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(54) **METHOD OF MAKING IMPROVED
BALLISTIC PRODUCTS**

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(76) Inventors: **Ashok Bhatnagar**, Richmond, VA
(US); **Lori L. Wagner**, Richmond, VA
(US); **David A. Hurst**, Richmond, VA
(US); **Brian D. Arvidson**, Chester, VA
(US)

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(57) **ABSTRACT**

Correspondence Address:
HONEYWELL INTERNATIONAL INC.
101 COLUMBIA ROAD
P O BOX 2245
MORRISTOWN, NJ 07962-2245 (US)

A method of making a ballistic resistant composite material having improved resistance to high energy rifle bullets and the like. The method comprises providing at least one fibrous layer comprising a network of high tenacity aramid fibers. The fibrous layer is coated with a thermoplastic polyurethane resin. The coated fibrous layer is molded at a pressure of at least about 1,500 psi (10.3 MPa). Preferably, a plurality of fibrous layers are employed, each of which is formed from unidirectionally oriented aramid fibers in a thermoplastic polyurethane resin matrix. Adjacent fibrous layers are preferably oriented at 90° with respect to each other.

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METHOD OF MAKING IMPROVED BALLISTIC PRODUCTS

BACKGROUND OF THE INVENTION

[0001] 1. Field of the Invention

[0002] This invention relates to ballistic products, in particular to ballistic products formed from aramid fibrous material.

[0003] 2. Description of the Related Art

[0004] Ballistic resistant products for vests and the like are known in the art. Many of these products are based on high tenacity fibers, such as aramid fibers. Although such products have excellent properties and have achieved commercial success, there is a constant need to improve the properties of armor products, such as body armor products.

[0005] In particular, it would be desirable to provide ballistic resistant products which had improved resistance to high energy rifle bullets and the like.

SUMMARY OF THE INVENTION

[0006] In accordance with this invention, there is provided a method of making a ballistic resistant composite material having improved resistance to high energy rifle bullets and the like, the method comprising providing at least one fibrous layer comprising a network of high tenacity aramid fibers; coating the fibrous layer with a thermoplastic polyurethane resin; and molding the fibrous layer at a pressure of at least about 1,500 psi (10.3 MPa).

[0007] This invention also provides a method for making a ballistic resistant composite material having improved resistance to high energy rifle bullets and the like, the method comprising providing a first fibrous layer comprising a network of high tenacity aramid fibers; coating the first fibrous layer with a thermoplastic polyurethane resin; providing a second fibrous layer comprising a network of high tenacity aramid fibers; coating the second fibrous layer with a thermoplastic polyurethane resin; and molding the first and second fibrous layers at a pressure of at least about 1,500 psi (10.3 MPa).

[0008] In addition, this invention provides a method for making a ballistic resistant composite material having improved resistance to high energy rifle bullets and the like, the method comprising providing a first non-woven fibrous layer comprising a network of high tenacity aramid fibers; coating the first non-woven fibrous layer with a thermoplastic polyurethane resin; providing a second non-woven fibrous layer comprising a network of high tenacity aramid fibers; coating the second non-woven fibrous layer with a thermoplastic polyurethane resin; arranging the first and second non-woven fibrous layers such that the first and second non-woven fibrous are oriented with respect to each other; and molding the first and second fibrous layers at a pressure of at least about 1,500 psi (10.3 MPa).

[0009] This invention further provides a method of improving the resistance of a ballistic resistant body armor to high energy rifle bullets and the like, the method comprising providing a first fibrous layer comprising a network of high tenacity aramid fibers; coating the first fibrous layer with a thermoplastic polyurethane resin; providing a second fibrous layer comprising a network of high tenacity aramid

fibers; coating the second fibrous layer with a thermoplastic polyurethane resin; molding the first and second fibrous layers at a pressure of at least about 1,500 psi (10.3 MPa) to form a molded article; and forming the body armor at least in part from the molded article.

[0010] It has been surprisingly discovered that when a thermoplastic polyurethane resin is used to form a composite aramid fibrous structure and the composite is formed under high pressure, the composite has improved ballistic resistance to high energy rifle bullets and the like. This is especially unexpected since similar results have not been seen with aramid composites that utilize other known coating resins.

DETAILED DESCRIPTION OF THE INVENTION

[0011] The present invention relates to composites formed from aramid fibers which have improved ballistic resistance, especially to high energy rifle bullets. These composites are particularly useful in ballistic resistant armor articles, both flexible or rigid. Examples include body armor, helmets, blankets and the like.

