

# United States Patent [19]

McMahon et al.

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[54] METHOD OF FORMING COMPOSITE FIBER BLENDS AND MOLDING SAME

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[22] Filed: Apr. 28, 1986

## Related U.S. Application Data

[63] Continuation of Ser. No. 589,930, Mar. 15, 1984, abandoned.

[51] Int. Cl.<sup>4</sup> ..... B65H 81/00; B32B 31/20

[52] U.S. Cl. .... 156/166; 19/299; 28/103; 28/283; 156/175; 156/309.6; 264/258

[58] Field of Search ..... 28/282, 103, 283, 216, 28/274; 57/908; 264/257, 258; 156/245, 175, 166, 180, 181, 309.6, 167; 19/299, 145.5, 66 T, 65 T; 428/364, 288, 296

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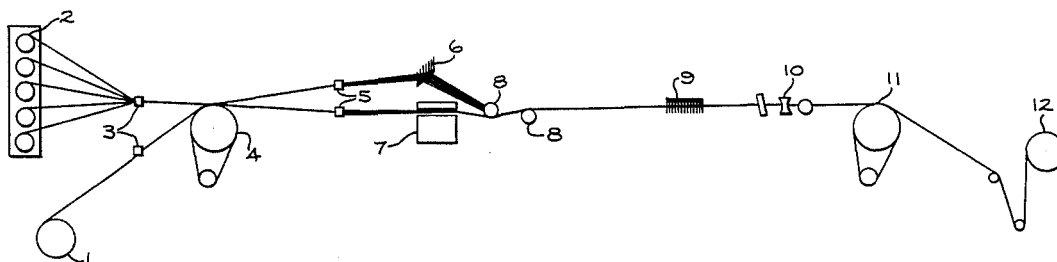
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Primary Examiner—Michael Ball  
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## [57] ABSTRACT

The instant invention involves a process used in preparing fibrous tows which may be formed into polymeric plastic composites. The process involves the steps of (a) forming a tow of strong filamentary materials; (b) forming a thermoplastic polymeric fiber; (c) intermixing the two tows; and (d) withdrawing the intermixed tow for further use.

19 Claims, 2 Drawing Sheets



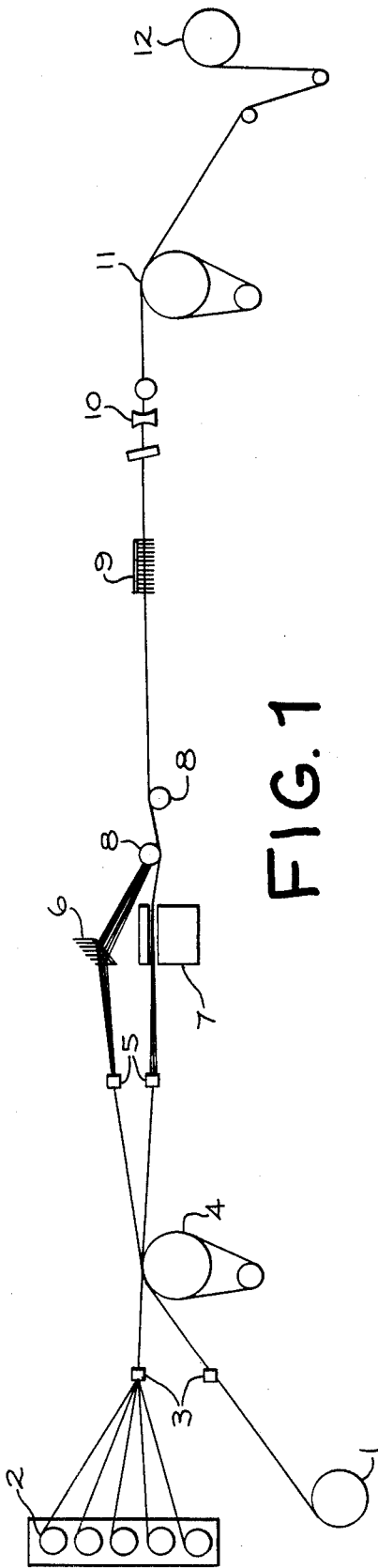


FIG. 1

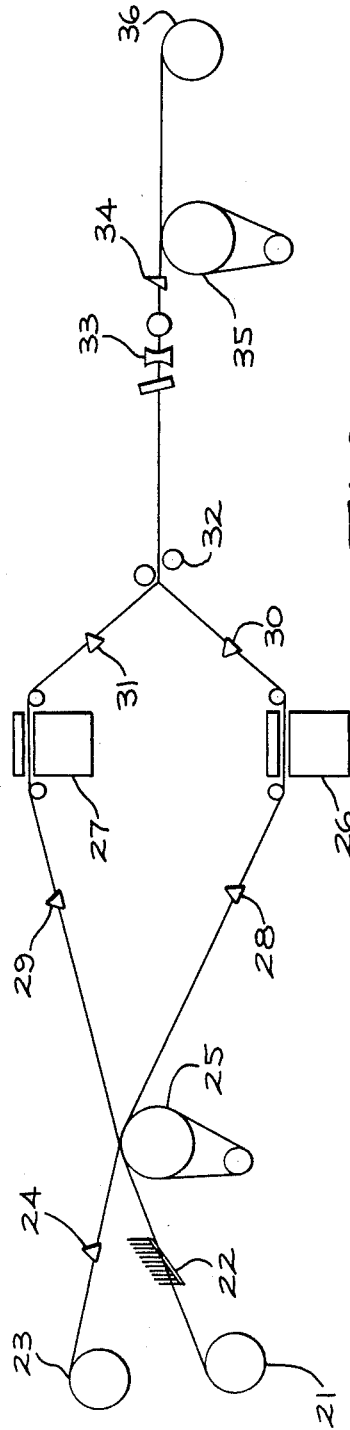
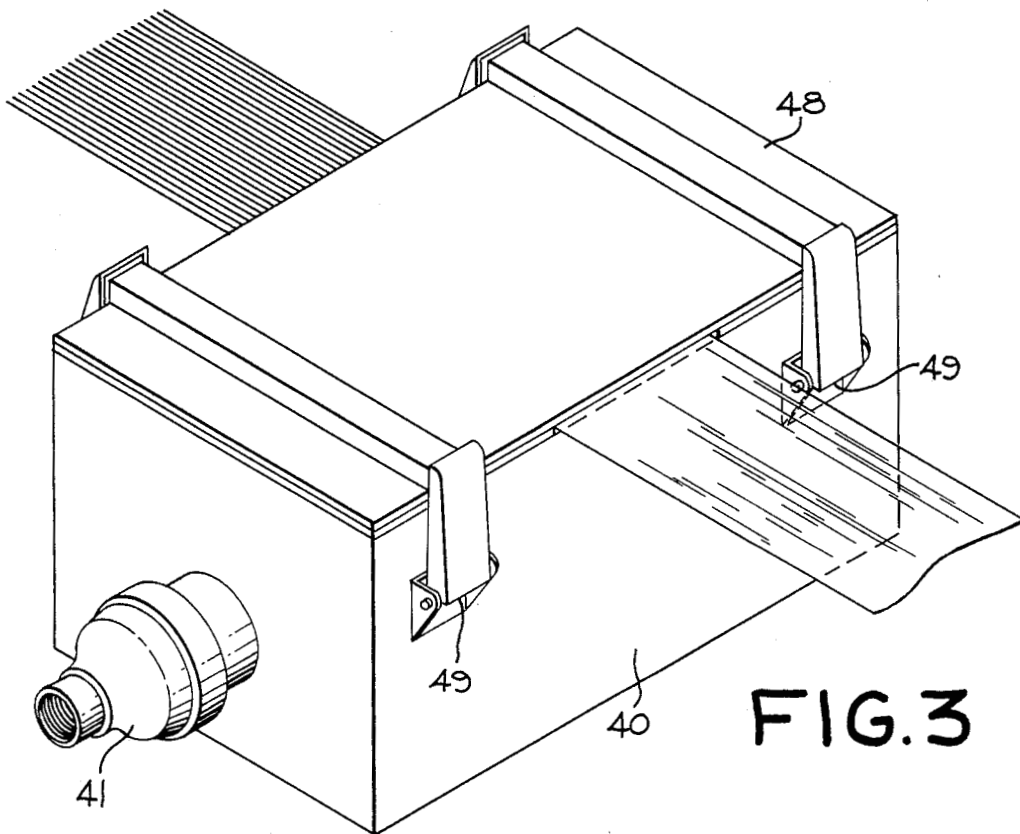
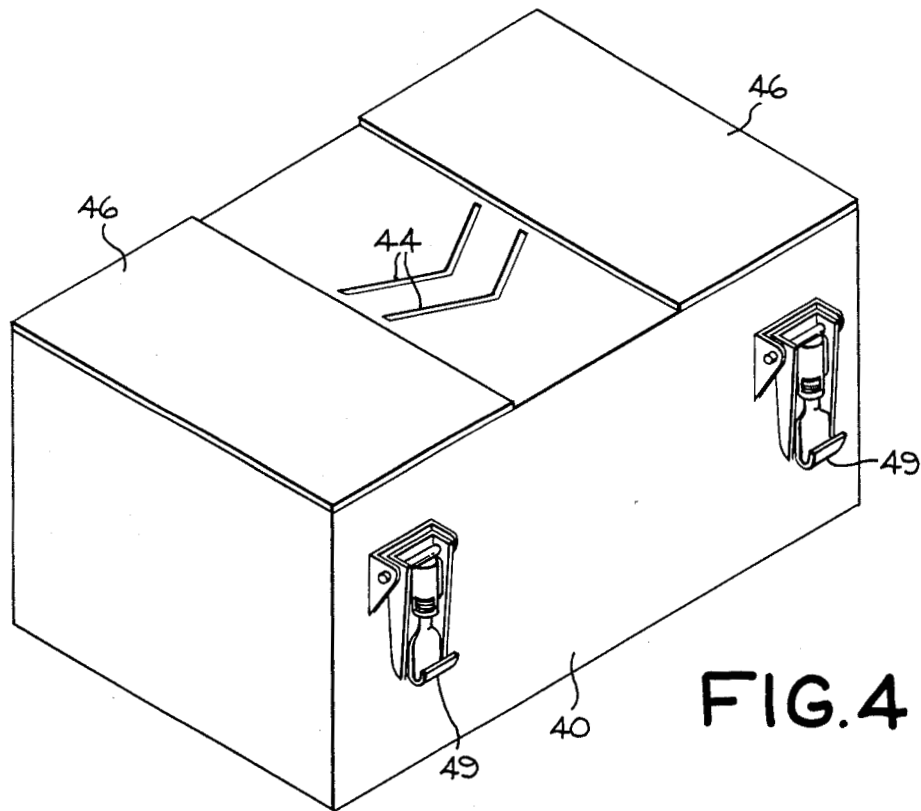


