INORGANIC POLYMERS:
IMPACT MODIFICATION OF ASBESTOS-PHOSPHORIC ACID COMPOSITION BOARD

Authors: G. D. Jacobs
J. A. Faucher

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SUMMARY: The work on this project has been concerned mainly with the inorganic mineral chrysotile, a form of asbestos currently being mined by the Nuclear Division at Coalinga, California. Attempts have been made to impact modify an asbestos-phosphoric acid-water composition board (code designation P-38) originally produced by the Nuclear Division. Previous experience here had shown that impact strength correlated well with low temperature "transitions" in the mechanical loss spectrum of organic polymers, and it was felt that the incorporation of one of these organic polymers in the asbestos board might lead to the desired product. To date, however, the addition of a rather large number of organic polymers in various percentages has not improved the strength of the board to any great extent. It is now felt that some material will be necessary that is capable of chemically reacting with the hydroxyls of either the asbestos or the phosphoric acid. Very little is known about the chemical reaction between the asbestos and phosphoric acid. In fact, the physical characteristics of the asbestos fibers are still open to controversy and a great deal of basic research is currently being carried out on this material. A brief sampling of some of this work is given in this report.

Present work on this project to modify the P-38 composition is concerned with the possibility of adding fibrous organic polymers to the mixture. This phase of the work is a direct result of the work carried out by the U.S. Army on the addition of nylon fibers to cement in which they were able to improve the impact strength of cement by a factor of twenty-seven. Preliminary work with asbestos shows an increase in impact strength, although not nearly as large as in the case of cement. Projected work includes the use of polycarbonate and polyhydroxyether fibers as additives.

INTRODUCTION: Asbestos is the generic name given to a number of mineral silicates varying quite widely in chemical composition. These silicates are divided into two mineral classes; serpentine and amphibole. A list of the more common types is presented in Table I along with their chemical formulae.

Research and Development Department
Chemicals Division
Union Carbide Corporation

By far the most important single type of asbestos is chrysotile, accounting for nearly 90% of world production. Certain ones of the amphibole group, noteably crocidolite (blue asbestos), amosite, and anthophylite, do find use in specialized plastics applications[1,2].

The major portion of this report is concerned with a chrysotile variety being mined by the Nuclear Division at Coalinga, California. Table II is a comparison of the physical properties of a general chrysotile asbestos with the high-purity grade UCC Coalinga fiber.* The unique properties of the Coalinga fiber are attributed to its greater specific surface area and adsorption properties as shown in the table.

Chemically, chrysotile has been described as a hydrated basic silicate of magnesia. Normally, some magnesium carbonate and hydroxide are associated with the fibers in the form of dolomite and brucite. Table III gives the chemical and mineralogical compositions of a general chrysotile fiber as compared to the Coalinga fiber.

Until a few years ago the formula for chrysotile was written as $3MgO \cdot 2SiO_2 \cdot 2H_2O$, implying a di-hydrate. As a result of recent research efforts[3,4,2], it is now felt that a better representation of the "molecule" is given by the formula $Mg_3Si_2O_5(OH)_4$, where the previous water molecules are now present in the form of hydroxyl groups. The individual fibers are pictured as layers of silicon-oxygen tetrahedra ($Si_4O_{10}^{-4}$) condensed onto magnesium hydroxide layers. Each of the silicon-oxygen/magnesium hydroxide layers is superimposed upon layers of similar composition, but no chemical bonding is thought to occur between the layers. A schematic drawing of a portion of the curved wall layer of a chrysotile fiber is shown in Figure 1[5]. Another view is shown as Figure 2.

A controversy has also arisen over the physical structure of the individual fibrils. Pictures taken with the electron microscope seem to indicate that the fibers are in the form of "hollow tubes"[6]. Recent evidence from X-ray diffraction measurements[5] and density determinations[7] has thrown doubt on this theory and the present proposed picture is that the central portion of the tubes is filled with amorphous or partially oriented material. As pointed out by Dr. E. J. W. Whittaker this filling of the tubes with amorphous material would lead to an appearance of emptiness under the electron microscope due to the contrasting effect between the walls of the fiber and the filling material. A recent study using ultrasonics[8] also provides evidence that the material filling the voids between fibers is amorphous.

Chemical reactions of chrysotile are also now being investigated. X-ray methods serve as the principal tool for studying these hydrothermal reactions, which are found to be predominantly topotactic. Being topotactic implies that the normal reaction involves the migration of cations, including silicon, while having little effect upon the oxygen framework[9,10].

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* Three product grades of asbestos are currently available from the Nuclear Division: Standard Grade, High Purity Grade, and Colloid

The preceding paragraphs should serve as a general introduction to the nature of the mineral asbestos and give some idea of the research being done on this material. Further specific information may be found in the references cited as well as in the four books listed in the bibliography.