[0012] High energy rifle bullets are bullets where the energy level generally is from about 1500 to about 3500 joules, or higher. Examples of such bullets are the M80 ball (also known as the NATO ball, the Dragov LPS, and the like).

[0013] For the purposes of the present invention, a fiber is an elongate body the length dimension of which is much greater than the transverse dimensions of width and thickness. Accordingly, the term fiber includes monofilament, multifilament, ribbon, strip, staple and other forms of chopped, cut or discontinuous fiber and the like having regular or irregular cross-section. The term "fiber" includes a plurality of any of the foregoing or a combination thereof. A yarn is a continuous strand comprised of many fibers or filaments.

[0014] The cross-sections of fibers useful in this invention may vary widely. They may be circular, flat or oblong in cross-section. They also may be of irregular or regular multi-lobal cross-section having one or more regular or irregular lobes projecting from the linear or longitudinal axis of the filament. It is particularly preferred that the fibers be of substantially circular, flat or oblong cross-section, most preferably that the fibers be of substantially circular cross-section.

[0015] As used herein, the term "high tenacity fibers" means fibers which have tenacity equal to or greater than about 7 g/d. These fibers preferably have initial tensile moduli of at least about 150 g/d and energies-to-break of at least about 8 J/g as measured by ASTM D2256. Preferred fibers are those having a tenacity equal to or greater than about 10 g/d, a tensile modulus equal to or greater than about 200 g/d and an energy-to-break equal to or greater than about 20 J/g. Particularly preferred fibers are those having a tenacity equal to or greater than about 16 g/d, a tensile modulus equal to or greater than about 400 g/d, and an energy-to-break equal to or greater than about 27 J/g. Amongst these particularly preferred embodiments, most preferred are those embodiments in which the tenacity of the fibers is equal to or greater than about 22 g/d, the tensile

modulus is equal to or greater than about 500 g/d, and the energy-to-break is equal to or greater than about 27 J/g. As used herein, the terms "initial tensile modulus", "tensile modulus" and "modulus" mean the modulus of elasticity as measured by ASTM 2256 for a yarn and by ASTM D638 for a matrix material.

[0016] Aramid fibers are known in the art. Suitable aramid fibers useful in the present invention are formed from aromatic polyamides, such as those are described in U.S. Pat. No. 3,671,542 the disclosure of which is expressly incorporated herein by reference to the extent not inconsistent herewith. Preferred aramid fibers will have a tenacity of at least about 20 g/d, an initial tensile modulus of at least about 200 g/d and an energy-to-break at least about 8 J/g, and particularly preferred aramid fibers will have a tenacity of at least about 20 g/d, an initial tensile modulus of at least about 400 g/d and an energy-to-break of at least about 20 J/g.

[0017] Most preferred aramid fibers will have a tenacity of at least about 23 g/d, a modulus of at least about 500 g/d and an energy-to-break of at least about 30 J/g. For example, poly(p-phenylene terephthalamide) filaments which have moderately high moduli and tenacity values are particularly useful in forming ballistic resistant composites. Examples are Twaron® T2000 from Teijin which has a denier of 1000. Other examples are Kevlar® 29 which has 500 g/d and 22 g/d and Kevlar® 49 which has 1000 g/d and 22 g/d as values of initial tensile modulus and tenacity, respectively, both available from du Pont. Copolymers of poly(p-phenylene terephthalamide) may also be used, such as co-poly(p-phenylene terephthalamide 3,4'-oxydiphenylene terephthalamide). Also useful in the practice of this invention are poly(m-phenylene isophthalamide) fibers produced commercially by du Pont under the trade name Nomex®.

[0018] The fibers may be of any suitable denier, such as, for example, about 50 to about 3000 denier, more preferably from about 200 to about 3000 denier, still more preferably from about 650 to about 1500 denier, and most preferably from about 800 to about 1300 denier.

[0019] The aramid fibers are formed into at least one layer of a fibrous network. Preferably the fibrous network is a non-woven fabric, although other types of fabrics may be employed herein, such as woven or knitted fabrics. In the case of woven fabrics, they may be woven with yarns having different fibers in the warp and weft directions, or in other directions.

[0020] Preferably there are at least two layers of fibrous networks used to prepare the ballistic resistant composites.

