from 1000 to 2000 g/mol.

As chain extenders C), it is possible to use generally known compounds, preferably diamines and/or alkanediols having from 2 to 10 carbon atoms in the alkylene radical, in particular ethylene glycol and/or 1,4-butanediol and/or hexanediol, and/or  
35 dioxyalkylene glycols and/or trioxyalkylene glycols having from 3 to 8 carbon atoms in the oxyalkylene radical, preferably corresponding oligopolyoxypropylene glycols, with

mixtures of the chain extenders also being used in some preferred embodiments. Use is also made of 1,4-bis(hydroxymethyl)benzene (1,4-BHMB), 1,4-bis(hydroxyethyl)benzene (1,4-BHEB) or 1,4-bis(2-hydroxyethoxy)benzene (1,4-HQEE) as preferred chain extenders. Preference is further given to using ethylene glycol, propanediol, butanediol and hexanediol, particularly preferably ethylene glycol and butanediol, as chain extenders.

It is preferred to use catalysts which accelerate the reaction between the NCO groups of the diisocyanates and the hydroxyl groups of the isocyanate-reactive components, preferably tertiary amines such as triethylamine, dimethylcyclohexylamine, N-methylmorpholine, N,N'-dimethylpiperazine, 2-(dimethylaminoethoxy)ethanol, diazabicyclo[2.2.2]octane and the like, and also, in particular, organic metal compounds such as titanate esters, iron compounds, preferably iron(III) acetylacetonate, tin compounds, preferably tin diacetate, tin dilaurate or the dialkyltin salts of aliphatic carboxylic acids, preferably dibutyltin diacetate, dibutyltin dilaurate or the like. The catalysts are preferably used in amounts of from 0.0001 to 0.1 parts by weight per 100 parts by weight of polyhydroxyl compound.

Apart from catalysts, preferably auxiliaries are also added to the components. Preferred auxiliaries are surface-active substances, flame retardants, nucleating agents, lubricants and mold release agents, dyes and pigments, inhibitors, stabilizers against hydrolysis, light, heat, oxidation or discoloration, agents for protection against microbial degradation, inorganic and/or organic fillers, reinforcing materials and plasticizers.

As flame retardants, it is generally possible to use the flame retardants known from the prior art. Suitable flame retardants are, for example, brominated ethers (Ixol B 251), brominated alcohols such as dibromoneopentyl alcohol, tribromoneopentyl alcohol and PHT-4-diol, and also chlorinated phosphates such as tris(2-chloroethyl) phosphate, tris(2-chloroisopropyl) phosphate (TCPP), tris(1,3-dichloroisopropyl) phosphate, tris(2,3-dibromopropyl) phosphate and tetrakis(2-chloroethyl) ethylenediphosphate, or mixtures thereof.

Apart from the abovementioned halogen-substituted phosphates, it is also possible to use inorganic flame retardants such as red phosphorus, preparations comprising red phosphorus, expandable graphite, aluminum oxide hydrate, antimony trioxide, arsenic

oxide, ammonium polyphosphate and calcium sulfate or cyanuric acid derivatives such as melamine or mixtures of at least two flame retardants such as ammonium polyphosphates and melamine and also optionally starch for making the rigid polyurethane foams produced according to the invention flame resistant.

5

As further liquid halogen-free flame retardants, it is possible to use diethyl ethanephosphonate (DEEP), triethyl phosphate (TEP), dimethyl propylphosphonate (DMPP), diphenyl cresyl phosphate (DPC) and others.

- 10 The flame retardants can be used in all customary amounts. When flame retardants are used, they are preferably used in an amount of from 1 to 50% by weight, based on the total weight of thermoplastic polyurethane.

- The molecular weight is preferably adjusted by means of monofunctional compounds  
15 which are reactive toward isocyanate, further preferably by monoalcohols.

The TPUs are usually produced by customary processes, preferably by means of belt units or reaction extruders.