Due primarily to the large supply available and to the unique characteristics of Coalinga fiber, the Nuclear Division initiated work on finding saleable products which utilized their asbestos. One of the materials produced was an asbestos-phosphoric acid-water composition board (code designation P-38),[11]. This material suffered, however, from a lack of impact strength as well as poor weatherability. The Nuclear Division also developed an asbestos-phenolic composition (code designation F-100) which showed both improved strength and weatherability[12]. Efforts at Tuxedo have since been directed primarily at improving and marketing the F-100 composition in the form of pipe.

Since previous experience was available on impact strength of organic polymers, as evidenced by studies on the low temperature loss peaks in the mechanical loss spectrum, it was decided to look again at the P-38 compositon with the thought of adding an impact modifying filler to the composition.

Experimental

The Coalinga asbestos used throughout these investigations was the high-purity grade - i.e. the material has been defilibrated and the magnetite removed. Early experiments were concerned with finding the best ratio of asbestos-phosphoric acid-water for easy mixing and extrusion. After several trials using various ratios, it was found that the following proportions were most satisfactory:

70 parts asbestos
35 parts water
30 parts 85% phosphoric acid

The dry, powdery asbestos is loaded into a Cincinnati Mix-Muller* and the phosphoric acid-water solution added through a funnel provided with the mix-muller. The time taken for addition of the phosphoric acid-water solution is rather critical in that water is apparently lost from the mixture for both short times of addition (causes heating of the mix) and also by evaporation if excessive time is involved. We have found, in agreement with the Nuclear Division, that a fifteen-twenty minute period for addition of ingredients is best. Additional ingredients were normally added after the phosphoric acid-water solution and in certain cases (liquid fillers) a proportionately smaller amount of water was necessary in order to acquire an extrudable product. The final product, ready for extrusion, is of a putty-like consistency.

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*Cincinnati Muller Co., Cincinnati, Ohio; Previous experiments had shown that a Hobart blender did not give adequate mixing on this scale (2 lbs asbestos).

The first experiments (before acquisition of an extruder) with the P-38 composition consisted of pressing the material into disc-shapes at 10,000 psi. Tests on these discs showed, however, that in order to obtain material with any strength whatever it would be necessary to extrude the composition. Previous work by the Nuclear Division (see reference 11) had shown that a ram-type extruder was best suited for the P-38 composition.

The ram extruder now in use was designed by Mr. Gene LeRoy of the Research and Development Department Special Projects Division, Machine Design. An Ener Pac* hydraulic, power-operated, pump and cylinder are incorporated in the design. The exit die is of a rectangular shape with dimensions 3" x $^1/_4$".

The P-38 composition is loaded into the extruder and then the ram moved forward to seal-off the chamber. The chamber is evacuated for several minutes before the extrusion is started. Starting with two pounds of asbestos, an extruded "board" approximately four feet in length is obtained (3" in width, $^1/_4$" in thickness). Normal extrusion pressure is 2000-3000 psi.

The "board" is cut into six and twelve inch lengths. The six inch lengths are rolled out (transverse to direction of extrusion) into pieces $^1/_8$" in thickness, using several passes through a large roll mill. All the pieces are then subjected to a room temperature cure followed by a cure at either 110°C or 150°C depending on the type of filler used. It is necessary during the cure-cycle to sandwich the asbestos strips between expanded-metal sheets in order to prevent warping.

After curing, the boards are removed from between the metal sheets and cut into small pieces for testing. The $^1/_8$" thick samples are given flexural strength and flexural modulus tests (ASTM D790-61) while the $^1/_4$" specimans are subjected to the Izod impact test (ASTM D256-56). The Gardner impact test proved unsatisfactory for testing these specimans. All samples are tested in both the parallel and transverse directions (designated P and T respectively in the tables).

DISCUSSION: The first experiments with the P-38 blend were concerned with finding the best ratio of ingredients and optimum mixing time, as pointed out in the experimental section of this report. A short study was also conducted to determine the function of room temperature curing time on the strength of the final board. Previous studies by the Nuclear Division had shown that both a room temperature cure and a final curing at an elevated temperature were necessary for a high-strength board. The results of our room temperature cure-time study are given in Table IV and shown plotted in Figure 3. From these results, it was concluded that a room temperature cure of at least sixteen hours was required. The three points shown plotted for a sixteen hour cure were taken as an indication of the deviation which can be expected from one batch to the next. Several runs were also made using different curing temperatures as well as different amounts of time at this elevated temperature but

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* Blackhawk Industrial Products Co., Butler, Wisconsin.

all seemed to indicate that 16+ hours at room temperature followed by 4 hours at 150°C gave the best results.

The next step in the project was to investigate the effect which various additives would have on the strength of the P-38 composition. The rest of the discussion section will be sub-divided into sections dealing with the various additives thus far investigated.

