International Journal of Environmental Sciences
ISSN: 2229-7359
Vol. 11 No. 23s, 2025
https://www.theaspd.com/ijes.php

Polymers In Surface Coating

Abeer J. Sahib[1], Thaer S. Hussein[2], Marwah k.Saleh [3], Abdulameer K. Farhood[4]
[1]Collage of Health and Medical Technology, Al-Zahraa University for Women, kerbala, 56001, Iraq.
abeer.jasim.sahib@alzahraa.edu.iq
[2]Department of pharmacy, Al amal College for Specialized Medical Sciences, Karbala, 56001, Iraq.
thaer.Shafi@alamal.edu.iq
[3]Department of pharmacy, Al amal College for Specialized Medical Sciences, Karbala, 56001, Iraq.
marwakadhim@alamal.edu.iq
[4]Department of pharmacy, Al Amal College For Specialized Medical sciences, karbala, Iraq.
abdulamir.kazem@alamal.edu.iq

Abstract
A new process was developed for synthesis of alkyd resins in which a conventional monoglyceride is reacted with a carboxy-functional acrylic copolymer. The novel products are called acrylated alkyd resins. The carboxy-functional acrylic copolymers were synthesized by solution-free radical polymerization. Three of acrylic copolymers were prepared from various combinations of acrylic monomers and reacted with a monoglyceride prepared from castor oil. The results revealed that acid functional acrylic copolymers containing phthalic acid and maleic anhydride as a functional co-monomer can successfully be used to modify alkyd resins yielding acrylated resins with better drying, solubility and chemical resistance properties. However there exist optimum levels for modification of alkyds with such copolymers beyond which certain film properties are adversely affected. The results revealed that acid functional acrylic copolymers containing phthalic acid and maleic anhydride as a functional co-monomer can successfully be used to modify alkyd resins yielding acrylated resins with better drying, and chemical resistance properties. Thermal analysis of Acrylated alkyd resins by Thermo Gravimetric Analysis (TGA) and thermal differential calorimeter (DSC) techniques. Reveals that these aromatic Acrylated alkyd resins possess thermal stability. Acrylated alkyd resins were characterized by (FTIR and ^{1}HNMR) spectroscopies. However there exist optimum levels for modification of alkyds with such copolymers beyond which certain film properties are adversely affected.
Key Words: *Acrylated alkyd resin, Castor oil, Binder, Surface coating, Copolymerization*

INTRODUCTION

The polyol polyester with a high number of OH groups present in the periphery of the molecule [1–4], can be modified in order to obtain materials with specific applications. Hyper branched alkyd resins are polyol polyesters modified with fatty acids [5]. The hyper branched alkyd resins are a good alternative for obtaining environmentally friendly coatings since they can be synthesized with high solid content and low viscosity due to its high packing structure. Furthermore they exhibit several advantages; such as lower time for chemical drying, and higher gloss and chemical resistance than conventional alkyd resins (linear structure) .Despite the fact that hyper branched alkyd resins can be obtained with less volatile organic compounds content (VOCs) than conventional alkyd resins, they still continue producing VOCs, which are toxic and responsible for global warming and photochemical ozone creation [6]. Therefore it is necessary to develop water-borne hyper branched alkyd resins with good properties for the coating industry.

Alkyd resins are used extensively as binder for making paints. Such paints are usually exposed to UV-radiation, thermal fluctuations, high humidity and especially when applied on superstructure of ships, the paint is also in addition to the above exposed to wind driven salt spray. Under these conditions, the paint shows considerable chalking, color fading and loss of gloss within six months under the tropical conditions. A good remedy to enhancing the durability of such paints is to improve its weather resistance through chemical modifications of alkyd resins with acrylic resins [7].

Alternative methods to produce more environmentally friendly resins (water borne) consist in modifying hyper branched alkyd resins with polar groups to interact with water. Studies of the copolymerization of maleic anhydride with acrylic monomers for increasing the hydrophilicity of conventional alkyd resins have been done [5-7]; grafting of maleic anhydride in polymers for obtaining specific interactions between polymers has also been done [6,7].Modification of alkyd resins by acrylic monomers offers the possibility of combining the desirable application and film forming properties of the alkyd with the weathering and general resistance properties of acrylic systems.

The modification of alkyd resins by acrylating has been extremely investigated and for a nondrying oil alkyds, Solomon suggested their acrylating by either condensation of a preformed addition copolymer with an alkyd or reaction between an acid containing acrylic copolymer and a monoglyceride followed by the addition of polyol and dibasic acid and then further condensation to the desired acid value and viscosity. For convenience the former method is called post acrylating and the latter monoglyceride method [7]. Reported that difficulties due to alkyd gelation were encountered in attempts to prepare methacrylated alkyds by the reaction between an alkyd and a preformed acid containing polymer.

In view of the above, this work aims at investigating the synthesis of acrylated *Castor* oil alkyd via a monoglyceride method. The alkyd would then be characterized and evaluated in comparison to the non-acrylated resin.

MATERIALS AND INSTRUMENTS

Materials

Castor oil, pentaerythritol, glycerol, Methanol, Acetone, Toluene benzene and Carbon tetrachloride from (BDH- Chemicals Limited Poole/ England) Phthalic anhydride , Lead oxide, Lead oxide , Xylene ,Tetra hydro furan(THF),propylene glycol ,Malic anhydride and Dimethyl Sulfoxide(DMSO) from (MERCK – Schumann /Germany). Phenolphthalein, Carbon tetrachloride, ethanol ether (Scarab S.L./Spain).Hydrochloric acid , Sodium chloride, Potassium hydroxide, Potassium Iodide, Sodium thiosulfate and Acrylic acid from (HIMEDIA Hi Media/India). Sulfuric acid from (SD fine-CHEM Limited / India). Di methyl form amide from (Scarab S.L./Spain). Hydroxide (Water purification company Baghdad).

Instruments:

(FTIR Spectrophotometer)Infrared spectra were recorded in the Department of Chemistry at College of Engineering at the University of Al-Qadisiyah with a device from (Shimadzu) of the type (8400).The Balance A sensitive balance with four levels after zero of Sartorius / BL2105Germany was used. Thermogravimetric analysis (TGA) Measurement was done using Polymer laboratories co. England, Model PT-1000 in the central laboratory / College of Pure Sciences - University of Tehran, with a heating rate of 10 m / min under a helium cover, and a temperature of (25-300) nuclear magnetic resonance spectrum (^{1}H-NMR) It was recorded using a Bruker, Ultra Shield 500 MHz spectrometer (Swiss origin) using (DMSO-d6) as a solvent. And at the University of (Education Education) Tehran - Iran. Differential calorimetric thermal analysis (DSC) The measurement was made using a differential thermal analysis device (DSC) type (DSC 131 Eva, SETARAM) of (France) origin and at the University of Tehran / College of Pure Sciences / Department of Chemistry. Oven drying oven type Hot Air Sterilizer Laboratory Oven / M6040P / Germany was used. The Headmen: A thermal heater was used for heating with a temperature of more than 250 °o. of the type Jenkins / HV65 / England. The Viscometer: A viscometer was used to measure the viscosity of alkyd resin samples prepared in the Department of Chemistry / College of Education / University of Al-Qadisiyah / by a device from (Brookfield) company of type (RVDV- II + P 8500) with a voltage (230 V ˜) and a frequency (50/60 Hz).) and with a power of (30 VA). The device was manufactured in (U.S.A).

Preparation of alkyd resin from castor oil:

Several alkyds resins were prepared by using dehydrated Castor oil in presence of glycerol, Pentaerythritol, and propylene glycol with phthalic anhydride, and maleic anhydride using lead (ii) oxide as catalyst using the formulations. The reactions were carried out in a three necked round bottom flask titled with a motorized stirrer, a dean-stark trap titled with water-cooled condenser and nitrogen in let tube at a temperature of 230-2500C. Xylene was also employed as the zeotropic solvent. Two stages were involved State 1 (Alcoholics): At this stage, the measured quantity of dehydrated palm kernel oil was poured into the flask and heated to about 120^0C to remove moisture. The heating was achieved with a heating mantle. Thereafter, the measured quantity of glycerol was added and the temperature was raised to 230°C. After 30 minutes, a small quantity of the aliquot was taken to check for its solubility in methanol. The reaction mixtures was cooled to about 140°C. In Stage 2 (Esterification process): At this stage, the measured quantity of phthalic anhydride, maleic anhydride and xylene was added into the flask and heated with a heating mantle. The temperature was gradually raised to about 2300C and maintained at a range of about 230-250^0C for about 3hours. Aliquots were withdrawn from the reaction mixture at time intervals of 30minutes to check for drop in acid value. The reaction was then discontinued as soon as the acid value of the mixture attained the value of about 10mg K0H/g.