- 20 The hollow polymer bodies M which are filled with blowing agent are preferably based on a polymer which has a lower polarity than the TPU used. They are preferably based on polystyrene or styrene-acrylonitrile polymers (SAN). In a preferred embodiment, expandable microspheres are used as hollow polymer bodies M filled with blowing agent. Expandable microspheres are hollow microspheres which are composed of a  
25 thin polymer shell preferably of polyacrylonitrile or copolymers thereof. These hollow microspheres are filled with gas or low-boiling liquids, preferably hydrocarbons. The temperature prevailing in thermoplastic processing results in softening of the polymer shell and at the same to expansion of the enclosed gas. This results in expansion of the microspheres. The expansion capability of the microspheres can be described by  
30 determination of the TMA density [ $\text{kg/m}^3$ ] (Stare Thermal Analysis System from Mettler Toledo; heat rate  $20^\circ\text{C}/\text{min}$ ). The TMA density is the minimum density which can be achieved at a particular temperature  $T_{\text{max}}$  under atmospheric pressure before the microspheres collapse.

- 35 The hollow polymer bodies M which are filled with blowing agents and are used according to the invention preferably have a diameter of from  $20\ \mu\text{m}$  to  $40\ \mu\text{m}$ . Such

hollow polymer bodies M which are filled with blowing agent can be obtained, for example, from Akzo Nobel, Casco Products GmbH, Essen, under the trade name Expancel .

- 5 It has been found surprisingly that a particularly fine cell structure, a suppression of void formation and no formation of sink marks is observed when hollow polymer bodies M which are filled with blowing agent and having a TMA density of less than  $10 \text{ kg/m}^3$ , preferably  $2 - 10 \text{ kg/m}^3$  and particularly preferably  $2 - 7 \text{ kg/m}^3$ , are used in powder form or masterbatch form and, in addition, the processing range, for example in respect of
- 10 temperature, is significantly greater, so that microspheres having such a TMA density are particularly preferred. In a further preferred embodiment, the hollow polymer bodies M filled with blowing agents have a bimodal particle size distribution. The particle sizes are selected so that a very optimal filling of space by the expanded particles is possible and a very low density of the hybrid foam of the invention is thus
- 15 obtained.

The content of hollow polymer bodies M which are filled with blowing agent in the mixture depends on the desired density of the expanded TPUs. Preference is given to using from 1 part by weight to 20 parts by weight, preferably from 2 parts by weight to

20 10 parts by weight, of the expandable hollow polymer bodies M which are filled with blowing agent according to the invention per 100 parts by weight of the TPU or TPU blend to be expanded, i.e. to be foamed.

Particular preference is given to hybrid foams according to the invention which are,

25 based on the total weight of thermoplastic polyurethane (TPU), hollow polymer bodies M filled with blowing agents and chemical or physical blowing agent T which is preferably used in the production process, based on from 75% by weight to 99% by weight, preferably from 80% by weight to 98% by weight, particularly preferably from 87% by weight to 97% by weight, of TPU; from 1% by weight to 20% by weight,

30 preferably from 2% by weight to 12% by weight, of hollow polymer bodies M which are filled with blowing agent and from 0 to 5% by weight, preferably from 0.1% by weight to 3% by weight, of chemical or physical blowing agent T. In this calculation, only the weight of the thermoplastic polymer derived from diisocyanates A), compounds B) having at least two hydrogen atoms which are reactive toward isocyanates and chain

35 extenders C) are taken into account; any further polymers or customary auxiliaries and additives such as UV inhibitors, flame retardants, fillers or plasticizers present are

disregarded in this calculation. Preference is given to setting a density of from 50 to 500 g/l, particularly preferably from 100 to 300 g/l and in particular from 110 to 200 g/l.

5 A microsphere masterbatch preferably comprises from 5% by weight to 90% by weight, preferably from 25% by weight to 70% by weight, of microspheres and from 10% by weight to 95% by weight, preferably from 30% by weight to 75% by weight, of carriers, preferably thermoplastic carriers, for example EVA (ethylene-vinyl acetate).

10 In a further preferred embodiment, micropelletized polystyrene bodies loaded with blowing agent, which preferably have a maximum diameter of 150  $\mu\text{m}$ , are used as hollow polymer bodies M filled with blowing agent. These particles are known and are usually used to produce expanded polystyrene (EPS).

15 Furthermore, appropriate additives can be added to the TPU and/or the hollow polymer bodies M in order to improve further properties, for example absorbers for protection against UV and visible light, flame retardants and plasticizers.

20 In a further preferred embodiment, a mold release agent is added to the TPU and/or preferably the hollow polymer bodies M filled with blowing agent before mixing with the TPU in order to reduce adhesion between the hollow bodies M and the TPU, in particular during and after stretching. As mold release agent, it is possible to use customary substances as are described, for example, in "Kunststoffhandbuch, volume 7, Polyurethane", Carl Hanser Verlag, 3<sup>rd</sup> edition 1993, chapter 3.4.9. Particular preference is given to using waxes, fats and/or oils as mold release agents.