[0021] A particularly preferred configuration of the fibers is in a network wherein the fibers are unidirectionally aligned so that they are substantially parallel to each other along a common fiber direction. Alternatively, a non-woven fabric may be used in which the fibers are felted in a random orientation.

[0022] Preferably, at least about 50% by weight of the fibers in the non-woven fabric are high tenacity aramid fibers, more preferably at least about 75% by weight of the fibers in the fabric are high tenacity aramid fibers, and most preferably substantially all of the fibers in the fabric are high tenacity aramid fibers. The yarns may be in essentially parallel alignment, or the yarns may be twisted, over-wrapped or entangled.

[0023] Fabrics formed from unidirectionally oriented fibers typically have one layer of fibers which extends in one direction and a second layer of fibers which extends in another direction (preferably 90°) from the fibers in the first layer. Where the individual plies are unidirectionally oriented fibers, the successive plies are preferably rotated relative to one another, for example at angles of 0°/90°, 0°/90°/0°/90°, or 0°/45°/90°/45°/0° or at other angles.

[0024] It is convenient to characterize the geometries of the composites of the invention by the geometries of the fibers. One such suitable arrangement is a fibrous layer in which the fibers are aligned parallel to one another along a common fiber direction (referred to as a "unidirectionally aligned fiber network"). Successive layers of such unidirectionally aligned fibers can be rotated with respect to the previous layer. Preferably, the fibrous layers of the composite are cross-plyed, that is, with the fiber direction of the unidirectional fibers of each network layer rotated with respect to the fiber direction of the unidirectional fibers of the adjacent layers. An example is a five layer article with the second, third, fourth and fifth layers rotated +45°, -45°, 90° and 0° with respect to the first layer. A preferred example includes two layers with a 0°/90° layup. Such rotated unidirectional alignments are described, for example, in U.S. Pat. Nos. 4,623,574; 4,737,402; 4,748,064; and 4,916,000.

[0025] In general, the fibrous layers of the invention are preferably formed by constructing a fiber network initially and then coating the network with a matrix composition. As used herein, the term "coating" is used in a broad sense to describe a fiber network wherein the individual fibers either have a continuous layer of the matrix composition surrounding the fibers or a discontinuous layer of the matrix composition on the surfaced of the fibers. In the former case, it can be said that the fibers are fully embedded in the matrix composition. The terms coating and impregnating are interchangeably used herein. The fiber networks can be constructed via a variety of methods. In the preferred case of unidirectionally aligned fiber non-woven fibrous networks, yarn bundles of the high tenacity filaments are supplied from a reel and led through guides and one or more spreader bars into a collimating comb prior to coating with the matrix material. The collimating comb aligns the filaments coplanarly and in a substantially unidirectional fashion.

[0026] The method of this invention includes initially forming the fiber network layer, preferably a unidirectional network as described above, applying a solution, dispersion or emulsion of the matrix composition onto the fiber network layer, and then drying the matrix-coated fiber network layer. The solution, dispersion or emulsion is preferably an aqueous solution of the polyurethane resin, which may be sprayed onto the filaments. Alternatively, the filament structure may be coated with the aqueous solution, dispersion or emulsion by dipping or by means of a roll coater or the like.

[0027] After coating, the coated fibrous layer may then be passed through an oven for drying in which the coated fiber network layer (unitape) is subjected to sufficient heat to evaporate the water in the matrix composition. The coated fibrous network may then be placed on a carrier web, which can be a paper or a film substrate, or the fibers may initially be placed on a carrier web before coating with the matrix resin. The substrate and the unitape can then be wound into a continuous roll in a known manner.

films and the like. These films may be of any desirable thickness. Typical thicknesses range from about 0.1 to about 1.2 mils (2.5 to 30 μm), more preferably from about 0.2 to about 1 mil (5 to 25 μm), and most preferably from about 0.3 to about 0.5 mils (7.5 to 12.5 μm). Most preferred are films of LLDPE. The films may be formed as part of each subassembly, or films may be introduced between sub-assemblies when placed in the mold. The films may be on one or both sides of the sub-assemblies and/or final molded product.

[0042] Various constructions are known for fiber-reinforced composites used in impact and ballistic resistant articles. These composites display varying degrees of resistance to penetration by high speed impact from projectiles such as bullets, shrapnel and fragments, and the like. Examples of such constructions are disclosed, for example, in U.S. Pat. Nos. 6,268,301, 6,248,676, 6,219,842; 5,677,029; 5,471,906; 5,196,252; 5,187,023; 5,185,195; 5,175,040; and 5,167,876.

