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<p>(54) Title: POLYMER CONCRETE COMPRISING FURFURYL ALCOHOL RESIN</p> <p>(57) Abstract</p> <p>A polymer concrete comprising by weight about 40-70% coarse aggregate, about 20-55% of a fine aggregate such as sand, about 2-15% silica flour and about 8% to 12% furfuryl alcohol monomer polymerized in situ with an acid catalyst in amounts of about 8% to 12% by weight of the furfuryl alcohol monomer produces a highly cross-linked concrete which contains no cement and is mixed without water. The furfuryl polymer concrete provides the broadest range of chemical resistance of all existing polymer concretes. The coarse and fine aggregate have a pH less than 7.0 and are provided with a specific size gradation.</p>		

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DescriptionPOLYMER CONCRETE COMPRISING
FURFURYL ALCOHOL RESIN5 BACKGROUND OF THE INVENTIONField of the Invention

10 This invention relates to an improved concrete, and in particular to what can be characterized by a polymer concrete in which a monomer polymerized in situ is used as the binder component for the concrete aggregate instead of conventional hydraulic binders which require the addition of water to set.

15 More specifically, the present invention relates to a polymer concrete free of water in which the polymeric binder comprises furfuryl alcohol monomer polymerized in situ with the aid of an acid catalyst.

20 Generally, a significant proportion of concrete used today in pavements, structural supports for buildings and machinery and other widely known uses is formed from a mixture of fine and coarse mineral aggregates and a paste of Portland cement and water. Such Portland cement formulations comprise from about 60% to 75%
25 aggregates and from about 25% to 40% paste by volume of the formulation. The quality of Portland cement concrete depends on many factors including the type of aggregate used and gradation of the aggregate
30 size as well as the quality and availability of the



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paste and the amount and quality of the water relative to the amount of Portland cement added.

Studies and tests have been performed on polymeric additives to concrete and polymeric materials used as substitutes for the typical hydraulic cement binder materials. For example, polymer cement concrete which is a mixture of conventional hydraulic cement concrete and high molecular weight polymers has been formed comprising generally thermoplastic or rubber polymers which are added as emulsions or dispersions to the hydraulic concrete mix. Polymers which have been utilized in such systems include polyvinylacetate, polyacrylates, polyvinylchloride, styrene-butadiene and polyvinylidenechloride. Copolymers of two or more of the polymers have also been utilized. While improvements in the physical properties such as compressive strength, bending strength and decreased water permeability have been reported in the literature for these polymer cement concretes, these improvements have been offset by significant dimensional shrinkage. It has been found that the wear-resistance of polymer cement concretes is significantly better than Portland cement concrete and thus, polymer cement concretes have found some use as floor and deck coverings in public buildings, industrial plants and bridges.

Over the last fifteen years, extensive laboratory studies have been performed in the United States on both polymer-impregnated concrete and



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polymer concrete in which the hydraulic binder is totally substituted with a polymeric material. Such studies have primarily focused on solving problems on failing concrete bridge decks and on concrete pipe in corrosive waste water environments.

5 Polymer-impregnated concrete consists of polymer-impregnation of Portland cement concrete with a low viscosity monomer that is subsequently polymerized in situ. The monomer penetrates the concrete matrix

10 to a finite depth (sometimes controlled) and is subsequently polymerized by heat, catalysts, or radiation. Significant property improvements in compressive strength (285%), tensile strength (292%), modulus of elasticity (80%), freeze-thaw

15 durability (300%) and water permeability have been reported by U.S. Department of Interior/Bureau of Reclamation, W. C. Cowan & H. C. Riffle Investigation of Polymer-Impregnated Concrete Pipe, September, 1974. Data on the resistance of polymer-impregnated

20 concrete to mild hydrochloric and sulfuric acids and permeation by chloride was presented by the Brookhaven National Laboratory in 1976, L. E. KuKacka and M. Steinberg Concrete-Polymer Composites, A Material For Use In Corrosive Environments, March,

25 1976.

