

# Air Release in PVC Plastisols

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The ability of a PVC plastisol to liberate entrapped air during mixing and processing is an important factor to the processors. This property, known as air release, is affected by several variables such as resin, plastisol viscosity, surface tension, surfactant system and plasticizer type. A study was conducted to obtain a more fundamental understanding of the effects of these variables on air release. Complicating the accurate study of a plastisol's air release properties is the fact that current test procedures such as the vacuum rise, syringe test and Huff or ring test each have limitations imposed by either plastisol properties or by testing technique. Any one of these procedures alone may not adequately measure air release. This paper, in addition to studying the factors affecting air release, discusses these testing limitations and makes recommendations as to the best methods for evaluating air release properties in the laboratory.

## INTRODUCTION

During the preparation of a PVC plastisol, large amounts of air can be entrapped in the plastisol which, if not removed, can cause poor product quality or hold ups in a processing line. The ability of a plastisol to liberate this entrapped air is known as air release. In most cases, air is removed by pulling a vacuum on the plastisol either during or after it has been mixed. If the plastisol does not release the entrained air during this deaeration step, frothing may occur. This can slow the process and also damage equipment. Also, air which is not removed during this deaeration step will carry over into the product and can result in poor clarity or surface defects. In addition to entrapment during mixing, air can also be introduced during the processing cycle. In a knife or coil coating operation, for example, air can be picked up in the nip behind the knife or roll and, if the bubble is not sheared out or broken upon spreading of the plastisol, it will result in a defective coating. Another example is dip coating where the plastisol which drips off of a mold will pick up air that, if not released, can ultimately end up in the finished product.

There are several factors which can affect the air release properties of a plastisol. Among these are formulation ingredients, plastisol viscosity, and plastisol surface tension. Surface tension effects can be related to the plastisol additives and PVC dispersion resin. This paper discusses these factors and their effects on air release as well as the procedures which can be used to predict the air release properties of a resin.

## EXPERIMENTAL

Several testing methods were used to characterize the air release properties of PVC resins. A brief description of these procedures is listed be-

low:

**Brookfield Viscosity**—procedure for measuring the low shear rate viscosity of a vinyl dispersion using a Brookfield viscometer. (SPI-VD-TI)

**Vacuum Rise**—procedure for the determination of a vinyl dispersion's ability to liberate air when under a vacuum. (SPI-VD-T20)

**Syringe Bubble**—procedure for the determination of a vinyl dispersion's ability to liberate air which is introduced after the plastisol has been prepared. (SPI-VD-T20)

**Huff Ring Test**—procedure for the determination of a vinyl dispersion's air release ability.

**Surface Tension**—determination of the surface tension of various liquids by means of a surface tensiometer.

## DISCUSSION

### Air Release Characterization

The ability to measure the air release properties of a PVC plastisol is of prime importance to many processors. It is also important for a resin supplier to have the ability to accurately predict the air release behavior of his products. Although the measurement of air release is important, currently there are only a few simple methods by which it is tested. These include the vacuum rise procedure, syringe bubble break test, and the Huff ring test. Despite the availability of these standard procedures, many processors measure air release by simply observing the performance of a plastisol when deaerated or by visual observation of air release in a cast film.

As typically used, tests such as the vacuum rise or syringe bubble break cannot adequately measure air release due to inconsistencies are due to the complexities of the controlling mechanisms of air release and the fact that each of these procedures has limitations imposed by either plastisol proper-

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