



Faculty of Mechanical and Manufacturing Technology

**DEVELOPMENT OF NEW FILAMENT WIRE FROM SUGARCANE
BAGASSE FIBRE REINFORCED THERMOPLASTIC COMPOSITES AS
FEED STOCK FOR FUSED DEPOSITION MODELLING (FDM) USING
EXTRUSION PROCESS**

Nur Shazwanie Binti Rashid

Bachelor's Degree in Manufacturing Engineering Technology (Product Design) with Honours

2018

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NUR SHAZWANIE BINTI RASHID

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DEDICATION

First of all, I would like to express my gratitude to Allah S.W.T. for His blessing and guidance. He's the One who fulfil my invocation. Alhamdulillah, then I would like to dedicate my thesis to my family, especially my mother, Mdm. Haslindawati binti Abdul Kadir, who always support and give advices for me. Their endless love, encouragement and supplication are the most important things happened in my life. In addition, I would like to dedicate this work to my project supervisor, Ts. Mohd Nazri bin Ahmad. He had given a lot of guidance, encouragement, assistance and support to me in completing this project. Lastly, I would like to dedicate my thesis to all my lecturers, assistance engineers and friends who gives me support and guidance in any situation.

ABSTRACT

Fused Deposition Modelling (FDM) is a process in 3D printing technology in producing thermoplastic product by heating the wire filament and builds the part layer by layer. Nowadays, natural fibre is getting popular among researcher to use it in thermoplastic composite either as filler or to reinforce the composite. In this study, sugarcane bagasse is chosen fibre to reinforce Polylactic Acid (PLA) composite to develop a wire filament for FDM. This wire filament developed through extrusion process at the same time, the parameter of the extrusion machine need to analyse. Before the experiment started, the materials were dividing into four ratios. In order to developed the wire filament, some processes such as alkalinised, dried and blending process need to emphasize. Not only that, to determine the appropriate temperature used in extrusion process, the materials through a test named rheology and from there, the viscosity of the material observed to ensure the wire filament in correct viscosity. Based on the rheology results, the optimum temperature for this material is 175 °C. Then, this temperature was used as the reference for the extrusion process.

ABSTRAK

Pemodelan Penyatuan Pemendapan (FDM) adalah proses dalam teknologi percetakan 3D dalam menghasilkan produk termoplastik dengan memanaskan wayar filamen dan membina lapisan demi lapisan. Pada masa kini, serat semulajadi semakin popular di kalangan penyelidik untuk menggunakannya dalam komposit termoplastik sama ada sebagai pengisi atau untuk mengukuhkan komposit. Dalam kajian ini, serat tebu dipilih untuk mengukuhkan komposit Asid Polilaktik (PLA) untuk menghasilkan wayar filamen untuk FDM. Wayar filamen ini dihasilkan melalui proses penyemperitan pada masa yang sama, parameter mesin penyemperitan perlu dianalisis. Sebelum eksperimen bermula, bahan-bahan perlu dibahagikan kepada empat bahagian. Untuk menghasilkan wayar filamen, beberapa proses seperti proses alkalinis, penegeringan dan kisar perlu ditekankan. Bukan itu sahaja, untuk menentukan suhu yang sesuai untuk digunakan dalam proses penyemperitan, bahan akan melalui ujian bernama reologi dan dari situ, kelikatan bahan akan diperhatikan untuk memastikan kelikatan wayar filamen dalam kelikatan yang betul. Berdasarkan keputusan reologi, suhu yang optimum ialah 175 °C. Setreusnya, suhu ini digunakan sebagai rujukan dalam proses penyemperitan.

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TABLE OF CONTENTS

	PAGE
DECLARATION	i
APPROVAL	ii
DEDICATION	iii
ABSTRACT	iv
ABSTRAK	v
ACKNOWLEDGEMENTS	vi
TABLE OF CONTENTS	vii
LIST OF FIGURES	ix
LIST OF TABLES	x
LIST OF ABBREVIATIONS AND SYMBOLS	xi
CHAPTER	
1. INTRODUCTION	1
1.1 Background	1
1.2 Problem Statement	2
1.3 Objective	3
1.4 Scope	3
2. LITERATURE REVIEW	4
2.1 Introduction	4
2.2 Additive Manufacturing	4
2.2.1 Fused Deposition Modelling (FDM)	5
2.2.2 Stereolithography (SLA)	6
2.2.3 Selective Laser Sintering (SLS)	8
2.3 Composite	10
2.3.1 Classification of composite	12
2.3.1.1 Metal Matrix Composites (MMCs)	12
2.3.1.2 Ceramic Matrix Composites (CMCs)	13
2.3.1.1 Polymer Matrix Composites (PMCs)	14