FIG. 2



## METHOD OF FORMING COMPOSITE FIBER BLENDS AND MOLDING SAME

This invention was made with government support under contract No. NAS1-15749 awarded by the National Aeronautics and Space Administration (NASA). The Government has certain rights in this invention.

This is a continuation of co-pending application Ser. No. 06/589,930 filed on Mar. 15, 1984, now abandoned.

### BACKGROUND OF INVENTION

This invention relates to processes for preparing fibers useful in forming composite articles. More particularly, this invention relates to fiber blends containing strong reinforcing fibers which are useful in preparing composite articles.

Fiber-reinforced products have been known for several years. See, for example, U.S. Pat. Nos. 3,914,499, 3,969,171 and 4,214,931, as well as U.S. Pat. No. 4,341,835.

Also, it is known to intermix two similar or different types of fibers, particularly to obtain high bulk. See, for example, U.S. Pat. Nos. 4,219,997, 4,218,869, 3,959,962, 3,968,638, and 3,958,310. And the combining of different types of fibers has been facilitated using various types of fluid jets. See, e.g., the '310 patent and U.S. Pat. No. 4,147,020. However, in the '020 patent, after combining the yarns are cut into short lengths.

U.S. Pat. No. 4,226,079, issued Oct. 7, 1980, discloses the combining of two different types of fibers, in order to produce a bulk yarn. The fibers are intermixed in a jet intermixing zone. However, the fibers disclosed in the patent are polyester and polyamid. No disclosure is made in the combining of carbon and thermoplastic fibers.

U.S. Pat. No. 3,175,351 discloses a method of bulking continuous filament yarns. In addition, it is disclosed that the two yarns which are combined may be of different compositions. However, none of the compositions is a carbon fiber.

U.S. Pat. No. 3,859,158 discloses the preparation of carbon fiber reinforced composite articles by forming an open weave of a carbon fiber and coating with a carbonaceous material. U.S. Pat. No. 4,368,234 discloses complex woven materials used for reinforcement which are formed from alternating bands of graphite fibers and low modulus fibers. However, the woven materials disclosed in this patent are subsequently impregnated with a thermosetting resin and cured.

Commonly assigned U.S. patent application Ser. No. 368,491 to Buckley and McMahon, discloses an improved woven fabric comprised of fusible and infusible fibers wherein the infusible fibers include graphite or carbon fibers, and the fusible fibers are thermoplastic in nature. According to the patent application, fusible and infusible fibers are woven into a fabric and thermally bonded together by heating above the melting point of the fusible fiber. This patent application does not disclose, however, the preparation of linearly intermixed fiber tow products or that such products are useful in forming composite articles. The patent application also does not disclose the preparation of such materials using a gas jet intermixing means.

In the prior art, there were two distinct methods of forming fiber-reinforced composites. The first and older method involved simply forming a tape or fabric prepreg by painting or coating reinforcing fiber tows or

fabric with a solution and/or low viscosity melt of a thermosetting material which was then cured. The second process involved the extrusion of reinforcing fiber tapes impregnated with high melting, thermoplastic polymers. These tapes or fabrics were then used in forming the composite. However, the prepreg formed by both of these processes were somewhat difficult to handle. Specifically, prior art thermoplastic tapes were stiff and "boardy" and could not be draped across intricately shaped molds. While thermoset prepreps were somewhat more flexible, they were often quite tacky and difficult to handle. As a result, the use of both types of tapes was limited.

Accordingly, it is an object of this invention to prepare fibrous blends which are useful in forming fiber-reinforced composites.

It is another object of this invention to prepare materials, e.g., fabrics, which may be formed into composites.

These and other objectives are obtained by employing the process of the instant invention.

### SUMMARY OF INVENTION

Basically, the process of this invention involves (a) forming a fiber tow from a multitude of strong filamentary reinforcement materials; (b) forming a thermoplastic polymeric fiber tow; (c) intermixing the two tows; and (d) withdrawing the intermixed tows for use. The filamentary reinforcing material is preferably non-thermoplastic. The intermixed tows may then be employed in forming various fiber-reinforced composites.

The fiber blends prepared according to the instant invention are flexible and handleable and have good draping properties, so that they can be used to form intricately shaped articles. In addition, because of the intermixing of the two fibers, good wetting of the reinforcing fiber by the thermoplastic material is obtained when appropriate heat and pressure are applied to the mold. Good wetting is obtained in large measure because of the substantially uniform distribution of the thermoplastic fiber and the reinforcing fiber within the fiber blend. Specifically, the products of the instant invention find particular utility in end-use applications where a small radius of curvature in the final product is desired. For example, using the prior art tapes, it was not possible in many instances to prepare articles which had 90° bend, because the tapes would crack or deform at the bend line. However, the processes of the instant invention may be employed with radii of curvature as low as 0.002 in.

### DESCRIPTION OF THE DRAWINGS

FIG. 1 is a diagrammatic view of the various devices used in carrying out one of the processes of the instant invention.

FIG. 2 is a diagrammatic view of the various devices used in carrying out another version of the processes of the instant invention.

FIG. 3 is a perspective view of the gas spreading means used in carrying out a part of the process of the instant invention.

FIG. 4 is a perspective view of the same device with the top removed.