Table (1). Recipe of the preparation of resins

Raw materials	Weight (g)	Weight (%)
castor oil	25	12.047
Phthalic anhydride	12.5	6.023
Maleic anhydride	12.5	6.023
Alcohol	50	4.911
Catalyst (Bo)	0.5	0.25
Total	100.5	29.254

Preparation of acrylate alkyd resin from castor oil:

The flask was charged with alkyd resin (10 gm)and acrylic acid(4gm) in the presence of an initiator benzoyl peroxide (0.605 gm) .The mixture was stirred and heated, under reflux at 120°C for 3hrs in the presence of nitrogen

Table (2). Recipe of the preparation of acrylate alkyd resin

Alkyd	Acrylic acid
10 (gm)	4 (gm)

Chemical properties of alkyd resin

Acid number

Acid value was determined according AOAC method and to standard 969.17 1997

Iodine number

Deliver (0.1) g sample to (300) ml conical flask with ground in stopper. Add 20 ml carbon tetrachloride and seal. Dissolve Sample in an ultrasonic washing machine, then add 25 ml Hans solution, and seal. Shake for one minute, then keep it sealed and leave in a dark room (about 20 "C) for 30 minutes. Then add (10) ml of 15% potassium iodide and 100 ml water, and seal. Shake for (30) seconds, then titrate with (0.1)mole / L sodium thiosulfate to obtain iodine value then also perform blank test to obtain blank level.

Saponification Number

Weight (I gm) of sample into an Erlenmeyer flask, in pipette 25 ml of 0.5N KOH put in the flask, then add 4 ml of the solvent (ethanol-ether) to the flask, then reflux for (30) minutes, rinse the inside of the condensers with about (25) ml DI water allow the solvent to drain into the Erlenmeyer Mask, and allow the solution to cool to room temperature, then add three to five drops of phenolphthalein indicator to the solution with moderate agitation, then add (0.5) HCI (titrant) to the burette, and

not level, then add titrant from the burette to the solution until the faint pink color permanently (for at least thirty seconds) disappears, and not level of titrant in the burette.

Physical properties of alkyd resin

Density

The density was determined according to NF EN 1097-6 using analytical scale and pycnometer S9611826 (100 ccs).

Drying

Aluminum plates were cleaned by ethanol to make sure that there are no contaminants present to affect the result. A land coater with different fixed thickness was used to evenly coat the resin on the surface of the testing plates.

Viscosity

Brookfield rotary Viscometer Ku-2 model RVDV-II P8500 was used to measure the viscosity at 25 °C; and using different spindle and speed.

Volatility

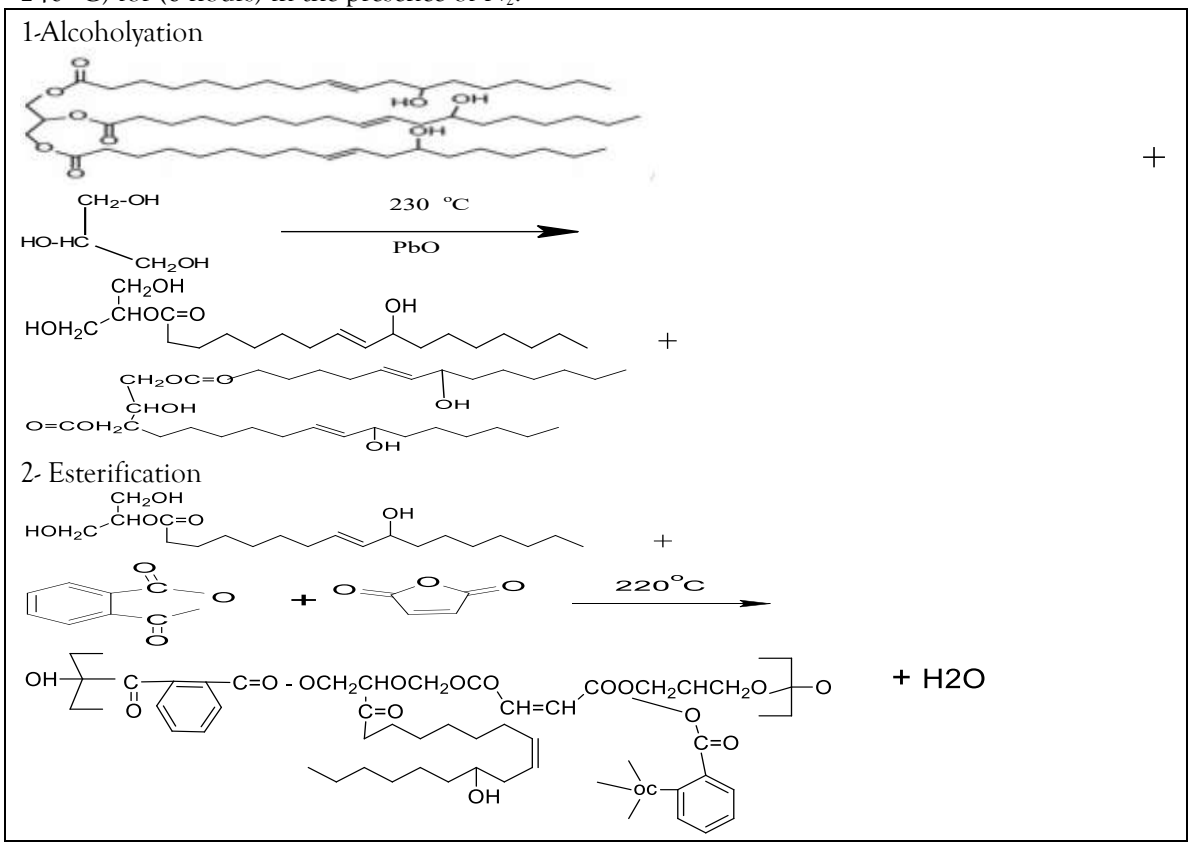
Three specimens were placed in the oven within (30) min after preparation of alkyd resin in previously weighed watch glass and heated for (2 h) at (135-140) °C. The Nonvolatile matter was calculated from the difference in initial and final weights of the watch glass. The mean value of the three results was reported as the percentage nonvolatile matter

RESULTS AND DISCUSSION

Synthesis and Characterization of alkyd resin from castor oil

Synthesis and characterization of alkyd resin from Castor oil with glycerol (C-G)

This alkyd resin was synthesized by the condensation of castor oil with propylene glycol and phthalic anhydride and malic anhydride in the presence of lead oxide as catalyst at temperature (120-240 °C) for (6 hours) in the presence of N_2.



Scheme (1) Synthesis of alkyd resin castor with glycerol

International Journal of Environmental Sciences
ISSN: 2229-7359
Vol. 11 No. 23s, 2025
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FTIR spectrum of alkyd resin from Castor oil with glycerol (C-G)

The FTIR spectrum of (CG) which indicatesThe appearance of absorption band at (3550 cm for (OH) of Carboxylic acid. While the emergence of two distinct bands at the two frequencies (2854, 2923Cm^{-1}) is due to the vibration of the stretching of the aliphatic (C-H) bond, also the appearance of the peak at the frequency (1743Cm^{-1}) is due to the vibration of the stretching of the bond (C=O) in the ester group. Also, the appearance of the peak at frequency (1465 Cm^{-1}) is due to the vibration of the aromatic bond (C=C), and the appearance of the peak at frequency (1615 Cm^{-1}) is due to the vibration of the bond stretching (C=C) of the alkene, as well as the appearance of the peak at frequency (1110 cm^{-1}) to the (C-O) straining vibration [8-9-10].

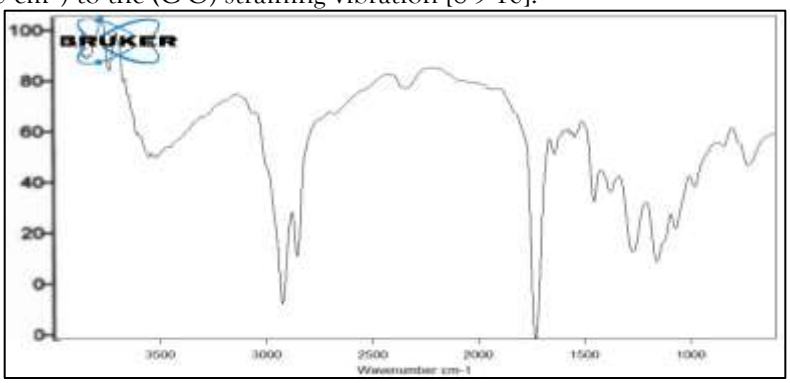


Figure (1) FTIR spectrum of alkyd resin from castor oil with glycerol

^{1}HNMR spectrum of alkyd resin from Castor oil with glycerol (C-G) ^{1}HNMR) Spectrum of (C-G) the following chemical shifts. (= 0.7 ppm) for methyl group, (= 1.2 ppm) for (CH2), (= 4.5 ppm) for (OCH_2), Multiple singles (= 8.7 ppm) for Ar-H group, (= 15 ppm) for COOH [8-9-10].

