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- (54) Benævnelse: **Ekspanderet polystyrenpartikel med et yderlag med særdeles god formbarhed, fremgangsmåde til fremstilling af samme og støbt genstand af ekspanderet polystyren under anvendelse af samme**
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Description**[Technical Field]**

5 **[0001]** The present invention relates to expanded polystyrene. More specifically,
the present invention relates to expanded polystyrene particles having a skin
layer with superior moldability wherein the skin layer is formed by coating the
surface of expanded polystyrene particles with a coating composition containing
10 functional additives such as an inorganic flame retardant, to reduce problems
such as deterioration in moldability and quality defects of molded articles which
may be generated during steam-heating expansion molding, a method for
preparing the same and an expanded polystyrene molded article using the same.

[Background Art]

15 **[0002]** Expanded polystyrene molded articles are molded materials having an
expanded shape obtained by adding an expanding agent such as pentane or
butane to a resin containing a polystyrene homopolymer or a styrene copolymer
including a styrene monomer to prepare expandable polystyrene particles,
20 heating the particles using a heat source such as steam to generate foams in the
particles and thus expand the same, thereby molding the particles. The
expanded polystyrene molded articles are white in color and lightweight, exhibit
superior properties such as water resistance, thermal insulation, sound
absorption, and buffer capability and are thus widely used in fields such as
25 package and construction materials.

30 **[0003]** Conventional processes for molding expanded polystyrene in which
expandable polystyrene particles are preliminarily expanded and aged once or
twice to prepare pre-expanded particles, the pre-expanded particles are injected
into a mold and are expansion-molded by steam-heating have no substantial
problems associated with the molding in the process of preparing general
expanded polystyrene molded articles. However, functional expanded
polystyrene molded articles having specific functions have several problems
associated with molding. Accordingly, such problems should be solved.

35 **[0004]** That is, expansion-molded articles used for insulating materials for
construction, the major application of expanded polystyrene, cannot exhibit
sufficient flame retardancy through addition of a general flame-retardant or non-
flammable agent to the resin, due to specific characteristics of the expanded
40 material.

[0005] In order to solve this problem, the present inventor suggested a method

in which a coating composition comprising a binder component such as a solution-type thermoplastic resin-based adhesive and a great amount of an inorganic flame retardant is applied to the surfaces of pre-expanded polystyrene particles to form skin layers and expansion-molded articles in which the skin layers are fused together are prepared to block spread of flames through flame retardant rib barriers formed by fusion of the skin layers and thereby exert flame retardancy.

[0006] This method was reported to be considerably effective in exerting superior functions such as flame retardancy, but disadvantageously caused deterioration in moldability when a great amount of inorganic additive was contained in the resin. That is, in order to exert excellent functionality such as flame retardancy, the coating composition should be prepared by adding an inorganic flame retardant in an amount substantially equivalent to the amount of the resin serving as a binder. The skin layer is leached due to the great amount of inorganic additive and permeation of steam into the skin layer thus cannot be sufficiently exhibited in the steam-heating expansion molding process after the skin layer is formed by applying the coating solution to the surface of pre-expanded resin particles, or the inorganic additive absorbs condensed water produced in a vacuum cooling process during molding, thus disadvantageously causing deterioration in adhesion force between expanded polystyrene particles, and causing slightly serious molding defects such as cracks, inner fusion defects and distortion by contraction to molded materials, which negatively affects production efficiency.

[0007] Meanwhile, in a case where, instead of the solution-type thermoplastic resin-based adhesive, other type of adhesive such as emulsion-type thermoplastic resin adhesive is used as the binder, although an inorganic additive which negatively affects moldability is not contained, the adhesive exhibits considerably poor moldability (for example, the resin component of the skin layer is leached) due to moisture in the steam-heating expansion molding process. Such an adhesive is unsuitable for application to molding of expanded polystyrene.

[Disclosure]

[Technical Problem]

[0008] Therefore, the present invention has been made in view of the problems generated in molding processes such as steam-heating expansion molding, associated with production of molded articles made of expanded polystyrene particles provided with skin layers to provide functionalities, and it is one object

of the present invention to provide an expanded polystyrene particles provided on the surface thereof with a skin layer which has an improved shape and exhibits superior moldability, to strength adhesion force of a binder, efficiently remove condensed water produced during cooling of injected steam and thereby reduce defect ratios of molded materials and improve physical properties thereof such as flexural strength or water resistance, a method for preparing the same, and an expanded polystyrene molded article using the same.

[Technical Solution]

[0009] The above and other objects of the related art can be accomplished by the following configurations of the present invention to reinforce adhesion force of the skin layer and thereby improve moldability.