DQDA 3269 (72/28 ethylene/vinyl acetate copolymer)

An informal report by Dr. G. H. Potter (Project No. 399M20; dated 16 December, 1963) reported the possibility of cross-linking or reaction of some type between asbestos and ester-containing polymers, after mixing on a hot roll-mill. Unfortunately this method coats the asbestos fibers so that they are no longer available for attack by the phosphoric acid-water solution used in the P-38 composition. Even prolonged extraction with toluene did not remove enough of the excess polymer so that the fibers could undergo further chemical reaction. An attempt was also made by first reacting approximately one-half of the phosphoric acid-water solution with the asbestos and then placing the material on the mill with DQDA. However, the DQDA would not react in this case and was present in the extruded board as an inert filler. Adding pulverized DQDA to the mixture in the mix-muller was also unsuccessful.

One further step was taken with this type polymer. Granulated AYAT was added to the dry asbestos in the mix-muller followed by the phosphoric acid-water solution. The AYAT appeared to be present as an inert filler also.

Hercules "Aquapel" (364 and 380)

The next material tried was "Aquapel", an alkylketene dimer manufactured by Hercules Powder Company. The dimer was added both in the form of dry flakes and as an emulsion in water. As can be seen from Table V, no significant increase in the strength of the P-38 composition was obtained.

Cationic Wet-Strength Resin

A cationic wet-strength resin consisting of poly β-asparagine polyamine partially crosslinked with epichlorohydrin (14.2% total solids) was obtained from Dr. P. M. Westfall and added to the standard P-38 mixture. The material before curing is very difficult to break apart but as shown in Table V, after curing it shows no great improvement in strength or impact.

Gantrez AN-139 Copolymer

As a result of reading U. S. Patent 3,113,064 entitled, "Asbestos paper containing vinyl alkyl ether-maleic anhydride copolymer and method of forming same", we decided to try adding one of these copolymers to the P-38 mixture. The one chosen was Gantrez AN-139, a copolymer of methyl vinyl ether and maleic anhydride manufactured by General Aniline and Film Corporation (gaf). The copolymer was

added both in the dry state and in the form of a water dispersion. There was some improvement in the strength of the cured P-38 board but not a significant amount. (see Table V).

Polyox - Carbopol 940

Carbopol 940 is a water-soluble, high molecular weight poly (acrylic acid) manufactured by the B. F. Goodrich Chemical Company. The Polyox and Carbopol were added to the asbestos in the mix-muller both in the dry state and as a mixture in water. A combination of Polyox and Carbopol was also tried but did not give any great improvement in strength as seen in Table V.

Latexes

Since the best way to obtain good dispersion of the filler material and at the same time enhance the possibility for any reaction between the filler and the asbestos is to add the filler as a water solution, the use of latexes becomes a logical possibility.

After a few batches were prepared, it became apparent that a new study of strength as a function of curing time and temperature was needed. A series of mixtures were prepared using as a filler 10.4% of a 60/40 styrene/butadiene latex containing 48% total solids. The variables included room temperature cure times of from 0 to 36 hours and high temperature cures (110°C) of 4,8,16, and 32 hours. The results are tabulated in Table VI and shown plotted in Figure 4. As a result of this study, the remainder of the runs using latex fillers involved room temperature cure times of 30+ hours followed by 24 hours at 110°C.

As can be seen from Table VII, various types and percentages of latexes were studied, including styrene/butadiene, polyethylene/acrylic acid, phenoxy A, and a carboxylic modified butadiene/acrylonitrile copolymer (a product of the Chemical Division of The Goodyear Tire and Rubber Company, known commercially as Chemigum Latex 550). Again, however, no really outstanding improvement in strength was obtained for any of the latexes used as fillers.

Di-(2-ethylhexyl) phosphoric acid

In place of a portion of the phosphoric acid used in the P-38 composition, di-(2-ethylhexyl) phosphoric acid was substituted. It was hoped that some cross-linking could be promoted by using this material but in all the mixes prepared, the cured board was extremely weak. The use of superphosphoric acid was also investigated but it proved unsuccessful. No testing of these samples was attempted.

Fibrous fillers

The use of fibrous fillers has proved to be the best choice to date. As shown in Table VIII, crocidolite (Cape blue asbestos), glass, and nylon fibers have been tested and they all seem to increase impact strength, especially the nylon. The work on nylon stems from

a report by the U. S. Army[13] on the addition of nylon fibers to cement. The impact strength of cement is reported to be increased by a factor of twenty-seven.

Further work is being planned along these same lines using as fillers, nylon (different denier), polycarbonate, and polyhydroxyether fibers.

F-100 Composition

For comparison purposes, a batch of the F-100 composition was prepared and tested. The ingredients were as follows: 60 parts asbestos, 15 parts water, and 25 parts BRL 1100 (water soluble phenolic predominating in dimerized trimethylol phenol with some residual monomer; 64-68% solids content). The test results are listed in Table VIII.

