

# POLYLACTIDE COMPOUNDING FOR INJECTION MOLDING PRODUCT

Sirinya Pairote

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**By:** Sirinya Pairote  
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**Thesis Advisor:** Assoc. Prof. Rathanawan Magaraphan

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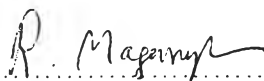
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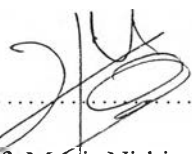
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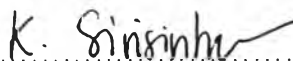
**Thesis Committee**



.....  
(Assoc. Prof. Rathanawan Magaraphan)



.....  
(Asst. Prof. Manit Nithitanakul)



.....  
(Assoc.Prof. Kalyanee Sirisinha)

## ABSTRACT

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Keywords: Epoxidized natural rubber, Lactide monomer, Polylactide, Ring-opening polymerization

The ring-opening polymerization of lactide was synthesized in single step process via using stannous (II) octoate,  $\text{Sn}(\text{Oct})_2$  as a catalyst to get the high molecular weight of polylactide (PLA). For improving the thermal and mechanical properties of PLA, the graft copolymerization between a lactide monomer and epoxidized natural rubber (ENR), ENR-g-PLA was synthesized. The ENR-g-PLA copolymers were successfully synthesized and confirmed by FT-IR spectra. The occurrence peak at  $1740\text{ cm}^{-1}$  and  $3400\text{ cm}^{-1}$  corresponded to the carbonyl group (C=O) and hydroxyl group (-OH) which resulted from the reaction between PLA and ENR. Moreover, the ENR-g-PLA copolymers gave the molecular weight around  $1.87 \times 10^4$  to  $2.78 \times 10^4$  g/mol. The highest amount of copolymer and the highest molecular demonstrated at the catalyst content around 0.2 wt% and the temperature of mixing around  $160\text{ }^\circ\text{C}$ . Furthermore, the calculation of grafting showed that there was 24%grafting of ENR on PLA. Also, the degree of grafting was directly proportional to various ENR contents. For the thermal properties, the decomposition temperature of copolymer ( $\sim 355\text{ }^\circ\text{C}$ ) was higher than pure PLA ( $\sim 332\text{ }^\circ\text{C}$ ). In addition, the impact strength of copolymer increased in the presence of ENR. The impact strength of ENR-g-PLA increased 1.5-folds in comparison to pure PLA. The elongation of copolymer was improved compared to pure PLA. Moreover, the morphology of copolymer was studied by FE-SEM. The results revealed the well dispersion phase of ENR in PLA matrix.

## บทคัดย่อ

ศิริญา ไพโรจน์ : ผลิตภัณฑ์ที่ขึ้นรูปโดยกระบวนการฉีด จากสารประกอบโพลีแลคไทด์ สังเคราะห์ (Polylactide Compounding for Injection Molding Product) อ. ที่ปรึกษา : รศ. ดร. รัตนาวรรณ มกรพันธุ์ 94 หน้า

ปฏิกิริยาพอลิเมอร์ไรเซชันแบบเปิดวงของแลคไทด์ ถูกสังเคราะห์ได้ภายในขั้นตอนเดียว โดยใช้กรดเกลือของธาตุสแตนนัสเป็นตัวเร่งปฏิกิริยาเพื่อให้ได้โพลีแลคไทด์ที่มีน้ำหนักโมเลกุลสูง แต่ยังมีข้อเสียในเรื่องความเปราะและแตกหักง่าย ดังนั้นเพื่อการปรับปรุงคุณสมบัติทั้งทางด้านความร้อนและเชิงกลของโพลีแลคไทด์ สามารถทำได้โดยกระบวนการพอลิเมอร์ไรเซชันแบบกึ่งระหว่างแลคไทด์โมโนเมอร์และยางธรรมชาติอีพอกซีไดซ์ ซึ่งจะสังเคราะห์ได้เป็น ENR-g-PLA ในส่วนของโครงสร้างทางเคมีของโคพอลิเมอร์นั้นสามารถวิเคราะห์ได้โดยเครื่องวิเคราะห์สารด้วยอินฟราเรด (FTIR) พบว่าจะมีการปรากฏของช่วงคลื่นที่  $1740\text{ cm}^{-1}$  และ  $3400\text{ cm}^{-1}$  แสดงถึงหมู่คาร์บอนิลและไฮดรอกซิลที่เป็นผลมาจากปฏิกิริยาระหว่างโพลีแลคไทด์และยางธรรมชาติอีพอกซีไดซ์ นอกจากนี้ ENR-g-PLA โคพอลิเมอร์ยังให้น้ำหนักโมเลกุลประมาณ  $1.87 \times 10^4$  ถึง  $2.78 \times 10^4$  กรัม/โมล โดยที่น้ำหนักโมเลกุลสูงสุดของโคพอลิเมอร์นั้นเกิดขึ้นเมื่อความเข้มข้นของตัวเร่งปฏิกิริยาประมาณ 0.2 เปอร์เซ็นต์โดยน้ำหนักและอุณหภูมิของการผสมประมาณ 160 องศา นอกจากนี้ เมื่อคำนวณหาปริมาณการเกิดโคพอลิเมอร์พบว่ามีปริมาณการเกิดโคพอลิเมอร์ของ ENR 24% และปริมาณการเกิดโคพอลิเมอร์แปรผันโดยตรงกับปริมาณ ENR สำหรับสมบัติทางด้านความร้อนนั้นอุณหภูมิในการสลายตัวของโคพอลิเมอร์สูงกว่าโพลีแลคไทด์ อีกทั้งสมบัติเชิงกลในการทนต่อแรงกระแทกนั้นก็เพิ่มขึ้นจากการที่มียางธรรมชาติอีพอกซีไดซ์ เป็นส่วนประกอบโดยการทนต่อแรงกระแทกของ ENR-g-PLA นั้นเพิ่มขึ้น 1.5 เท่าเมื่อเทียบกับโพลีแลคไทด์บริสุทธิ์ สมบัติการยึดตัวของโคพอลิเมอร์สามารถวัดได้โดย เครื่องทดสอบแรงดึง ซึ่งแสดงให้เห็นว่ามีการยึดตัวที่ดีขึ้นเมื่อเทียบกับโพลีแลคไทด์บริสุทธิ์ นอกจากนี้รูปร่างของโคพอลิเมอร์ สามารถศึกษาได้โดยเครื่องฟิวด์อิมิตชันสแกนนิ่งอิเล็กตรอนไมโครสโคป. ซึ่งผลแสดงให้เห็นว่ามีการกระจายตัวที่ดีของวัฏภาคยางธรรมชาติอีพอกซีไดซ์ในโพลีแลคไทด์.

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## ABBREVIATIONS

ENR	:	Epoxidized Natural Rubber
ENR-g-PLA	:	Epoxidized Natural Rubber graft polylactide copolymer
LA	:	Lactide monomer
PLA	:	Polylactide