

Contents

Series Preface				
Preface				
Li	st of (Contributors		xvii
1	Bio-	Based Plastics – Introdu	iction	1
	Step	han Kabasci		
	1.1	Definition of Bio-Based	Plastics	2
	1.2	A Brief History of Bio-I	Based Plastics	3
	1.3	Market for Bio-Based P	lastics	5
	1.4	Scope of the Book		6
2	Star	ch		9
	Cati	a Bastioli, Paolo Magistr	ali, and Sebastià Gestí Garcia	
	2.1	Introduction		9
	2.2	Starch		10
	2.3	Starch-Filled Plastics		13
	2.4	Structural Starch Modifi	cations	14
		2.4.1 Starch Gelatiniza	ation and Retrogradation	14
		2.4.2 Starch Jet-Cooki	ng	16
		2.4.3 Starch Extrusion	Cooking	16
		2.4.4 Starch Destructu	rization in Absence of Synthetic Polymers	17
		2.4.5 Starch Destructu	rization in Presence of Synthetic Polymers	19
		2.4.6 Additional Infor	mation on Starch Complexation	23
	2.5	Starch-Based Materials	on the Market	27
	2.6	Conclusions		28
	Refe	rences		28
3	Cell	ulose and Cellulose Ace	tate	35
	Joho	nnes Ganster and Hans-	Peter Fink	
	3.1	Introduction		35
	3.2 Raw Materials			

vi	-	tents		
and the second	a	A second and a s		
	3.3	Structure		37
		3.3.1 Cellulose		37
		3.3.2 Cellulose Derivatives		40
	3.4	Principles of Cellulose Technology		42
and the state	White set	3.4.1 Regenerated Cellulose		43
		3.4.2 Organic Cellulose Esters – Cellulose Acetate		46
	3.5	Properties and Applications of Cellulose-Based Plastics		52
		3.5.1 Fibres		53
		3.5.2 Films		54
ner ner fonder og er	and reference and perform	3.5.3 Moulded Articles		56
	3.6	Some Recent Developments		57
		3.6.1 Cellulose		57
		3.6.2 Cellulose Acetate and Mixed Esters		58
	3.7	Conclusion		59
	Refe	erences		59
4	Mat	erials Based on Chitin and Chitosan		63
	Mar	guerite Rinaudo		
	4.1	Introduction		63
	4.2	Preparation and Characterization of Chitin and Chitosan		64
		4.2.1 Chitin: Characteristics and Characterization		64
		4.2.2 Chitosan: Preparation and Characterization		66
	4.3	Processing of Chitin to Materials and Applications		69
		4.3.1 Processing of Chitin and Physical Properties of Materials		69
		4.3.2 Applications of Chitin-Based Materials		70
	4.4	Chitosan Processing to Materials and Applications		71
		4.4.1 Processing of Chitosan		71
		4.4.2 Application of Chitosan-Based Materials		74
	4.5	Conclusion	a in the	77
	Refe	erences		77

and the second of the second with a second we will be a second of the second se

* 11 m

Lignin Matrix Composites from Natural Resources – ARBOFORM® 5

	Helr	nut Näg	gele, Jürgen Pfitzer, Lars Ziegler, Emilia Regina Inone-Kauffmann,	
	Wilh	elm Ec.	kl, and Norbert Eisenreich	
	5.1	Introd	uction	89
	5.2	Appro	aches for Plastics Completely Made from Natural Resources	90
	5.3	Formu	lation of Lignin Matrix Composites (ARBOFORM)	92
		5.3.1	Lignin	92
		5.3.2	Basic Formulations and Processing of ARBOFORM	95
		5.3.3	The Influence of the Fibre Content	97
	5.4	Chemi	ical Free Lignin from High Pressure Thermo-Hydrolysis (Aquasolv)	100
		5.4.1	Near Infrared Spectroscopy of Lignin Types	100
		5.4.2	Lignin Extraction by High-Pressure Hydrothermolysis (HPH)	101
		5.4.3	Thermoplastic Processing of Aquasolv Lignin	104
- *	5.5	Functi	onalizing Lignin Matrix Composites	105
		5.5.1	Impact Strength	106