Gerald D. Jordan

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2. V. E. Barrable, A. Bennett, and A. F. Jerome, I and EC Product Res. and Dev. 2, 186 (1963).
3. Handbook of Asbestos Textiles, Asbestos Textile Institute, Philadelphia, Pa., 2nd edition, p. 3 (1961).
4. F. L. Pundsack, J. Phys. Chem. 59, 892 (1955).
5. after E. J. W. Whittaker, Chem. and Eng. News, p. 35, 30 Sept. 1963.
6. T. F. Bates, L. B. Sand, and J. F. Mink, Science 111, 512 (1950); in addition, reference 12 contains a picture of some Coalinga fibers taken with an electron microscope.
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10. L. S. Dent Glasser, F. P. Glasser, and H. F. W. Taylor, Quart. Revs. 16, 343 (1962).
11. Nuclear Division, Research Report No. 39: Development of New Building and Pipe Materials From Coalinga Fibers, G. S. Jordan and N. J. Setter.
12. Nuclear Division, F-100 Data Book, G. S. Jordan, H. F. Reichard, and N. J. Setter.
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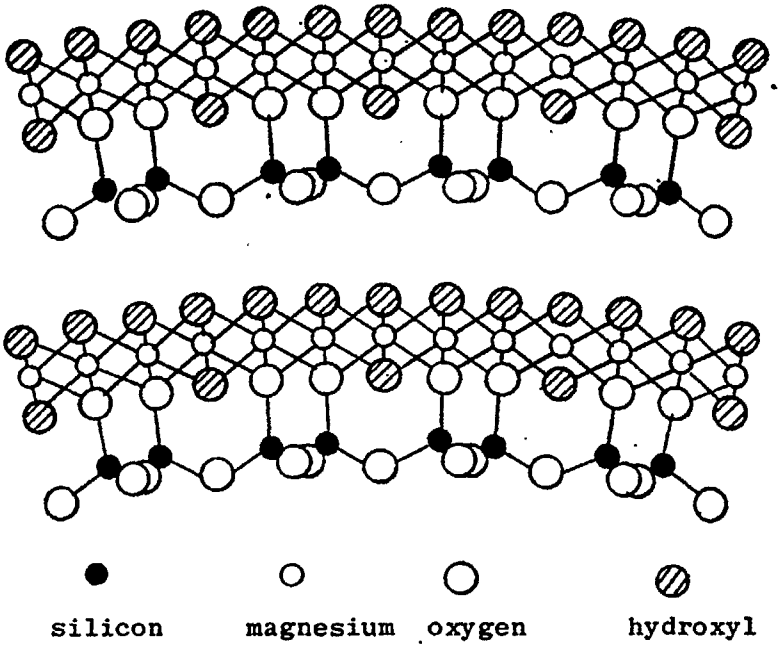
(1) Asbestos, From Rock to Fabric, The Textile Institute, Manchester, 1956.

(2) Asbestos, Its Industrial Applications, D. V. Rosato, Reinhold Publishing Co., 1959.

(3) Handbook of Asbestos Textiles, Asbestos Textile Institute, 2nd edition, 1961

(4) Asbestos Fundamentals, H. Berger, Chemical Publishing Co.

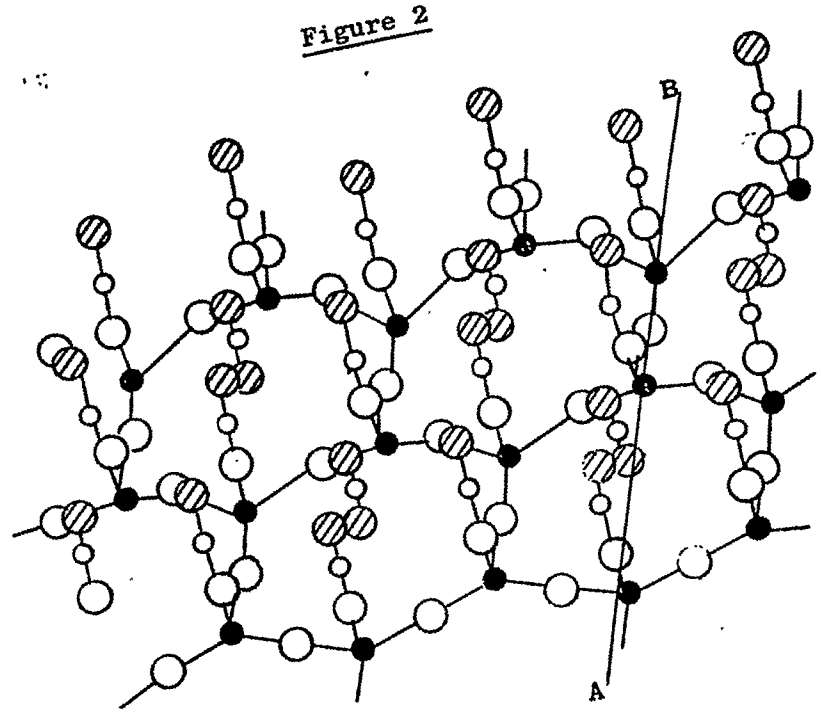
Figure 1*



* Chem. and Eng. News. p. 35, 30 Sept. 1963

This drawing represents a portion of the curved wall layer of a fiber of chrysotile asbestos. The fiber walls are composed of 12 to 20 such layers; each layer being about 7.3 Å thick.