[0043] In one embodiment of the invention, a vest or other body armor or other article is formed in a conventional manner from a plurality of layers of the composite material. These layers preferably are not laminated together but may be stitched together to avoid slippage of the individual plies with respect to each other. For example, the layers may be tack stitched at each corner. Alternatively, the layers may be encased as a whole in a pocket or other covering.

[0044] The following non-limiting examples are presented to provide a more complete understanding of the invention. The specific techniques, conditions, materials, proportions and reported data set forth to illustrate the principles of the invention are exemplary and should not be construed as limiting the scope of the invention. All percentages are by weight, unless otherwise stated.

EXAMPLES

Example 1

[0045] A two-ply non-woven composite was formed from layers of aramid fiber having a denier of 1000 and a tenacity of 26 g/d (Twaron® T2000 from Teijin). Unitapes were prepared by passing the aramid fibers from a creel and through a combing station to form a unidirectional network. The fiber network was then placed on a carrier web and the fibers were coated with a matrix resin. The resin was a dispersion of a thermoplastic polyurethane resin, namely a copolymer mix of polyurethane resins in water (40-60% resin) which is described by the manufacturer as having a relative density of 1.05 g/cc at 23° C. and a viscosity of 40 cps at 23° C.

[0046] The coated fiber network was then passed through an oven to evaporate the water in the composition and was wound up on a roller, with the carrier web stripped therefrom, in preparation for forming the composite material. The resulting structure contained 16 weight percent of the polyurethane resin. Two continuous rolls of unidirectional fiber prepregs were prepared in this manner. Two such unitapes were cross-plyed at 90° and consolidated to create a laminate with two identical aramid fiber laminae. Panels of this material measuring 12×12 in. (30.5×30.5 cm) were used to form a multilayer composite structure.

[0047] A total of 270 layers of the 2-ply construction were placed into a matched die mold of a hydraulic press and molded at 240° F. (115.6° C.) at a molding pressure of 1500

psi (10.3 MPa) for a period of 20 minutes. The laminate that was formed had a substantially flat configuration. After molding, the laminate was allowed to cool to room temperature.

[0048] The ballistic characteristics of multiple layers of the 4-ply composite were determined. The bullet was a NATO ball (also known as a M80 ball), the size of which was 7.62×51 mm. This projectile is a high energy rifle bullet. The ballistic resistance was determined in accordance with NIJ Standard NIJ 0101.04. The results are shown in Table 1, below.

[0049] The V50 calculation was determined based on the average of 6-10 pairs of bullets stopped on the shoot pack and penetrated the shoot pack. V50 velocity is that velocity for which the projectile has a 50% probability of penetration.

Comparative Example 2

[0050] Example 1 was repeated, except that the molding pressure was 500 psi (3.4 MPa). The samples were again tested for their ballistic resistance using the same type of bullet, and the results are shown in Table 1, below.

Example 3

[0051] Example 1 was repeated, except that a total of 315 layers of the composite was used to form the panels. The samples were again tested for their ballistic resistance using the same type of bullet, and the results are shown in Table 1, below.

Comparative Example 4

[0052] Example 3 was repeated, except that the molding pressure was 500 psi.

[0053] The samples were again tested for their ballistic resistance using the same type of bullet, and the results are shown in Table 1, below.

Example 5

[0054] Example 1 was repeated, except that a total of 360 layers of the composite was used to form the panels. The samples were again tested for their ballistic resistance using the same type of bullet, and the results are shown in Table 1, below.

Comparative Example 6

[0055] Example 5 was repeated, except that the molding pressure was 500 psi. The samples were again tested for their ballistic resistance using the same type of bullet, and the results are shown in Table 1, below.