2.4 Polymers	14
2.4.1 Thermoplastic	15
2.4.1.1 Poly Lactic Acid (PLA)	16
2.4.1.2 Acrylonitrile Butadene Styrene (ABS)	17
2.4.1.3 Polypropylene (PP)	17
2.4.2 Thermoset	19
2.5 Natural Fibre	20
2.5.1 Natural Fibre Reinforce Composite	23
2.5.2 Types of Natural Fibre	23
2.5.2.1 Banana Fibre	24
2.5.2.2 Pineapple Leaves Fibre	27
2.5.2.3 Sugarcane Bagasse	31
2.6 Alkali Treatment	34
2.7 Extruder Machine	35
2.7.1 Parts of Extruder Machine	35
2.8 Filament	37
2.9 Temperature and Speed	37
3. METHODOLOGY	39
3.1 Introduction	39
3.2 Flow Chart	39
3.2 Material Preparation	41
3.3.1 Poly Lactic Acid (PLA) as the Matrix	41
3.3.2 Sugarcane Bagasse as the Reinforcement Material	42
3.3.3 Alkaline Treatment in Improving the Fibre Surface	43
3.4 Ratio Composition	45
3.5 Mixing Process	45
3.6 Hot Pressing and Crushing Process	47
3.7 Rheology	49
3.8 Extrusion Process	51
4. RESULT AND DISCUSSION	52
4.1 Introduction	52
4.2 Rheology Analysis	52
4.3 Extrusion Process	58

4.4 Discussions of the Problems	64
5. CONCLUSION AND RECOMMENDATIONS	66
5.1 Conclusion	66
5.2 Recommendations	67
REFERENCES	68

LIST OF FIGURES

Figure 2.1	Types of Additive Manufacturing (AM)	5
Figure 2.2	FDM Process	6
Figure 2.3	SLA Printing Process	7
Figure 2.4	SLS Process	9
Figure 2.5	The Comparison of Surface Between FDM and SLS	10
Figure 2.6	Composites Structure	11
Figure 2.7	Product of Thermoplastic Materials	15
Figure 2.8	Cross-linked for Epoxy Resin	19
Figure 2.9	Classification of Natural Fibre	20
Figure 2.10	Example of Banana Fibre's Extract	21
Figure 2.11	Banana Pseudo-stem	24
Figure 2.12	Banana Fibre	25
Figure 2.13	Production of Pineapple Leaf Fibre	27
Figure 2.14	Above-knee Prosthesis	28
Figure 2.15	Pineapple Leaf Fibres	29
Figure 2.16	Hand Lay-up Composite Sample Before Being Cut Into Various Standards	30
Figure 2.17	Sugarcane Stalk	31
Figure 2.18	The Sugarcane Extractor Machine	32
Figure 2.19	Drying The Bagasse Process	33
Figure 2.20	Components of Extruder Machine	36
Figure 3.1	Flow Chart	40
Figure 3.2	PLA Pearls	41
Figure 3.3	Sugarcane Bagasse	42
Figure 3.4	The Dried Sugarcane Bagasse	43
Figure 3.5	The Fibre Soak with Sodium Hydroxide (NaOH)	44
Figure 3.6	The Mixed and Sieve Process of The Fibre	46
Figure 3.7	Hot Press Machine and Mixture Plate	48
Figure 3.8	Crusher Machine and The Pellets	48
Figure 3.9	The Pellets Were Extrude as for Make The Fibres and PLA	49

	Become Truly Mix	
Figure 3.10	Rheometer Machine	50
Figure 4.1	Graph of The Rheology Test	57
Figure 4.2	The Temperature and Speed Sets on The Extruder	58
Figure 4.3	The Results	58
Figure 4.4	Temperature Used for The Third Trials	59
Figure 4.5	The Extruded Materials	59
Figure 4.6	Temperature and speed used	60
Figure 4.7	The Extruded Materials With 5% Bagasse	61
Figure 4.8	The Temperature and Speed Used	61
Figure 4.9	Materials Melted	62
Figure 4.10	The Materials Stick to Other Materials in The Machine	62
Figure 4.12	The Temperature and Speed Used	63
Figure 4.13	Materials Come Out	63