Polymer concrete differs from typical Portland cement concrete, polymer cement concrete and polymer-impregnated concrete. Polymer concrete contains no cement or water. The development of

30 physical and chemical properties of polymer concrete



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depends entirely on the chemical and slightly physical reaction between the polymeric binder, hardener and the aggregate system. Most of the early experimentation on polymer concrete has occurred in Eastern Europe and the Soviet Union. More recent experimentation in the United States has focused on bridge deck and highway repairs and experimental attempted use of a polymer concrete lining for steel pipe in geothermal applications. Few commercial applications of polymer concrete are known, but experimental use of polymer concrete materials has been ongoing since about 1960. For example, in bridge deck and geothermal applications, polymer concrete systems containing methyl-methacrylate and blends of polyester/styrene have been evaluated and their properties have been measured and reported by G. W. DePuy, L. E. Kukacka, Concrete-Polymer Materials, Fifth Topical Report, Brookhaven National Laboratory, December, 1973. Significant improvements in compressive strength (18-20,000 PSI) water absorption (less than 1%) and chemical resistance are obtained versus conventional Portland cement concretes. However, for applications in heavy industrial environments, even more chemically resistant polymer concretes are needed.

The present invention provides a polymer concrete with improved physical properties over conventional Portland cement concretes and which can be used for a wide variety of uses such as coatings, coverings, repairs and for applications



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in heavy industrial environments in which strength, flexibility and chemical resistance are required. It has been found that furan resins, particularly those formed from furfuryl alcohol monomers can

5 be mixed with a novel aggregate system to yield polymer concretes of improved chemical and physical characteristics. Furan polymers have found wide use in the formation of foundry cores in which small-sized aggregates (sand) are mixed therewith, all

10 large-sized aggregates being excluded from such formulations. Likewise, there have been studies performed on polymer concrete systems including polymer concrete systems utilizing furan polymers in the United States, such as by the U.S. Atomic Energy

15 Commission, Oak Ridge National Laboratory, Oak Ridge, Tennessee, Translation Series AEC-tr-7147, November, 1971, and further testing on furan polymer concretes in the Soviet Union in which it was found that the performance of polymer concretes are

20 significantly influenced by aggregate selection to produce furan polymer concretes with a range of compressive strengths varying from 5000 to 15,000 PSI; I. M. Elshin, Scientific Research Institute of Hydrotechnics, Kiev, U.S.S.R., "Experience in Using

25 Plastic Concrete with Furan Resins in Different Structures". Likewise, Sneck, Tenho, Marttiner, Pertti, Eneback, and Carl, The State Institute for Technical Research, Otamiemi, Finland, A Preliminary Investigation on the Properties of Some Fufural

30 Acetone Resin Mortars, have tested various physical



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properties of furan polymer concretes as has The Quaker Oats Company, Chemical Division, Chicago, Illinois.

SUMMARY OF THE INVENTION

5 In accordance with the present invention, an improved polymer concrete is provided in which a resin binder of polymerized furfuryl alcohol is formed in situ within a novel aggregate system.

10 Briefly, the polymer concrete of the present invention comprises about 40 to about 70% by weight coarse aggregate, about 20 to about 55% by weight fine aggregate (sand), about 2 to about 15% silica flour and about 8 to about 12% furan resin formed by the in situ polymerization of furfuryl alcohol with aid of an acid catalyst. It has been
15 found that by varying the aggregate formulation within the disclosed range, furan polymer concretes can be produced with compressive strengths varying from 5000 to 15,000 PSI, flexural strengths of 2500
20 to 5400 PSI and tensile strengths of about 2000 PSI. Porosity can be controlled by varying the aggregate gradation, binder level and curing temperature.

25 In accordance with the teachings of the present invention, certain factors have been recognized which are critical if a viable furfuryl alcohol polymer concrete is to be produced. Accordingly, it has been found that aggregate sources and types of aggregates are critical to
30 achieve proper curing and high strength. In



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particular, aggregate size gradations as well as the pH of the aggregate components must fall within the range set forth in the present invention. Moisture content is very critical and must be
5 minimized. Relatively high moisture content retards cure and greatly reduces strength of the furan polymer concrete. Control of the polymerization reaction is important especially when large batches of the concrete product are made to
10 allow for uniform mixing and ease of pouring.

The furan polymer concretes of the present invention when cured produce a highly cross-linked resinous concrete in which the aggregate materials are dispersed within the resin binder. The furan
15 polymer concretes of the present invention offer the broadest range of chemical resistance over all other types of polymer concretes which are based upon different polymer systems or based on furan polymer systems of different aggregate types.

20 Accordingly, it is an object of the present invention to provide an improved concrete.

In accordance with the aforementioned object, another object of the present invention is to provide a polymer concrete in which a furan
25 polymer is utilized as the binder for the concrete aggregate system, replacing typical hydraulic cement and water binder systems.