TABLE 1

Example	Molding Pressure, psi (MPa)	Number of Layers	Areal Density, psf (kg/m ²)	V50, fps (mps)
1	2500 (10.3)	270	6.00 (29.34)	2740 (835.7)
2*	500 (3.4)	270	6.00 (29.34)	2560 (780.8)
3	2500 (10.3)	315	7.00 (34.23)	3012 (918.7)
4*	500 (3.4)	315	7.00 (34.23)	2828 (862.5)

TABLE 1-continued

Example	Molding Pressure, psi (MPa)	Number of Layers	Areal Density, psf (kg/m ²)	V50, fps (mps)
5	2500 (10.3)	360	8.00 (39.12)	3218 (981.5)
6*	500 (3.4)	360	8.00 (39.12)	3060 (933.3)

*= comparative example

[0056] As can be seen from the above data, when the matrix resin was a polyurethane copolymer and the composite was molded at a high pressure (2500 psi (17.2 MPa)) as per Example 1, the ballistic resistance substantially better than using the same matrix resin but molding at a low pressure as per Comparative Example 1. This result was consistent when the number of layers was increased from 270 to 315 to 360 as indicated in the examples. Furthermore, it can be seen that a fewer number of layers of the composite formed in accordance with the invention can be employed to obtain similar ballistic properties than with a larger number of layers which were molded under low pressure. As a result, the weight of the composite that is molded under high pressures can be decreased, without sacrificing ballistic properties.

Comparative Examples 7-9

[0057] In Example 7, Example 1 was repeated, except that the matrix resin was Kraton® D1107 styrene-isoprene-styrene block copolymer thermoplastic elastomer and the resin content of the composite layers was 20% by weight. A total of 250 layers of the 2-ply pre-assembly was used to form the test panels, which were molded at 250° F. (121.1° C.) for 30 minutes at a molding pressure of 200 psi (1.4 MPa). The samples tested for their ballistic resistance using the same type of bullet under MIL-STD-662-F. The results are shown in Table 2, below.

[0058] In Example 8, Example 7 was repeated, except that the molding pressure was 2000 psi (13.8 MPa). The samples were tested for their ballistic performance using the same type of bullet, and the results are shown in Table 2, below.

[0059] In Example 9, Example 7 was repeated, except that the molding pressure was 4000 psi (27.6 MPa). The samples were tested for their ballistic performance using the same type of bullet, and the results are shown in Table 2, below.

TABLE 2

Example	Molding Pressure, psi (MPa)	Number of Layers	Areal Density, psf (kg/m ²)	V50, fps (mps)
7*	200 (1.4)	250	7.00 (34.23)	3217 (981.2)
8*	2000 (13.8)	250	7.00 (34.23)	3383 (1031.8)
9*	4000 (27.6)	250	7.00 (34.23)	3225 (983.6)

*= comparative example

[0060] From Table 2, it can be seen that as the molding pressure increased using a composite having a styrene-isoprene-styrene matrix thermoplastic elastomer resin, the ballistic properties were not substantially improved. Thus, the substantial improvement in ballistic properties seen with composites that are formed under high pressure and which utilize the polyurethane matrix are not found in composites which used a thermoplastic elastomer matrix resin.

Comparative Examples 10 and 11

[0061] In Example 10, Example 7 was repeated, except that the matrix resin was an epoxy vinylester resin (Derkane 411) The resin content of the composite layers was also 20% by weight. A total of 250 layers of the 2-ply pre-assembly was used to form the test panels, which were molded at 200° F. (93.3° C.) for 30 minutes at a molding pressure of 200 psi (1.4 MPa). The samples tested for their ballistic resistance using the same type of bullet, and the results are shown in Table 3, below.

[0062] In Example 11, Example 10 was repeated, except that the molding pressure was 889 psi (6.1 MPa). The samples were tested for their ballistic performance using the same type of bullet, and the results are shown in Table 3, below.

TABLE 3

Example	Molding Pressure, psi (MPa)	Number of Layers	Areal Density, psf (kg/m ²)	V50, fps (mps)
10*	200 (1.4)	250	7.00 (34.23)	2362 (720.4)
11*	889 (6.1)	250	7.00 (34.23)	2404 (732.6)

*= comparative example

[0063] Comparative Examples 10 and 11 Table 3 likewise illustrate that substantial improvements in ballistic properties are not obtained when the molding pressure is increased in composites which employ another conventional matrix resin (epoxy vinylester).

Comparative Examples 12 and 13

[0064] In Example 12, Example 10 was repeated, except that the total number of layers was 36. The samples were tested for their ballistic performance using a 9 mm handgun bullet with full metal jacket. The molding pressure was again 200 psi (1.4 MPa). The ballistic results are shown in Table 4, below.

[0065] In Example 13, Example 12 was repeated, except that the molding pressure was 889 psi (6.1 MPa). The samples were tested for their ballistic performance using a 9 mm handgun bullet with full metal jacket, and the results are shown in Table 4, below.