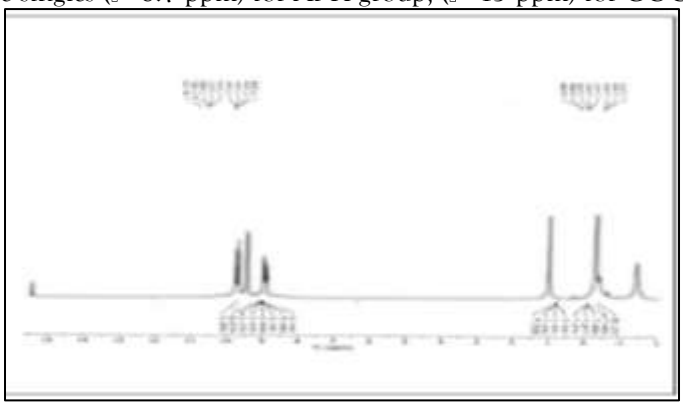
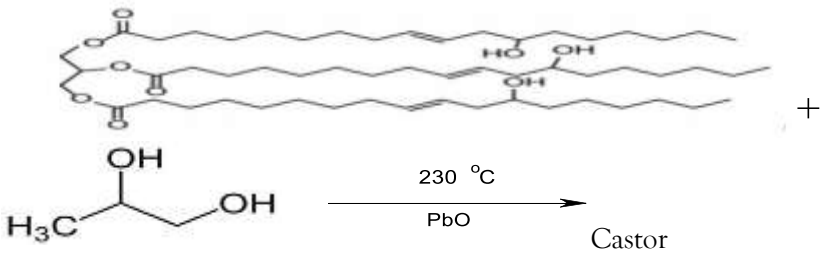


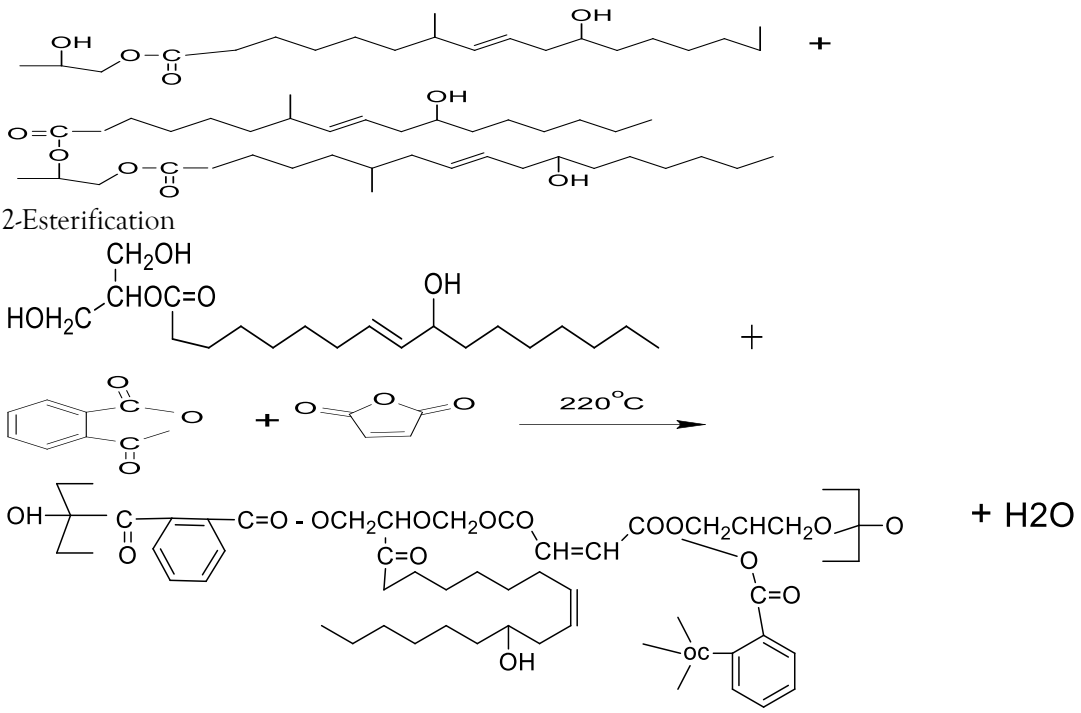
Figure (2) ^{1}HNMR spectrum of alkyd resin castor oil with glycerol

Synthesis and characterization of alkyd resin from Castor oil with propylene glycol (C-PR)

This alkyd resin was synthesized by the condensation of castor oil with propylene glycol and phthalic anhydride and malic anhydride in the presence of lead oxide as catalyst at temperature (120-240 °C) for (6 hours) in the presence of N_2.

1-Alcoholyation





Scheme (2) Synthesis of alkyd resin Castor oil with propylene glycol

FTIR spectrum of alkyd resin from Castor oil with propylene glycol (C-PR)

The FTIR spectrum of (CPR) which indicatesThe appearance of absorption band at (3550 cm for (OH) of Carboxylic acid. While the emergence of two distinct bands at the two frequencies (2854, 2923Cm^{-1}) is due to the vibration of the stretching of the aliphatic (C-H) bond, also the appearance of the peak at the frequency (1743Cm^{-1}) is due to the vibration of the stretching of the bond (C=O) in the ester group. Also, the appearance of the peak at frequency (1465 Cm^{-1}) is due to the vibration of the aromatic bond (C=C), and the appearance of the peak at frequency (1615 Cm^{-1}) is due to the vibration of the bond stretching (C=C) of the alkene, as well as the appearance of the peak at frequency (1110 cm^{-1}) to the (C-O) straining vibration [8-9-10].

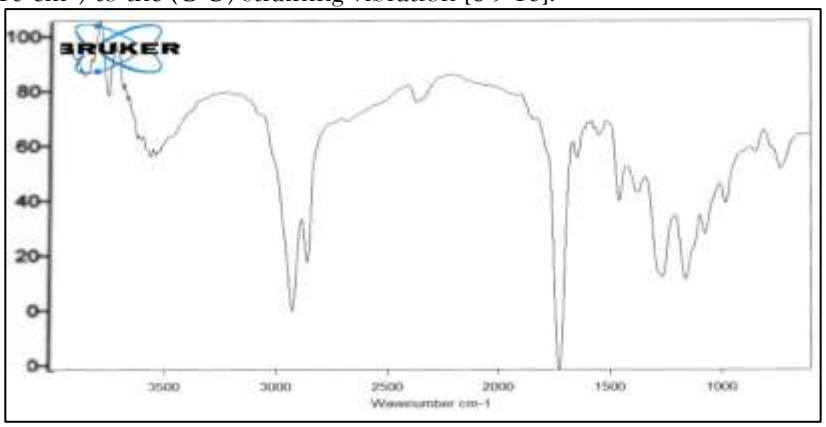
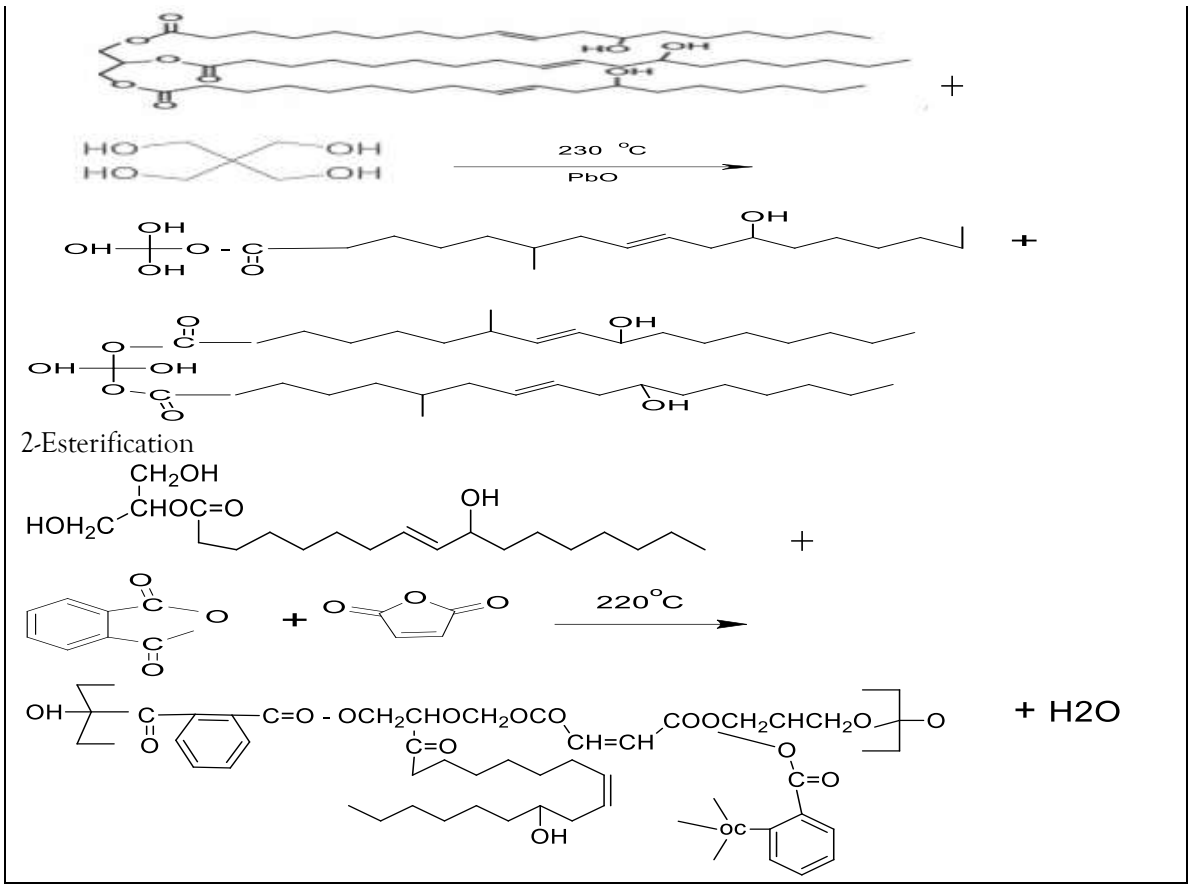


Figure (3) FTIR spectrum of alkyd resin from castor oil with propylene glycol

Synthesis and characterization of alkyd resin from Castor oil with Pentaerythritol (C-PE)

This alkyd resin was synthesized by the condensation of castor oil with Pentaerythritol and phthalic anhydride and malic anhydride in the presence of lead oxide as catalyst at temperature (120-240 °C) for (6 hours) in the presence of N_2.