[0010] Accordingly, in accordance with one aspect of the present invention, provided is an expanded polystyrene particle having a skin layer with superior moldability, and more specifically, provided is an expanded polystyrene particle provided on the surface thereof with a skin layer wherein the skin layer contains a binder selected from the group consisting of a thermoplastic resin-based adhesive, a thermosetting resin-based adhesive, an inorganic adhesive, a protein-based adhesive and a mixture thereof, wherein the skin layer contains methylene diphenyl diisocyanate (hereinafter, simply referred to as "MDI").

[0011] As used herein, methylene diphenyl diisocyanate (MDI) is a substance obtained by treating diphenylmethane diamine, a condensate of aniline and formaldehyde, with phosgene (COCl_2) (phosgenation). This substance exhibits superior adhesion force when reacted with moisture and is then cured. A variety of MDIs such as polymeric MDIs, modified MDIs, monomeric MDIs, or pure MDIs (prepolymers) are prepared taking into consideration storage stability or convenience. Any MDI may be used in the present invention and the form thereof is not particularly limited. Accordingly, a suitable form of MDI may be selected and used taking into consideration factors such as operation conditions, operation environments, stability, efficiency and cost.

[0012] Most preferably, methylene diphenyl diisocyanate (MDI) is used in an amount of 0.1 to 30%, based on the weight of expanded polystyrene particles. When the content is lower than 0.1% by weight, improvement effects of moldability are insufficient. When the content is higher than 30% by weight, it is not preferable since a byproduct to decompose polystyrene is produced by hydrothermal decomposition and the expanded polystyrene may be thus melted and contracted, although the steam-heating expansion molding is possible.

[0013] Meanwhile, the most preferred form of binder in the present invention is a solution-type thermoplastic resin-based adhesive which has no or almost no effect on expanded polystyrene particles and is least troublesome in steam-

heating expansion molding. The thermoplastic resin is preferably a resin having a softening point and a melting point lower than those of the expanded polystyrene taking into consideration conditions of the steam-heating expansion molding process. When a resin having a softening point and a melting point higher than those of the expanded polystyrene is used, fusion property is lowered due to deterioration of expansion force under optimal heating-expansion conditions of the polystyrene, and problems, in which the surface of the resin is molten, the appearance thereof is worsened (deformed) and molding cycles are lengthened, occur out of optimal heating conditions.

[0014] In particular, a thermoplastic resin solution obtained by dissolving a vinyl acetate-based resin in a solvent containing one or more selected from water, alcohols, esters, ketones, carboxylic acids, aromatic compounds and halogenated hydrocarbons, such that the concentration of vinyl acetate resin is 3 to 80% by weight, is preferred in view of affinity with the expanded polystyrene particles, harmlessness, workability, moldability.

[0015] The skin layer may further contain a variety of functional additives to provide functionalities or improve functions of the coating composition during formation of the skin layer and the functional additive may be suitably selected from a variety of additives such as expanding agents, nucleating agents, lubricants, antioxidants, thermal stabilizers, UV stabilizers, biostabilizers, fillers, reinforcing agents, plasticizers, coloring agents, impact resistance agents, flame retardants, anti-static agents, cross-linking agents, fluorescent whitening agents, thermally conducting agents, electrically conducting agents, permeation controllers, magnetic agents, surfactants, stabilizers, excipients, medicines, solvents, hardeners, moisture absorbents, reinforcing agents, flavoring agents and antimicrobial agents. The additive may be used alone or in combination thereof. The performance of the additive is not limited particularly. The same is also applied to below. The additive may be an organic or inorganic additive.

[0016] In a case where a skin layer containing a relatively great amount of inorganic additive is formed in order to impart flame retardancy or flame resistance, the present invention is particularly useful for improving moldability.

[0017] The expanded polystyrene particles of the present invention includes all of expanded particles obtained by expanding expandable particles composed of a homopolymer of a styrene monomer, expandable particles composed of a copolymer of a styrene monomer and another monomer which can be copolymerized with the styrene monomer, and expandable particles composed of a polymer which can be blended therewith.

[0018] Meanwhile, In accordance with another aspect of the present invention, provided is a method for preparing expanded polystyrene particles having a skin layer with superior moldability comprising: preparing a coating composition containing a binder selected from the group consisting of a thermoplastic resin-based adhesive, a thermosetting resin-based adhesive, an inorganic adhesive, a

protein-based adhesive and a mixture thereof; uniformly applying the coating composition to the surface of the expanded polystyrene particles; and drying the coating composition, wherein the skin layer contains methylene diphenyl diisocyanate (MDI).

[0019] The MDI may be mixed with the coating composition containing a binder and may be then applied to the surface of expanded polystyrene particles, or may be separately applied thereto after or before application of the coating composition.

[0020] Meanwhile, the expanded polystyrene molded article according to the present invention is prepared by expansion-molding the expanded polystyrene particles having a skin layer with superior moldability according to the present invention through steam-heating.