TABLE 4

Example	Molding Pressure, psi (MPa)	Number of Layers	Areal Density, psf (kg/m ²)	V50, fps (mps)
12*	200 (1.4)	36	1.00 (4.89)	1522 (464.2)
13*	889 (6.1)	36	1.00 (4.89)	1502 (458.1)

*= comparative example

[0066] Comparative Examples 12 and 13 similarly show that that substantial improvements in ballistic properties are not obtained when the molding pressure is increased in composites which employ another conventional matrix resin (epoxy vinyl ester) in which the number of layers is decreased. The ballistic improvement is not seen with higher pressures with a handgun bullet.

Example 14

[0067] The aramid ballistic materials of this invention were tested to determine their structural properties. Panels of the same size were formed as in Example 1 under similar conditions, except that the molding pressure was 1500 psi (10.3 MPa). A total of 45 layers were molded and samples measuring 1 inch (2.54 cm) by 6 inch (15.24 cm) were cut from the panels. The structural properties were determined in accordance with ASTM D790, and the results are shown in Table 5, below.

Comparative Example 15

[0068] Example 14 was repeated, except that the molding pressure was 150 psi (1.0 MPa). The structural properties were determined in accordance with ASTM D790, and the results are shown in Table 5, below.

TABLE 5

Example	Molding Pressure, psi (MPa)	Flexural Strength, 1000 psi (MPa)	Flexural Modulus, 1000 psi (MPa)	Deflection, inch (cm)
14	1500 (10.3)	2.16 (14.9)	155.3 (1070)	2.61 (6.63)
15*	150 (1.0)	1.60 (11.0)	100.3 (691)	2.47 (6.27)

*= comparative example

[0069] As can be seen from Table 5, the aramid fiber composites employing the polyurethane matrix resin of this invention that are molded under high pressure are stronger than similar composites that are molded under low pressure. Thus, this invention provides aramid fiber composites that have improved ballistic properties as well as improved mechanical properties.

[0070] Accordingly, it can be seen that the present invention provides a method of making aramid composite ballistic structures that have improved ballistic properties, such as ballistic resistance to high energy rifle bullets, when molded under high pressures as compared with structures that are molded under low pressure. In addition, the same improvements are not seen with the use of other matrix resins.

[0071] Having thus described the invention in rather full detail, it will be understood that such detail need not be strictly adhered to but that further changes and modifications may suggest themselves to one skilled in the art, all falling within the scope of the invention as defined by the subjoined claims.

What is claimed is:

1. A method of making a ballistic resistant composite material having improved resistance to high energy rifle bullets and the like, said method comprising:

providing at least one fibrous layer comprising a network of high tenacity aramid fibers;

coating the fibrous layer with a thermoplastic polyurethane resin; and

molding the fibrous layer at a pressure of at least about 1,500 psi (10.3 MPa).

2. The method of claim 1 wherein at least two fibrous layers are provided, each of said fibrous layers comprising a network of high tenacity aramid fibers, and said method further comprises coating each of said fibrous layers with a thermoplastic polyurethane resin, and molding said fibrous layers at a pressure of at least about 1,500 psi (10.3 MPa).

3. The method of claim 2 wherein said fibrous layers are molded at a pressure of at least about 2000 psi (13.8 MPa).

4. The method of claim 2 wherein said fibrous layers are molded at a pressure of at least about 3000 psi (20.7 MPa).

5. The method of claim 2 wherein said fibrous layers are molded at a temperature of from about 75 to about 260° F. (24 to 127° C.).

6. The method of claim 2 wherein said thermoplastic polyurethane resin is present in an amount from about 1 to about 40 percent by weight of the total weight of the composite.

7. The method of claim 2 wherein said thermoplastic polyurethane resin is present in an amount from about 10 to about 30 percent by weight of the total weight of the composite.

8. The method of claim 2 wherein adjacent fibrous layers are cross-plyed with respect to one another.

9. The method of claim 8 wherein each of said fibrous layers comprise a non-woven fabric in which said fibers are arranged unidirectionally in each layer.

10. The method of claim 9 wherein adjacent fibrous layers are said fibers in said non-woven fibrous layers are arranged unidirectionally in each layer.