### DETAILED DESCRIPTION OF INVENTION

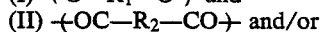
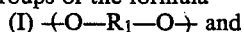
The thermoplastic polymers which are useful in carrying out the instant invention constitute virtually any type of relatively high molecular weight thermoplastic

polymer, including polyethylene, polypropylene, polyester, the various polyamides, polyimides, polyamidimides, polyetherimides, polysulfones (e.g., polyether sulfones), polyether ether ketones, polybutylene terephthalate and the like. The melting point of the polymer must be at least 50° F. and preferably at least 200° F. above ambient conditions. Higher melting temperatures insure that there will be no undue sticking or binding of the spun fibers prior to use. In addition to one component polymer systems, mixtures of various thermoplastic polymers may also be employed to advantage where specific combinations of properties are desired.

Of particular importance are the liquid crystal polymers or LCP's. Examples of these polymers include the wholly aromatic polyester resins which are discussed in the following publications: (a) *Polyesters of Hydroxybenzoic Acids*, by Russell Gilkey and John R. Caldwell, J. of Applied Polymer Sci., Vol. II, Pages 198 to 202 (1959); (b) *Polyarylates (Polyesters From Aromatic Dicarboxylic Acids and Bisphenols)*, by G. Bier, Polymer, Vol. 15, Pages 527 to 535 (August 1974); (c) *Aromatic Polyester Plastics*, by S. G. Cottis, Modern Plastics, Pages 62 to 63 (July 1975); and (d) *Poly(p-Oxybenzoyl Systems): Homopolymer for Coatings: Copolymers for Compression and Injection Molding*, by Roger S. Storm and Steven G. Cottis, Coatings Plast. Preprint, Vol. 34, No. 1, Pages 194 to 197 (April 1974). See also, U.S. Pat. Nos. 3,039,994; 3,169,121; 3,321,437; 3,553,167; 3,637,595; 3,651,014; 3,723,388; 3,759,870; 3,767,621; 3,778,410; 3,787,370; 3,790,528; 3,829,406; 3,890,256; and 3,975,487.

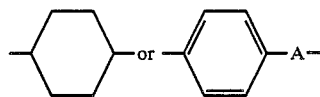
Other polyesters are disclosed, for instance, in (a) Polyester X7GOA Self Reinforced Thermoplastic, by W. J. Jackson, Jr., H. F. Kuhfuss, and T. F. Gray, Jr., 30th Anniversary Technical Conference, 1975 Reinforced Plastics/Composites Institute, The Society of the Plastics Industry, Inc., Section 17-D, Pages 1 to 4; (b) Belgian Pat. Nos. 838,935 and 828,936; (c) Dutch Pat. No. 7505551; (d) West German Pat. Nos. 2520819; 2520820; 2722120; 2834535; 2834536 and 2834537; (e) Japanese Pat. Nos. 43-223; 2132-116; and 3021-293; and (f) U.S. Pat. Nos. 3,991,083; 4,991,014; 4,057,597; 4,066,620; 4,067,852; 4,075,262; 4,083,829; 4,093,595; 4,112,212; 4,118,372; 4,130,545; 4,130,702; 4,146,702; 4,153,779; 4,156,070; 4,159,365; 4,160,755; 4,161,470; 4,169,933; 4,181,792; 4,183,895; 4,184,996; 4,188,476; 4,191,681; 4,201,856; 4,219,461; 4,224,433; 4,226,970; 4,230,817; 4,232,143; 4,238,598; 4,236,600; 4,239,913; 4,242,496; 4,245,082; 4,245,804; 4,247,514; 4,256,624; 4,265,802; 4,267,289; 4,269,965; 4,279,803; and 4,299,756.

The polyesters and copolyesters which are preferred consist essentially of structural units having recurring groups of the formula

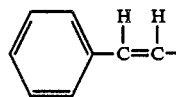


wherein units I and II, if present, are present in substantially equimolar amounts; R<sub>1</sub>, R<sub>2</sub> and R<sub>3</sub> are radicals selected from the group of (1) single and fused six-membered aromatic carbocyclic ring systems wherein the chain-extending bonds of the ring system if attached to the same ring, are positioned 1,3- or 1,4- (preferably 1,4-) to each other, and if attached to different rings, are preferably in positions parallel and oppositely directed, and (2) multiple six-membered aromatic carbocyclic ring systems in which the individual rings are joined by a chemical bond or a trans-vinylene group and in which

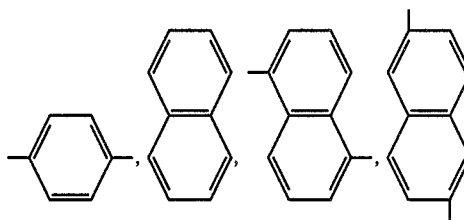
the chain extending bonds of each ring are in the 1,3- or 1,4- (preferably 1,4-) positions; R<sub>2</sub> may also be



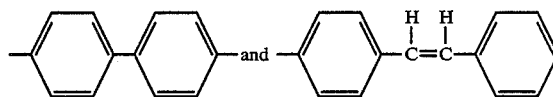
wherein A is a divalent radical containing one or two bicyclic in-chain atoms; and R<sub>3</sub> may also be



wherein the aliphatic portion is attached to the carbonyl group. Preferred group (1) radicals are phenylene and Preferred group (2) radicals are two-ring systems. Illustrative of (1) are

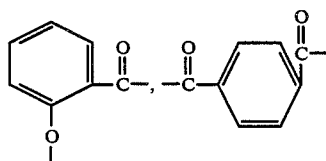


and of (2) are

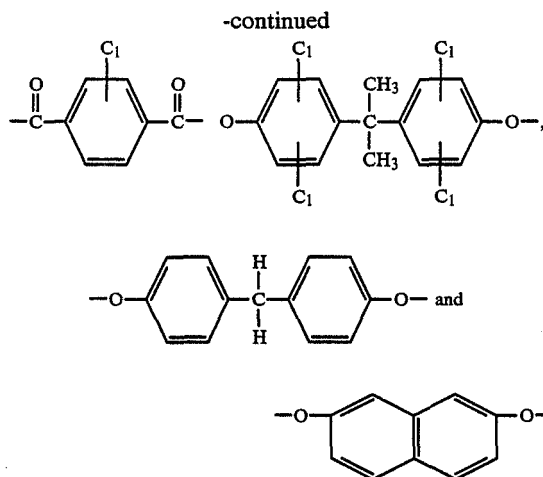


The foregoing ring systems, except for R<sub>2</sub> as indicated below, are also intended to include one or more substituents, e.g., chloro, bromo, fluoro, or lower alkyl (1-4 carbon atoms) on the ring or rings. The R<sub>2</sub> aromatic ring systems should preferably be unsubstituted when only one kind of unit I and one kind of unit II are used, i.e., when a homopolymer is formed to insure obtaining oriented fibers. In the case of copolymers, it is preferred that the R<sub>2</sub> aromatic ring systems be unsubstituted because of thermal or hydrolytic instability and/or cost of the R<sub>2</sub>-ring substituted copolymers.

Also included are those (co)polyesters wherein up to 25 mol %, preferably up to 5 mol %, based on the total I, II and III units, are aromatic polymer-forming units (i.e., units wherein the chain extending functional groups are attached to aromatic rings) not conforming to those described above and which do not interfere with the anisotropic melt forming capability of the polymers. A non-limiting list of these units includes

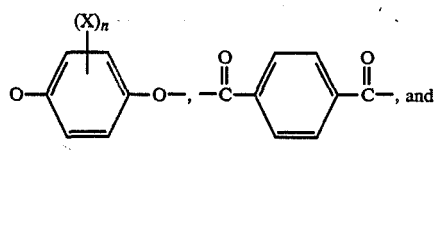


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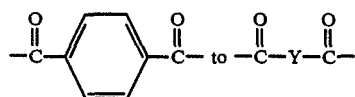


The (co)polyesters, as mentioned above, may comprise units I and II in substantially equimolar amounts or may comprise unit III or may comprise a combination of units I, II, and III and, of course, more than one kind of unit (I, II and/or III) can be present in the polymer.