25 In a particularly preferred embodiment, additional chemical or physical blowing agents T which are not enclosed in polymer bodies are used in addition to the blowing agents used in the hollow polymer bodies M. The chemical blowing agents referred to here are such substances which release gases on thermal decomposition when the hybrid foam according to the invention is produced, preferably hydrogencitrates, hydrogencarbonates or azodicarboxamides, e.g. Celegoene<sup>®</sup>, Tracel<sup>®</sup>, Hydrocerol<sup>®</sup>. For the present purposes, physical blowing agents are substances, preferably liquids which do not react, which vaporize during the production of the hybrid foam of the invention. Particular preference is also given to using a combination of sodium  
35 hydrogencitrate and sodium hydrogencarbonate as blowing agent T. The chemical or physical blowing agents are preferably also made up to form a masterbatch in

thermoplastic carriers, for example EVA (ethylene-vinyl acetate).

To produce the hybrid foams of the invention, the TPU and the hollow polymer bodies M filled with blowing agent and also, if appropriate, the additional blowing agent T are  
5 mixed and thermoplastically processed to produce the desired shaped bodies. This can be effected, for example, by means of injection molding, sintering or extrusion. The temperature during thermoplastic processing results in expansion of the expandable microspheres and thus to formation of the expanded TPUs. The melt is preferably continuously brought into the desired shaped and solidified or recrystallized.

10

Mixing of the TPU or TPU blend with the hollow polymer bodies M can be carried out in simple polymer granule mixers such as tumble mixers with or without prior application of 0.05 - 2% of binder, e.g. paraffin or mineral oil. Mixing of the TPU or TPU blend with  
15 masterbatches of the hollow polymer bodies M can likewise be carried out in simple polymer granule mixers, preferably tumble mixers, mechanically or by hand in simple plastic boxes, to give a dry blend. TPU, hollow polymer bodies M and blowing agents T are preferably also metered separately into the processing machine by means of suitable metering devices.

20 The hollow polymer bodies M filled with blowing agent are, in a preferred embodiment, added to the TPU after it has been produced. However, it is also possible to add the hollow polymer bodies M to the appropriate starting components during formation of the TPU. After the TPU has been mixed with the hollow polymer bodies M and, if used, the additional blowing agent T, the TPU is foamed, preferably in or directly after the  
25 end segment of the mixing apparatus, preferably in the die of the extruder or after exit.

In a particularly preferred embodiment of the process of the invention, the hollow polymer bodies M filled with blowing agent are mixed with the thermoplastic polyurethane TPU directly in the plant in which thermoplastic processing is carried out.  
30 Here, any additional blowing agent T is preferably introduced into the plasticizing unit of the processing machine.

The hybrid foam according to the invention can be obtained, depending on the design of the extruder which is preferably used, as, for example, strand, tubing, film, sheet or  
35 block.

The temperature in the reaction apparatus, preferably in the extruder, is, in a preferred embodiment, selected so that the hollow polymer bodies M soften and expand in the die or immediately after the machine outlet and that it is, if appropriate, above the decomposition point of the optionally added blowing agent T. However, in a preferred  
5 embodiment, the melt is initially prevented from foaming or allowed to foam to only a slight extent by setting of a high counterpressure in the extruder. As a result of decreasing counterpressure and appropriate temperatures in the end zones of the extruder, full foaming can be achieved in these end zones or on exit. In a preferred embodiment, the density range of the foam obtained in this processing step is from  
10 about 50 g/l to 500 g/l, preferably from 100 g/l to 300 g/l and in particular from 110 to 200 g/l.

According to the invention, the foam is at least monoaxially stretched by at least 10%, preferably 100 – 500%, particularly preferably 200 – 400%. Stretching (in the literature  
15 sometimes also referred to synonymously as "orientation") is carried out in a manner known per se. The foam is particularly preferably stretched biaxially, preferably at an angle of from 60 to 120°, particularly preferably from 80 to 100°. Here, the stretching along the two axes is preferably carried out in a ratio of from 2 : 1 to 5 : 1 and transverse stretching is carried out in a ratio of from 2 : 1 to 5 : 1. Particular preference  
20 is given to carrying out stretching of from 3 : 1 to 5 : 1.