[0021] In accordance with another aspect of the present invention, provided is an expanded polystyrene molded article comprising expanded polystyrene particles provided on the surface thereof with skin layers with superior moldability, wherein the skin layers comprise a binder selected from the group consisting of a thermoplastic resin-based adhesive, a thermosetting resin-based adhesive, an inorganic adhesive, a protein-based adhesive and a mixture thereof, wherein the skin layers are fused and thus present in the form of rib barriers between the particles, wherein the skin layers further comprise a cured and modified substance produced by reacting methylene diphenyl diisocyanate with moisture and the binder to reinforce adhesion force between particles.

[0022] As mentioned above, MDI reacts with moisture and is cured and modified in the steam-heating expansion molding process, thus exerting adhesion force. The presence of the cured and modified material such as MDI enables great improvement of mechanical properties and shapes of expanded polystyrene molded articles and molding properties such as prevention of cracks.

[Advantageous Effects]

[0023] The present invention provides expanded polystyrene particles having a skin layer on the surface thereof and an expanded polystyrene molded article using the same which can considerably reduce molding defects such as cracks, inner fusion defects, distortion by contraction even a case where the skin layer contains a great amount of inorganic additive to impart functionalities to the resin, thus advantageously improving production efficiency and qualities of functional expanded polystyrene molded article.

[0024] In addition, when steam-heating expansion molding is performed using the expanded polystyrene particles, methylene diphenyl diisocyanate (MDI) reacts with moisture and is cured to provide strong adhesion force, unreacted

parts of MDI melt the surface of pre-expanded polystyrene particles and roughness is thus formed on the surface, thus advantageously preventing the binder resin from being leached by steam and thus improving qualities such as mechanical properties of completed expansion molded articles.

[0025] The use of the expanded polystyrene particles enables preparation of expanded polystyrene molded articles with superior moldability and physical properties in spite of using a coating composition containing a binder (for example, an emulsion-type thermoplastic resin-based adhesive, a thermosetting resin-based adhesive, an inorganic adhesive, a protein-based adhesive, which could not be conventionally molded through a steam-heating expansion molding process due to moldability defects even in a case where a great amount of inorganic functional additive was not added.

[Description of Drawings]

[0026] The above and other objects, features and other advantages of the present invention will be more clearly understood from the following detailed description taken in conjunction with the accompanying drawings, in which:

FIG. 1 is an image showing the appearance of an expanded polystyrene molded article prepared in Comparative Example 1;

FIG. 2 is an image showing the appearance of an expanded polystyrene molded article prepared in Example 1;

FIG. 3 is an image showing the appearance of an expanded polystyrene molded article prepared in Comparative Example 2;

FIG. 4 is an image showing the appearance of an expanded polystyrene molded article prepared in Example 2;

FIG. 5 is an image showing the appearance of an expanded polystyrene molded article prepared in Comparative Example 3;

FIG. 6 is an image showing the appearance of an expanded polystyrene molded article prepared in Example 3;

FIG. 7 an image showing the appearance of an expanded polystyrene molded article prepared in Comparative Example 4;

FIG. 8 is an image showing the appearance of an expanded polystyrene molded article prepared in Example 4;

FIG. 9 is an image showing the cross-sectional view of an expanded polystyrene molded article prepared in Comparative Example 5;

FIG. 10 is an image showing the cross-sectional view of an expanded polystyrene molded article prepared in Example 5;

5 FIG. 11 is an image showing the appearance of an expanded polystyrene molded article prepared in Comparative Example 6;

FIG. 12 is an image showing the appearance of an expanded polystyrene molded article prepared in Example 6;

10 FIG. 13 is an image showing the appearance of an expanded polystyrene molded article prepared in Comparative Example 7; and

FIG. 14 is an image showing the appearance of an expanded polystyrene molded article prepared in Example 7.

[Best Mode]

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[0027] Hereinafter, the present invention will be described in more detail with reference to the following preferred examples.

Examples 1 to 7 and Comparative Examples 1 to 7

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(A) Preparation of pre-expanded polystyrene particles

25 **[0028]** Expanded polystyrene particles obtained by pre-expanding commercially available EPS particles (expandable polystyrene particles available from Shinho Yuhwa Co., Ltd.) in an expanding machine at a temperature of 103 to 105°C, followed by drying and aging in a silo were used for Examples and Comparative Examples. Expansion ratio was 105x on average.

(B) Formation of skin layer

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[0029] A skin layer of each of Examples and Comparative Examples was

formed by applying a coating composition having a composition set forth in Table 1 below to the expanded polystyrene particles prepared in the process (A), wherein the weight ratio of the expanded polystyrene particles and the coating composition are shown in Table 1, followed by drying. At this time, polymeric MDI (available from BASF Corp.) was used as MDI and mixed with the coating composition. In Example 2, the skin layer was formed by applying a coating composition containing a binder and an inorganic additive to the particles, and adding MDI to the coating composition, followed by applying and drying.