1-Alcoholyation



Scheme (3) Synthesis f alkyd resin Castor oil with Pentaerythritol

FTIR spectrum of alkyd resin from Castor oil with Pentaerythritol (C-PE)

The FTIR spectrum of (CPE) which indicatesThe appearance of absorption band at (3550 cm for (OH) of Carboxylic acid. While the emergence of two distinct bands at the two frequencies (2854, 2923Cm^{-1}) is due to the vibration of the stretching of the aliphatic (C-H) bond, also the appearance of the peak at the frequency (1743Cm^{-1}) is due to the vibration of the stretching of the bond (C=O) in the ester group. Also, the appearance of the peak at frequency (1465 Cm^{-1}) is due to the vibration of the aromatic bond (C=C), and the appearance of the peak at frequency (1615 Cm^{-1}) is due to the vibration of the bond stretching (C=C) of the alkene, as well as the appearance of the peak at frequency (1110 cm^{-1}) to the (C-O) straining vibration [8-9-10].

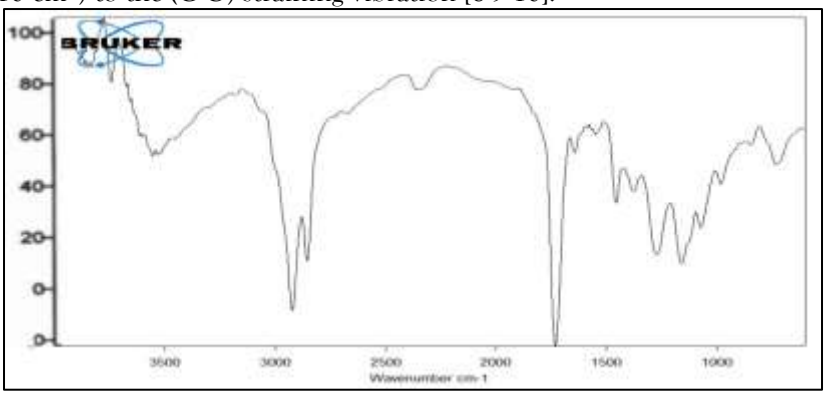


Figure (4) FTIR spectrum of alkyd resin castor oil with Pentaerythritol

^{1}HNMR spectrum of alkyd resin from Castor oil with Pentaerythritol (C-PE)

^{1}HNMR) Spectrum of (C-PE), the following chemical shifts. (= 0.7 ppm) for methyl group, (= 1.2 ppm) for (CH2), (= 3.8 ppm) for (OCH_2), Multiple singles (= 6.2-7.0 ppm) for AR-H group, singles (= 12.2-13 ppm) for COOH [8-9-10].

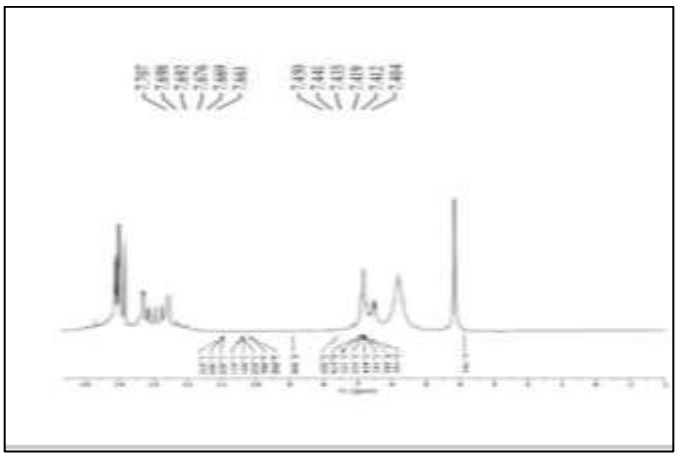


Figure (5) ^{1}HNMR spectrum of alkyd resin castor oil with Pentaerythritol

Chemical properties of alkyd resin

Acid value: It is useful to determine the acid value to find out the number of milligrams of potassium hydroxide KOH needed to neutralize one gram of the model (the prepared resin), and it is measured by the amount of carboxylic acid groups in chemical compounds such as fatty acids.

An increase in this value is an indication of the occurrence of rancidity of the fatty substance, as there is an allowable limit for the amount of free fatty acids present in the triglycerides (oil). This characteristic is important in evaluating the quality of oil seeds at the time of extraction. These seeds contain an enzyme (lipase), which decomposes under suitable conditions of humidity and temperature into triglycerides (oils). Therefore, a good storage process for these seeds is very important in preventing oil seeds from spoiling and reduces the production of fatty acids in oil seeds. When manufacturing resins Alkyd free fatty acids are rapidly inactivated in alcoholic reactions, so damaged vegetable oil is not suitable for the manufacture of alkyd resins [11].

This test was applied to all alkyd resin prepared by taking 0.2 gm of it and putting it in 5 ml of methanol and then rinsing it with potassium hydroxide solution using phenolphthalein as an index to obtain the neutral point when the color changed.

It was noted from the results shown in Table (3) that changes occurred between each resin prepared according to the type of oil used and its storage period. The acid value of the prepared resin increases with the increase in the length of the fatty acid chain of which the vegetable oil is composed. The acid value of alkyd resin from castor oil is low. Due to the short chain of fatty castor oil has (18) a carbon atom.

Table (3) shows the acid values of the prepared alkyd resins from castor oil

Alkyd resins	Acid value (mg KOH g^{-1})
C-G	9.6
C-PR	9.5
C-PE	**9.7**

Iodine number

It is the number of grams of iodine needed to saturate the double bonds present in 100 grams of fat. It is a property that can be used to measure the degree of unsaturation (double bonds) in unsaturated fatty acids (note that the iodine number of saturated fatty acids = zero). The iodine number is also used to detect adulteration of vegetable oils, as it is considered one of the constants of oils. If the iodine number is high, it means that it contains a high percentage of unsaturated fatty acids. If the iodine number is low, it indicates the saturation of the fatty acids [12].

The results were noted for the alkyd resins prepared through Table (4). Castor oil contain double bonds in their composition, and as was said previously, the iodine number measures the degree of

unsaturation (double bonds). While it is noted from the results that alkyd resins from olive showed the lowest value of iodine number because the short chain of olive oil (C18) and the presence of unsaturation in small quantities in the chain.

Table (4) shows the iodine number values for the prepared alkyd resin

Alkyd resins	Iodine number (gI_2/100 g)
C-G	123
C-PR	121
C-PE	**126**

Saponification number

It is the number of milligrams of potassium hydroxide needed to spoon (1 gram) of fat or oil. The saponification number (value) is used:

A) Know the length of the fatty acid chain in glycerides, as the value of saponification is inversely proportional to the length of the fatty acid chain (the lower the saponification value, the longer chain fatty acid and vice versa) because it has the lowest relative number of functional (effective) carboxyl groups per unit mass of fat Balancing with short chain fatty acids.

b) Estimating the approximate molecular weight of the fat (particularly mixed poly glycerides), also, and the saponification number is one of the important constants for the identification of some oils [12].The results were observed from Table (5), the saponification number is inversely proportional to the length of the fatty acid chain, as well as having relatively fewer carboxyl functional groups (active) in balance with the short chain of fatty acids, therefore the saponification value of alkyd resins from castor oil are high.

Table (5) shows the saponification values of the prepared alkyd resins

Alkyd resins	Saponification Number (mg KOH g^{-1})
C-G	223
C-PR	221
C-PE	228

Physical properties of alkyd resin

Density

The density of the prepared alkyd resins was determined according to the standard NF EN 1097-6 (using a Pycnometer according to specification S96118226). The test was applied by taking a quantity of the prepared resin and placing it in the Pycnometer and calculating the weight of the resin with the Pycnometer and then finding the difference in weight between the Pycnometer when it was filled and when it was empty according to the volume Pycnometer (25 ml).

The results were observed for the resins prepared in Table (6), the density of alkyd resins decreased with the increase in the length of the fatty acid chain and vice versa, also, due to the presence of the lowest relative number of active carboxyl groups. It is noted that the alkyd resins prepared from castor oil showed a high density than the alkyd due to the length of the fatty acid chain of which the oils are composed, which is inversely proportional to the density of alkyd resin.