LIST OF TABLES

Table 2.1	PLA properties	16
Table 2.2	ABS properties	17
Table 2.3	PP properties	18
Table 2.4	Annual production of natural fibres and sources	22
Table 2.5	Chemical compositions of banana fibre	25
Table 2.6	The composition for the specimen	26
Table 2.7	Chemical composition of sugarcane bagasse	32
Table 3.1	Ratio composition of sugarcane bagasse and PLA	45
Table 3.2	Approximate temperature and screw speed parameter	51
Table 4.1	Results for virgin PLA	53
Table 4.2	Results for 5% of sugarcane bagasse	54
Table 4.3	Results for 10% of sugarcane bagasse	55
Table 4.4	Results for 15% of sugarcane bagasse	56

LIST OF ABBREVIATIONS AND SYMBOLS

FDM	-	Fused Deposition Modelling
SCBRP	-	Sugarcane bagasse reinforced plastic
PLA	-	Polylactic Acid
ABS	-	Acrylonitrile Butadiene Styrene
PE	-	Polyethylene
PP	-	Polypropylene
SLA	-	Stereolithography
SLS	-	Selective Laser Sintering
CAD	-	Computer Aided Design
CO ₂	-	Carbon dioxide
MMC	-	Metal Matrix Composites
CMC	-	Ceramic Matrix Composites
PMC	-	Polymer Matrix Composites
HDT	-	Heat deflection temperature
NaOH	-	Sodium hydroxide
ρ	-	Density
m	-	Mass
V	-	Volume
°C	-	Celsius
g	-	Gram
kg	-	Kilogram

CHAPTER 1

INTRODUCTION

1.1 Background

3D printing is not a new as we think. 3D printing turned out to be such a hotly debated issues and they were trusted that it was another innovation while it was protected as mid-1980s. From 1980s until now, this technology is picking up broadly and progressively complex. One of the techniques of 3D printing that widely used is Fused Deposition Modelling (FDM). Since FDM technology is the most prevalent contemporary technology to make products, all manufacturers will compete to deliver better products. So, the first thing should consider for create better products is they need to emphasize the material utilized for the production of the product. The material used or we called as filament will influence the mechanical properties and precision of the printed part, but also its cost.

The filaments are produced from thermoplastic that can blend with other additives or main pure polymers. With the improvement of this technology, numerous explorers are improved composite plastic. Among the methods utilized is to combine thermoplastic with synthetic fibres such as glass fibre. Glass is widely used because of its ability of high quality and solidness, impact resistance, chemical resistance and thermal stability at a low cost (Unterweger, 2014). In any case, this method will give issues that it cannot be discarded. This will influence nature and tourism industry of our nation. Therefore, this

study aims to replace synthetic fibres with natural fibres that can provide better benefits to the environment while reducing manufacturing costs and improving product quality.

1.2 Problem Statement

Additive Manufacturing development has generally been utilized for prototyping application amid the item outline and advancement stage in various mechanical segments. However, 3D printed models have constrained mechanical properties and the printed parts usually cannot fulfil mechanical requirements for practical applications. As a result, this issue has offered rise to another idea of 3D printing procedure in view of adding filaments to the polymeric material grid. It is realized that the polymers created by FDM lose some part of their properties and have a tendency to be less stiff materials (Ting & Shen, 2017). Hence, by adding fibres will be one of the solutions for enhances mechanical properties to the original material. The innovative ventures have additionally shown the enthusiasm on the characteristic fibre like flax, hemp, Jute, coconut and sisal for the production of new things. Natural fibre is a fascinating contrasting option to engineered fibre for the composite innovation. The regular filaments are more affordable and have better solidness in regards to weight appeared differently in relation to fabricated fibre (Pandey, 2015). Therefore, with innovation in plastic composites, a study will be conducted to produce a new product that is wire filament as a feedstock for FDM which are made from a thermoplastic composite that reinforced by sugarcane bagasse.

1.3 Objective

The objectives of this project are:

- i. To develop a new filament wire from sugarcane bagasse fibres reinforced plastic (SCBRP) by using extrusion process.
- ii. To study the flow and deformation of sugarcane bagasse fibres reinforced plastic (SCBRP) by rheology testing.