Figure 2



- silicon
- magnesium
- oxygen
- hydroxyl

The line $\overline{AB}$ parallels one of the layers shown in Figure 1.

Figure 3

Strength as a Function of Curing Time

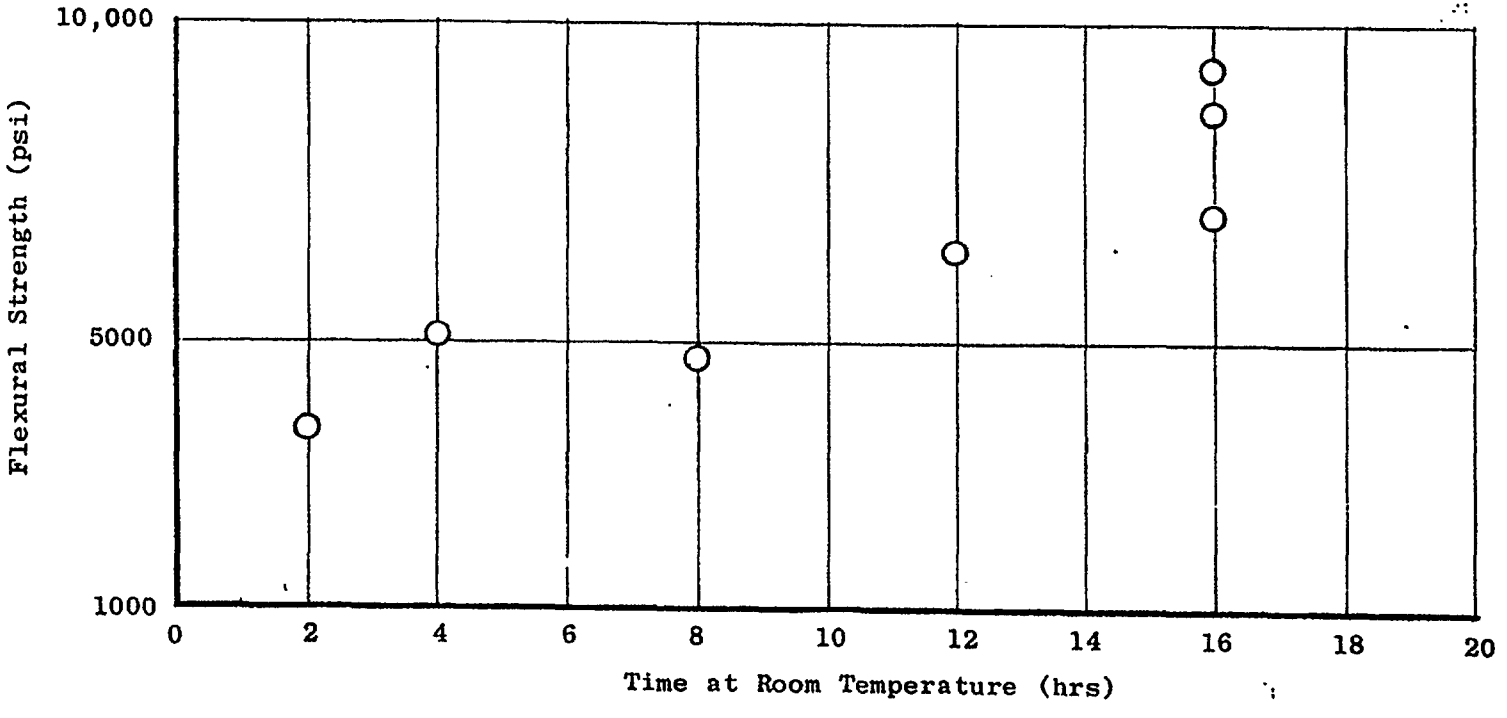


Figure 4

Flexural Strength vs Time at Room Temperature

(all samples received later cure of 16 hrs at 110°C)