Another object of the present invention is to provide a polymer concrete devoid of water and
30 which is formed from the in situ polymerization



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of furfuryl alcohol monomer mixed with an aggregate system to provide a concrete product which can be used successfully for a wide variety of purposes.

5 Still another object of the present invention is to provide an improved furan polymer concrete which comprises the in situ polymerization product of furfuryl alcohol monomer mixed with an aggregate system comprising coarse and fine aggregates of controlled size gradation to yield a
10 concrete product usable for a wide variety of purposes.

These together with other objects and advantages which will become subsequent apparent reside in the details of the composition and method
15 of making same as more fully herein after described and claimed.

DETAILED DESCRIPTION OF THE INVENTION

Specifically, the polymer concrete of the present invention is formed from a blend of furfuryl alcohol monomer and an acidic hardener mixed with a
20 mineral aggregate system. The furfuryl alcohol monomer is polymerized in situ within the mixture to produce a highly cross-linked resinous polymer concrete in which the mineral aggregates are
25 dispersed or bound within the polymer binder.

Polymer concretes formed from furan polymers offer the broadest range of chemical resistance reported and are further advantageous for producing a usable concrete product because of the
30 relatively low viscosity, ease of handling, mixing,



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consolidation, flow and finish, rapid cure at ambient temperatures of such concretes and because of the advantageous raw material availability and cost performance relative to other organic binders which have been utilized in polymer concretes. The chemical resistance of various polymer concretes are presented in TABLE 1.

5



TABLE 1*
RELATIVE CHEMICAL RESISTANCE OF POLYMER CONCRETE AND PORTLAND
CEMENT CONCRETE

Rated 1 (Poorest) to 10 (Best)

Material	To Acids	To Oxidizers	To Alkali	To Salts	To Solvents	To Fats and Petroleum Products
Phenol PC	9-10	3-4	3-4	10	7	8
Furan PC	10	2-3	10	10	8	8
Polyester PC	8-9	7	3-4	3-5	1-5	7-9
Epoxy PC	9	3	8	5-6	3-7	9
Portland Cement Concrete	1	1	9	2-3	3-7	5-6

*Taken from Translation Series AEC-tr-7147, November, 1971, U.S. Atomic Energy Commission, Oak Ridge National Laboratory, Oak Ridge, Tennessee.



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Furfuryl alcohol monomer cures in the presence of most inorganic, organic and latent acid hardeners, such as phosphoric acid, sulfuric acid, urea nitrate, benzene sulfonic acid, and toluene sulfonic acid. Selection of an optimum catalyst system, whether solid or liquid, depends on many factors including the field conditions in which the polymer concrete is to be used. Such field conditions as temperature, humidity and batch size of the polymer concrete must be considered since all of these condition will be a factor in which catalyst system is utilized.

Further, the performance of furan polymer concrete is significantly influenced by aggregate selection including type and size gradation. Many fine and coarse aggregate types are available and can be chosen to produce furan polymer concretes with a range of compressive strengths varying from 5000 to 15,000 PSI. It has been found that the size gradation of both the coarse and fine aggregates used in polymer concrete mixture not only affect the compressive strengths of the polymer concrete but greatly influence the ability to form a uniform concrete mixture, ease of handling and chemical resistance properties of the formed polymer concrete. Furthermore, aggregates containing base substances such as carbonates, limestone, sandstone and clay are undesirable because these impurities neutralize the hardener (acid catalyst) and as such optimum property development will not occur.



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Accordingly, the aggregate must have a pH less than 7 in order to produce a concrete product which can be used successfully in the field.

5 The polymerization rate and the final
properties of furan polymer concrete are also
greatly influenced by the amount of moisture in
the aggregate. Published data has shown that when
containing as little as 5% to 6% moisture in the
10 aggregate, the furan polymer concrete develops very
low compressive strength, and at higher moisture
contents, the material will not harden. Accord-
ingly, to produce a high quality furan polymer
concrete, the aggregate which is selected must have
the proper sizing, be clean and free of any alkaline
15 impurities, and have a moisture content preferably
below 1%.

Initial laboratory work on furan polymer
concretes focused on characterizing and optimizing
the chemical property development, binder levels,
20 handling properties and chemical resistance. In
performing this work, three aggregates and a 65%
toluene sulfonic acid hardener in water were used.
Various binder and hardener levels and curing
temperatures were evaluated. To produce laboratory
25 test specimens, the components were mixed according
to the following procedures:

The dried aggregates were blended for 3
minutes, using a small motor mixer, while the
hardener was slowly added to the aggregate. In some
30 cases it was necessary to further dilute the hardener



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with solvent to insure uniform distribution. Careful attention was given to measuring the hardener, since concentration influenced polymerization rate and mechanical properties.

