

## Accepted Manuscript

Title: *Greensilica*<sup>®</sup> vectors for Smart Textiles

Author: Joana C. Matos Inês Avelar M. Bárbara F. Martins M. Clara Gonçalves



PII: S0144-8617(16)30950-X  
DOI: <http://dx.doi.org/doi:10.1016/j.carbpol.2016.08.015>  
Reference: CARP 11440

To appear in:

Received date: 4-7-2016  
Revised date: 28-7-2016  
Accepted date: 5-8-2016

Please cite this article as: Matos, Joana C., Avelar, Inês., Martins, M Bárbara F., & Gonçalves, M.Clara., *Greensilica*<sup>®</sup> vectors for Smart Textiles. *Carbohydrate Polymers* <http://dx.doi.org/10.1016/j.carbpol.2016.08.015>

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*Greensilica*® vectors for Smart Textiles

Joana C. Matos<sup>1,2</sup>, Inês Avelar<sup>1</sup>, M. Bárbara F. Martins<sup>3</sup>, M. Clara Gonçalves<sup>1,2\*</sup> clara.goncalves@ist.utl.pt

<sup>1</sup>Departamento de Engenharia Química, Instituto Superior Técnico, Universidade de Lisboa, Av. Rovisco Pais, 1049-001 Lisboa, Portugal

<sup>2</sup>CQE, Centro de Química Estrutural, Instituto Superior Técnico, Universidade de Lisboa

<sup>3</sup>Intracellular Trafficking Modulation for Advanced Drug Delivery Group, iMed.UL, Faculdade de Farmácia da Universidade de Lisboa, Lisboa, Portugal.

\*Corresponding author: Tel: +351-218418137

#### Highlights

- SiO<sub>2</sub>, amineSiO<sub>2</sub>, diamineSiO<sub>2</sub> and epoxySiO<sub>2</sub> particles were ecofriendly synthesized;
- cotton and polyester textiles were impregnated with silica-based particles;
- *cure* and *no cure* impregnation were tested;
- fabrics impregnation was confirmed by SEM and quantified by ICP;
- diamine-SiO<sub>2</sub> particles exhibited the best performance in *cured* textile matrices;
- diamine-SiO<sub>2</sub> particles still exhibited the best performance in *non-cured* cotton textile;
- while amine-SiO<sub>2</sub> present the best achievement in *no cure* polyester matrix;

#### Abstract

The present work aims developing a *versatile Greensilica*® vector/carrier, able to bind to a wide range of textile matrices of carbohydrate polymers and susceptible of being loaded with chemicals/drugs/therapeutic molecules, to create a *green* tailor-made (multi)functional *high-tech* textile. A green, eco-friendly, ammonia-free, easily scalable, time-saving sol-gel process was established for the production of those silica-based colloidal particles (SiO<sub>2</sub>, amine-SiO<sub>2</sub>, diamine-SiO<sub>2</sub>, and epoxy-SiO<sub>2</sub>). Two different textile matrices (cotton, polyester) were functionalized, through the impregnation of *Greensilica*® particles. The impregnation was performed *with* and *without cure*. Diamine-SiO<sub>2</sub> colloidal particles exhibited the higher bonding efficiency in *cured* textile matrices (both cotton and polyester), while with *no cure* the best adherence to cotton and polyester textile matrices was achieved with diamine-SiO<sub>2</sub> and amine-SiO<sub>2</sub>, respectively. *Use once and throw away* and *continued use* applications were envisaged and screened through washing tests. The efficiency of the textiles impregnation was confirmed by SEM, and quantified by ICP.

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