

PATENT SPECIFICATION

(11) 1 247 373

DRAWINGS ATTACHED

- (21) Application No. 49623/68 (22) Filed 18 Oct. 1968
 (31) Convention Application No. 676 497 (32) Filed 19 Oct. 1967 in
 (33) United States of America (US)
 (45) Complete Specification published 22 Sept. 1971
 (51) International Classification D 04 h 3/16; B 32 b 27/02
 (52) Index at acceptance

DIR 3

B5N 177 178 17Y 214 227 228 22X 241 250 252X 254X
 344 348 349 350 352 35X 35Y 38X 436 540 542
 55X 570 574 577 591 62Y 630 631 63X 653 656
 67X 682 690 698 713 71X 735 750 765 774



(54) SMOOTH SURFACED OPEN FILAMENTARY MATERIAL

(71) We, MINNESOTA MINING AND MANUFACTURING COMPANY, a Corporation organised and existing under the laws of the State of Delaware, United States of America, of 2501 Hudson Road, Saint Paul, Minnesota 55101, United States of America, do hereby declare the invention for which we pray that a patent may be granted to us and the method by which it is to be performed to be particularly described in and by the following statement:—

This invention relates to filamentous materials and methods of making the same. More particularly, the invention relates to the preparation of smooth-surfaced open porous integrated matt (i.e. tangled matt) of continuous crinkled fibres or mono-filaments.

According to the invention a method of making such a matt comprises extruding a hot thermoplastic polymeric material in the form of a bundle of closely-spaced separate continuous filaments, permitting said filaments to fall under their own weight toward the surface of a liquid quench bath, maintaining a contact surface above said quench bath surface and in position to permit a glancing contact with at least a portion of the outer filaments of said bundle, and advancing the resulting bundle of filaments within said quench bath at a linear speed substantially less than the extrusion speed of said filaments, whereby to cause crinkling welding together and interengagement of said filaments into a lightly unified matt having a flat surface area of increased density.

Thus a smooth surfaced open filamentary article according to the invention comprises an open matt of interengaged continuous crinkled filaments of resilient thermoplastic polymeric material welded together at points of mutual contact to form an integrated structure at least a portion of one surface of which is flattened and contains a higher density of filament than does the inner portion of said matt.

An important field of utility for the pro-
 [Pri-

ducts of the invention is in weather-resistant outdoor mats or carpeting. The smooth face of the web permits improved contact with the supporting surface and is particularly helpful in assuring good bonding with mastic or adhesive compositions applied thereto. The crush-resistant large-diameter crinkled filaments provide a safe, pleasant and wear-resistant walking surface. The extremely open nature of the web and the smooth surface of the filaments permits easy cleaning and washing as well as rapid drying. If desired, the matt may be further reinforced and strengthened by treatment with various resins or polymers applied from solution or suspension or in other ways; but the material as first formed has a surprisingly high degree of integrity permitting winding into rolls for storage, unwinding and handling for application, and subsequent treatment in use without disintegration.

The matt has also been found useful in the preparation of flexible molds for electrical cable splice areas and the like. A section of the matt is placed against an adhesive-coated non-porous flexible film, and the combination then folded about the splice area and sealed at the sides, in effect forming an open-top pouch which is then filled with suitable potting compound. The crush-resistant open matt holds the film at the desired distance from the cable while permitting the liquid compound to penetrate and fill the entire pouch and, after hardening, to encapsulate and insulate the splice area.

The invention will now be further described by way of example and with reference to the accompanying drawings in which:—

Figure 1 is a schematic illustration in elevation showing the process and apparatus used in making the matt;

Figures 2 and 3 are representations of front and back surface areas of a portion of a typical matt as made on the apparatus and by the method of Figure 1; and

Figure 4 is a representation of an edge

1247373

50

55

60

65

70

75

80

85

90

view of a segment of a matt having two oppos-
ing flattened surfaces.