- 5 Excess hardener led to nearly instantaneous setting of the mix and poor physical properties. The binder was added to the hardener/aggregate blend and mixed for 5 minutes. The mixed furan polymer concrete was placed in 1-inch diameter by
- 10 2-inch high compression molds and allowed to cure at room temperature for fourteen days. Data on resulting mechanical properties versus type-1 Portland cement concrete are shown in TABLE 2.



TABLE 2
MECHANICAL PROPERTIES OF FURAN PC MIXES CURED 14 DAYS

VS.

TYPE 1 PORTLAND CEMENT CONCRETE CURED 28 DAYS

Furan PC Mix (Wt. %) Type 1 Portland Cement Concrete

Component	Mix A	Mix B	Mix C	5.5 Bag Mix	7 Bag Mix
#8 Quartz	43.5	44.2	49.2		
#50 Quartz	17.4	17.7	22.5		
Silica Flour	26.1	26.6	18.3		
FA Binder	11.8	10.5	9.1		
65% TSA Hardener	1.2	1.0	0.9		
Total	100.00	100.00	100.00		
Compressive Strength (psi)					
ASTM C579	6,370	6,660	5,030		
ASTM C39				3,000	4,500
Flexural Strength (psi)					
ASTM C580	2,880	2,680	3,310		
ASTM C78				500	750
Tensile Strength (psi)					
ASTM C307	1,470	1,550	1,250		
Porosity (Vol.%)	0.35	0.17	0.09		



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The same mixing procedures were followed to obtain specimens for elevated temperature curing. After curing for 14 days at room temperature, the specimens were post cured for 1 hours at 200° F. and an additional 2 hours at 250° F. The affect of post cure on physical property development is shown in TABLE 3. As can be seen from the TABLE, higher strengths and greater porosity resulted from post curing. For most applications, minimum porosity is desirable.



TABLE 3

MECHANICAL PROPERTIES OF FURAN PC
POST CURED AT ELEVATED TEMPERATURES

Test	Mix A	Mix B	Mix C
Compressive Strength (PSI) (ASTM C579)	10,740	11,390	12,750
Flexural Strength (PSI) (ASTM C580)	2,550	5,400	5,400
Tensile Strength (PSI) (ASTM C307)	1,980	2,070	2,000
Porosity (Vol. %)	1.12	.42	.38



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Published information has further characterized the mechanical properties of furan polymer concretes. Such published studies have illustrated the compressive strength

5 development of furan polymer concrete as a function of time at 20° C. and 73% relative humidity using a 14% binder/hardener level. It has been found that at those defined conditions, approximately 28 days are needed to develop maximum compressive strength

10 properties. However, approximately 79% of ultimate strength is developed within 7 days and 95% within 14 days. Another published study has characterized the compressive strength development of furan

15 polymer concrete as a function of relative humidities. The specimens contained in an 11% binder level and strengths were determined after exposure to different relative humidities for 28 days at 20° C. This study found that a significant sacrifice in

20 compressive strength results when the samples are mixed and cured at high relative humidities. Another study has shown the change of length (shrinkage) of furan polymer concrete with time. In the published studies, various specimens were

25 measured at 20° C. and 73% relative humidity. The shrinkage measurements started after 24 hours cure and continued through 28 days. The data reveal a low level of shrinkage (less than 0.72%) occurs, most during the first 7 days of ambient cure.

Laboratory chemical resistance tests were

30 conducted by totally immersing the post cured



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compression cylinders formed by the procedures set forth above in selected reagents at 150° F. for various times. Changes in compressive strength, weight, and color were observed. The 6-month data are presented in TABLE 4. With the exception of immersion in 5% sodium hydroxide, which attack the aggregate, furan polymer concrete exhibited excellent resistance to the reagents. The reagent color changes may indicate only surface attack of furan polymer concrete specimens.