Preferred (co)polyesters of the invention consist essentially of units I and II. In such polymers, it is preferred that R<sub>1</sub> is selected from the group of 1,4-phenylene; chloro-, dichloro-, bromo-, dibromo-, methyl-, dimethyl- and fluoro-1,4 phenylene; 4,4'-biphenylene; 3,3',5,5'-tetramethyl-4,4'-biphenylene and R<sub>2</sub> is selected from the group of trans-1,4-cyclohexylene; trans-2,5-dimethyl-1,4-cyclohexylene; trans-vinylenebis(1,4-phenylene); 4,4'-biphenylene; 2,6-naphthylene; and 1,4-phenylene and with the proviso that more than one kind of unit I or II are present. Of such copolyesters, two types are particularly preferred because of properties and cost. In the first type, the polymers consist of essentially of the recurring units

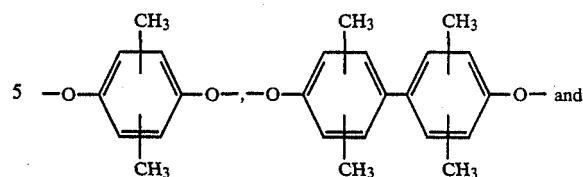


wherein X is selected from the group of chloro-, bromo-, fluoro-, and methyl radicals; n is 1 or 2; and Y is selected from the group of 4,4'-biphenylene and 2,6-naphthylene, the ratio of

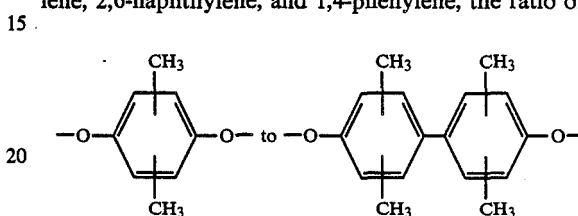


units being within the range of 4:1 to 1:4. In the second type, the polymers consist essentially of the recurring units

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wherein Z is selected from the group of 4,4'-biphenylene, 2,6-naphthylene, and 1,4-phenylene, the ratio of

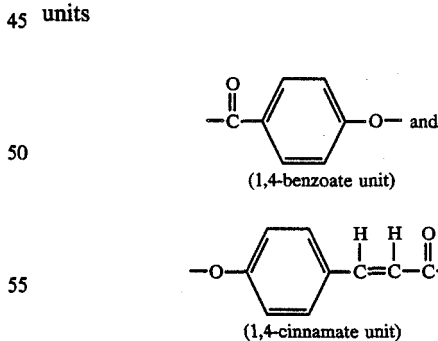


units being within the range of 4:1 to 3:2. With each type of polymer, up to 25 mol percent of non-conforming units may be present as described above.

A list of useful dicarboxylic acids includes terephthalic acid, 4,4'-biphenyl dicarboxylic acid, 4,4'-oxydiphenyl dicarboxylic acid, 4,4'-thiodiphenyl dicarboxylic acid, 4-carboxyphenoxyacetic acid, 4,4'-trans-bis(4-carboxyphenyl) ether, 2,6-naphthalenedicarboxylic acid, ethyleneoxy-4,4'-diphenyl dicarboxylic acid, isophthalic acid, the halogen and methyl substituted derivatives of the foregoing dicarboxylic acids, 1,4-trans-cyclohexanedicarboxylic acid, 2,5-dimethyl-1,4-trans-cyclohexanedicarboxylic acid, and the like.

A nonlimiting list of phenolic carboxylic acids includes 6-hydroxy-2-naphthoic acid, 4-hydroxy-4'-carboxy azobenzene, ferulic acid, 4-hydroxybenzoic acid, 4-(4'-hydroxyphenoxy)benzoic acid and 4-hydroxycinnamic acid and the alkyl, alkoxy and halogen substituted versions of these compounds.

Of the (co)polyesters containing only type III units, the polymers consisting essentially of the recurring units



are preferred.

The (co)polyesters are prepared preferably by melt polycondensation of derivatives of dihydric phenols and aromatic-aliphatic, aromatic and cycloaliphatic dicarboxylic acids or their derivatives. A convenient preparative method is the melt polycondensation of the diacetate of a dihydric phenol with a dicarboxylic acid. Alternatively, phenolic carboxylic acids or their derivatives may be used as coreactants in the preparation of polyesters and copolyesters.

A list of useful dihydric phenols, preferably in the form of their diacetate derivatives includes hydroquinone, chlorhydroquinone, bromohydroquinone, methylhydroquinone, dimethylhydroquinone, dichlorohydroquinone, dibromohydroquinone, 4,4'-oxydiphenol, 4,4'-isopropylidenediphenol, 4,4'-thiodiphenol, 4,4'-biphenol, 3,5,3',5'-tetramethyl-4,4'-bisphenol, 3,5,3',5'-tetrachloro-4,4'-biphenol, 2,6-dihydroxynaphthalene, 2,7-dihydroxynaphthalene, and 4,4'-methylenediphenol and the like.

In addition, it is possible to prepare anisotropic polymers by polymerizing methylacryloxy benzoic acid utilizing an alkali metal hydroxide and free radical initiators as described in U.S. Pat. Nos. 4,112,212, 4,130,702 and 4,160,755.

Useful phenolic-carboxylic acid derivatives include p-acetoxybenzoic acid and p-acetoxycinnamic acid and the like.

A nonlimiting list of various polyesters and copolymers includes: poly(methyl-1,4-phenylene, 2,5-dimethyl-trans-hexahydroterephthalate); copoly(methyl-1,4-phenylene trans-hexahydroterephthalate/terephthalate) (8/2); copoly(chloro-1,4-phenylene trans-hexahydroterephthalate/isophthalate) (9/1) and (8/2); copoly(ethyl-1,4-phenylene terephthalate/-2,6-naphthalate) (7/3); copoly(tert. butyl-1,4-phenylene/-3,3',5,5'-tetramethyl-4,4'-biphenylene/terephthalate) (7/3); copoly(chloro-1,4-phenylene/-3,3',5,5'-tetrachloro-4,4'-biphenylene terephthalate) (7/3).

The liquid crystal polymers including wholly aromatic polyesters and poly(ester-amide)s which are suitable for use in the present invention may be formed by a variety of ester forming techniques whereby organic monomer compounds possessing functional groups which, upon condensation, form the requisite recurring moieties are reacted. For instance, the functional groups of the organic monomer compounds may be carboxylic acid groups, hydroxyl groups, ester groups, acryoxy groups, acid halides, amine groups, etc. The organic monomer compounds may be reacted in the absence of a heat exchange fluid via a melt acidolysis procedure. They, accordingly may be heated initially to form a melt solution of the reactants with the reaction continuing as said polymer particles are suspended therein. A vacuum may be applied to facilitate removal of volatiles formed during the final state of the condensation (e.g., acetic acid or water).

Commonly-assigned U.S. Pat. No. 4,083,829, entitled "Melt Processable Thermotropic Wholly Aromatic Polyester", describes a slurry polymerization process which may be employed to form the wholly aromatic polyesters which are preferred for use in the present invention. According to such a process, the solid product is suspended in a heat exchange medium. The disclosure of this patent has previously been incorporated herein by reference in its entirety. Although that patent is directed to the preparation of wholly aromatic polyesters, the process may also be employed to form poly(ester-amide)s.

When employing the either the melt acidolysis or slurry procedure of U.S. Pat. No. 4,083,829, the organic monomer reactants from which the wholly aromatic polyesters are derived may be initially provided in a modified form whereby the usual hydroxy groups of such monomers are esterified (i.e., they are provided as lower acyl esters). The lower acyl groups preferably have from about two to about four carbon atoms. Preferably, the acetate esters of organic monomer reactants

are provided. When poly(ester-amide)s are to be formed, an amine group may be provided as a lower acyl amide.

Representative catalysts which optionally may be employed in either the melt acidolysis procedure or in the slurry procedure of U.S. Pat. No. 4,083,829 include dialkyl tin oxide (e.g., dibutyl tin oxide), diaryl tin oxide, titanium dioxide, antimony trioxide, alkoxy titanium silicates, titanium alkoxides, alkali and alkaline earth metal salts of carboxylic acids (e.g., zinc acetate), the gaseous acid catalysts such as Lewis acids (e.g.,  $\text{BF}_3$ ), hydrogen halides (e.g.,  $\text{HCl}$ ), etc. The quantity of catalyst utilized typically is about 0.001 to 1 percent by weight based upon the total monomer weight, and most commonly about 0.01 to 0.2 percent by weight. The wholly aromatic polyesters and poly(ester-amide)s suitable for use in the present invention tend to be substantially insoluble in common polyester solvents and accordingly are not susceptible to solution processing. As discussed previously, they can be readily processed by common melt processing techniques. Most suitable wholly aromatic polymers are soluble in pentafluorophenol to a limited extent.