As shown in Figure 1 the liquid fused poly-
mer is extruded from a perforated nozzle or
5 spinnerette head 10 as individual streams or
filaments 11 which fall freely for a short
distance before advancing into the quench
bath 13. As the filaments enter the quench
10 bath they cool and rigidify, thereby setting up
a degree of resistance to the flow of the
molten streams which as a consequence are
caused to oscillate just above the bath sur-
face. The resulting wavy motion establishes
15 irregular periodic point contact between
streams, causing spot welding of the filaments
at those points. Some of the other filaments
also come into contact with the smooth surface
of the drum 12 and are thereby prevented
20 from oscillation in that direction. The drum
12 rotates at a predetermined surface speed
which is substantially lower than the rate of
extrusion of the filaments. Thus the linear
advancing speed of the matt is less than the
25 extrusion speed. In general it is found that a
ratio of advancing speed to extrusion speed of
2 to 7 is advantageous. The bundle of fila-
ments is rapidly cooled and rigidified in the
quench bath to form the integrated matt 14,
30 which is then withdrawn from the bath and
wound up on storage roll 15. The surface of
the drum may be provided with spaced pins
or pegs 16 or may be otherwise modified to
assist in controlling the advance or modifying
35 the structure of the matt 14 but is preferably
generally smooth.

It will be seen that the surface of the drum
12 is wetted by immersion in the quench bath;
but this is not essential, since stationary dry
polished metal or other plates or the like have
40 also been found to provide effective contact
surfaces. Where danger of adhesion or other-
wise induced sticking at the surface may be
present, low-adhesion smooth coatings or films
may be applied to the contact surface.

The amount of bonding or spot welding
occurring during the process just described
may be adjusted by changes in the particular
polymer employed, the temperature of the
45 filament at point of contact, the diameter of
the filament, the rate of withdrawal of the
matt, and in other ways. The additional num-
ber of contacts between filaments occasioned
by contact with the smoothing plate or roll
50 adds sufficient bonding to maintain adequate
integrity and good handling characteristics in
the matt while still permitting the removal
of individual filaments in substantially con-
tinuous lengths without breakage.

The width and thickness of matt which
60 may be produced by the technique just de-
scribed is limited, e.g. by the size of extruder
and number of orifices. As an example, a
typical matt may contain a total of 260 fila-
ments and have a width of eight inches and
65 a thickness of 3/4 inch (1.9 cm.). In general

however it has been found that matts can
be made by the invention upwardly from one
quarter of an inch thick. Fortunately it
found that the edges or faces of such v
may be joined together in a fully effected
manner to produce webs of any desired width.
The laterally extending coils and loops of the
filaments along the adjacent surfaces inter-
mesh sufficiently to produce a surprisingly
effective bond when further treated with mini-
75 mal quantities of hardenable liquid adhesive.

Usually the ratio of the average length of
the contained filaments to the length of the
matt is between 2 and 7.

The flattened surface portion of the matt
contains a higher concentration or density of
filament than does the remainder of the
structure, and presents a greater contact area
than does the opposite unflattened surface. As
a result, adhesives are enabled to form a
85 strong bond with the flattened surface. Prefer-
ably the ratio of fibre density at the flattened
surface to that at a parallel plane removed
from the flat surface is at least two. It is
possible to flatten both surfaces, simply by
including a second smooth-surfaced plate or
drum in position for glancing contact with
the other surface of the web of extruded soft
filaments, where such modification is desired,
90 while still retaining the open low density struc-
ture throughout the centre of the web. In an-
other modification the filaments are extruded
in a bundle having a generally circular or oval
or other non-circular cross-section which is
completely encircled by an annular contact
95 plate to form a cylindrical structure having a
continuous high-density smooth surface and
a low-density interior.

The difference in surface density obtained
between matt surfaces formed under free fall
105 conditions and against a contact surface re-
spectively is graphically illustrated in Figures
2 and 3, representing contact prints prepared
by lightly touching the surface of the matt to
a smoothly inked plate or roll and then lightly
110 pressing the inked surface against a smooth
white paper. The black lines 20 and 30 repre-
sent the inked surfaces of the filaments at the
paper-contacting surface. Another method of
measuring these surface differences involves a
115 measurement of the gloss, i.e. the amount
of light reflected at a given angle from the
surface of the matt when illuminated from a
standard source at the same angle. Typically,
the reflection from the front surface is one-
120 fourth to one-third the reflection from the
more dense flat back surface.