TABLE 4

SIX MONTH CHEMICAL RESISTANCE OF FURAN PC IN IMMERSION

Reagent	% Compressive Strength Retention	% Weight Change	Reagent Color at Six Months
Deionized Water	92	+ .70	Clear
Saturated Sodium Chloride	105	+ .16	Clear
5% Sodium Hydroxide	49	- 5.46	Black
15% Hydrochloric Acid	100	+ .13	Orange
Methyl Ethyl Ketone	98	+ .17	Black
Perchloroethylene	100	- .64	Green
Chlorobenzene	108	- .54	Yellow

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Further scale-up trials have been conducted to focus on aggregate optimization, large scale handling properties and improved physical properties. Crushed granite stone conforming to ASTM D-448 seive specifications and silica sand conforming to ASTM C-33 were blended in various size ratios. Moisture contents of the blends varied and were not part of the tests. Basic concrete mix design and concrete test procedures were utilized. Compressive strength tests were used as the strength criteria. Concrete test cylinder molds 6 inches in diameter x 12 inches high were filled from a 30-pound batch, prepared with a small mortar mixture. The mix procedure used for the laboratory tests was duplicated for these scaled trials. Various blends combining aggregates with different particle sized distributions, different binder levels and hardener levels were investigated. The mixing was performed at 50-60° F. and relative humidities varying from 40-70%. As the ingredients were placed in the concrete test cylinder molds, they were rodded and lightly screeded to remove excess mix. No external vibration was used for consolidation. Tests with the addition of glass reinforcement to the batch proved difficult to mix, pour and finish, and did not improve physical property development.

TABLE 5 summarizes some typical findings of the scale-up tests. With the exception of mix #1, the binder content of the mix is shown as



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constant, so that the effect of aggregate size distribution on strength development, handling and finished characteristics may be compared.



STRENGTH DEVELOPMENT OF FURAN PC VERSUS AGGREGATE

Sieve Size	Size Opening (Inches)	Mix Number				
		1	2	3	4	5
		(Wt. Percent Aggregate Retained)				
1/2"	.530	23.4	0.4	32.9	0.4	32.9
3/8"	.375	14.7	25.8	20.5	25.8	20.6
No. 4	.187	11.0	20.1	2.5	19.6	2.5
No. 8	.0937	7.6	10.4	0.8	11.4	0.3
No. 16	.0469	6.2	14.1	5.4	22.4	6.4
No. 30	.0232	9.5	12.1	10.0	10.6	18.3
No. 50	.0117	9.3	8.5	11.0	2.5	9.4
No. 100	.0059	6.8	8.6	8.3	7.3	2.3
Less than No. 100		11.5		8.6		7.3
	TOTAL	100.0	100.00	100.0	100.00	100.00
Binder Level (Wt. % of total mix)		6	8	8	8	8
Hardener (wt. % of binder)		12	20			
Cure Conditions		R.T.	R.T.			
Compressive Strength (psi) (ASTM C-39)		7,145	8,500	8,850	5,700	7,700
Comments		7 days @ R.T./5Hrs. @ 120°F	1 Day @ R.T./2 Hrs. @ 250°F	Good flow. Some difficulty Temp. Good finish	Fair flow; affected by coarse sand. Reasonable appearance. Fair smoothness.	Appearance smooth. Finish fair.



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From field tests in which the furan polymer concrete was installed as a pump base in a chemical plant, the following factors were found:

- 5 (1) Aggregate sources and types are critical to achieve proper cure and high strengths in furan polymer concretes.
- (2) Moisture content is critical to set time and strength of furan polymer concretes.
- 10 Aggregates must be pre-dried in order to achieve consistent results.
- (3) Safety is a critical concern. The hardener needs to be preblended with the aggregate in order to safely control the reaction time with
- 15 the furfuryl alcohol monomer binder.
- (4) To achieve a suitable working time and good finishing, the proportion of liquids in the batch must be in the proper range. To effect economy this may mean adding some non-reactive
- 20 dilutants to the batch.
- (5) Control of the exothermic reaction is critical to minimize shrinkage and permit good consolidation and finishing.
- (6) To scale-up for pouring major
- 25 structures with furan polymer concrete, a system of automated field batching equipment appears to be necessary. Control of environmental factors such as rain, humidity and temperature would be certainly critical.
- 30 (7) Good adhesion of furan polymer



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concrete to Portland cement concrete and to steel reinforcing can be achieved with the proper priming system.