The wholly aromatic polyesters which are preferred for use in the present invention commonly exhibit a weight average molecular weight of about 2,000 to 200,000, and preferably about 10,000 to 50,000, and most preferably about 20,000 to 25,000. The wholly aromatic poly(ester-amide)s which are preferred for use in the present invention commonly exhibit a molecular weight of about 5,000 to 50,000, and preferably about 10,000 to 30,000; e.g., 15,000 to 17,000. Such molecular weight may be determined by gel permeation chromatography and other standard techniques not involving the solution of the polymer, e.g., by end group determination via infrared spectroscopy on compression molded films. Alternatively, light scattering techniques in a pentafluorophenol solution may be employed to determine the molecular weight.

The wholly aromatic polyesters and poly(ester-amide)s additionally commonly exhibit an inherent viscosity (I.V.) of at least approximately 2.0 dl./g., e.g., approximately 2.0 to 10.0 dl./g., when dissolved at a concentration of 0.1 percent by weight in pentafluorophenol at 60° C.

For the purposes of the present invention, the aromatic rings which are included in the polymer backbones of the polymer components may include substitution of at least some of the hydrogen atoms present upon an aromatic ring. Such substituents include alkyl groups of up to four carbon atoms; alkoxy groups having up to four carbon atoms; halogens; and additional aromatic rings, such as phenyl and substituted phenyl. Preferred halogens include fluorine, chlorine and bromine. Although bromine atoms tend to be released from organic compounds at high temperatures, bromine is more stable on aromatic rings than on aliphatic chains, and therefore is suitable for inclusion as a possible substituent on the aromatic rings.

It is emphasized that an important aspect of the present invention which complements the concept of substantially uniform distribution of intermixed fibers is the combination of compatible thermoplastic materials with non-thermoplastic materials or materials having a sufficiently high melting temperature, whereupon effective bonding and integration can be achieved by application of heat and pressure sufficient to melt the thermoplastic material but not sufficient to melt the reinforcing mate-

rial. Thus, the use of relatively high melting thermoplastic materials are contemplated as reinforcing fibers of the present invention, although such materials are referred to as "non-thermoplastic" throughout the specification and claims solely for the sake of brevity.

The reinforcing fibers useful herein are metallic or ceramic, amorphous, polycrystalline or single-crystal reinforcing fibers or filaments. Common examples are carbon, glass, boron and boron nitride, ceramic fibers, such as silicon carbide, silicon nitride and alumina, aramides, ordered polymers, etc.

The use of carbon fibers as reinforcing fibers are specifically described and claimed in co-pending application Ser. Nos. 589817, 589823, 589825, 589928, and 589929, all filed contemporaneously herewith.

The glass fibers utilized are manufactured and marketed commercially. The fibers are drawn from a molten supply of glass contained in a platinum container having a large plurality of very fine holes in the bottom thereof from which the molten glass is drawn at high rates of speed which attenuate the glass into extremely fine diameter. The glass filaments are pretreated as drawn from the platinum container, usually called a "bushing" with a size serving to enhance the compatibility of the ultimate glass yarn with the thermoplastic fiber which is utilized.

The glass fibers contemplated are continuous glass fibers in the form of unstranded filaments, stranded glass filaments, untwisted bundles of stranded glass filaments including twistless roving all hereinafter referred to as glass fibers.

Size compositions are contemplated herein and those preferred for use in the practice of the present invention are those conventionally used in the treatment of glass fibers. Such size compositions contain, as the essential component, a glass fiber anchoring agent such as an organo silicon compound or a Werner complex compound.

Preferred anchoring agents are the amino silanes, such as gamma-aminopropyltriethoxy silane, N-(beta-aminoethyl)gamma-aminopropyltriethoxy silane, etc. However, use can also be made of any of the organo silanes as well as the corresponding silanols and polysiloxanes. Representative of other suitable anchoring agents which can be used in the practice of this invention are the organo silicons, their hydrolysis products and polymerization products (polysiloxane).

Instead of organo silicon as described above, use can also be made of Werner complex compounds containing a carboxylato group coordinated with the trivalent nuclear chromic atoms, and in which the carboxylato group may also contain an amino group or an epoxy group. Suitable Werner complex compounds include stearato chromic chloride, methacrylato chromic chloride, aminopropylato chromic chloride, glycine chromic complex or glyclato chromic chloride.

Ceramic fibers contemplated for use herein include silicon carbide (composed of ultrafine beta-SiC crystals), silicon nitride ( $\text{Si}_3\text{N}_4$ ) and alumina ( $\text{Al}_2\text{O}_3$ ) fibers.

Any silicon carbide fiber system with the requisite strength can be used, although a multi-filament silicon carbide yarn with an average filament diameter up to 50 microns is preferred and yarn with average filament diameter of 5 to 15 microns is especially preferred. If a silicon carbide monofilament is used, a typical silicon carbide monofilament of approximately 140 microns diameter is available from AVCO Systems Division, Lowell, Mass. This fiber exhibits an average tensile

strength of up to 3450 MPa, has a temperature capability of over 1300° C. and is stable in oxidizing environments.

Alumina fibers have been available for several years. They have been of particular interest for application in metal matrix composites because of their excellent strength and modulus, especially at high temperature. The two principal types of alumina fiber had been, however, the large diameter ( $>350\mu$ ) single crystal rods or alumina whiskers. The problems of handling and processing of whiskers and the very high cost of the single crystal fiber dampened the enthusiasm for their use in composites. The situation changed, however, with the advent of high quality alumina yarns which, because of their low potential cost and attractive mechanical properties, could be seriously considered for use in composites. In general, these fibers are produced by E. I. DuPont de Nemours, Inc., 3M Corporation and in the USA and Sumitomo Chemicals Co., Japan.

The DuPont fiber, referred to as fiber FP, is a round cross section, 20  $\mu\text{m}$  diameter, continuous length yarn having 210 fibers per tow. It is available in two forms. Type I is pure alpha alumina while Type II is similar but coated with a thin layer of glass. Type II was originally intended for resin matrix composites and Type I for metal matrix composites; however, it is found by this invention that both are suitable for ceramic composites. Although the initial fiber strength is not particularly high, on the order of 1380 MPA (200,000 psi), it is very important to note that this strength is stable and not affected by handling and is not much different from that realized in composites reinforced with alumina rods of initially higher unhandled "pristine" strength.

The Sumitomo Chemicals fiber are also produced in yarn form; however, there the similarity with fiber FP ends. This fiber is not pure alumina and in fact, it is the presence of some  $\text{SiO}_2$  and a very fine structure which permit a claimed use temperature to be 1350° C.

On the basis of specific mechanical properties this fiber is attractive. Its low density and high tensile strength provide a specific strength nearly twice that of fiber FP while the specific modulus approximately equals the FP property. The Sumitomo fiber appears to have superior handleability.

The known properties of boron nitride, properties such as exceptionally high heat resistance (1800° F. in oxidizing 5000° F. in reducing atmospheres), dielectric strength (950 v./mil), high surface and volume resistivity and low dissipation factor over a wide temperature range, make it a potentially attractive high temperature reinforcing fiber candidate. The fibers may vary in diameter, although those preferred are about 10 microns in diameter and fibers having diameters up to about 30 microns may be used. Continuous boron nitride fibers (99+ % boron nitride) are available commercially from the Carborundum Corporation.

The fibers also should exhibit a tensile strength of at least about 100,000 psi and a tensile modulus of about 10-120  $\times 10^6$  psi.

The thermoplastic fibers which are particularly useful herein have bundle cross-sectional areas ranging from about twice that of the reinforcing fiber tows to about one-half that of the reinforcing fiber tow. Bundle or tow denier will be in the range of 1 to 50 and the fiber count will depend upon single filament denier (higher counts are required with lower denier filaments). However, in general, from about 10 to about 150,000 filaments, preferably 100 to 10,000 filaments, are employed.



The modulus of the fiber should be in the range of 50,000 to 500,000 psi. The thermoplastic fiber also must exhibit a melting point of more than 50° F., preferably more than 200° F., above ambient temperatures. And of course, the fiber must melt and fuse at temperatures no higher than about 1,000° F., preferably no higher than 800° F., in order to be useful herein.