As polymeric materials may be used poly-
carbonate, polyalkylene, polyester, polyvinyl,
polyamide, ionomer and other resins which
125 are extrudable at elevated temperatures in the
form of soft flexible continuous filaments and
which at lower temperatures have the required
stiffness, toughness and other required physi-
cal and chemical characteristics. Particular
130

O	T	D	L	t	V
.031(.79)	490(254)	.026(.66)	5.0(12.7)	.63(1.6)	95.0
.031(.79)	500(260)	.024(.61)	7.3(18.6)	.63(1.6)	95.5
.031(.79)	510(266)	.020(.51)	9.8(24.8)	.63(1.6)	95.3
.024(.61)	490(254)	.081(.46)	6.5(16.5)	.69(1.8)	95.7
.024(.61)	500(260)	.018(.46)	6.8(17.3)	.69(1.8)	95.3
.024(.61)	510(266)	.016(.41)	7.8(19.8)	.69(1.8)	

In each instance there is produced a unified, well bonded matt which is resistant to crushing under normal hand pressure. It is resilient and springy. The individual continuous filaments are bonded to each other at points of contact but may be broken away and removed intact. The back surface of the matt is flattened and is seen to contain a high concentration of filament, whereas the front

surface is rough and irregular and is much more open.

EXAMPLE 2

The procedure of Example 1 is repeated using polycarbonate resin having a density of 1.26 and with the surface of the water quench bath positioned at a distance of six inches (15 cm.) beneath the spinneret. Rate of feed is 400 gm./min. and extrusion pressure is in the neighborhood of 800 psi (56 kg./sq.cm.).

O	T	D	L	t	V
.031(.79)	660(349)	.030(.76)	6.5(16.5)	.63(1.6)	93.6
.031(.79)	680(360)	.024(.61)	8.0(20.3)	.69(1.8)	93.6
.031(.79)	695(368)	.018(.46)	9.3(23.5)	.63(1.6)	90.7
.024(.61)	650(343)	.018(.46)	8.0(20.3)	.63(1.6)	—
.024(.61)	660(349)	.017(.43)	9.0(22.8)	—	—
.024(.61)	670(354)	.061(.41)	11.3(43.6)	—	—

The resulting product is generally similar to that of Example 1 but is somewhat more rigid.

25

EXAMPLE 3

Plasticized white pigmented polyvinyl chloride ("Geon 8814"; Geon is a Registered Trade Mark) having a density of 1.29 is pro-

cessed as in the preceding Examples, except that the distance from spinneret to quench bath is six inches (15 cm.), and the take-up speed is 8 inches/min. (20 cm./min.). The extrusion pressure is less than 50 psi (3.5 kg./sq.cm.).

30

11

4

5

1,247,373

5

V

5.0

5.5

5.3

5.7

5.3

ch

ed of ch 15 is in 20

	O	T	D	L	t	V
	.031(.79)	380(193)	.035(.89)	4.5(11.4)	.50(1.3)	90.4
	.031(.79)	390(199)	.022(.56)	11.8(30.0)	.50(1.3)	91.0
	.031(.79)	400(204)	.020(.51)	10.8(27.5)	.63(1.6)	92.2
	.024(.61)	380(193)	.018(.46)	7.0(17.8)	.80(2.0)	89.7
	.024(.61)	390(199)	.017(.43)	8.5(21.5)	.63(1.6)	92.3
	.024(.61)	400(204)	.017(.43)	8.0(20.3)	.63(1.6)	92.6
	.016(.40)	380(193)	.016(.41)	7.0(17.8)	.50(1.3)	90.7
	.016(.40)	390(199)	.016(.41)	7.8(19.7)	.38(1.0)	89.0
	.016(.40)	400(204)	.015(.38)	5.5(13.9)	.38(1.0)	89.0

A red pigmented plasticized polyvinyl chloride ("Geon 8812") under the same conditions gives the following values:

.031(.79) 310(154) .022(.56) 10.8(27.5) .44(1.2) 89.0

7

5.6

5.6

5.5

5.7

pt ch 30 re-he 3.7

- 5 When the vinyl resin is extruded directly into the quench bath without first contacting the drum, the strands contact and bond together to such a very limited extent that they come apart or separate into smaller groups or into separate strands under the gentlest handling and the matt cannot effectively be dried, wound up, or otherwise processed as a unit.
- 10 In a modified procedure a strip of thin, flexible, vinyl resin coated glass cloth, lightly pre-coated with liquid plasticizer for the vinyl resin, is introduced between the filaments and the rotating drum, which in this instance is free of pins 16. The filaments are lightly bonded to the cloth and to each other in a unified laminate.
- 15 The slight degree of bonding initially attained may be improved by subsequent treatment of the product with bonding resins, for example by adding a vinyl plastisol and heating. Similar treatment may be used to bond together two or more matts in either face-to-face or side-by-side position.
- 20
- 25
- 30
- 35
- 40
- EXAMPLE 4
- "Surlyn A-1601" ionomer (Surlyn is a Registered Trade Mark), having a density of .94 gm./cc., is extruded in the apparatus previously described, with a drop of 3 1/4 inches (8.9 cm.) from spinneret to quench bath, at a rate of 180 grams/minute with matt recovery at 5 feet/minute (2.5 cm./sec.), using the .031 inch (.79 mm.) orifice and a melt temperature of 450°F. (232°C.), to produce a strong open crush-resistant matt which is flat and dense at the back surface.
- The ionomer is a thermoplastic tough copoly-

mer of monomers of the type ethylene and methacrylic acid, and is particularly resistant to abrasion.

WHAT WE CLAIM IS:—

1. Method of making a smooth-surfaced open porous integrated articles of continuous crinkled filaments, which comprises extruding a hot thermoplastic polymeric material in the form of a bundle of closely-spaced separate continuous filaments, permitting said filaments to fall under their own weight toward the surface of a liquid quench bath, maintaining a contact surface above said quench bath surface and in position to permit a glancing contact with at least a portion of the outer filaments of said bundle, and advancing the resulting bundle of filaments within said quench bath at a linear speed substantially less than the extrusion speed of said filaments, whereby to cause crinkling, welding together and inter-engagement of said filaments into a lightly unified matt having a flat surface area of increased density.

2. Method of claim 1 wherein the ratio of advancing speed to extrusion speed is between 2 and 7.

3. Method of claim 1 wherein the polymeric material is extruded as filaments having a diameter between 5 and 125 mils.

4. Method of claim 3 wherein the polymeric material is extruded as filaments having a diameter between 15 and 35 mils.

5. A smooth-surfaced open filamentary article comprising an open matt of inter-engaged continuous crinkled filaments of resilient thermoplastic polymeric material welded together at points of mutual contact to

45
50
55
60
65
70
75



V
95.0
95.5
95.3
95.7
95.3

is much

repeated
density of
x quench
rches (15
f feed is
are is in
/sq.cm.). 20

V
93.6
93.6
93.5
90.7
—
—

, except
quench 30
re take-
n.). The
(3.5 kg./

O	T	D	L	t	V
.031(.79)	380(193)	.035(.89)	4.5(11.4)	.50(1.3)	90.4
.031(.79)	390(199)	.022(.56)	11.8(30.0)	.50(1.3)	91.0
.031(.79)	400(204)	.020(.51)	10.8(27.5)	.63(1.6)	92.2
.024(.61)	380(193)	.018(.46)	7.0(17.8)	.80(2.0)	89.7
.024(.61)	390(199)	.017(.43)	8.5(21.5)	.63(1.6)	92.3
.024(.61)	400(204)	.017(.43)	8.0(20.3)	.63(1.6)	92.6
.016(.40)	380(193)	.016(.41)	7.0(17.8)	.50(1.3)	90.7
.016(.40)	390(199)	.016(.41)	7.8(19.7)	.38(1.0)	89.0
.016(.40)	400(204)	.015(.38)	5.5(13.9)	.38(1.0)	89.0

A red pigmented plasticized polyvinyl chloride ("Geon 8812") under the same conditions gives the following values:

.031(.79) 310(154) .022(.56) 10.8(27.5) .44(1.2) 89.0

- 5 When the vinyl resin is extruded directly into the quench bath without first contacting the drum, the strands contact and bond together to such a very limited extent that they come apart or separate into smaller groups or into separate strands under the gentlest handling and the matt cannot effectively be dried, wound up, or otherwise processed as a unit.