In accordance with the present invention,
 5 a furan polymer concrete containing the following ingredients and proportions thereof has been found to produce satisfactory results and can be used successfully in the numerous known concrete applications:

10	Coarse aggregate	40-70%	by weight
	Fine aggregate (sand)	20-55%	" "
	Silica flour	2-15%	" "
	Furfuryl alcohol resin	8-12%	" "

An amino silane coupling agent may be
 15 added in minor amounts. Further, the acid catalyst is added in amounts ranging from about 8% to about 12% of the total weight of the polymerized resin. A more preferred range of ingredients is as follows:

20	Coarse aggregate	45-60%	by weight
	Fine aggregate	30-40%	by weight
	Silica flour	2-10%	by weight
	Resin	8-12%	by weight

More specifically, the following
 25 combination of components yields an excellent polymer concrete:

	Coarse aggregate	54%	by weight
	Fine aggregate (sand)	36%	by weight
	Silica flour	<u>10%</u>	by weight
30	Total	100%	



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Further, the furfuryl alcohol monomer is added in amounts of about 8-10% of the total batch weight, depending upon compressive strengths required, the more resin, the greater the compressive strengths.

5 The preferred acid catalyst is toluene sulfuric acid added as a 65% in water solution in amounts of about 8% to about 12% of the total resin weight.

The procedure for forming the polymer concrete of the present invention is as follows:

10 (1) mix sand, coarse aggregate and silica flour thoroughly in an electric mixer such as of the rotary type for several minutes to insure complete blending, using batches of not more than 150 pounds at a time; (2) add to the blended mix the acid
15 catalyst in the correct proportions and mix thoroughly for several minutes (2-4 minutes);
(3) slowly add, while the mixer is still rotating, the furfuryl alcohol monomer in the proportion shown above; and (4) after mixing for about 2-4 minutes,
20 pour into the form, screed off and allowed to cure.

The function of each of the ingredients added to the polymer concrete of the present invention can be characterized. The fine and coarse
25 aggregates serve as fillers and compression strength contributors after the monomer has polymerized and the polymerized resin has hardened. The silica flour serves to give a smooth finish on sides, top and bottom, filling voids left by the fine aggregate.
30 The polymerized furan resin, of course, serves as



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the binder for the aggregates and silica flour, holding the strength-giving mineral aggregates together as a monolithic structure. The catalyst serves to polymerize the furfuryl alcohol monomer to form a solid binder. Other agents may be added such as coupling agents to enhance the adherence of the resin binder to the mineral aggregates. Pigments as well as other materials may be added to control reaction time, ease of handling, flow, etc. so long as such materials do not adversely affect the strength of the formed polymer concrete.

Catalysts other than the 65% toluene sulfonic acid solution can be used in the formulation of the polymer concrete so that the "set time" or "field work time" can be extended. Such catalysts include more dilute solutions of toluene sulfonic acid (35-45%); phosphoric acid; combinations of toluene sulfonic acid and phosphoric acid; and zinc chloride in water (5% zinc chloride solution). If zinc chloride or other latent catalysts are used, the concrete mix must be heated to temperatures of about 140° F. to 180° F. to insure a proper and adequate cure.

Coarse aggregate which can be used in the polymer concrete of the present invention can consist of gravel, stone or slag. All coarse aggregates must be washed and dried to a moisture content of less than 1% and preferably no more than one-half of 1% moisture. The coarse aggregate must be free from disintegrated pieces, salt,



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alkali, carbonates, vegetable matter and adherent coatings. The weight of extraneous substances must not exceed the following percentages:

	Coal and lignite	1.00
5	Coal lumps	0.05
	Soft fragments	10.00
	Cinders and clinkers	0.50
	Free shells	1.00
	Material passing No. 200 Sieve	1.75
10	In addition, the sum of the percentages of all of the substances above shall not exceed 10%. Gravel used in the formulation of the polymer concrete must be composed of clean, tough, durable quartz. Loss when the material is subjected to the Los	
15	Angeles abrasion test should not be more than 50%. The dry-rodded weight per cubic foot of the gravel should not be less than 95 pounds. The PH must be 7.0 or less. Stone used in the formulation of the polymer concrete should be clean, durable rock.	
20	The loss, when subjected to the Los Angeles abrasion test should not exceed more than 45%. The dry-rodded weight should not be less than 95 pounds per cubic foot and the pH must be 7.0 or less. Slag used must be clean, tough and durable. It must be	
25	air-cooled blast-furnace slag only. It should be reasonably uniform in density and quality, and free from deleterious substances and contain not more than 1.5% sulfur. The dry-rodded weight should not be less than 70 pounds per cubic foot, and the loss,	
30	when subjected to the Los Angeles abrasion test	



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should not exceed 45%. The pH again must not be greater than 7.0. Coarse aggregates of different types cannot be mixed, nor used alternately in sections adjacent to each other or considered part of "one pour".