C	
Contents	VII
Contents	VII

-

)

		5.5.2	Flame Retardancy	106
			Electrical Conductivity with Nanoparticles	106
			Pyrolysis to Porous Carbonaceous Structures	108
	5.6	Injecti	ion Moulding of Parts – Case Studies	109
		-	Loudspeaker Boxes	110
			Precision Parts	110
		5.6.3	Thin Walled and Decorative Gift Boxes and Toys	111
	Ack		gements	112
		erences		112
		7		
6			from Lipids	117
	Stua	rt Cole		
	6.1	Introd	uction	117
	6.2	Defini	tion and Structure of Lipids	117
		6.2.1	Fatty Acids	117
		6.2.2	Mono-, Di- and Tri-Substituted Glycerols	118
		6.2.3	Phospholipids	118
		6.2.4	Other Compounds	119
	6.3	Source	es and Biosynthesis of Lipids	119
		6.3.1	Sources of Lipids	119
		6.3.2	Biosynthesis of Lipids	120
		6.3.3	Composition of Triglycerides	120
	6.4	Extrac	ction of Plant Oils, Triglycerides and Their Associated Compounds	120
		6.4.1	Seed Cleaning and Preparation	121
		6.4.2	Seed Pressing	121
		6.4.3	Liquid Extraction	121
		6.4.4	Post Extraction Processing	122
	6.5	Biopo	lymers from Plant Oils, Triglycerides and Their Associated	
		Comp	ounds	122
		6.5.1	Generic Triglycerides	122
		6.5.2	Common Manipulations of Triglycerides	123
		6.5.3	Soybean Oil-Based Bioplastics	125
		6.5.4	Castor Oil-Based Bioplastics	126
		6.5.5	Linseed Oil-Based Bioplastics	127
		6.5.6	Other Plant Oil-Based Bioplastics	127
		6.5.7	Biological Synthesis of Polymers	128
	6.6	Applic	cations	128
		6.6.1	Mimicking to Reduce R&D Risk	128
		6.6.2	Composites	129
			Coatings	129
		6.6.4	Packaging Materials	130
			Foams	130
		6.6.6	Biomedical Applications	130
			Other Applications	131
	6.7	Conch		131
	Refe	rences		131

7 Polyhydroxyalkanoates: Basics, Production and Applications of Microbial				
	Bio	polyest	ers	137
	Mar	tin Kol	ler, Anna Salerno, and Gerhart Braunegg	
	7.1	7.1 Microbial PHA Production, Metabolism, and Structure		137
		7.1.1	Occurrence of PHAs	137
		7.1.2	In Vivo Characteristics and Biological Role of PHAs	139
		7.1.3	Structure and Composition of PHAs	140
		7.1.4	Metabolic Aspects	141
	7.2	Availa	able Raw Materials for PHA Production	143
	7.3	Recov	very of PHA from Biomass	144
		7.3.1	General Aspects of PHA Recovery	144
		7.3.2	Direct Extraction of PHA from Biomass	146
		7.3.3	Digestion of the non-PHA Cellular Material	147
		7.3.4	Disruption of Cells of Osmophilic Microbes in	
			Hypotonic Medium	148
	7.4	Differ	ent Types of PHA	149
		7.4.1	Short Chain Length vs. Medium Chain Length PHAs	149
		7.4.2	Enzymatic Background: PHA Synthases	149
	7.5	Globa	I PHA Production	151
	7.6	Appli	cations of PHAs	152
		7.6.1	General	152
		7.6.2	Packaging and Commodity Items	152
		7.6.3	Medical Applications	154
		7.6.4	Application of the Monomeric Building Blocks	155
		7.6.5	Smart Materials	156
		7.6.6	Controlled Release of Active Agents	156
	7.7	Econo	omic Challenges in the Production of PHAs and Attempts to	
		Overc	ome Them	156
		7.7.1	PHA Production as a Holistic Process	156
		7.7.2	Substrates as Economic Factor	156
		7.7.3	Downstream Processing	157
		7.7.4	Process Design	157
		7.7.5	Contemporary Attempts to Enhance PHA Production in Terms of	
			Economics and Product Quality	158
	7.8	Proce	ss Design	160
4	7.9	Concl	usion	162
	Refe	erences		163
8	Poly	(Laction	c Acid)	171
	Hide	eto Tsuj	ji	
	8.1	Introd	uction	171
	8.2	Histor	rical Outline	173
		•	esis of Monomer	174
	8.4	Synth	esis of Poly(Lactic Acid)	176
		8.4.1	Homopolymers	176
			Linear Copolymers	176
	8.5	Proces	ssing	178