[0030] More specifically, 2 Kg of the expanded polystyrene particles were added to a 200L mixer, 2 kg of the prepared coating composition was added thereto while stirring at a rate of 50 rpm, and stirring was maintained for about one minute to uniformly apply the coating composition to the surface of expanded polystyrene particles. Then, the particles were dried in 60°C hot air until the solvents used for the coating composition were completely volatilized, to obtain expanded polystyrene particles, in which a skin layer composed of the coating composition was formed on the surface thereof.

[Table 1]

No. of Examples	Amount used (wt%)			
	EPS particles	Coating composition		MDI
		Binder	Inorganic additive	
Comp. Ex. 1	40	Methanolic polyvinyl acetate solution, 30	Aluminum hydroxide, 30	-
Ex. 1	40		Aluminum hydroxide, 25 Iron oxide, 1	4
Comp. Ex. 2	40	Emulsion type polyvinyl acetate, 30	Aluminum hydroxide, 29 Iron oxide, 1	-
Ex. 2	40		Aluminum hydroxide, 25 Iron oxide, 1	4
Comp. Ex. 3	40	Acrylic adhesive, 30	Aluminum hydroxide, 30	-
Ex. 3	40		Aluminum hydroxide, 25	5
Comp. Ex. 4	40	EVA additive, 30	Aluminum hydroxide, 29 Carbon black, 1	-
Ex. 4	40		Aluminum hydroxide, 25 Carbon black, 1	4
Comp. Ex. 5	40	Silicate inorganic adhesive, 30	Aluminum hydroxide, 30 Iron oxide, 1	-
Ex. 5	40		Aluminum hydroxide, 25 Iron oxide, 1	4

No. of Examples	Amount used (wt%)			
	EPS particles	Coating composition		MDI
		Binder	Inorganic additive	
Comp. Ex. 6	40	Polyvinyl alcohol	Aluminum hydroxide, 30	-
Ex. 6	40	adhesive, 30	Aluminum hydroxide, 25 Iron oxide, 1	4
Comp. Ex. 7	40	Thermosetting resin adhesive, 30	Aluminum hydroxide, 19 Iron oxide, 1 Calcium hydroxide 10	-
Ex. 7	40		Aluminum hydroxide, 15 Iron oxide, 1 Calcium hydroxide, 10	4

(C) Steam-heating expansion molding

[0031] The expanded polystyrene particles having a skin layer prepared in Examples and Comparative Examples were injected into a molding die, seam of a high temperature of 110 to 120°C was added thereto, to elevate an inner temperature of the molding die to 108 to 116°C, to expand an expanding agent contained in the expanded polystyrene particles and thereby produce expansion-molded articles. The density of expansion-molded articles was about 16 kg/m³.

[0032] The respective expansion-molded articles were cut using an oscillating cutter and inner fusion state and physical properties thereof were evaluated.

(D) Tests and Evaluation

[0033] The expanded polystyrene particles having a skin layer prepared in Examples and Comparative Examples were evaluated in terms of flexural strength, water resistance, moldability and fusion properties and the results thus obtained are shown in Table 2.

[0034] Among the test items, flexural strength was tested using a flexural strength meter in accordance with KS M 3808. Test criteria were based on 15/cm³ noted on an insulating board No. 4, and the flexural strength was represented by "good" provided that the value thereof reached the base level or

higher, and was represented by "bad" provided that the value thereof was lower than the base level.

5 **[0035]** Evaluation of water resistance was carried out by adding a part of samples collected from expansion-molded materials to a constant-temperature water bath set at 50°C, dipping the samples for one hour and measuring strength using a flexural strength meter, and was evaluated based on the same criteria as the flexural strength.

10 **[0036]** Evaluation of moldability was carried out by observing the state of products after molding through variations in size and observation by the naked eye.

15 **[0037]** Evaluation of fusion properties was carried out by cutting expansion molded articles and synthetically evaluating evenness of the surface thereof observed by the naked eye and values of flexural strength obtained by measurement. Fusion properties were evaluated based on an area where expanded particles are broken in an inner part thereof, rather than on the outer surface part, with respect to the overall broken surface, when an outer force is applied. In this test, the distance between expanded particles and evenness thereof were observed by the naked eye and products having a value of fusion property of lower than 80% were considered to be "defective".

25 **[0038]** Meanwhile, the shapes of expansion-molded articles prepared in Examples and Comparative Examples were photographed, the images are shown in FIGS. 1 to 13 and evaluation results of the shapes are shown in Table 2.

30 **[0039]** As can be seen from Table 2 and FIGS. 1 to 14, regardless of the type of binder component, by adding MDI to the skin layer, most molding defect problems generated by moisture in the steam-heating expansion molding process can be reduced and superior results can thus be obtained in view of overall properties including the shape of molded materials, as well as flexural strength, water resistance, moldability and fusion properties thereof.