The weight ratio of the two fibers which are intermixed can vary widely. However, in order to prepare satisfactory composites, it is necessary that sufficient thermoplastic polymer fiber be employed to obtain complete wetting of the reinforcing fibers. Generally, no less than about 30 percent, by volume, of the thermoplastic polymer fibers may be employed. The maximum amount of thermoplastic polymer depends upon the strength properties which are required. In general, when less than about ten percent, by volume of the reinforcing fiber is present, the resulting composite products have strength and stiffness properties which are poor in relation to products containing higher amounts of reinforcing fibers and exhibit little or no improvement over unreinforced matrices. Preferably about 20 to about 60 percent, by volume of the reinforcing fiber material should be present in the combined tow.

In addition to the reinforcing fiber and the thermoplastic fibers which are used herein, it is contemplated to add carbon fibers to the fiber blends of the instant invention as reinforcing fibers. In the event additional carbon fibers are added, it is possible to reduce the amount of the reinforcing fiber which is used to as low as approximately 10 volume percent. However, the maximum combined amount of the added carbon fiber plus the amount of the reinforcing fiber which is employed should not exceed the upper limit specified above for the reinforcing fiber alone.

In FIG. 1 of the instant invention, a reinforcing fiber tow (1) is obtained having the properties specified above. The fibers form the reinforcing fiber tow are passed through a fiber guide (3) and onto a first Godet roll (4). The first Godet roll is synchronized with a second Godet roll (11) at rates of speed such that the second Godet roll revolves slightly slower than the first Godet roll. Hence, the fibers between the two Godet rolls, which are subsequently spread and intermixed during the process of the invention remain in a low tensioned (approaching tension-free) state which provides for effective fiber intermixing. Individual thermoplastic polymer fibers, such as polybutylene terephthalate fibers, are mounted on a bobbin rack (2) and the fibers are fed through a fiber guide (3) onto the first Godet roll (4). A tension comb may be employed after the fibers leave the bobbin and before they are brought into contact with the Godet roll. This tension comb serves to improve the contact of the fiber with the Godet roll and to increase the width of

At this point in the process neither the reinforcing fibers nor the thermoplastic fibers are intermixed or are in contact. Rather, both are wrapped separately around the first Godet roll (4) to provide tension control. After leaving the Godet roll, the individual fibers separately pass through a fiber guide (5) to maintain directional control. After leaving the fiber guide (5), the thermoplastic polymer fibers pass through a fiber comb (6). The fiber comb having a plurality of spaced-apart fingers acts to maintain as separate the various fine yarns of the thermoplastic polymeric fiber so as to preserve separation of the individual fibers. The reinforcement

fibers, on the other hand, after leaving the fiber guide (5), are directed into a gas banding jet (7).

The gas banding jet showing in FIGS. 3 and 4 is used to uniformly spread the fiber tows. A gas "banding" jet can also be used as an intermixing means whereby the gas jet serves to uniformly intermix the two fiber tows. The banding jet consists of a gas box (40) into which compressed air or another gas is fed through a conventional adjustable gas metering means (41). The preferred pressure of gas flow into the gas jet is in the range of approximately 0.5 to 10 psi. One, or more than one, gas exit ports (44) are provided to cause gas from within the gas box to impinge in a generally perpendicular fashion upon the fiber tow which passes across the exit ports. Preferably, the exit ports are V-shaped and pointed in the direction of movement of the fiber tow across the box.

As shown in FIG. 4, the gas banding jet is provided with shims (46) or other means to allow a gas box cover (48) to be attached, so that a flow channel for the fibers is provided. The gas box cover is held in place by convenient attachment means, such as clamps (49).

In an alternative process shown in FIG. 2 both the thermoplastic fiber and the reinforcing fiber are subject to gas banding jet treatment (26) and (27). However, particularly with lower molecule weight, less high melting polymers, such as polybutylene terephthalate, a fiber comb having a plurality of spaced-apart fingers, as described above, may be employed in place of the banding jet.

After the fibers are spread by banding jets or banding jets in combination with combs, they are intermixed using an intermixing means (8). In FIG. 1 the intermixing means is a pair of stationary rods or bars. The fibers from the spread reinforcement fiber tow and the fibers from the spread thermoplastic tow or yarns both initially come into contact together on the bottom of the first stationary rod or bar. The fibers then are deflected across the top of the second stationary bar or rod and, as a result, are intermixed. In order to ensure complete intermixing, it is necessary that both fibers be uniformly spread across their entire width and that the area within which both fibers are spread be virtually identical. Finally, it is necessary that intermixing be undertaken in a relatively tension-free state. If high tension is imparted to either of the fiber tows, full (or optimal) intermixing may not occur. After passing over and under the stationary bars, the combined fiber tow may be further intermixed using an air entanglement jet as described above.

After intermixing, the fibers pass through a comb (9) to maintain dimensional stability and through twist guides (10) to impart a slight twist to the intermixed fibers. The twist is imparted in order to maintain the intermixing of the fibers. Instead of using an actual half-twist, false-twisting of the fibers using methods well known in the art may be employed. In the alternative, a fiber wrap may be used to hold the intermixed fibers together. The overwrap may be of any convenient type of fiber. However, it is preferred that the overwrap consist of a relatively small quantity of thermoplastic fibers.

The mixed fibers are then wrapped around a second Godet roll (11) which, as pointed out above, serves in conjunction with the first Godet roll to provide a relatively tension-free zone to allow fiber intermixing. The fibers are then taken up by a take-up roll (12) for storage. Of course, it is possible to impart false-twisting or actual twisting or to wrap the fiber tow with another

fiber either before or after the Godet roll. In addition, the intermixed fibers may be made stable by application of an appropriate fiber finish which serves to hold the intermixed fibers together and enable easier handling in subsequent operations, such as weaving.

FIG. 2 is similar to FIG. 1 but is the process most preferred when a liquid crystal type polymer or other higher melting point polymer is used. In FIG. 2 a roll of reinforcing filamentary material (21) feeds fiber through tension comb (22) and onto Godet roll (25). Liquid crystal fibers from a roll (23) are fed through a guide (24) and onto the same Godet roll (25). Separation is maintained between both fibers on the Godet roll. As pointed out above, the first Godet roll (25), when used in combination with the optional second Godet roll (35), serves to maintain the fibers in a relatively tension-free state during the intermixing process. High tension during intermixing must be avoided to assure that complete intermixing occurs.

After the reinforcing fibers and the liquid crystal fibers leave the first Godet roll they are both fed into gas banding jets (26) and (27) through guides (28) and (29), respectively. In the gas banding jet the fibers are spread to a uniform width. The fibers then pass through a second set of fiber guides (30) and (31) and are intermixed using stationary, longitudinally extended bars shown at (32). In general, intermixing occurs as the thermoplastic bundle is fed onto the same bar in the same areas as is the reinforcement fiber. At this point in the processing, the width of both tows is the same, and as they are brought simultaneously into contact with the same area of the bar, intimate intermixing occurs. In an alternative intermixing process, the two fiber tows are fed simultaneously into a gas jet or other gaseous intermixing device in a relatively tension-free state. In addition, the fibers may be fed into a gas jet for further intermixing after they have been treated on the stationary bars. In the gas intermixing means a jet of air impinges on the fibers, preferably perpendicular to their direction of flow.

Following intermixing, the fibers are fed through twist guides (33) to add at least a half-twist per yard to the fiber to ensure dimensional stability. Fibers then pass through a guide (34) onto a second Godet roll (35) and from there onto a take-up roll (36).