1.4 Scope

This project will be focused on how to develop a new wire filament from natural fibre which is sugarcane bagasse that will reinforce thermoplastic composites. Furthermore, the types of thermoplastics such as Acrylonitrile Butadiene Styrene (ABS), Polylactic Acid (PLA), Polyethylene (PE) and others need to be studied to identify what type is appropriate and produce stronger structure after mixing to produce such composites. To develop this filament, the determination of which part in sugarcane gives the optimum content of fibre that will give more strength to composite need to be considered. Not only that, some processes such as alkalised, dried and blending process are important to produce the fibre. Furthermore, the parameter in the extruder machine also need to study which are the temperature and speed setting.

CHAPTER 2

LITERATURE REVIEW

2.1 Introduction

This project is to develop a wire filament from sugarcane bagasse as a feedstock for Fused Deposition Modelling (FDM) which is made by extrusion process. This literature review is a combination of information gathered from various sources such as journals, articles, reviews, websites and books. Those sources are related to additive manufacturing, 3D printing, FDM and research about materials used.

2.2 Additive Manufacturing (AM)

Additive manufacturing (AM) or also known as 3D printing, rapid prototyping (RP) or freeform fabrication was inspired by Scott Crump at the end of 80's and was marketed in 1990 (Srivastava, 2017). Industry reports demonstrates that AM is an adaptable advancement and one that still cannot appear to accomplish its full assurance, particularly in the field of composite (Cerneels, Voet, Ivens, & Kruth, 2013). Exactly 3D printing advancements utilize dissolving material to make the layers. Selective Laser Sintering (SLS), Fused Deposition Modelling (FDM) and Stereolithography (SLA) are among the examples of process that utilized for printing. Figure 2.1 shows the types of additive manufacturing processes.

Additive Manufacturing (AM) Processes														
Process	Laser Based AM Processes				Extrusion Thermal	Material Jetting	Material Adhesion	Electron Beam						
	Laser Melting		Laser Polymerization											
Process Schematic														
Name Material	SLS	Green	DMD	Green	SLA	Blue	FDM	Red	3DP	Green	LOM	Red	EBM	Green
	SLM	Green	LENS	Green	SGC	Blue	Robocasting	Red	IJP	Blue	SFP	Red		
	DMLS	Green	SLC	Green	LTP	Blue			MJM	Blue				
			LPD	Green	BIS	Blue			BPM	Blue				
					HIS	Blue			Thermojet	Blue				
Bulk Material Type		Powder	Green	Liquid	Blue	Solid	Red							

Figure 2.1: Types of AM (Sunpreet Singh, 2017)

Today, this technique has become most popular invention in manufacturing industry because of the ability to develop flexible design, high complex and also can reduce the production cycle (Ting & Shen, 2017). Not only that, there are few advantages of RP process especially it can convey parts free of geometrical objectives and gives complete in plan and development (Cerneels et al., 2013).

2.2.1 Fused Deposition Modelling (FDM)

FDM is a standout amongst the most used additive manufacturing technique today because of its capability to make extremely complex geometries, the real research issues have been to adjust capacity to deliver stylish engaging looking items with usefulness (Onwubolu & Rayegani, 2014). FDM technology is a technique build parts layer upon layer by heating thermoplastic material to a semi liquid state and extruding it according to CAD information. Figure 2.2 shows the FDM process.

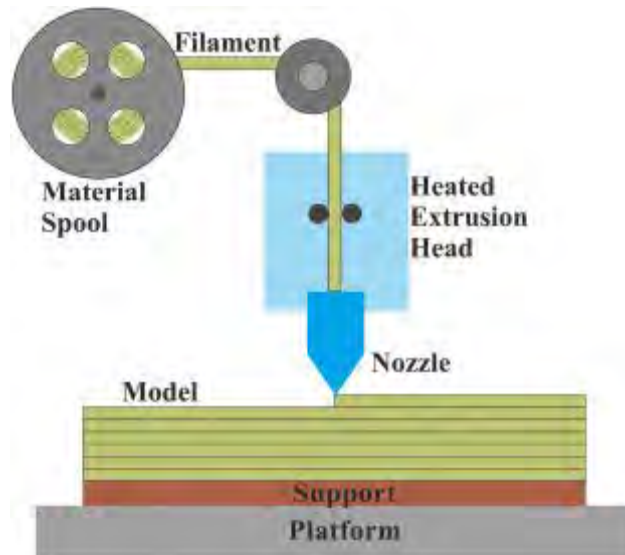


Figure 2.2: FDM Process

In FDM printer, the nozzle is fed a long plastic filament from a spool which are melted and drawn on the platform immediately. Those nozzle moves should put those material in the correct zone on create the model layer by layer. At the point when the layer is drawn, the platform brings down by one layer thickness with the goal that printer may begin for the accompanying layer. FDM utilizes two materials to execute a print work, first showing the material, which goes about as framework (Pandey, 2015).