Table (6) shows the density values for the prepared alkyd resins from castor oil

Alkyd resins	**Density (gm/Cm^3)**

C-G	0.88
C-PR	0.86
C-PE	0.89

Drying time

The unsaturation in the fatty acid chains is unaffected during alkyd resin manufacture and so the mechanism of film formation in such alkyds is same as that of oils. The molecular weight of alkyds is higher than that of oil so less cross-link are required to form a film resulting in rapid drying as compare to corresponding oil.

Semi-drying oils discolor less on drying than the highly conjugated drying oils. Keeping the above point in mind, resin formulator can employ semi-drying oils in alkyds to have rapid drying capability with better color. Oil lengths of 50-60% are generally used for such alkyds but it must be remembered that though higher oil length provide improved drying rates, they also adversely affect color and gloss retention as well as durability of film.

There are two types of drying: physical drying, and chemical drying. Chemically dried are alkyd resins. These resins are characterized by the fact that they dry quickly due to the fact that most of the fatty acid chains included in the composition of these oils are unsaturated, which makes them have the ability to interact with air oxygen, that is, the drying process occurs as a result of the occurrence of the oxidation and polymerization process of the alkyd resin, and the auto-oxidation mechanism is a complex process[11]. And there are more than one type of intermediates that can be formed, and the double bonds in fatty acids or vegetable oils may be conjugated or unconjugated, and the form of the double bonds has effects in drawing cross-linking [11,12], which is formed in the polymerization process, and in general, the auto-oxidation process is divided into five stages They are 1) initiation, 2) hydro peroxide formation, 3) hydro peroxide dissociation, 4) crosslinking, and 5) dissolution. It was noted through the results shown in Table (7) the difference in the drying time between each prepared alkyd resin depending on: a) the length of the fatty acid chain of which the alkyd resin is composed, so the drying time of alkyd resins prepared from castor oil is less dry due to the location of the double bonds on which the drying process (oxidation) takes place, and the number of daily carbon atoms is of particular importance because it distinguishes the centers transverse entanglement.

It also depends on the type of vegetable oil used. Among the best oils used in the production of dried resins (Castor) oil by removing water from it .The thickness of the aluminum plate on which the model is placed. If the thickness of the plate is 120 µm, it requires more time to dry. Balance with the aluminum plate, whose thickness is 30 µm. The dried used (solvent) in order to speed up the drying process because without the drier the process would be very slow but the amounts of driers should be kept to the lowest possible level because they not only stimulate drying but also stimulate the reaction after drying which causes brittleness, splitting and color change.

Table (7) shows the drying time values for the prepared resins from castor oil

Alkyd resins	**Drying Time (min.)**
C-G	25
C-PR	33
C-PE	**20**

Viscosity

The viscosity of the solution is an important method for the characterization of polymers, as it is a measure of the molecular weight of the polymer, as the viscosity of the solution is a measure of the

volume, and the polymer solutions are distinguished by a unique characteristic from the solutions of other materials by being more viscous. Among the factors affecting viscosity:
Pressure: The effect of pressure on viscosity is of little importance, but the effect of viscosity appears when the pressure exceeds (68 bar).
Temperature: When the temperature increases, the viscosity of liquids decreases; when the temperature of the liquid increases, the distances between the molecules increase, so the friction between them decreases, and then the viscosity decreases [13]. It is noted that the viscosity of alkyd resins increases during the reaction for all types of oils used in manufacturing. It is also noted that the viscosity increases slowly during the hours (3) of the reaction. After that, the viscosity increases significantly in the esterification reaction between mono glycerides and phthalic anhydride and maleic anhydride. After 5 or 6 hours the reaction ends and the alkyd resin is very viscous, i.e.: the polymeric chains are in the form of a gelatinous substance. According to this test, using a viscometer (RVDV-II + P 8500), with a voltage of (230 V˜), a frequency of (50/60), and a power of (30) VA.

It was noted through the results shown in Table (8) that the viscosity of alkyd resins differs according to the vegetable oils they are composed of. It is noted that the viscosity is high for short-chain resins prepared from castor oil , and the viscosity value decreases in long-chain fatty acid resins. due to the presence of the double bonds associated in the chains of fatty acids.

Table (8) shows the viscosity values of the prepared alkyd resin resins from castor oil

Alkyd resins	Viscosity (CP)	Temperature	Number of spindle	Speed of viscosity
C-G	1050	25	63	60
C-PR	1604	25	63	60
C-PE	**High Viscosity**	**25**	**63**	**60**

Volatility

This test was applied by taking an amount of alkyd resin samples prepared about (0.2 gm) and placing them in a dish glass and weighing them, then inserting them into the oven at a temperature of (140 ° C) for two hours, and then calculating the difference by weight before and after entering the oven. The results of the volatility value of the prepared alkyd resins were noted in Table (9), as it shows the difference in the volatility value between each prepared resin, so the alkyd resins from castor oil show the lowest volatility value due to the short chain of fatty acid consisting of castor oil. While the alkyd resins showed a high volatility value due to the long chain, which contains double bonds with the ability to interact with oxygen, so it volatilizes quickly.

Table (9) shows the volatility values of the prepared alkyd resins from castor oil

Alkyd resins	Volatile percent (%)
C-G	76
C-PR	74
C-PE	**78**

Chemical resistance

The resistance of the prepared alkyd resins to some chemicals was tested; As it was noted from the results shown in Table (10) the difference in chemical resistance between each resin As it is noted that the resins prepared from castor oil are resistant, i.e. (insoluble) in water, because the resins are a component From a series of unsaturated fatty acids, that is, they are non-polar organic compounds, and water is a polar solvent. Also, all previous resins are resistant in a Tetrahydrofuran (THF) solvent, because it is a non-polar organic solvent.

It is also noted that the resins prepared from castor oil are resistant in hydrochloric acid, sulfuric acid, sodium hydroxide and sodium chloride. While these resins are non- resistant (soluble) in the

KOH, and the reason is due to the different type of vegetable oils from which alkyd resins are made according to their nature and the extent of their resistance to solvents.

Table (10) shows the chemical resistance values of the prepared alkyd resins from castor oil

Alkyd Resin	Dist.H_2O	HCL	H_2SO_4	KOH	NaCl	THF
C + G	+	+	+	-	+	+
C + PR	+	+	+	-	+	+
C+ PE	**+**	**+**	**+**	**-**	**+**	**+**

(_) denotes non-resistant alkyd resins (melted)
(+) denotes the insoluble resistant alkyd resin

Solubility

The solubility of alkyd resins was conducted qualitatively in some common organic solvents and is summarized in Table (11). The solubility was measured by taking (0.01 g) of the prepared resin sample and dissolving it in (2 ml) of solvent. Polar aprotic solvents of these solvents (DMF, Acetone, Toluene, Xylene,) and non-polar solvents such as (Benzene, CHCl3) and other solvents such as methanol, ethanol and kerosene. (It increases the rate of reaction rate, i.e. the rate of formation of polyester. This is due to the hydrogen bonding between the oxygen atom of the carboxyl ester group (O- Carboxyl ester) and the solvent. In addition, the (acid-base) interaction between the solvent and the polyester (alkyd resin) prevents proton dissociation (24). Also among the factors affecting solubility (temperature, stirring and surface area), it is noted, also, through Table (11) that resins prepared from castor oil are dissolved in these solvents , and the solvents molecules attack the chain and dissolve these resins easily.

Table (11) shows the solubility of alkyd resins from castor oil

resin	solvent							
	Xylene	DMF	Toluene	Acetone	DMSO	Benzene	Methanol	Ethanol
C + G	+	+	+	+	+	+	+	+
C+ PR	+	+	+	+	+	+	+	+
C+ PE	+	+	+	+	+	+	+	+

+ Soluble at room temperature

Thermal Gravimetric Analysis (TGA) Study for the prepared alkyd resins from castor oil:

Thermal stability is defined as the specific temperature at which the chemical decomposition of polymers begins, accompanied by volatile products, or it is the maximum temperature to which the polymer is exposed without noticeable changes in an atmosphere of nitrogen, oxygen, or an inert gas [14]. Thermal stability is one of the most important thermal properties, through which it is possible to know the possibility of using polymers in applied fields in which the material is exposed to high temperatures. Several techniques were used to study the thermal stability of polymers, including thermal gravimetric analysis (TGA), which is one of the techniques used to evaluate and study the thermal stability and flame rear Dancy of the polymeric materials under study [15]; this is done by determining the change in weight that occurs when the sample is heated. The chemical changes that occur during the heating process from the sample's loss of weight indicate the occurrence of a process of disintegration (shattering) of the materials subject to measurement.