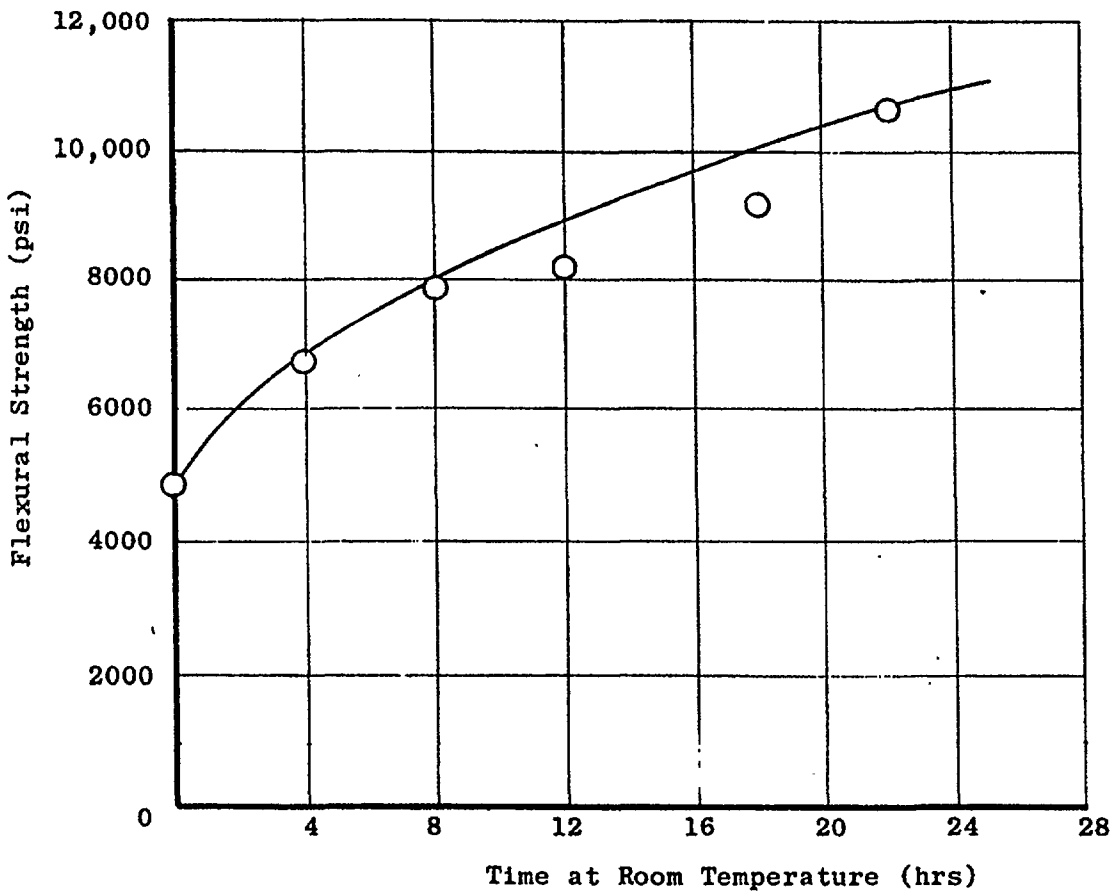


TABLE I

Classification	Common Name	Formula
Serpentine	Chrysotile*	$Mg_3Si_2O_5(OH)_4$
Amphibole**	Crocidolite	$Na_2Fe_5Si_8O_{22}(OH)_2$
	Tremolite	$Ca_2Mg_5Si_8O_{22}(OH)_2$
	Actinolite	$Ca(MgFe)_5Si_8O_{22}(OH)_2$
	Anthophyllite	$(MgFe)_7Si_8O_{22}(OH)_2$
	Amosite	$(MgFe)_6Si_8O_{22}(OH)_2$

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* chrysotile exists in at least three modifications depending upon the form of the crystal lattice. The following four papers are recommended for the interested reader.

1. E. J. W. Whittaker, Acta Cryst. 6, 747 (1953)
2. E. J. W. Whittaker, Acta Cryst. 9, 855 (1956)
3. E. J. W. Whittaker, Acta Cryst. 9, 862 (1956)
4. E. J. W. Whittaker, Acta Cryst. 9, 865 (1956)

** for more information on the crystal chemistry of amphiboles see:

5. E. J. W. Whittaker, Acta Cryst. 13, 291 (1960)

TABLE II*

Property	General Chrysotile Asbestos	UCC Coalinga Asbestos (high-purity grade)
Density, g/cc	2.25-2.75	
Hardness	2.5-4.0	
Specific Surface m^2/g	10-50	60-70
Oil Adsorption g/10g	4-5	14-16
Water Retention g/20g	32-34	
Bulk Density		
Wet cc/5g		175+
Dry lb/ft^3	10-15	3-5
Refractive Index	1.50-1.55	
Luster	silky	
Color	green-gray	white
Brightness (% of MgO)		75-80
Electrical Charge	positive	
Acid Resistance	poor	
Alkali Resistance	good	
Specific Heat BTU/lb-°F	0.266	
Tensile Strength lb/in^2	80,000-100,000	
Temp. of Max. Loss	800°C	
Temp. of Struct. Loss	600°C	

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* Table taken from letter of W. H. Dresher, Nuclear Division