5

TABLE 6 below indicates a coarse aggregate gradation. As can be seen from the TABLE, most of the coarse aggregate falls in the range of about 1 inch to no less than #4 ASTM sieve size (.187

10 inch). Preferably, most of the aggregate is equal to or less than 3/8 inch and not less than .187 inch. Preferably, 90% of the coarse aggregate should be in the range of one-half inch to .187 inch.



TABLE 6

COARSE AGGREGATE - GRADATION

Percent by Weight of Coarse Aggregate Passing Square-Opening

Laboratory Sieves

GRADE	3 in.	2 in.	1 1/2 in.	1 in.	3/4 in.	1/2 in.	3/8 in.	No. 4	No. 8	No. 10	No. 16
3M	100	97-100	75-100	40-75	15-35			0-5			
5		100	95-100	85-100	60-90	30-60		0-10			
7				100	90-100	40-70	40-70	0-15			
9			100	95-100	75-100	35-70	5-30	0-10			
11				95-100		0-30	0-9				
12				100	90-100	30-65	0-15				
14					100	85-100	40-75	0-15			
15					100	90-100		0-10	0-2		
16S					100	90-100	70-90	30-50	0-8		0-5,
89						100	90-100	20-55		0-30	



The combination of fine aggregates used in the formulation of the of the polymer concrete of the present invention should consist of sand composed of hard, strong, durable uncoated grains of quartz, either quarry pit material or material dredged from river bottoms. All fine aggregates should be completely free from lumps, clay, soft or flakey particles, salt, alkali, organic matter, loam or extraneous substances. Moisture content should be no more than one-half of 1% and the pH must be 7.0 or less. The fine aggregates should be well graded, from coarse to fine, and when tested by means of laboratory sieves meet the following requirement, in percent of total weight:

15 Total Retained On:

	<u>SIEVE NO.</u>	<u>PERCENT</u>
	4	0 - 5
	8	0 - 15
	16	3 - 35
20	30	30 - 75
	50	65 - 95
	100	93 - 100

No. 200-140 mesh silica flour used in the formulation of the polymer concrete preferably is of commercial grade, dry, bagged silica flour free of carbonates.

25 Preferably, at least 75% of the fine aggregate has a size range from about .047 inch to about .006 inch.



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CLAIMS

1. A polymer concrete composition comprising by weight about 40% to about 70% coarse mineral aggregate ranging in size from about 1-1/2
5 inches to about 0.187 inch, about 20% to about 55% fine mineral aggregate ranging from about .187 inch to about .0059 inch; about 2% to about 15% silica flour, about 8% to about 12% furfuryl alcohol monomer polymerized in situ by the
10 addition of an acid catalyst contained in amounts of about 8% to about 12% by weight of said monomer, said mineral aggregates having a pH less than about 7.0, and the moisture content of the mineral aggregates being less than about
15 1% by weight.
2. The polymer concrete of claim 1 wherein the moisture content of the mineral aggregates is less than 0.5% by weight of said mineral component.
- 20 3. The polymer concrete of claim 1 wherein the amount of extraneous substances must not exceed 10% by weight of said concrete.
4. The polymer concrete of claim 1 wherein said
25 coarse aggregate is provided in amounts of about 45% to about 60% by weight; said fine aggregate in amounts of about 30% to about 40% by weight; said silica flour in amounts of about 2% to about 10% by weight.



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5. The polymer concrete of claim 4 wherein at least 90% of said coarse aggregate ranges from about one-half inch to about .187 inch.
6. The polymer concrete of claim 5 wherein at least 75% of said fine aggregate has a size range from about .047 inch to about .006 inch.
7. The polymer concrete of claim 6 wherein said mineral component comprises 54% by weight of said coarse aggregate, about 36% by weight of said fine aggregate and about 10% by weight of silica flour.
8. A polymer concrete composition comprising a furfuryl alcohol monomer polymerized in situ and a mineral aggregate mixture, said mineral aggregate comprising 40% to 70% of a coarse aggregate greater than about .187 inch and about 20% to 55% of a fine aggregate less than .187 inch, said aggregate having a moisture content of 1% or less by weight and a pH of less than 7.0.
9. The polymer concrete of claim 1 wherein the concrete contains by weight percent less than 1.00 of coal and lignite, 0.05 of coal lumps, 10.00 of soft fragments, 0.50 of cinders and clinkers, 1.00 of free shells, and 1.75 of material passing a No. 200 sieve.