In use, the intermixed fibers may be filament wound, or otherwise assembled and placed on a mold, and heated under pressure to the flow temperature of the thermoplastic polymer to form composite articles which are useful in a variety of end-uses where high strength, high stiffness and low weight are essential. For example, the composites formed from products prepared according to this invention may be used in forming spacecraft, airplane or automobile structural components. In addition, the reinforced fiber blends of the instant invention find particular utility in those end-uses where complex, three-dimensional shapes are involved. As pointed out above, the compositions of the instant invention are particularly useful where there is a small radius of curvature requiring substantial bending and shaping of the compositions of the instant invention. The only limiting factor in forming reinforced fiber shaped articles using the compositions of the instant invention is the "bendability" of the reinforcing fiber itself. Therefore, utilizing the compositions of the instant invention, it is possible to prepare materials having a minimum radius of curvature of about 0.002 in., preferably as low as 0.003 in. However, with prior art

thermoplastic tapes, the minimum radius of curvature is about 0.005 in. (Even then fiber directionality or alignment is distorted.) As structural elements formed from the fiber tows of this invention are heated under pressure above the melting point of the thermoplastic fiber, these fibers melt and fuse the fibers together forming a consolidated composite product containing well-dispersed reinforcing fibers. Using the fiber blends of the instant invention, it is possible to prepare recreational articles, such as tennis racquet frames, racquetball racquet frames, hockey sticks ski poles, fishing rods, golf club shafts and the like.

The fibers of the instant invention find particular utility in filament winding applications. As pointed out above, in the prior art it was extremely difficult to prepare composite articles utilizing the prior art fiber tapes. These tapes, which are prepared on extremely large scale, are difficult to handle on a small scale, and it is particularly difficult to form them into intricately shaped articles. While the prior art employed the filament winding process with success, this process was limited to use of reinforcing fibers in combination with thermosetting resins if long, thin rods were to be prepared. In the prior art process, the reinforcing fiber was wound onto a mold after applying a thermosetting coating or coated with the thermosetting material after winding. As a result, however, it was often difficult for the thermosetting material actually to penetrate and/or achieve good wetting of closely wound products.

Utilizing the process of the instant invention in a modified filament winding procedure, it is possible to prepare intricately shaped articles when the fiber blends are oriented in directions not parallel to the long axis of the article, utilizing thermoplastic polymers in conjunction with fiber reinforcements. This modified filament winding process begins with the use of the intermixed tows of the instant invention. These tows may be fed directly to a filament winder. As the filament winder moves around or up and down the mandrel or form, the reinforcement fiber/thermoplastic fiber tow is applied directly to the mold and heated using a radiant heater or other suitable means for immediately melting and fusing the thermoplastic polymeric fibers within the reinforcing fiber tow. In other words, the reinforcing fiber/thermoplastic fiber tow should be heated under pressure as soon as or soon after it meets the mandrel. After full melting and resolidification occurs, the mandrel either may be dissolved using a suitable solvent, may be pulled from the product, or the mandrel may actually become a part of the product.

Another unique use for the fiber blends prepared according to the instant invention is in forming woven fabrics utilizing standard techniques. According to this process, the tow of the instant invention is used either alone or in combination with other tows or fibers to form a woven mat. The woven fabrics prepared according to the process of this invention may be applied to the desired mold or otherwise used in forming a composite. The previous method of choice of forming such materials involved laying down a layer of reinforcing fibers, e.g., glass fibers, followed by a layer of thermoplastic film, followed by another layer of glass, etc. Now the materials can be combined in a solid woven layer and much more readily applied to a mold. After the composite is formed, it is then heated under pressure above the flow point of the thermoplastic polymer, and a composite having good mechanical strength and stiffness properties results. The strength and stiffness enhance-

ment can occur in one or more directions, i.e., those directions along which reinforcement fiber is aligned parallel to the defining vector.

#### EXAMPLE 1

A liquid crystal polymeric (LCP) fiber tow based upon a copolymer prepared from 6-hydroxy-2-naphthoic acid and p-hydroxy benzoic acid is obtained. The LCP has a density of 1.4 g/cc, and the tow itself is formed of 660 filaments (2.25 denier per filament). The tow had an initial modulus of 5670 gms, a tenacity of 10.5 g/denier, and an elongation of 2%. The second fiber to be used for intermixing with the LCP fiber is E-glass fiber (204 filament count designated as ECG 150 1/0), having a density of 2.55 g/cc, a tensile strength of 300,000 psi, a tensile modulus of 10,500,000 psi and an ultimate elongation of 2.8%. The glass fiber is available from both PPG Industries and OCF.

Bobbins containing the LCP polymeric fiber tow and the glass fiber tow are spaced apart on a bobbin rack. Fibers from both bobbins are fed onto and separately wrapped around a Godet roll, so that upon mixing the mixed tow contains approximately 50% by volume of liquid crystal polymer and approximately 50% by volume of glass. The LCP polymeric fiber is subject to a 50 gram weight on a tensioning device prior to being wrapped around the Godet roll, in order to maintain smooth tracking on the roll. After leaving the Godet roll, both fibers are separately subjected to air jet banding treatments utilizing an air jet which impinges air approximately perpendicular to the fiber through V-shaped nozzles. The jet for the liquid crystal polymer is operated at 5 psi, while the glass fiber jet was operated at 4 psi. After leaving the banding jets, the fibers are brought together over the top and underneath of two parallel, longitudinally extended, staggered stationary bars and are fed through fiber guides into an entanglement jet, which is similar in design to the gas banding jet and operated at a gas pressure of 7 psi. Following intimate intermixing of the two tows, the fibers are taken up on a take-up roll at a take-up speed of 7-8 m/min.

The composite panels ( $3\frac{1}{2}'' \times 10''$ ) are prepared using 20 layers of the intermixed fiber tow. Each layer is prepared by first wrapping a heated drum with a Kapton film and then filament winding parallel rows of the fiber blend prepared above onto the Kapton wrapped drum. A layer of Kapton film is then placed over the drum, and the entire wrapped drum is heated so as to temporarily fuse the fibers together. The composite containing the 20 fused layers is placed in a pressure mold, heated to about 315° C. and held at this temperature for five minutes without application of significant mold pressure. The mold pressure is then increased to 500 psi and held at about 315° temperature and under such increased pressure for thirty minutes. The material is then cooled at 70° C. and removed from the mold. The resulting material contains about 50% by volume of E-glass fiber and has a panel thickness of about 0.103".

Utilizing the same process, a six-ply  $3\frac{1}{2}'' \times 10''$  composite panel is prepared having a glass fiber volume of about 60%, a panel thickness of about 0.035". The composites are evaluated and exhibit excellent tensile, flexural and compression properties.

#### EXAMPLE 2

Utilizing the same glass fiber as described in Example 1, an approximate 50% by volume polybutylene tere-

phthalate (PBT)/glass fiber blend is prepared. The polybutylene terephthalate material has a density of 1.34 g/cc and a denier of 1520 g/9000 m. The polybutylene terephthalate has a draw ratio of 2.25-1, an initial modulus of 24 g, a tenacity of 5.3 g/denier, an elongation of 28%, a melting point of 227° C. and a denier per filament of 2.7. Ten packages of 33 filament count yarn are employed on a creel, and all packages are merged into a single polybutylene terephthalate fiber tow on a Godet roll. Maintained separately, but on the same Godet roll, ten packages of 408 filament count glass fiber (Tyep ECK 75 2/1) to provide a total approximate blend of 50/50 by volume glass fiber/PBT.

The polybutylene terephthalate tow is fed through a fiber comb having approximately 30 teeth, while the glass fiber tow is fed through a gas banding jet operating as described in Example 1, at a pressure of about  $2\frac{1}{2}$  to  $3\frac{1}{2}$  psi. The two tows are then intermixed over and under parallel extending rods by feeding both tows into the same area on the bars. Intermixing is aided by the use of a second gas banding jet of the type described in Example 1, operating at  $2\frac{1}{2}$  to  $3\frac{1}{2}$  psi. After leaving the banding jet, the fibers are fed through a second fiber comb which was arranged parallel to the direction of flow of the fiber, so as to provide a tensioning path to aid in intermixing. After leaving the comb, the fibers are fed through twist guides to provide approximately a one-half twist per yard, so as to maintain the fibers in their intermixed state. The fibers are then wrapped around a second Godet roll and taken up at a speed of 7-8 m/min. In order to minimize tension during the intermixing process, the second Godet roll is operated at a slightly lower speed than the first Godet roll.

$3\frac{1}{2}'' \times 10''$  panel composites are prepared generally as described in Example 1 and evaluated satisfactorily.