The weight loss caused by the disintegration of materials forms a curve (TG) and this curve provides useful data and information regarding the properties of the material being measured. The thermal behavior of the polymers prepared through this technique (TGA) has been determined, in an atmosphere of inert Nitrogen gas, with a heating rate of (10 °C per minute) and a temperature of (25-300 °C), so the (TGA) technique can serve as a useful indicator. To know the decomposition of polymeric materials, and this method is the most preferable to know the evaluation, balancing and arrangement of thermal stability of the polymers under study. Through the curves shown in the Table (12) below, it is observed that the initial weight loss process it for alkyd resins. It started slightly from (150°C) to (200°C). Then, the process of losing weight by increasing up to (600 °C), the increase in weight loss could be due to chemical reactions with gaseous substances that lead to the formation of non-volatile compounds or due to the physical transformation that occurs due to the absorption of gaseous substances by the alkyd resin [16] ; It was also noted that the temperatures when alkyd resins lost 50% of their weight (T50%) increased from 460 to 790 °C, while the percentage of the residue was at 800 °C for alkyd resins ranged between (43-55%), as the high carbonization rate of the prepared alkyd resins was at 700 °C (Char%) Ranging between (60-75%), some high rates of carbonization act as an insulating layer or as a barrier that reduces the decomposition of the lower layers of alkyd resins and thus increases thermal stability and combustion resistance. Also, the increase in aromatic compounds in the alkyd resins composition increases the charring rate, and this makes its decomposition more difficult. Also, the presence of (methylene, hydroxyl) groups in its composition increases stability [17].

Table (13): Thermal behavior data of alkyd resins

Samples	TGA (°C) T_i	T_{op1}	T_{op2}	T_f	$T_{50\%}$	Residue % at 800 Ċ	Chart % at 700 Ċ
C + G	150	440	770	800	790	55	75
C + PE	200	400	710	800	500	43	60
C + PR	150	350	505	800	460	43	62

Ti: Initial decomposition temperature.
Top: Optimum decomposition temperature.
Tf: Final decomposition temperature. The final degree of dissociation temperature
T50%: Temperature of 50% weight loss, obtained from TGA.
Char% at 700 ° C.
Residual weight percentage at **800** ° C.

Differential Scanning Calorimeter Analysis (DSC) Study for the prepared alkyd resins from castor oil:

This type of analysis expresses the amount of energy absorbed from the sample during its heating and cooling or at a constant temperature. And the degree of crystallization (Tc) [17].

figure (6) for a sample prepared from the interaction of castor oil with glycerol shows, and the results showed the glass transition value (Tg) of the mixture (100°C), indicating an increase in the temperature flow, and then the rate of heat absorption of the sample increased to The melting point (Tm) reaches (700°C) .

figure (8) for a sample prepared from the interaction of castor oil with propylene glycol shows, and the results showed the glass transition value (Tg) of the mixture (100°C), indicating an increase in the temperature flow, and then the rate of heat absorption of the sample increased to The melting point (Tm) reaches (430°C) .

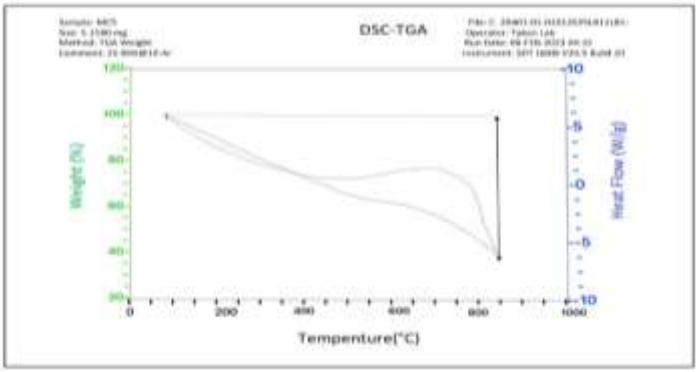
figure (7) for a sample prepared from the interaction of castor oil with Pentaerythritol shows, and the results showed the glass transition value (Tg) of the mixture (150°C), indicating an increase in

the temperature flow, and then the rate of heat absorption of the sample increased to The melting point (Tm) reaches (708°C) .

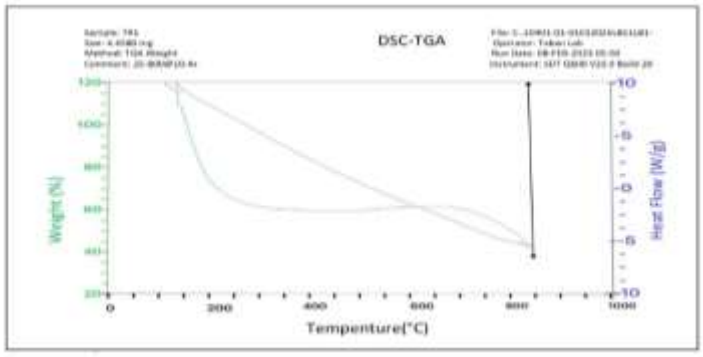
Table (14) shows the degree of glass transition, the melting point and the degree of crystallization in differential thermal analysis.

Samples	Tg (°C)	Tm (°C)
C + G	100	700
C + PE	150	708
C + PR	100	430

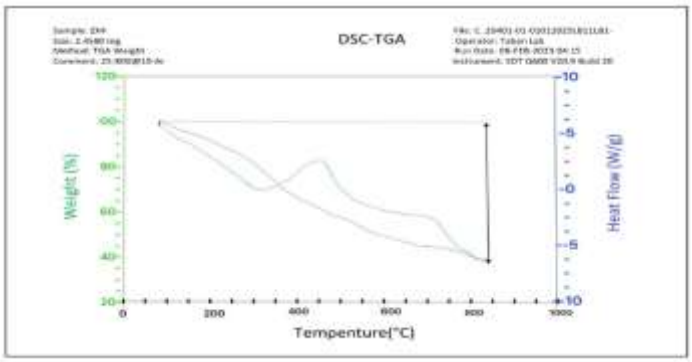
TG: Degree glass transition /Tm: Melting Point /Tc: Degree of crystallization



Figure(6) TGA and DSC curve of alkyd resin from castor oil with glycerol



Figure(7) TGA and DSC curve of alkyd resin from castor oil with Pentaerythritol

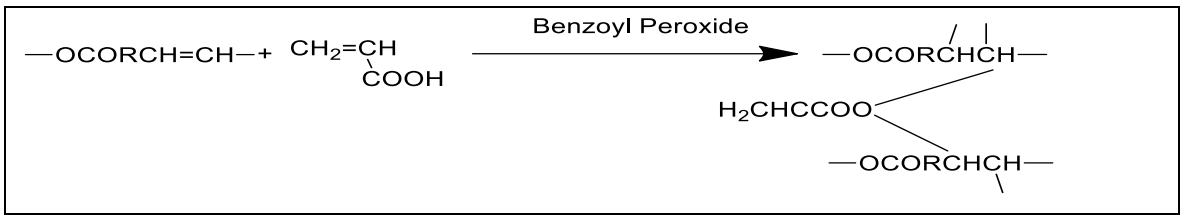


Figure(8) TGA and DSC curve of alkyd resin from castor oil with propylene glycol

Synthesis and Characterization of acrylated alkyd resin from castor oil

The acrylated alkyds were prepared by polymerization of the alkyd resin. The alkyds were withdraw into 100ml flask and heated in the presence of an initiator, benzoyl peroxide, under reflux at 120^0C for 3hrs in presence of N_2.

International Journal of Environmental Sciences
ISSN: 2229-7359
Vol. 11 No. 23s, 2025
https://www.theaspd.com/ijes.php



Scheme (4) Synthesis of acrylated alkyd resin

FTIR spectrum of acrylated alkyd resin from Castor oil (C-G-A)

The FTIR spectrum of (C-G-A) which indicatesThe appearance of absorption band at (3300 cm^{-1}) for (OH) of Carboxylic acid. While the emergence of two distinct bands at the two frequencies (2854, 2923Cm^{-1}) is due to the vibration of the stretching of the aliphatic (C-H) bond, also the appearance of the peak at the frequency (1750Cm^{-1}) is due to the vibration of the stretching of the bond (C=O) in the ester group and peak at the frequency (1680Cm^{-1}) is due to the vibration of the stretching of the bond (C=O) in carboxylic group . Also, the appearance of the peak at frequency (1465 Cm^{-1}) is due to the vibration of the aromatic bond (C=C), and the appearance of the peak at frequency (1615 Cm^{-1}) is due to the vibration of the bond stretching (C=C) of the alkene, as well as the appearance of the peak at frequency (1110 cm^{-1}) to the (C-O) straining vibration. The band at 2135.62 cm^{-1} is due to carboxylic acid (RCOOH) group was indicated stretching at CO, also at peaks of 1321.513 cm^{-1} and1397.105 cm^{-1} methyl (CH_3) group. This presence of unsaturated compounds is both resins and acrylate resins is an evidence that both alkyds and acrylate alkyds can dry at any a particular time [8-9-10].