11. The method of claim 10 wherein said fibrous layers are cross-plyed at 90° to each other.

12. The method of claim 2 further comprising at least one plastic film in contact with at least one of said fibrous layers.

13. A method for making a ballistic resistant composite material having improved resistance to high energy rifle bullets and the like, said method comprising:

providing a first fibrous layer comprising a network of high tenacity aramid fibers;

coating said first fibrous layer with a first thermoplastic polyurethane resin;

providing a second fibrous layer comprising a network of high tenacity aramid fibers;

coating said second fibrous layer with a second thermoplastic polyurethane resin; and

molding said first and second fibrous layers at a pressure of at least about 1,500 psi (10.3 MPa).

14. The method of claim 13 wherein each of said fibrous layers comprise a non-woven fabric.

15. The method of claim 14 wherein said fibers in each of said first and second fibrous layers are arranged unidirectionally in each layer.

16. The method of claim 15 wherein said fibrous layers are cross-plyed at 90° to each other.

17. The method of claim 14 wherein said fibrous layers are molded at a pressure of at least about 2000 psi (13.8 MPa).

18. The method of claim 14 wherein said fibrous layers are molded at a pressure of at least about 3000 psi (20.7 MPa).

19. The method of claim 14 wherein said fibrous layers are molded at a temperature of from about 75 to about 260° F. (24 to 127° C.).

20. The method of claim 16 wherein said first and second thermoplastic polyurethane resins are present in an amount from about 1 to about 40 percent by weight of the total weight of the each of said layers.

21. The method of claim 20 wherein said first and said second thermoplastic polyurethane resins are the same polyurethane resin.

22. The method of claim 21 wherein said polyurethane resin comprises a copolymer mix of polyurethane resins.

23. The method of claim 21 wherein said fibers in said first and second fibrous layers have a tenacity of at least about 20 g/d.

24. The method of claim 23 wherein said fibers in said first and second fibrous layers have a denier of from about 200 to about 3000.

25. The method of claim 23 further comprising at least one plastic film in contact with at least one of said fibrous layers.

26. An article formed by the method of claim 13.

27. A method for making a ballistic resistant composite material having improved resistance to high energy rifle bullets and the like, said method comprising:

- providing a first non-woven fibrous layer comprising a network of high tenacity aramid fibers;
- coating said first non-woven fibrous layer with a first thermoplastic polyurethane resin;
- providing a second non-woven fibrous layer comprising a network of high tenacity aramid fibers;
- coating said second non-woven fibrous layer with a second thermoplastic polyurethane resin;
- arranging said first and second non-woven fibrous layers such that said first and second non-woven fibrous are oriented with respect to each other; and

molding the first and second fibrous layers at a pressure of at least about 1,500 psi (10.3 MPa).

28. The method of claim 27 wherein said fibrous layers are molded at a pressure of at least about 2000 psi (13.8 MPa), wherein said fibers in each of said first and second fibrous layers are arranged unidirectionally in each layer, and wherein said fibrous layers are cross-plyed at 90° to each other.

29. The method of claim 28 wherein said first and second thermoplastic polyurethane resins are present in an amount from about 10 to about 30 percent by weight of the total weight of the each of said layers.

30. An article formed by the method of claim 29.

31. A method of improving the resistance of a ballistic resistant body armor to high energy rifle bullets and the like, said method comprising:

- providing at least a first fibrous layer comprising a network of high tenacity aramid fibers;
- coating said first fibrous layer with a first thermoplastic polyurethane resin;
- providing at least a second fibrous layer comprising a network of high tenacity aramid fibers;
- coating said second fibrous layer with a second thermoplastic polyurethane resin;
- molding said first and second fibrous layers at a pressure of at least about 1,500 psi (10.3 MPa) to form a molded article; and
- forming the body armor at least in part from said molded article.

32. The method of claim 31 comprising a least about 40 pair of fibrous layers, each of which comprises a network of high tenacity aramid fibers; coating each of said fibers with a thermoplastic polyurethane resin, and molding said fibrous layers at a pressure of at least about 1,500 psi (10.3 MPa) to form said molded article.

33. The method of claim 32 wherein said fibrous layers comprise non-woven fabrics the fibers of which are arranged unidirectionally in each layer, and wherein said fibrous layers are cross-plyed at 90° to each other.

34. The method of claim 33 further comprising at least one plastic film in contact with at least one of said fibrous layers.

35. A ballistic resistant armor article formed by the method of claim 34.

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