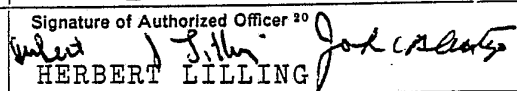
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10. The polymer concrete of claim 1 wherein the concrete is free of salt, alkali, carbonates, and vegetable matter.



INTERNATIONAL SEARCH REPORT

International Application No PCT/US83/00062

I. CLASSIFICATION OF SUBJECT MATTER (if several classification symbols apply, indicate all) ³		
According to International Patent Classification (IPC) or to both National Classification and IPC INT CL. ³ C08L- 95/00 C08K- 3/36 U.S. CL. 524/705, 789, 847; 524/853		
II. FIELDS SEARCHED		
Minimum Documentation Searched ⁴		
Classification System	Classification Symbols	
U.S. CL.	524/705 524/847 524/789 524/853	
Documentation Searched other than Minimum Documentation to the Extent that such Documents are Included in the Fields Searched ⁵		
III. DOCUMENTS CONSIDERED TO BE RELEVANT ¹⁴		
Category ¹⁵	Citation of Document, ¹⁶ with indication, where appropriate, of the relevant passages ¹⁷	Relevant to Claim No. ¹⁸
	US, A, 3,024,215 PUBLISHED MARCH 1962 FREEMAN ET AL	1-10
A	US, A, 3,487,043 PUBLISHED DECEMBER 1969 GRUDUS	1-10
A	US, A, 3,529,063 PUBLISHED SEPTEMBER 1970 SMITH ET AL	1-10
A	US, A, 3,700,604 PUBLISHED OCTOBER 1972 METIL	1-10
A	US, A, 3,738,955 PUBLISHED JUNE 1973 BOZER ET AL	1-10
A	US, A, 3,888,816 PUBLISHED JUNE 1975 BROWN ET AL	1-10
A	US, A, 4,033,925 PUBLISHED JULY 1977 ANDERSON	1-10
X	FR, A, 1,542,422 PUBLISHED OCTOBER 1968 MALLETT COMPANY	1-10
<p>* Special categories of cited documents: ¹⁵</p> <p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier document but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p> <p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.</p> <p>"&" document member of the same patent family</p>		
IV. CERTIFICATION		
Date of the Actual Completion of the International Search ²	Date of Mailing of this International Search Report ³	
MAY 5, 1983	24 MAY 1983	
International Searching Authority ¹	Signature of Authorized Officer ²⁰	
ISA/US	 HERBERT LILLING	

FURTHER INFORMATION CONTINUED FROM THE SECOND SHEET

A	CA, A, 964,784 PUBLISHED MARCH 1975 BROWN ET AL	1-10
A	DERWENT ABSTRACT 32594 T/21 PUBLISHED OCTOBER 1972 NI INST. (DT2053482)	1-10
A	DERWENT ABSTRACT 57063 Y/32 PUBLISHED NOVEMBER 1977 ROAD RES. INST. (SU-530868)	1-10
A	DERWENT ABSTRACT 62996 X/33 PUBLISHED FEBRUARY 1976 IRTUGANOVA (SU-491597)	1-10

V. OBSERVATIONS WHERE CERTAIN CLAIMS WERE FOUND UNSEARCHABLE ¹⁰

This international search report has not been established in respect of certain claims under Article 17(2) (a) for the following reasons:

1. Claim numbers _____, because they relate to subject matter ¹² not required to be searched by this Authority, namely:

2. Claim numbers _____, because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out ¹³, specifically:

VI. OBSERVATIONS WHERE UNITY OF INVENTION IS LACKING ¹¹

This International Searching Authority found multiple inventions in this international application as follows:

1. As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims of the international application.

2. As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims of the international application for which fees were paid, specifically claims:

3. No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claim numbers:

4. As all searchable claims could be searched without effort justifying an additional fee, the International Searching Authority did not invite payment of any additional fee.

Remark on Protest

- The additional search fees were accompanied by applicant's protest.
 No protest accompanied the payment of additional search fees.

III. DOCUMENTS CONSIDERED TO BE RELEVANT (CONTINUED FROM THE SECOND SHEET)		
Category *	Citation of Document, ¹⁶ with indication, where appropriate, of the relevant passages ¹⁷	Relevant to Claim No ¹⁸
A	DERWENT ABSTRACT 90655 B/50 PUBLISHED MARCH 1979 ANDREEV LV (SU-654569)	1-10