Contents ix

1.0

8.6	Crystal	lization	178
	8.6.1	Crystal Structures	178
	8.6.2	Crystalline Morphology	181
	8.6.3	Crystallization Behaviour	182
8.7	Physica	al Properties	182
	8.7.1	Mechanical Properties	182
	8.7.2	Thermal Properties	186
	8.7.3	Permeability	188
	8.7.4	Surface Properties	188
	8.7.5	Electrical Properties	189
	8.7.6	Optical Properties	189
8.8	Hydrol	ytic Degradation	191
	8.8.1	Degradation Mechanism	192
	8.8.2	Effects of Surrounding Media	195
	8.8.3	Effects of Material Parameters	196
8.9	Therma	al Degradation	200
8.10	Biodeg	radation	204
8.11	Photod	egradation	205
8.12	High-P	Performance Poly(Lactic Acid)-Based Materials	207
	8.12.1	Nucleating or Crystallization-Accelerating Fillers	207
	8.12.2	Composites and Nanocomposites	208
	8.12.3	Fibre-Reinforced Plastics (FRPs)	211
	8.12.4	Stereocomplexation	212
8.13	Applic	ations	213
	8.13.1	Alternatives to Petro-Based Polymers	213
	8.13.2	Biomedical	214
	8.13.3	Environmental Applications	216
8.14	Recycl	ing	217
8.15	Conclu	isions	219
Refer	ences		219

.

4

Other Polyesters from Biomass Derived Monomers 9

241

Daar	S. van	Es, Frits van der Klis, Rutger J. I. Knoop, Karin Molenveld,	
Lolke	e Sijtsma	, and Jacco van Haveren	
9.1	Introdu	action	241
9.2	2 Isohexide Polyesters		
	9.2.1	Introduction	242
	9.2.2	Semi-Aromatic Homo-Polyesters	244
<i>a</i> .	9.2.3	Semi-Aromatic Co-Polyesters	247
	9.2.4	Aliphatic Polyesters	248
	9.2.5	Modified Isohexides	250
9.3	Furan-	Based Polyesters	251
	9.3.1	Introduction	251
	9.3.2	2,5-Dihydroxymethylfuran (DHMF)-Based Polyesters	253
	9.3.3	5-Hydroxymethylfuroic Acid (HMFA) Based Polyesters	254
	9.3.4	Furan-2,5-Dicarboxylic Acid (FDCA) Based Polyesters	254
	9.3.5	Future Outlook	256