35 **[0040]** On the other hand, it can be seen that Comparative Examples using no MDI caused a variety of defect problems including surface contraction to most expansion-molded articles, although there was differences between respective test items depending on the type of binder component.

40 **[0041]** Accordingly, without great limitation as to the type of binder component, addition of MDI enables great improvement of moldability and physical properties of expanded polystyrene particles provided with a skin layer containing a binder during the steam-heating expansion molding process.

[Table 2]

No. of Examples	Shape of molded material	Flexural strength	Water resistance	Moldability	Fusion properties
Comp. Ex. 1	Surface contraction	Excellent	Excellent	Bad	Good
Ex. 1	Good shape stability	Excellent	Excellent	Excellent	Excellent
Comp. Ex. 2	Expansion loss due to steam absorption of surface	Bad	Bad	Bad	Bad
Ex. 2	Good shape stability	Excellent	Excellent	Excellent	Excellent
Comp. Ex. 3	Resin surface is leached during addition of steam and inner fusion state is thus deteriorated	Bad	Bad	Bad	Presence of difference between parts
Ex. 3	Good shape stability	Excellent	Excellent	Excellent	Excellent
Comp. Ex. 4	Partial peel during release of molded material due to condensed water remaining on surface during vacuum cooling	Presence of difference between parts	Bad	Bad	Presence of difference between parts
Ex. 4	Good shape stability	Excellent	Excellent	Excellent	Excellent
Comp. Ex. 5	Good surface appearance and fusion properties, but bad inner fusion properties	Presence of difference between parts	Bad	Bad	Presence of difference between parts
Ex. 5	Good shape stability	Excellent	Excellent	Excellent	Excellent
Comp. Ex. 6	Insufficient flow of steam, secondary expansion by inner latent heat and	Presence of difference between	Bad	Bad	Presence of difference between parts

No. of Examples	Shape of molded material	Flexural strength	Water resistance	Moldability	Fusion properties
	cracking of molded articles	parts			
Ex. 6	Good shape stability	Excellent	Excellent	Excellent	Excellent
Comp. Ex. 7	Surface contraction	Excellent	Good	Excellent	Excellent
Ex. 7	Good shape stability	Excellent	Good	Excellent	Excellent

[Industrial Applicability]

- 5 **[0042]** The present invention enables production of expanded polystyrene molded articles which exhibit superior functionalities and excellent qualities, thus causing no problem in view of moldability, appearance and physical properties, when used for producing expanded polystyrene molded articles widely used as construction materials such as insulating materials.
- 10 **[0043]** Although the preferred embodiments of the present invention have been disclosed for illustrative purposes, those skilled in the art will appreciate that various modifications, additions and substitutions are possible.

P A T E N T K R A V

1. Ekspanderet polystyrenpartikel, på hvilken overfladen er påført et yderlag med særdeles god formbarhed, hvor yderlaget omfatter et bindemiddel udvalgt fra gruppen bestående af et termoplastisk resinbaseret klæbemateriale, et termohærdende resinbaseret klæbemateriale, et uorganisk klæbemateriale, et proteinbaseret klæbemateriale og en blanding deraf, hvor yderlaget desuden omfatter methylen-diphenyl-diisocyanat.
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2. Ekspanderet polystyrenpartikel ifølge krav 1, hvor methylen-diphenyl-diisocyanat udgør mellem 0,1 og 30 vægt%, baseret på vægten af den ekspanderede polystyrenpartikel.
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3. Ekspanderet polystyrenpartikel ifølge krav 1, hvor bindemidlet er et termoplastisk resinbaseret klæbemateriale omfattende et termoplastisk resin med et blødgøringspunkt og et smeltepunkt lavere end det for ekspanderet polystyren.
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4. Ekspanderet polystyrenpartikel ifølge krav 3, hvor bindemidlet er en termoplastisk resinopløsning fremstillet ved at opløse et vinylacetatresin i et opløsningsmiddel bestående af en eller flere udvalgt fra vand, alkoholer, estere, ketonstoffer, carboxylsyrer, aromatiske forbindelser og halogenholdige kulbrinter, således at koncentrationen af vinylacetatresinet justeres til mellem 3 og 80 vægt%.
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5. Ekspanderet polystyrenpartikel ifølge krav 1, hvor yderlaget endvidere omfatter et funktionelt tilsætningsstof.
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6. Ekspanderet polystyrenpartikel ifølge krav 5, hvor det funktionelle tilsætningsstof er udvalgt fra gruppen bestående af opskumningsmidler, kimdannere, smøremidler, antioxidanter, termiske stabilisatorer, UV-stabilisatorer, biostabilisatorer, fyldstoffer, forstærkningsmidler, blød-
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gøringsmidler, farvestoffer, slagstyrkemidler, brandhæmmere, antistatiske stoffer, tværbindingsmidler, fluorescerende blegemidler, termisk ledende stoffer, elektrisk ledende stoffer, gennemtrængningsregulatorer, magnetiske stoffer, overfladeaktive stoffer, stabilisatorer, hjælpestoffer, lægemidler, opløsningsmidler, hærdere, fugtabsorberingsmidler, forstærkningsmidler, smagsstoffer, antimikrobielle stoffer og blandinger deraf.