TABLE III*

CHEMICAL COMPOSITION

Compound		General Chrysotile Asbestos	UCC Coalinga Asbestos (high-purity grade)
MgO		36-44%	42
SiO_2		35-44	42
Fe_3O_4		0.5-5.0	<1.0
Fe_2O_3		0-6.0	--
FeO		0-6.0	0.3-1.6
H_2O	Total	12-15	16.0
	Combined	--	13.5

MINERALOGICAL COMPOSITION

Mineral	General Chrysotile Asbestos	UCC Coalinga Asbestos (high-purity grade)
chrysotile	major	major
brucite	moderate	minor
magnetite	0.5-5.0%	<1.0%
hydrotalcite	--	minor

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* Table taken from letter of W. H. Dresher, Nuclear Division

TABLE IV

Study of Strength as a Function of Curing Time

Notebook Reference 5808-	Curing Time (hours)		Flexural Strength (psi)		Flexural Modulus (psi x 10^6)		Izod (ft. lbs.)		Density (g/cc)
			P*	T*	P	T	P	T	
	25°C	150°C							
27-1	2	4	3692	3729	1.61	1.34	0.15	0.12	1.36
27-2	4	4	5171	3981	2.57	1.76	0.16	0.31	1.44
28-1	8	4	4808	3919	2.44	2.05	0.14	0.13	1.48
28-2	12	4	6488	4630	2.89	2.39	0.14	0.17	1.63
25-1	16	4	7059	5562	3.46	2.11	0.13	0.14	1.57
25-2	16	4	8662	6250	3.20	2.64	0.16	0.14	1.57
45-2	16	4	9306	8484	2.86	2.49	0.28	0.20	1.53

Ingredients: 70 parts asbestos; 35 parts water; 30 parts phosphoric acid (85%)

*P - parallel direction, T - transverse direction

TABLE V

P-38 Composition Plus Additives

Notebook Reference 5808-	Additive*	Flexural Strength (psi)		Flexural Modulus (psi x 10^6)		Izod (ft. lbs.)		Density (g/cc)
		P	T	P	T	P	T	
38-1	4.7% Aquapel (emulsion)	4431	4280	1.27	1.18	0.17	0.11	1.44
37-1	4.7% Aquapel (dry flakes)	5076	3759	2.36	1.57	0.17	0.14	1.43
41-2	14.4% Cationic wet-strength resin	7680	7563	1.80	1.75	0.16	0.14	1.55
41-1	28.7% Cationic wet-strength resin	7317	7078	1.76	1.73	0.15	0.14	1.55
62-1	0.3% Gantrez AN-139 (dispersion)	8501	5922	2.66	2.08	0.24	0.18	1.60
62-2	1.3% Gantrez AN-139 (dispersion)	8118	9795	2.61	2.58	0.22	0.17	1.57
63-1	1.3% Gantrez AN-139 (dry)	8295	7716	2.66	2.38	0.27	0.22	1.52
34-1	1% Polyox (coagulant grade)	8083	6553	1.89	1.63	0.17	0.19	1.55
69-1	0.3% Carbopol 940	8329	6733	3.09	2.66	0.28	0.19	1.62
69-2	0.6% Carbopol 940	9589	6964	2.94	2.70	0.24	0.19	1.58
70-1	1.3% Carbopol 940	8076	6019	3.01	2.45	0.25	0.18	1.63
72-1	0.3% Carbopol + 0.3% Polyox	5927	3908	2.29	1.83	0.43	0.14	1.51
72-2	0.6% Carbopol + 0.6% Polyox	4525	4652	2.07	1.83	0.29	0.16	1.52

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* percentages are based on initial charge of ingredients (i.e. before curing)

TABLE VI

P-38 Composition Plus Additives

Notebook Reference 5808-	Additive* 10.4% of a 60/40 styrene/butadiene latex; 48% total solids		Flexural Strength (psi)		Flexural Modulus (psi x 10^6)		Izod (ft. lbs.)		Density (g/cc)
			P	T	P	T	P	T	
	Curing Times								
	room.temp.	110°C							
48-4	0 hrs.	8 hrs.	4787	4447	2.45	1.83	0.20	0.17	1.44
48-3	0	16	4861	4520	2.21	1.97	0.21	0.15	1.45
47-2	2	8	5671	5123	2.09	2.01	0.22	0.30	1.47
48-2	4	8	6682	6025	2.27	2.14	0.24	0.23	1.49
48-1	4	16	6726	5872	2.57	2.13	0.21	0.24	1.54
49-4	8	8	7303	6948	2.23	2.04	0.23	0.20	1.51
49-3	8	16	7934	6662	2.29	2.06	0.23	0.34	1.51
47-1	12	4	7197	6417	2.12	2.14	0.27	0.21	1.55
49-2	12	8	9014	7906	2.52	2.26	0.25	0.18	1.55
49-1	12	16	8211	8183	2.96	2.43	0.28	0.32	1.60
49-8	16	8	8753	7790	2.70	2.27	0.23	0.18	1.58
49-7	18	16	9233	8251	2.47	2.34	0.24	0.18	1.57
49-6	20	8	9722	9416	2.56	2.49	0.25	0.20	1.57
49-5	22	16	10,695	8843	3.00	2.61	0.24	0.20	1.57