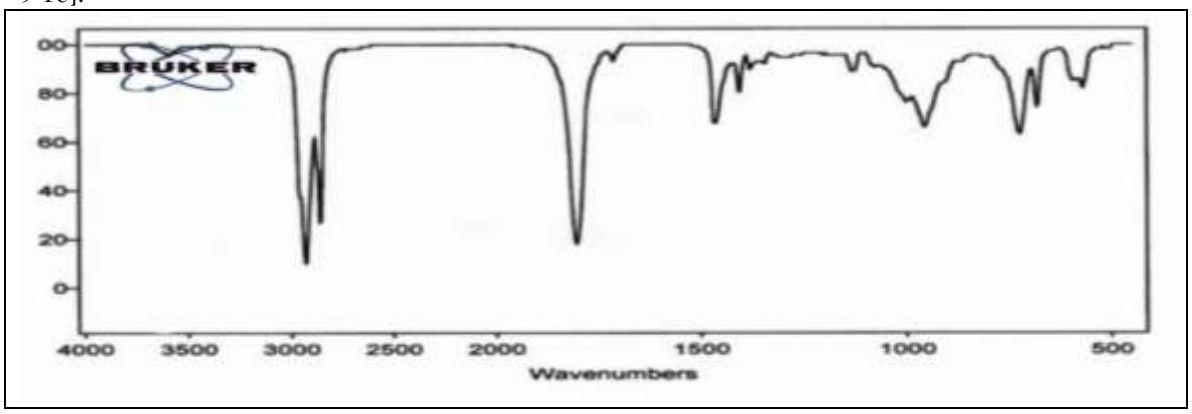


Figure (9) FTIR spectrum of acrylated alkyd resin from castor oil with glycerol

FTIR spectrum of acrylated alkyd resin from Castor oil (C-PR-A)

The FTIR spectrum of (C-PR-A) which indicatesThe appearance of absorption band at (3300 cm^{-1}) for (OH) of Carboxylic acid. While the emergence of two distinct bands at the two frequencies (2854, 2923Cm^{-1}) is due to the vibration of the stretching of the aliphatic (C-H) bond, also the appearance of the peak at the frequency (1750Cm^{-1}) is due to the vibration of the stretching of the bond (C=O) in the ester group and peak at the frequency (1680Cm^{-1}) is due to the vibration of the stretching of the bond (C=O) in carboxylic group . Also, the appearance of the peak at frequency (1465 Cm^{-1}) is due to the vibration of the aromatic bond (C=C), and the appearance of the peak at frequency (1615 Cm^{-1}) is due to the vibration of the bond stretching (C=C) of the alkene, as well as the appearance of the peak at frequency (1110 cm^{-1}) to the (C-O) straining vibration. The band at 2135.62 cm^{-1} is due to carboxylic acid (RCOOH) group was indicated stretching at CO, also at peaks of 1321.513 cm^{-1} and1397.105 cm^{-1} methyl (CH_3) group. This presence of unsaturated compounds is both resins and acrylate resins is an evidence that both alkyds and acrylate alkyds can dry at any a particular time [8-9-10].

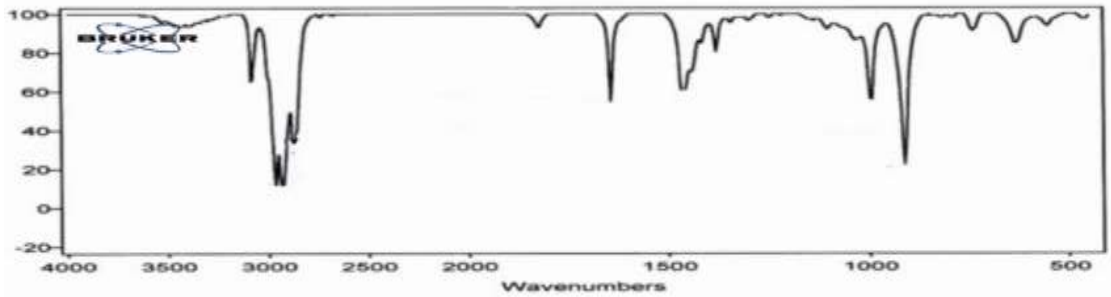


Figure (10) FTIR spectrum of acrylated alkyd resin from castor oil with propylene glycol

^{1}HNMR spectrum of acrylated alkyd resin from Castor oil(C-PR-A)

^{1}HNMR Spectrum of (C-PR-A) assigns the following chemical shifts. Singles (= 0.4 ppm) for methyl group, singles (= 1.2-1.7 ppm) for (CH_2), singles (= 7 ppm) for Ar-H group, singles (= 3.4 ppm) for OCH_2, singles (=14.2 ppm) for COOH. (= 10.2 ppm) indicates the presence of alcohol (RCHOH) group (OH) [8-9-10].

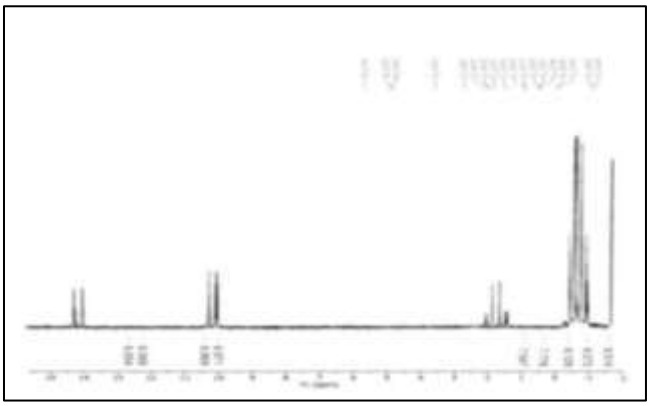


Figure (11) ^{1}HNMR spectrum of acrylated alkyd resin from castor oil with propylene glycol

FTIR spectrum of acrylated alkyd resin from Castor oil (C-PE-A)

The FTIR spectrum of **(C-PE-A)** which indicatesThe appearance of absorption band at (3300 cm^{-1}) for (OH) of Carboxylic acid. While the emergence of two distinct bands at the two frequencies (2854, 2923Cm^{-1}) is due to the vibration of the stretching of the aliphatic (C-H) bond, also the appearance of the peak at the frequency (1700Cm^{-1}) is due to the vibration of the stretching of the bond (C=O) in the ester group and peak at the frequency (1680Cm^{-1}) is due to the vibration of the stretching of the bond (C=O) in carboxylic group . Also, the appearance of the peak at frequency (1465 Cm^{-1}) is due to the vibration of the aromatic bond (C=C), as well as the appearance of the peak at frequency (1110 cm^{-1}) to the (C-O) straining vibration. The band at 2135.62 cm^{-1} is due to carboxylic acid (RCOOH) group was indicated stretching at CO, also at peaks of 1321.513 cm^{-1} and1397.105 cm^{-1} methyl (CH_3) group. This presence of unsaturated compounds is both resins and acrylate resins is an evidence that both alkyds and acrylate alkyds can dry at any a particular time [8-9-10].

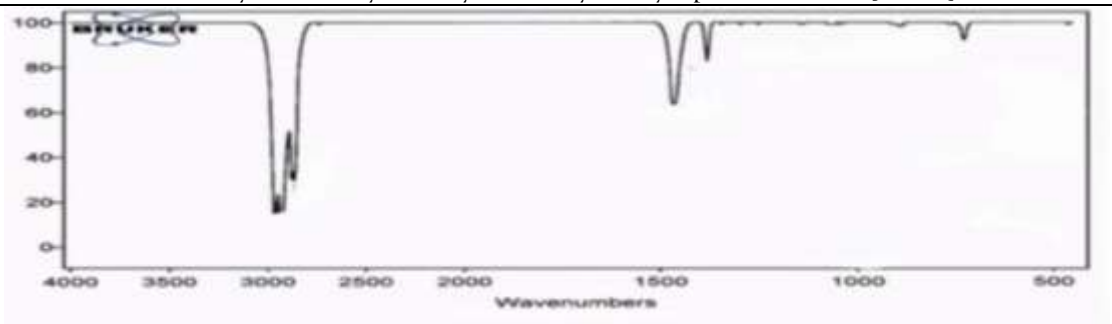


Figure (12) FTIR spectrum of acrylated alkyd resin from castor oil with pentayrethritol

Physiochemical properties of acrylated resin

Drying time

The steel panel used for evaluating the drying time of the resins was kept in vertical position after application of the resins. The results as presented in Table (15) reveal that drying time of the acrylated alkyds is lower than that of the un acrylated alkyds. Acrylic monomers are known to increase the molecular weight [13], and with increase in molecular weight, fewer crosslinks are required to form coherent film [13], or to reach the drying stage. The drying time of the thicker films can dramatically accelerate the oxygen uptake either at the double bond or at the methylene group as the increasing presence of driers [14]. It was observe that the ability of the acrylate alkyd resin to air dry is due to phthalic and maleic anhydride and modification in definite proportion that causes the resin to cross link. The higher the presence of phthalic and maleic anhydride provide reasonable longer chain length and a higher cross linked dense resin through condensation polymerization. The resin becomes denser, viscous and more compact conferring self-curing tendency.

Table (15) shows the drying time values for the prepared acrylate alkyd resins

Alkyd resins	Drying Time (min.)
C-G-A	40
C-PR-A	50
C-PE-A	39

Solubility: The acrylate alkyd resin, showed high solubility in different type of solvents. The solvent used include benzene, toluene, xylene, DMF, acetone, ethanol and methanol. The solvent molecules increase with the distance between the molecular chains of the resin. The spaces between long chains with pendant side group of resin are 'invaded' by solvent molecules as they fill the space made available by chain movements. When movements bring two chains close to proximity, short range attractive forces are therefore established resulting in restricted chain movement and thus the formation of a viscous system [15]. Solvent are added to deal with the problem of high viscous resin which is an obstacle in substrate's wet ability. The acrylated resins showed better resistance towards xylene, ethanol, and methanol

Table (16) shows the solubility of acrylate alkyd resins

Acylated Alkyd Resin	solvent							
	Xylene	DMF	Toluene	Acetone	DMSO	Benzene	Methanol	Ethanol
C+ G + A	-	+	+	+	+	+	-	-
C+ PR + A	-	+	+	+	+	+	-	-
C + PE +A	-	+	+	+	+	+	-	-

+ Soluble at room temperature /- Insoluble at room temperature

Chemical resistance

Table (17) shows that the acid and alkali resistance of the acrylated alkyds are better than the unmodified alkyds. [16] Had made similar observations for acrylated alkyd resin. They attributed the improved acid and alkali resistance to inclusion of acrylic polymer which are known to give better alkali and acid resistances [17]. Our results further reveal that the alkali and acid resistance decreased with increase in maleic anhydride and phthalic anhydride content. This might be due to decrease in acrylic monomer proportion in the copolymer composition.