Stretching can preferably be carried out on the following apparatuses: longitudinal stretchers, transverse stretchers, longitudinal/transverse stretchers, diamond stretchers, rolling stretchers. It is preferably carried out at a temperature below the  
25 softening temperature of the polymers and below the foaming temperature of the blowing agents.

It has surprisingly been found that after stretching, particularly when using blowing agent T, a very soft, highly elastic material is obtained which has excellent resilience.  
30 The hollow polymer bodies M are then preferably present in the form of closed-celled spheres in the TPU matrix. In a preferred embodiment, there is no or only slight adhesion between the TPU and the hollow bodies M after stretching.

The elastic hybrid foam according to the invention has, in a preferred embodiment, an elongation at break of at least 200%, particularly preferably from about 700% to 1000% (DIN 53504). After stretching, no great application or force is necessary to effect

elongation even in the initial region but instead the foam has a virtually linear force/elongation curve up to the region of up to, for example, 500%, i.e. the deviation of the force-elongation curve from the line which connects the force at 500% elongation to the origin of the coordinate system is not more than 10% of the force value at 500% elongation. Here, the hybrid foam of the invention preferably displays a stress at 100% elongation of less than 0.5 MPa and at 200% elongation of less than 1 MPa, particularly preferably less than 0.25 MPa at 100% elongation and less than 0.35 MPa at 200% elongation. Furthermore, the hybrid foam of the invention has an elongation at yield of at least 150%, particularly preferably 200% and in particular 250%. Here, the "elongation at yield" is the elongation at which a maximum deformation of 0.2% remains after the stress is released.

The foams of the invention have a soft, highly elastic matrix and a substantially closed-celled structure. Here, substantially closed-celled means that more than 60% of the cells are closed. In a preferred embodiment, at least 80% of the microspheres are present as closed cells.

The hybrid foam of the invention preferably has a Shore A hardness of less than 75, particularly preferably less than 70.

In a particularly preferred embodiment, the elastic hybrid foam of the invention is covered at least on one side with a woven fabric, preferably a woven textile, for example by adhesive bonding or lamination into the as yet uncured material.

The hybrid foam of the invention can then be processed, for example by welding, to give the final article, for example a piece of clothing.

The foams according to the invention are suitable, in particular, as functional materials in the sports, shoe and clothing industry for producing thermally insulating articles. Apart from a low hardness and excellent elongation behavior, the hybrid foams of the invention display excellent insulation behavior, excellent UV stability, a pleasant feel on being touched and high resistance to hydrolysis and aging phenomena, for example the loss of mechanical properties, in particular in salted water. The high UV resistance in particular also makes uses of light-coloured or white hybrid foams possible where they are exposed to UV. Owing to the thermoplastic properties, the hybrid foam of the invention can also be processed without seams. Possible uses are therefore all types of pieces of clothing intended for use in water and adjacent to water, e.g. surfing suits,

diving suits, swimming suits, and also gloves, head coverings and ankle socks. The present invention therefore also provides such a piece of clothing. If flame retardant is present, the materials according to the invention can also be used as sea rescue suits. Apart from use in the clothing industry, the hybrid foams of the invention can be used, for example, in the interior furnishing of transport means, for example cars and aircraft, for example as wall or door cladding, armrests, gear knob or dashboard, or in the furniture industry. Furthermore, the articles according to the invention can also be used as thermally insulating and shock-damping packaging or sometimes casings of articles, for example for electronic appliances such as laptops and cell phones. In this application, the high extensibility of the material and the seamless processing are especially advantageous, as a result of which the material also does not have to be taken off for use when flipping open, for example, a cell phone or computer.

### Examples

15

#### Starting materials

	Isocyanate 1:	4,4'-Diisocyanatodiphenylmethane
20	Polyol 1:	Polytetrahydrofuran having an OH number of 56
	Polyol 2:	Polytetrahydrofuran having an OH number of 112
	Polyol 3:	Polyesterol based on adipic acid, butanediol and ethanediol (1 : 1) and having an OH number of 56
	KE1:	1,4-butanediol
25	Plast1:	Dipropylene glycol dibenzoate (plasticizer)
	TPUad1:	TPU based on polyesterol (adipic acid, butanediol) having an OH number of 46, 1,4-butanediol, 4,4'-diisocyanatodiphenylmethane and having a Shore A hardness of 95
30	Stab1:	Sterically hindered phenol (antioxidant)
	Stab2:	Polymer carbodiimide (hydrolysis stabilizer)
	Stab3:	Antioxidant concentrate in TPU
	UV1:	Benzotriazole derivatives (UV stabilizer)
	Wax1:	Bisstearylamide (lubricant)
35	Wax2:	Lubricant concentrate in TPU
	Blow1:	Concentrate of sodium hydrogencitrate (32%) and sodium

hydrogencarbonate (24%) in ethylene-vinyl acetate copolymer (EVA)