7. Fremgangsmåde til fremstilling af en ekspanderet polystyrenpartikel, på hvilken overfladen er påført et yderlag med særdeles god formbarhed, omfattende:

fremstilling af en overfladebelægningssammensætning indeholdende et bindemiddel udvalgt fra gruppen bestående af et termoplastisk resinbaseret klæbemateriale, et termohærdende resinbaseret klæbemateriale, et uorganisk klæbemateriale, et proteinbaseret klæbemateriale og en blanding deraf;

ensartet påføring af overfladebelægningssammensætningen på overfladen af ekspanderede polystyrenpartikler; og tørring af overfladebelægningssammensætningen,

hvor yderlaget omfatter methylen-diphenyl-diisocyanat.

8. Fremgangsmåde ifølge krav 7, (I) hvor methylen-diphenyl-diisocyanat blandes med overfladebelægningssammensætningen omfattende et bindemiddel og derefter påføres overfladen af de ekspanderede polystyrenpartikler, eller påføres separat før eller efter påføringen af overfladebelægningssammensætningen; eller
(II) hvor methylen-diphenyl-diisocyanat anvendes i en mængde af mellem 0,1 og 30 vægt%, baseret på vægten af de ekspanderede polystyrenpartikler.

9. Fremgangsmåde ifølge krav 7, hvor overfladebelægningssammensætningen endvidere omfatter et funktionelt tilsætningsstof.

- 5 10. Fremgangsmåde ifølge krav 9, hvor det funktionelle tilsætningsstof udvælges fra gruppen bestående af opskumningsmidler, kimdannere, smøremidler, antioxidanter, termiske stabilisatorer, UV-stabilisatorer, biostabilisatorer, fyldstoffer, forstærkningsmidler, blødgøringsmidler, farvestoffer, slagstyrkemidler, brandhæmmere, antistatiske stoffer, tværbindingsmidler, fluorescerende blegemidler, termisk ledende stoffer, elektrisk ledende stoffer, gennemtrængningsregulatorer, magnetiske stoffer, overfladeaktive stoffer, stabilisatorer, hjælpestoffer, lægemidler, opløsningsmidler, hærdere, fugtabsorberingsmidler, forstærkningsmidler, smagsstoffer, antimikrobielle stoffer og blandinger deraf.
- 10
- 15 11. Fremgangsmåde ifølge krav 7, hvor bindemidlet er et termoplastisk resinbaseret klæbemateriale omfattende et termoplastisk resin med et blødgøringspunkt og et smeltepunkt lavere end det for ekspanderet polystyren.
- 20 12. Fremgangsmåde ifølge krav 11, hvor det termoplastiske resinbaserede klæbemateriale er en opløsning af et termoplastisk resin i et opløsningsmiddel udvalgt fra gruppen bestående af vand, alkoholer, estere, ketonstoffer, carboxylsyrer, aromatiske forbindelser, halogenholdige kulbrinter og blandinger deraf.
- 25 13. Genstand støbt af ekspanderet polystyren, (I) hvor den støbte genstand af ekspanderet polystyren fremstilles ved ekspansionsstøbning af den ekspanderede polystyrenpartikel forsynet med et yderlag ifølge krav 1 ved dampopvarmning; eller (II) omfattende ekspanderede polystyrenpartikler ifølge krav 1,
- 30 hvor yderlagene er sammensmeltede og således forefindes som ribbebarrierer mellem partiklerne, hvor yderlagene endvidere omfatter et hærdet og modificeret stof fremstillet ved at reagere methylen-diphenyl-diisocyanat med fugt og bindemidlet for at styrke adhæsionskraften mellem partiklerne.

- 5 14. Støbt genstand af ekspanderet polystyren omfattende ekspanderede partikler ifølge krav 13, hvor hvert yderlag endvidere omfatter et funktionelt tilsætningsstof udvalgt fra gruppen bestående af opskumningsmidler, kimdannere, smøremidler, antioxidanter, termiske stabilisatorer, UV-stabilisatorer, biostabilisatorer, fyldstoffer, forstærkningsmidler, blødgøringsmidler, farvestoffer, slagstyrkemidler, brandhæmmere, antistatiske stoffer, tværbindingsmidler, fluorescerende blegemidler, termisk ledende stoffer, elektrisk ledende stoffer, gennemtrængningsregulatorer, magnetiske stoffer, overfladeaktive stoffer, stabilisatorer, hjælpestoffer, 10 lægemidler, opløsningsmidler, hærdere, fugtabsorberingsmidler, forstærkningsmidler, smagsstoffer, antimikrobielle stoffer og blandinger deraf.
- 15 15. Støbt genstand af ekspanderet polystyren ifølge krav 14, hvor det funktionelle tilsætningsstof er et uorganisk materiale.