A sample of the PBT/glass fiber blend prepared above is wrapped with 90 denier polybutylene terephthalate yarn as described above at four wraps per in. to form a compact yarn suitable for fabric weaving. The PBT fabric wrap is chosen, so that it would form a part of the matrix upon composite fabrication. The resulting wrapped yarn is then divided into 96 different yarn segments and placed on spools mounted on a special creel. A 6" wide fabric is then woven on a modified Draper XD loom, using a plain weave pattern. The resulting woven product has dimensions of 16 ends per inch  $\times$  15 picks per inch and weighs ca. 0.05 oz./yd<sup>2</sup>. The fabric is ca. 10 mils in thickness, is soft but compact, and exhibits good dimensional stability. Satisfactory fiber composites having irregular shapes are prepared from the resulting fabric.

#### EXAMPLE 3

An approximate 50/50% by volume blend is prepared based upon the glass fiber described in Example 1 and a polyether ether ketone (PEEK) thermoplastic polymer. The fiber prepared from the PEEK has a density of 1.3 g/cc, a melting point of 338° C., an initial modulus of 53 grams, a tenacity of 2.7 g/denier, an elongation of 65%, and in 10 filaments per package tows a dpf of 367 (g/9000 m). Four (10 filaments per package) tows are placed on a creel and the fibers are blended together on a Godet roll, but maintained separately from the glass fiber which is also wrapped around the Godet roll. The PEEK fiber is then directed through a fiber comb as described in Example 2 and into a gas banding jet. The glass fiber after leaving the Godet roll also enters a gas banding jet. Both jets are operating

at a pressure of about 3 psi. After leaving the jets the fibers are intermixed above and below two parallel, longitudinally extended rods and are fed through a second parallel fiber comb, twisted to maintain dimensional stability, fed over a second Godet roll and taken up at a speed of 7-10 m/min. A satisfactory composition results.

What is claimed is:

1. A process for preparing a composite article which comprises:

- (a) forming a continuous tow of continuous non-thermoplastic reinforcing fibers;
- (b) forming a continuous tow of continuous thermoplastic polymer fibers having a melting point of at least about 50° C.;
- (c) uniformly and continuously spreading the thermoplastic polymer fiber tow to a selected width;
- (d) uniformly and continuously spreading the non-thermoplastic reinforcing fiber tow to a width that is essentially the same as the selected width for the thermoplastic polymer fiber tow;
- (e) intimately, uniformly and continuously intermixing the spread non-thermoplastic reinforcing fiber tow and the spread thermoplastic polymer fiber tow in a relatively tension-free state by employing a gas intermixing means which directs a generally perpendicular gas flow onto the fibers and by bringing the tows into simultaneous contact with each other in substantially the same area such that there is provided a substantially uniform distribution of the thermoplastic fibers and the non-thermoplastic reinforcing fibers within an intimately intermixed tow;
- (f) continuously withdrawing the intimately intermixed tow;
- (g) applying the intimately intermixed tow to a mold; and
- (h) heating the intermixed tow to a temperature above the melting point of the thermoplastic fibers.

2. A process for preparing a composite article which comprises:

- (a) forming a continuous tow of continuous non-thermoplastic reinforcing fibers;
- (b) forming a continuous tow of continuous thermoplastic polymer fibers having a melting point of at least about 50° C.;
- (c) uniformly and continuously spreading the thermoplastic polymer fiber tow to a selected width;
- (d) uniformly and continuously spreading the non-thermoplastic reinforcing fiber tow to a width that is essentially the same as the selected width for the thermoplastic polymer fiber tow;
- (e) intimately, uniformly and continuously intermixing the spread non-thermoplastic reinforcing fiber tow and the spread thermoplastic polymer fiber tow in a relatively tension-free state by employing a gas box which directs a generally perpendicular gas flow onto the fibers and by bringing the tows into simultaneous contact with each other in substantially the same area such that there is provided a substantially uniform distribution of the thermo-

plastic fibers and the non-thermoplastic reinforcing fibers within an intimately intermixed tow;

- (f) continuously withdrawing the intimately intermixed tow;
  - (g) applying the intimately intermixed tow to a mold; and
  - (h) heating the intermixed tow to a temperature above the melting point of the thermoplastic fibers.
3. The process of claims 1 or 2 wherein the reinforcing fibers are formed from the group consisting of metallic, ceramic, amorphous, and polycrystalline fibers.
4. The process of claim 3 wherein the reinforcing fibers are formed from glass, boron or ceramic fibers.
5. The process of claims 1 or 2 wherein the tow of reinforcing fibers has a bundle denier of about 100 to 100,000.
6. The process of claims 1 or 2 wherein the tow of reinforcing fibers has a bundle denier of about 1,000 to 16,000.
7. The process of claims 1 or 2 wherein the tow of reinforcing fibers contains about 100 to 300,000 filaments.
8. The process of claims 1 or 2 wherein the two of reinforcing fibers contains about 3,000 to 24,000 filaments.
9. The process of claims 1 or 2 wherein the thermoplastic polymer fibers are selected from the group consisting of polyethylene, polypropylene, polyesters, nylons, polyamidimides, polyetherimides, polysulfones, polyether ether ketones and wholly aromatic polyester resins.
10. The process of claims 1 or 2 wherein the thermoplastic polymer fibers are liquid crystal polymer fibers.
11. The process of claims 1 or 2 wherein the thermoplastic polymer fibers are wholly aromatic polyester fibers.
12. The process of claims 1 or 2 wherein the denier of the individual thermoplastic fibers is in the range of about 1 to about 50 and wherein the tow of thermoplastic fibers contains from about 10 to about 150,000 filaments.
13. The process of claims 1 or 2 wherein the intimately intermixed tow contains about 10 to about 70 percent by volume of non-thermoplastic reinforcing fibers.
14. The process of claim 13 wherein the intimately intermixed tow contains about 20 to about 60 percent by volume of non-thermoplastic reinforcing fibers.
15. The process of claim 14 wherein the intermixed tow contains about 60 percent by volume of non-thermoplastic reinforcing fibers.
16. The process of claims 1 or 2 wherein the intimately intermixed tow is continuously applied to a mold employing a filament winding process.
17. The process of claims 1 or 2 wherein the intimately intermixed tow is applied to a mold in the form of a woven fabric.
18. The process of claims 1 or 2 wherein the composite article is a recreational article.
19. The process of claim 18 wherein the composite article is a tennis racquet frame.

\* \* \* \* \*

UNITED STATES PATENT AND TRADEMARK OFFICE  
CERTIFICATE OF CORRECTION

PATENT NO. : 4,799,985

Page 1 of 2

DATED : January 24, 1989

INVENTOR(S) : Paul E. McMahon, Tai-Shung Chung and Lincoln Ying

It is certified that error appears in the above—identified patent and that said Letters Patent is hereby corrected as shown below:

On the cover page, in the Inventors, after "Summit" delete ", both" and insert --; Lincoln Ying, Bridgewater, all--

On the cover page, in the Assignee, delete "Hoechst Celanese Corporation, Somerville, N.J." and insert --BASF Structural Materials, Inc., Charlotte, N.C.--

Column 2, line 39, delete "nold" and insert --mold--

Column 10, line 57, before the word "The" insert --The reinforcing fibers which are particularly useful herein have bundle or tow deniers in the range of from 100 to 100,000 and filament counts of from 100 to 300,000, preferably deniers of 1,000 to 16,000 and filament counts of 3,000 to 24,000 .--

Column 10, line 63, delete "Bundle"

Column 10, line 64, delete "or tow" and insert --The-- before the word "denier" and --of individual thermoplastic fibers-- before the word "will"

UNITED STATES PATENT AND TRADEMARK OFFICE  
**CERTIFICATE OF CORRECTION**

**PATENT NO.** : 4,799,985

Page 2 of 2

**DATED** : January 24, 1989

**INVENTOR(S)** : Paul E. McMahon, Tai-Shung and Lincoln Ying

It is certified that error appears in the above-identified patent and that said Letters Patent is hereby corrected as shown below:

Column 11, line 39, delete "form" and insert --from--

Column 12, line 26, delete "molecule" and insert --molecular--

Column 14, line 12, delete "gold" and insert --golf--

Column 14, line 38, delete "th" and insert --the--

Signed and Sealed this  
Nineteenth Day of November, 1991

*Attest:*

HARRY F. MANBECK, JR.

*Attesting Officer*

*Commissioner of Patents and Trademarks*