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* percentages are based on initial charge of ingredients (i.e. before curing)

TABLE VII

P-38 Composition Plus Additives

Notebook Reference 5808-	Additives* (latexes)	Flexural Strength (psi)		Flexural Modulus (psi x 10^6)		Izod (ft. lbs.)		Density (g/cc)
		P	T	P	T	P	T	
42-1	2.6% 60/40 S/B (48% total solids)	8600	7360	2.73	2.28	0.22	0.17	1.61
42-2	10.4% 60/40 S/B (48% total solids)	8361	7535	2.35	2.14	0.23	0.17	1.58
45-1	20.7% 60/40 S/B (48% total solids)	5833	5062	1.72	1.48	0.26	0.36	1.47
53-1	9.9% 60/40 S/B; 4.7% ZnO	5629	4908	2.22	2.27	0.18	0.16	1.54
53-2	10.2% 60/40 S/B; 2.5% Sulfur	6954	6835	2.36	2.40	0.20	0.17	1.59
44-1	2.6% 50/50 S/B (51.5% total solids)	8156	7850	2.73	2.40	0.20	0.17	1.55
44-2	10.4% 50/50 S/B (51.5% total solids)	7427	6827	2.34	2.20	0.22	0.19	1.56
44-3	20.7% 50/50 S/B (51.5% total solids)	4682	4824	1.46	1.38	0.43	0.21	1.43
67-2	2.6% 45/55 S/B (50% total solids)	9444	8434	2.76	2.54	0.22	0.20	1.63
52-1	10.4% 45/55 S/B	7746	6812	2.34	1.89	0.21	0.17	1.54
46-1	2.6 % polyethylene-acrylic acid latex (7% acrylic; 47.4% total solids)	9415	7842	3.21	3.10	0.25	0.26	1.56
46-2	10.4% " " "	8874	8524	2.50	2.34	0.27	0.28	1.54
55-1	2.6% PE-AA, (15% acrylic; 40% total solids)	8535	7409	2.79	2.54	0.25	0.16	1.59
58-1	10.4% PE-AA, (6% acrylic; 48% total solids)	6977	6507	2.40	2.15	0.17	0.13	1.42
71-1	2.6% phenoxy latex (38% total solids)	4721	3908	1.91	1.78	0.20	0.15	1.49
71-2	5.2% phenoxy latex (38% total solids)	4607	3677	1.83	1.71	0.22	0.17	1.49
71-3	10.4% phenoxy latex (38% total solids)	4580	4101	1.50	1.58	0.18	0.14	1.43
73-2	2.6% Chemigum 550 (38.1% total solids)	5035	3579	2.34	1.77	0.17	0.17	1.54
76-1	5.2% Chemigum 550 (38.1% total solids)	5606	4824	2.41	1.99	0.21	0.17	1.51
76-3	10.4% Chemigum 550 (38.1% total solids)	6608	5760	2.18	1.94	0.24	0.21	0.92
76-4	9.85% Chemigum + 4.92% ZnO	5031	4807	1.45	1.42	0.17	0.15	1.47

* percentages are based on initial charge of ingredients (i.e. before curing)

TABLE VIII

P-38 Compositon Plus Additives

Notebook Reference 5808-	Additive	Flexural Strength (psi)		Flexural Modulus (psi x 10^6)		Izod (ft. lbs.)		Density (g/cc)
		P	T	P	T	P	T	
26-1	2.8% crocidolite (blue asbestos)	5716	5064	2.64	2.19	0.36	0.25	1.47
26-2	2.8% 1/4" glass fibers	5892	3464	2.77	1.88	0.24	0.14	1.48
30-1	2.8% 1" glass fibers	4587	2691	1.09	0.73	0.32	0.13	1.30
68-1	0.5% 1"-3" nylon fibers (140 denier)	6834	6709	2.66	2.64	0.42	0.17	1.61
68-2	0.3% 1"-3" nylon fibers (140 denier)	8834	6966	2.93	2.24	0.42	0.52	1.62
79-1	F-100 composition	13,912	12,562	2.33	1.91	0.27	0.22	1.59

Distribution

Dr. J. W. Biddle, 511
Dr. F. E. Bailey, 511
Mr. D. L. Engle, 511
Dr. J. O. Koehler, 511
Dr. J. V. Koleske, 511
Dr. R. D. Lundberg, 511
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Dr. Ivey Allen, 312
Dr. A. Brown, 312
Dr. L. Imhof, 312
Mr. S. Jordan, Sterling Forest, N.Y.
Dr. C. N. Merriam, 312
Dr. F. P. Reding, ERA
Dr. H. F. Reichard, Sterling Forest, N.Y.
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Authors (4)