Fig. 1

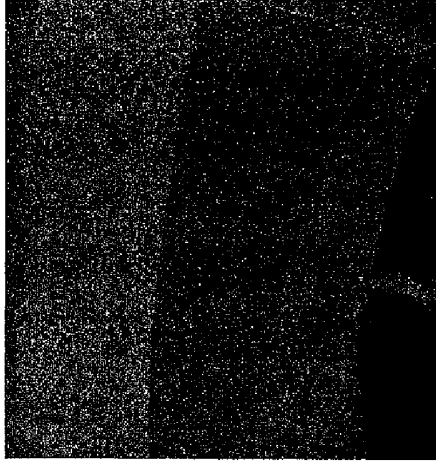


Fig 2

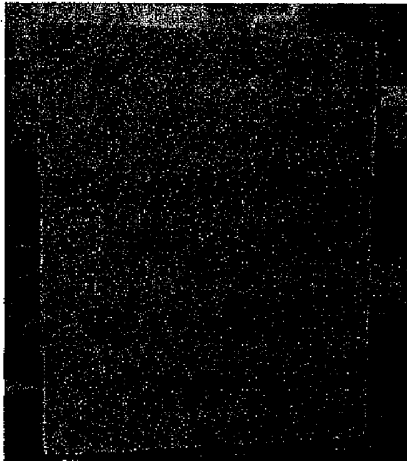


Fig 3

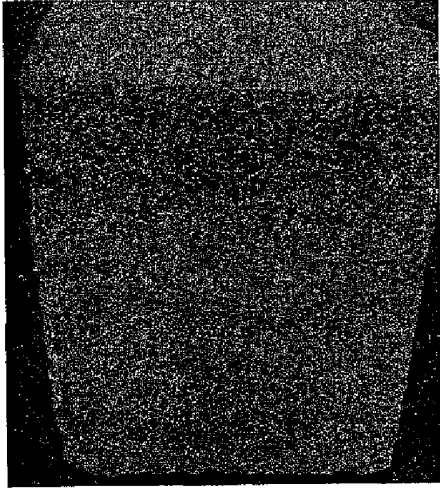


Fig 4

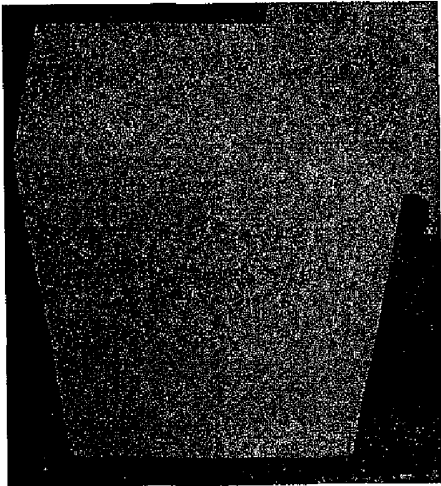


Fig 5

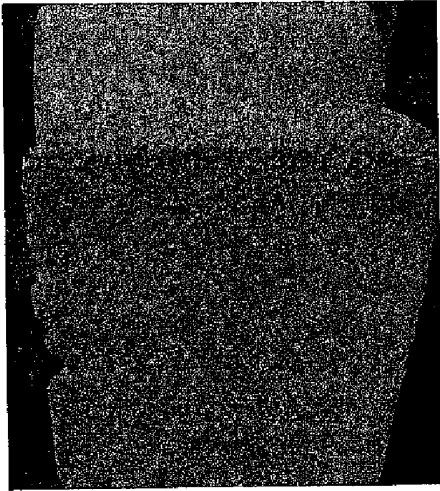


Fig 6

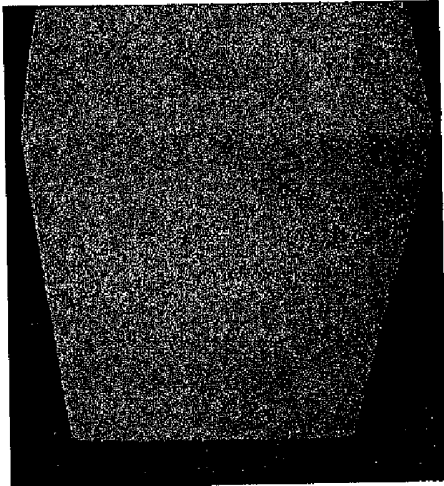


Fig 7

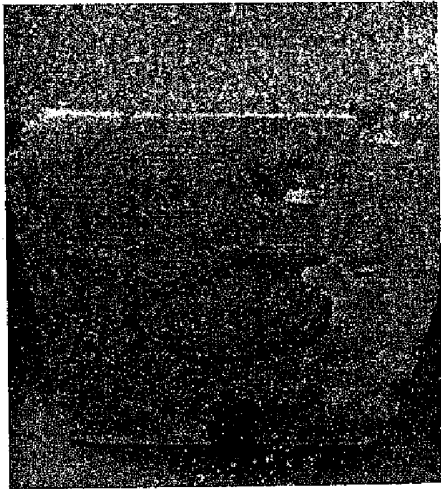