Table (17) Show the chemical resistance of acrylate alkyd resins

ylated Alkyd Resin	Dist.H_2O	HCl	H_2SO_4	KOH	NaCl	THF
C+ G + A	+	+	+	+	+	+
C + PR + A	+	+	+	+	+	+
C+ PE +A	+	+	+	+	+	+

(+) denotes the insoluble resistant alkyd resin

Thermogravimetric analysis (TGA) for acrylate alkyd resin

The thermal properties of the prepared acrylated alkyd resins were investigated by means of Thermogravimetric analysis (TGA) analysis in a Nitrogen atmosphere at a heating rate of 10°C/min and the results such as It, Ft., T50%, and char yields at 700°C are summarized in Table (18). The temperatures of 50% weight loss of polymers as a standard indication for thermal stability of acrylated alkyd resins were all above 560°C, which indicates excellent thermal stability of polymers. The stability of the polymer increased with the increase in content of aromatic rings.

The char yields of acrylated alkyd resins at 700°C "between" 50% to 98% in nitrogen, which was good for Nano copolymers, which indicate they could meet high temperature resistant requirements as some special materials in fiber reinforcements, fire-retardants and curing agents.Through TGA experiments, it was found that both rates of the first weight monomer. Then an endothermic behavior observed at high temperature region observed caused by crystallization. The study of acrylated alkyd resins decomposition allows us to understand the thermal stability of the material, as well as direct us to the creation of new and better structures with greater thermal resistance.

The thermos grams of acrylated alkyd resins exhibits two distinct stages. One is in the range of 40-200°C due to water loss and decomposition of acrylated alkyd resins low molecular weights, the other stage in the range of 250–550 °C. During industrial production of alkyds, there might be some oxygen present. In order to determine the oxidative thermal stability of the resin in these conditions. Because the thermal degradation was already pronounced at 250 °C. The extent of cross-linking between the polymer chains is expected to be reduced. These resins are mainly intended for applications in paint and ink formulation and therefore the lower thermal stability is not expected to be an issue because typical industrial processes proceed far below the degradation temperature.

The acrylated alkyd resin exhibit three-stage thermolysis processes. But the values are different for each stage, the first group starts from (150,190 and 200) and the second group starts at (300,250 and 520), while the third group appears at (460,520 and 750). With further increasing temperature to 250°C, acrylated alkyd resins exhibits a second step decomposition implying the decomposition of carboxyl groups of polymer chains. The third decomposition step is suggested to be due to the thermal decomposition of the chain backbone [18].

Table (18): Thermal behavior data of acrylate alkyd resins

Samples	TGA (Ċ)					Residue % at 800 Ċ	Chart % at 600 Ċ
	T_i	T_{op1}	T_{op2}	T_f	$T_{50\%}$		
C + G + A	150	300	520	800	500	45	51
C + PR + A	190	250	460	800	500	68	50
C + PE +A	200	520	750	800	710	40	75

Differential Scanning Calorimeter Analysis (DSC) Study for the prepared acrylate alkyd resins from castor oil:

This type of analysis expresses the amount of energy absorbed from the sample during its heating and cooling or at a constant temperature. And the degree of crystallization (Tc) [18]. For a

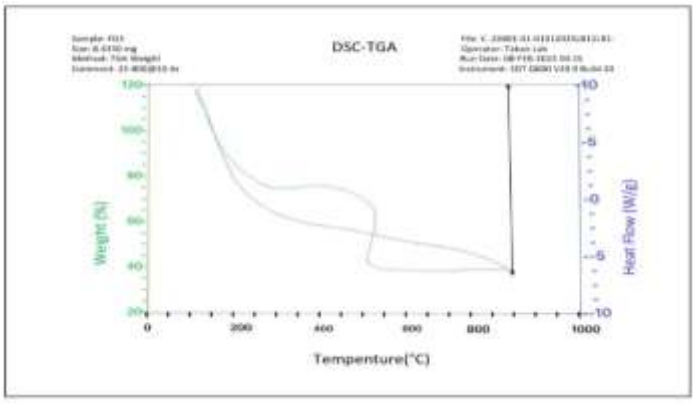
sample prepared from the interaction of acrylated castor oil with glycerol shows, and the results showed the glass transition value (Tg) of the mixture (120°C), indicating an increase in the temperature flow, and then the rate of heat absorption of the sample increased to the melting point (Tm) reaches (450°C).

For a sample prepared from the interaction of acrylated castor oil with propylene glycol shows, and the results showed the glass transition value (Tg) of the mixture (150°C), indicating an increase in the temperature flow, and then the rate of heat absorption of the sample increased to the melting point (Tm) reaches (400°C).

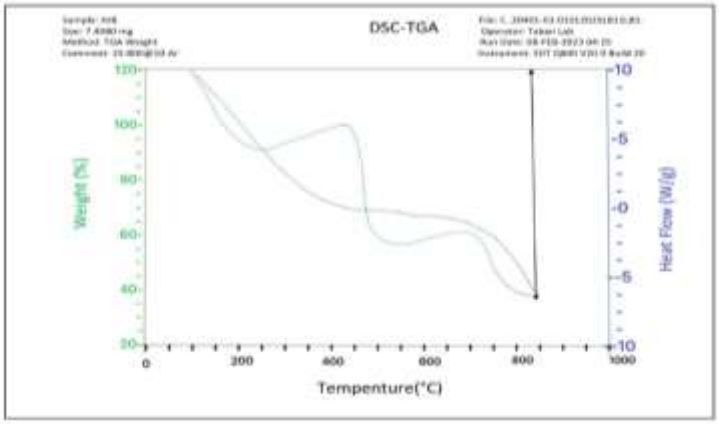
For a sample prepared from the interaction of acrylated castor oil with Pentaerythritol shows, and the results showed the glass transition value (Tg) of the mixture (160°C), indicating an increase in the temperature flow, and then the rate of heat absorption of

Table (18) shows the degree of glass transition, the melting point and the degree of crystallization in differential thermal analysis.

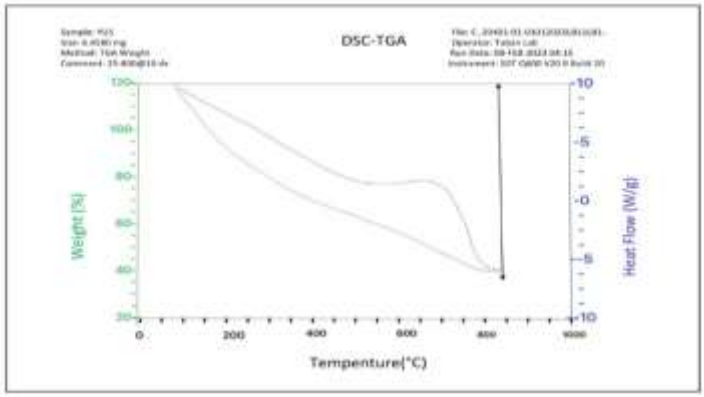
Samples	Tg (°C)	Tm (C°)
C + G + A	120	450
C + PR + A	150	400
C + PE +A	160	660



Figure(13) TGA and DSC curve of acrylated alkyd resin from castor oil with glycerol



Figure(14) TGA and DSC curve of acrylated alkyd resin from castor oil with propylene glycol



Figure(15) TGA and DSC curve of acrylated alkyd resin from castor oil with Pentaerythritol

CONCLUSION

Acrylated alkyd resins were synthesized by free-radical polymerization of acrylic monomer in the presence of castor oil-based alkyd resin. The acrylic phase was constructed from a variety of acrylic monomers including both individual and commoner formulations. It was found that the oil length of the alkyd phase had the most effect on final film properties such as chemical resistance, crosslink density, and dry time. On the other hand, acrylic to alkyd ratio was found to have the most effect on resin characteristics, such as acid number, molecular weight and hydrolytic stability. Thus final acrylic-alkyd hybrid performance is most sensitive to oil length of the alkyd phase. Characterization techniques, including NMR, and FTIR, confirmed the formation of an acrylic alkyd hybrid structure. It was determined that block structure plays an important role in the final performance of this new class of acrylated-alkyds. Systems containing blocks of acrylic exhibited the most impact on film properties compared to a traditional solvent borne alkyd. This study reveals the importance of the development of coatings binders from controlled radical polymerization techniques and the relationship of reaction mechanisms to final performance properties.