x Contents

	9.4	Poly(B	utylene Succinate) (PBS) and Its Copolymers	257
		9.4.1	Succinic Acid	257
		9.4.2	1,4-Butanediol (BDO)	258
		9.4.3	Poly(Butylene Succinate) (PBS)	259
		9.4.4	PBS Copolymers	259
		9.4.5	PBS Biodegradability	260
		9.4.6	PBS Processability	260
		9.4.7	PBS Blends	260
		9.4.8	PBS Markets and Applications	260
		9.4.9	Future Outlook	261
	9.5	Bio-Ba	sed Terephthalates	261
		9.5.1	Introduction	261
		9.5.2	Bio-Based Diols: Ethylene Glycol, 1,3-Propanediol,	
			1,4-Butanediol	262
		9.5.3	Bio-Based Xylenes, Isophthalic and Terephthalic Acid	263
	9.6	Conclu	sions	267
	Refe	rences		267
10	Poly	amides f	rom Biomass Derived Monomers	275
	Benj	amin Bre	hmer	
	10.1	Introdu	iction	275
		10.1.1	What are Polyamides?	275
		10.1.2	What is the Polymer Pyramid?	276
		10.1.3	Where do Polyamides from Biomass Derived Monomers Fit?	277
	10.2	Technie	cal Performance of Polyamides	277
		10.2.1	How to Differentiate Performance	277
		10.2.2	Overview of Current Applications	279
		10.2.3	Typical Association of Biopolymers	280
	10.3	Chemic	cal Synthesis	281
		10.3.1	Castor Bean to Intermediates	281
		10.3.2	Undecenoic Acid Route	283
		10.3.3	Sebacic Acid Route	283
		10.3.4	Decamethylene Diamine Route	284
	10.4	Monon	ner Feedstock Supply Chain	284
			Description of Supply Chain	284
		10.4.2	Pricing Situation	285
	10.5	Produc	ers	287
	10.6	Sustain	ability Aspects	287
		10.6.1	Biosourcing	287
		10.6.2	Lifecycle Assessments	288
		10.6.3	Labelling and Certification	291
	10.7	Improv	ement and Outlook	292
	Refe	rences		293
11	•		sed Plastics from Biomass-Derived Monomers	295
		Koopman		
	11.1	Introdu	ction	295

-)

Contents	xi

11.2	Polyolefin-Based Plastics	296
11.3	Biomass	299
11.4	Chemicals from Biomass	300
11.5	Chemicals from Biotechnology	302
11.6	Plastics from Biomass	303
11.7	Polyolefin Plastics from Biomass and Petrochemical Technology	303
	11.7.1 One-Carbon Building Blocks	304
	11.7.2 Two-Carbon Building Blocks	305
	11.7.3 Three-Carbon Building Blocks	305
11.8	Polyolefin Plastics from Biomass and Biotechnology	305
11.9	Bio-Polyethylene and Bio-Polypropylene	306
11.10	Perspective and Outlook	307
Refer	ences	308

12	Future Trends for Recombinant Protein-Based Polymers: The Case Study				
	of De	velopment and Application of Silk-Elastin-Like Polymers	311		
	Margarida Casal, António M. Cunha, and Raul Machado				
	12.1	Introduction	311		
	12.2	Production of Recombinant Protein-Based Polymers (rPBPs)	312		
	12.3	The Silk-Elastin-Like Polymers (SELPs)	314		
		12.3.1 SELPs for Biomedical Applications: Hydrogels for Localized			
		Delivery	317		
		12.3.2 Mechanical Properties of SELP Hydrogels	319		
		12.3.3 Spun Fibres	320		
		12.3.4 Solvent Cast Films	323		
	12.4	Final Considerations	324		
	Refer	ences	325		
13		wable Raw Materials and Feedstock for Bioplastics	331		
	Achim Raschka, Michael Carus, and Stephan Piotrowski				
	13.1	Introduction	331		
		First- and Second-Generation Crops: Advantages and Disadvantages	331		
		The Amount of Land Needed to Grow Feedstock for Bio-Based Plastics	333		
		Productivity and Availability of Arable Land	336		
		Research on Feedstock Optimization	338		
	13.6	Advanced Breeding Technologies and Green Biotechnology	339		
	13.7	Some Facts about Food Prices and Recent Food Price Increases	341		
	13.8	Is there Enough Land for Food, Animal Feed, Bioenergy and Industrial			
		Material Use, Including Bio-Based Plastics?	343		
	Refer	ences	345		
14		Denvise of Displayting Displayed and Displayed able Commerciable			
14		Promise of Bioplastics – Bio-Based and Biodegradable-Compostable	247		
	Plast		347		
		ni Narayan Nalua Proposition for Dia Doged Digstiga	210		
	14.1	Value Proposition for Bio-Based Plastics	348		
	14.2	Exemplars of Zero or Reduced Material Carbon Footprint – Bio-PE,	240		
		Bio-PET and PLA	349		

.

14.3	Process Carbon Footprint and LCA	351
14.4	Determination of Bio-Based Carbon Content	352
14.5	End-of-Life Options for Bioplastics – Biodegradability-Compostability	353
14.6	Summary	356
References		356

Index