Fig 8

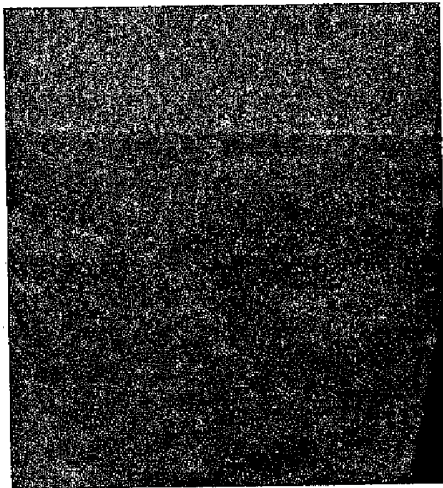


Fig 9

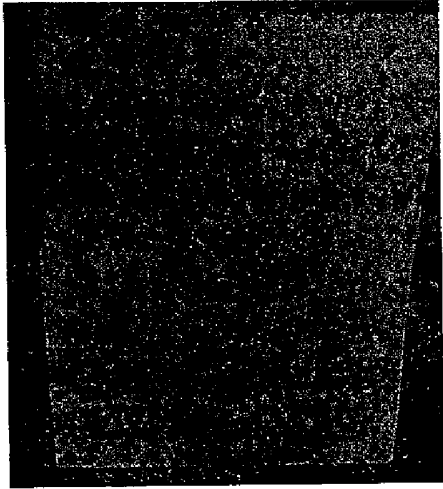


Fig 10

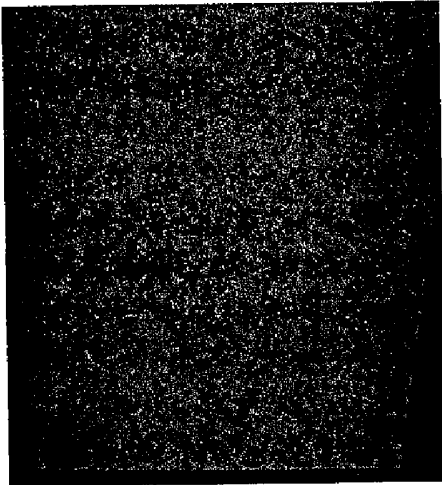


Fig 11

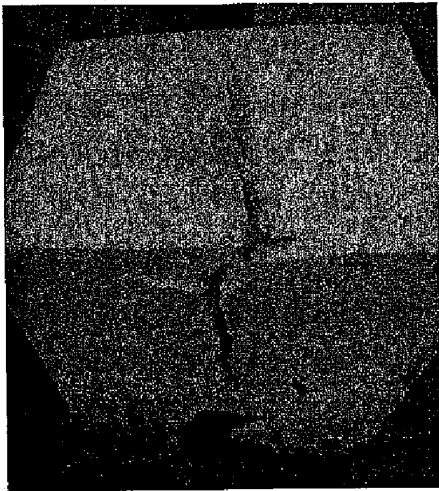


Fig 12

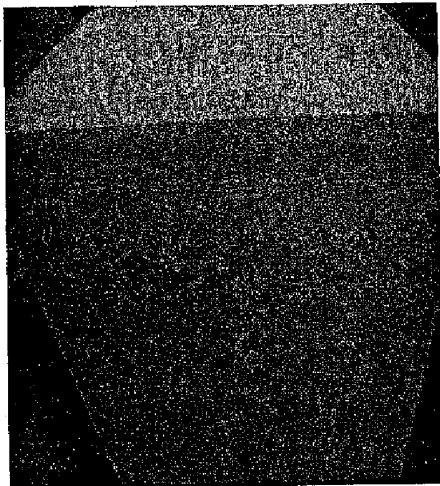


Fig 13

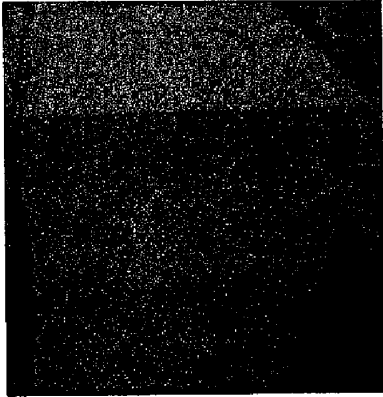


Fig 14