2.2.2 Stereolithography (SLA)

Stereolithography (SLA or SL; generally called stereolithography contraction, optical manufacture, photo solidifying, or resin printing) is a sort of 3D printing innovation utilized for making models, prototypes, patterns, and generation of parts in a layer by layer fashion utilizing photo polymerization, a procedure by

which light makes chains of atoms connect forming polymers. The model is at first composed through a CAD programming, the CAD information record is changed over into cuts of known measurements and exchanged to the stereolithographic contraption for building (Ruiz et al. , 2015) . The SLA procedure uses vat photo polymerisation. An UV bar or laser shaft is coordinated over a vat with photopolymers. The photopolymers harden when struck by the beam. The fluid vat (bowl) contains a stage that is submerged between each layer and the procedure proceeds until the requested 3D article is made. At the point when the procedure is done, the article is evacuated from the vat. When the article is printed, advance treatment is vital. Figure 2.3 shows the SLA printing process.

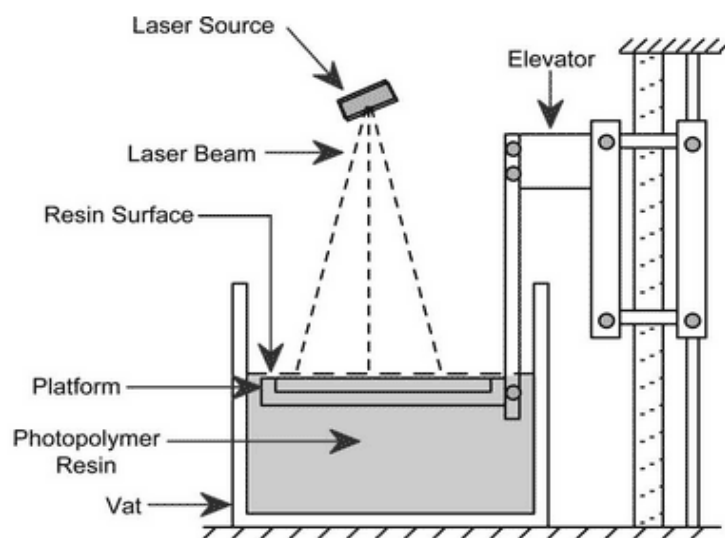


Figure 2.3: SLA Printing Process

Nowadays, SLA becomes the most technique that can develop precise form of part in 3D printing. There are two main types of SLA Technology which are laser based (typically abbreviated as SLA) or projection based (abbreviated DLP

for Digital Light Projection). SLA development is greatly adaptable and it can be utilized when precision is the general need and where frame, fit and get together are essential. The tolerances on a SLA part are usually less than 0.05 mm, and this development offers the smoothest surface complete of any added substance producing process. Considering the level of quality SLA can achieve (case study), It is particularly helpful for making exceptionally exact throwing designs (e.g., for injection moulding (process page), casting and vacuum casting (applications/process page/contextual analysis) as well as functional prototypes (ODM), appearance models (ODM), and for performing structure and fit testing.

2.2.3 Selective Laser Sintering (SLS)

Selective Laser Sintering (SLS) is an additive manufacturing producing process that has a place with the powder bed fusion family. In SLS, a laser specifically sinters the particles of a polymer powder, melding them and building a section layer-by-layer. The materials utilized as a part of SLS are thermoplastic polymers that arrive in a granular form. SLS is utilized for both prototyping of functional polymer component and for small production runs, as it offers high plan flexibility, high precision and produces parts with great and steady mechanical properties, dissimilar to FDM or SLA. The abilities of the innovation can be utilized to its fullest however, just when the architect thinks about its key advantages and confinements. Figure 2.4 shows the SLS process.