Polymer1: PS/SAN microspheres in EVA

The abbreviations here have the following meanings

5

KE: Chain extender

PS: Polystyrene

SAN: Styrene-acrylonitrile

10 The TPUs 1 to 3 shown in table 1 are produced from the starting materials.

Table 1

	TPU 1 (parts by weight)	TPU 2 (parts by weight)	TPU 3 (parts by weight)
Polyol 1	34.24		
Polyol 2	34.24		
Polyol 3		50.74	49.41
Isocyanate 1	25.47	19.28	8.42
KE1	4.52	4.57	0.54
Plast1		25.00	16.70
TPUad1			21.18
Stab1	1.00		
Stab2		0.41	
Stab3			1.67
UV1	0.50		
Wax2			1.25

15 General method for production of the TPUs

The polyols (polyol 1 - 3) were admixed with KE1 while stirring. After subsequent heating of the solution to 80°C, isocyanate 1 and, if appropriate, the additives indicated in the formulations were added and the mixture was stirred until a homogeneous

20 solution was obtained. The reaction mixture heated up and was then poured onto a heated, Teflon-coated table. The cast sheet was heated at 110°C for 12 hours and

subsequently granulated.

#### Extrusion

In the comparative examples C1 - C3, the TPUs 1-3 obtained were in each case admixed with 0.5% by weight of Wax1 and processed on a Brabender single-screw extruder to give strands.

In examples B1 - B3 according to the invention, the TPUs 1-3 obtained were likewise in each case mixed with 0.5% by weight of Wax1 and also 2.5% by weight of Blow1 and 7.5% by weight of Polymer1 and extruded as a dry blend using the following extruder:

10 Extruder: Brabender Plasti-Corder PLE 331

L/D ratio: L = 25 D

Screw diameter: D = 19 mm

Compression ratio of the screw: 3:1

Die: round die

15 Type of extrusion: Strand

More precise extrusion conditions are shown in table 2 below:

Table 2

No.	Composition	Temperature profile [°C]				Rot. Sp. [rpm]	Tor- que [Nm]	Remarks
		Z 1	Z 2	Z 3	Z 4			
C1	TPU1 + 0.5% of Wax1	190	190	190	190	15	18	Compact, homogeneous strand
C2	TPU2 + 0.5% of Wax1	170	175	175	170	25	30	Compact, homogeneous strand
C3	TPU3 + 0.5% of Wax1	150	160	155	150	17	17	Compact, homogeneous strand
E1	TPU1 + 7.5% of Polymer1 + 2.5% of Blow1 + 0.5% of Wax1	165	170	170	160	40	33	Foamed, homogeneous strand
E2	TPU2 + 7.5% of Polymer1 + 2.5% of Blow1 + 0.5% of	160	165	165	160	40	15	Foamed, very homogeneous

	Wax1							strand
E3	TPU3 + 7.5% of Polymer1 + 2.5% of Blow1 + 0.5% of Wax1	150	160	155	150	40	10	Foamed, very homogeneous strand

Rot. Sp. = rotational speed, Torque = torque on the screw

- 5 Mechanical properties of the TPUs used without stretching according to the invention and without addition of microspheres (Polymer 1) measured on injection-molded plates are shown in table 3.

Table 3

Experiment		C1	C2	C3
TPU		TPU1	TPU2	TPU3
Density	[g/cm <sup>3</sup> ]	1.08	1.19	1.18
Hardness	[Shore A]	73	62	39
Tensile strength	[MPa]	36	39	17
Elongation at break	[%]	830	1030	1260
Tear propagation resistance	[N/mm]	45	42	35

- 10 Hardness: DIN 53505

Tensile strength, elongation at break and stress: DIN 53504

Tear propagation resistance: DIN ISO 34-1, B (b)

Density: DIN 53479

- 15 Mechanical properties of the TPUs according to the invention measured on prestretched strand sections foamed according to the invention by methods based on the DIN standards are shown in table 4:

Table 4

20

Experiment		E1	E2	E3	E3
TPU		TPU1	TPU2	TPU3	TPU3
Stretching		200% prestretching	200% prestretching	200% prestretching	400% prestretching

Density	[g/cm <sup>3</sup> ]	0.222	0.155	0.225	0.225
Tensile strength	[MPa]	3.1	1.4	1.5	1.5
Stress at 100%	[KPa]	480	320	280	210
Stress at 200%	[KPa]	860	540	480	340
Stress at 300%	[KPa]	1090	550	590	550
Elongation at break	[%]	820	750	850	790

The advantageous properties of the stretched TPUs according to the invention, namely  
5 low density, ready elongation, i.e. only little force has to be applied in order to elongate the specimens, can be seen from the values in table 4.

Throughout this specification and the claims which follow, unless the context requires  
otherwise, the word "comprise", and variations such as "comprises" or "comprising", will  
10 be understood to imply the inclusion of a stated integer or step or group of integers or steps but not the exclusion of any other integer or step or group of integers or steps.

The reference in this specification to any prior publication (or information derived from it),  
or to any matter which is known, is not, and should not be taken as, an acknowledgement  
15 or admission or any form of suggestion that that prior publication (or information derived from it) or known matter forms part of the common general knowledge in the field of endeavour to which this specification relates.

The claims defining the invention are as follows:

- 5 1. A piece of clothing, comprising an elastic hybrid foam based on
- a) at least one thermoplastic polyurethane (TPU),
  - b) hollow polymer bodies M which are filled with blowing agents,
  - c) optionally an additional physical or chemical blowing agent T,
  - 10 d) and optionally auxiliaries and additives,
- wherein the hybrid foam is at least monoaxially stretched, and wherein the Shore A hardness of the TPU employed is less than 75.
- 15 2. The piece of clothing according to claim 1, wherein the hybrid foam is biaxially stretched.
3. The piece of clothing according to claim 1 or 2, wherein the hybrid foam is, based on the total weight of thermoplastic TPU, hollow polymer bodies M filled with blowing agents and chemical or physical blowing agent T, based on from 75 to
- 20 99% by weight of thermoplastic polyurethane, from 1 to 20% by weight of hollow polymer bodies M filled with blowing agents and from 0 to 5% by weight of chemical blowing agent T.
4. The piece of clothing according to any one of the preceding claims, wherein the
- 25 elongation at break is at least 200%.
5. The piece of clothing according to any one of the preceding claims, wherein the Shore A hardness of the TPU employed is less than 70.
- 30 6. The piece of clothing according to any one of the preceding claims, wherein the tensile stress is less than 0.5 MPa at 100% elongation and less than 1 MPa at 200% elongation.
7. The piece of clothing according to any one of the preceding claims, wherein the
- 35 TPU comprises mold release agent, preferably a wax, fat or oil.

8. The piece of clothing according to any one of the preceding claims, wherein the TPU comprises a plasticizer.
- 5 9. The piece of clothing according to claim 8, wherein the plasticizer is selected from a group including phthalates, benzoates or esters of citric acid.
- 10 10. The piece of clothing according to any one of the preceding claims, wherein the foam cells of which are essentially closed.
- 11 11. The piece of clothing according to claim 10, wherein the foam cells have a cell diameter of less than 200  $\mu\text{m}$ .
- 15 12. A process for producing pieces of clothing which have an elastic hybrid foam, wherein thermoplastic polyurethane is mixed with hollow polymer bodies M filled with blowing agents and optionally chemical or physical blowing agent T and also optionally further auxiliaries and additives, the hollow polymer bodies M filled with blowing agents and the chemical or physical blowing agent T are made to expand and the resulting expanded hybrid material is at least monoaxially stretched and processed to produce the piece of clothing.
- 20 13. The process according to claim 12, wherein stretching is effected by means of a longitudinal stretcher, transverse stretcher, longitudinal/transverse stretcher, diamond stretcher or rolling stretcher.
- 25 14. The process according to any one of the preceding claims, wherein stretching is by at least 200 - 400%.
15. The process according to claim 12, wherein the processing to produce the piece of clothing is carried out by welding.
- 30 16. A piece of clothing according to any one of claims 1 to 11, wherein the piece of clothing is selected from the group consisting of surfing suits, diving suits, swimming suits, gloves, head coverings, ankle socks and sea rescue suits.