- 10 In a modified procedure a strip of thin, flexible, vinyl resin coated glass cloth, lightly pre-coated with liquid plasticizer for the vinyl resin, is introduced between the filaments and the rotating drum, which in this instance is free of pins 16. The filaments are lightly bonded to the cloth and to each other in a unified laminate.

- 15 The slight degree of bonding initially attained may be improved by subsequent treatment of the product with bonding resins, for example by adding a vinyl plastisol and heating. Similar treatment may be used to bond together two or more matts in either face-to-face or side-by-side position.

EXAMPLE 4

- 20 "Surlyn A-1601" ionomer (Surlyn is a Registered Trade Mark), having a density of .94 gm./cc., is extruded in the apparatus previously described, with a drop of 3½ inches (8.9 cm.) from spinneret to quench bath, at a rate of 180 grams/minute with matt recovery at 5 feet/minute (2.5 cm./sec.), using the .031 inch (.79 mm.) orifice and a melt temperature of 450°F. (232°C.), to produce a strong open crush-resistant matt which is flat and dense at the back surface.

The ionomer is a thermoplastic tough copoly-

mer of monomers of the type ethylene and methacrylic acid, and is particularly resistant to abrasion.

WHAT WE CLAIM IS:—

1. Method of making a smooth-surfaced open porous integrated articles of continuous crinkled filaments, which comprises extruding a hot thermoplastic polymeric material in the form of a bundle of closely-spaced separate continuous filaments, permitting said filaments to fall under their own weight toward the surface of a liquid quench bath, maintaining a contact surface above said quench bath surface and in position to permit a glancing contact with at least a portion of the outer filaments of said bundle, and advancing the resulting bundle of filaments within said quench bath at a linear speed substantially less than the extrusion speed of said filaments, whereby to cause crinkling, welding together and inter-engagement of said filaments into a lightly unified matt having a flat surface area of increased density.

2. Method of claim 1 wherein the ratio of advancing speed to extrusion speed is between 2 and 7.

3. Method of claim 1 wherein the polymeric material is extruded as filaments having a diameter between 5 and 125 mils.

4. Method of claim 3 wherein the polymeric material is extruded as filaments having a diameter between 15 and 35 mils.

5. A smooth-surfaced open filamentary article comprising an open matt of inter-engaged continuous crinkled filaments of resilient thermoplastic polymeric material welded together at points of mutual contact to

45

50

55

60

65

70

75

(12)



- form an integrated structure at least a portion of one surface of which is flattened and contains a higher density of filament than does the inner portion of said matt.
- 5 6. The article of claim 5 wherein the filaments have a diameter of between 5 and 125 mils.
7. The article of claim 6 wherein the filaments have a diameter of between 15 and
- 10 35 mils.
8. The article of claim 5 wherein the ratio of the average length of the contained filaments to the length of the matt is between 2 and 7.
- 15 9. The article of claim 5 wherein the ratio of the fiber density at the flat surface to that at a parallel plane removed from the flat surface is at least two.
10. The article of claim 5 having a thickness of at least one-quarter inch (.6 cm.). 20
11. The article of claim 5 having two opposing flattened faces.
12. A method of making a smooth-surfaced open porous article substantially as herein described. 25
13. An article made by the method of any one of claims 1—4 or 12.
14. A smooth-surfaced open filamentary web substantially as herein described.

For the Applicants,
LLOYD, WISE, BOULY & HAIG,
Norman House,
105—109 Strand,
London W.C.2.

Printed for Her Majesty's Stationery Office by the Courier Press, Leamington Spa, 1971.
Published by the Patent Office, 25 Southampton Buildings, London, WC2A 1AY, from which copies may be obtained.