



**Faculty of Mechanical and Manufacturing Engineering
Technology**

**STUDY OF FIBER LOADING EFFECT ON THERMAL AND
RHEOLOGICAL PROPERTIES OF BIO COMPOSITE FUSED
FILAMENT FABRICATION**

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Bachelor of Manufacturing Engineering Technology (Product Design) with Honours

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PROPERTIES OF BIO COMPOSITE FUSED FILAMENT FABRICATION**

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ABSTRAK

Kajian ini dijalankan untuk menentukan sifat Fizikal, Termal dan Rheologi bagi variasi jumlah kegunaan menggunakan Kenaf Fiber dengan campuran Acrylonitrile butadiene stirena (ABS) untuk Proses Fabrikasi pencetakan filamen yang menunjukkan dengan menggunakan ujian analisis dan hasil eksperimen. Objektif projek ini adalah untuk mengkaji kesan pemuatan serat pada ciri-ciri komposit serat semula jadi dan untuk mengkaji tingkah laku fizikal, haba dan rheologi komposit serat semulajadi dalam cetakan 3D. Di samping itu, sebagai pencapaian yang perlu dicapai untuk kajian ini, pelbagai skop kajian telah digariskan iaitu pembesaran yang dibuat dalam tekstur serbuk komposit kenaf fiber. Membezakan sifat terma degradasi terma, peralihan kaca, suhu lebur dan haba gabungan menggunakan analisis DSC. Kenal pasti kelikatan sebenar dan kadar ricih yang tinggi menggunakan analisis rajah meter kapilari. Pembuatan filamen untuk gentian kenaf dengan komposit ABS melalui Fabrikasi pencetakan filamen. Kajian penyelidikan ini melibatkan proses penyediaan bahan serbuk serat kenaf dengan jumlah 5%, 7.5% dan 10% dengan campuran ABS. Selepas itu, ujian itu menjalankan sifat fizikal yang memperoleh keputusan penyerapan air dan kandungan lembapan untuk menunjukkan peratusan berat, ketebalan dan pengukuran kandungan. Sudah tentu, kandungan lembapan kenaf serat menyatakan bahawa 0% kandungan serat kenaf dalam ABS adalah 10% lebih rendah daripada serat 5%, 7.5% dan 10% kenaf. Kemudian, sifat termal serat kenaf dilakukan oleh Pengimbangan Calorimetri untuk memperoleh nilai suhu lebur 219.83°C untuk serat kenaf yang serat kenaf 5% menunjukkan 105.48°C peralihan kaca untuk menentukan kemerosotan material atau mengalami perubahan bahan. Selanjutnya, kertas ini membincangkan pengukuran rintangan ricih polimer yang dicairkan oleh rejim kapilari. Penekanan khusus diletakkan pada penyiasatan kesan pemanasan likat dan tekanan ketergantungan kelikatan dalam aliran kapilari. Semasa ujian untuk sifat-sifat reologi, sampel serat kenaf dan ABS pada asalnya berbentuk ketulan kecil, yang dibuat cecair oleh pemanasan dan terpaksa mengalir keluar silinder melalui 5 mm, 20 mm dan 30 mm panjang acuan kapiler dengan 1 mm diameter Keputusan yang diperolehi dari ujian menunjukkan bahawa kelikatan komposit kenaf serat apabila peningkatkan kadar ricih yang tinggi..

ABSTRACT

This research study was carried out to determine the Physical, Thermal and Rheological Properties of variable volume use Kenaf Fiber with the mixture of Acrylonitrile butadiene styrene (ABS) for the Fused Filament Fabrication process that indicate by the using of analysis testing and experimental results. The objective of this project are to study the impact of fiber loading on natural fiber composite characteristics and to investigate the physical, thermal and rheological behavior of natural fiber composite in 3D printed. In addition, as the attainment that need to be achieve for this study, an assorted scope of study have been outlined which is enlargement made in the texture of the kenaf fiber composite powder. Differentiate the thermal properties of thermal degradation, glass transition, melting temperature and heat of fusion using DSC analysis. Identify the true viscosity and high shear rate using capillary rheometer analysis. Fabrication of filament for kenaf fiber with ABS composite through Fused Filament Fabrication. This research study involve a process of material preparation of kenaf fiber powder with volume of 5 %, 7.5 % and 10 % with the mixture of ABS. Thereafter, the test carry out the physical properties which to obtain the results of water absorption and moisture content as to indicate percentage of weight, thickness and content measurement. Certainly, the moisture content of kenaf fibers specify that 0 % of kenaf fiber content in ABS is 10 % degrade than 5 %, 7.5 % and 10 % kenaf fiber. Then, thermal properties of kenaf fiber was carried out by Differential Scanning Calorimetry to obtain melting temperature value of 219.83 °C for kenaf fiber which 5 % kenaf fiber indicate 105.48 °C of glass transition to determine material degradation or undergoes change of substance. Next, this paper discusses shear viscosity measurements of polymer melts by the capillary rheometer. Particular emphasis is placed on investigating the effects of viscous heating and pressure dependence of viscosity in capillary flows. During the test for rheological properties, sample of kenaf fiber and ABS is originally in the shape of granules, which made fluid by heating and forced to flow out of a cylinder through a 5 mm, 20 mm and 30 mm capillary die length with 1 mm diameter. The results obtain from the testing shows that the kenaf fiber composite viscos when increasing of high shear rate.

DEDICATION

This study is dedicated to my beloved parents Mr. Aminallah Jaafar and Mrs. Noorullhamezon Binti Mohd Noor, not to forget to my big family, siblings and ATS-SAC crew who never stop to support me and encourage me to perform this study and completed my bachelor degree.

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TABLE OF CONTENTS

	Page
DECLARATION	i
APPROVAL	ii
ABSTRAK	iii
ABSTRACT	iv
DEDICATION	v
ACKNOWLEDGEMENT	vi
TABLE OF CONTENT	vii
LIST OF TABLES	viii
LIST OF FIGURES	ix
LIST OF APPENDICES	x
LIST OF SYMBOLS	xi
LIST OF ABBREVIATIONS	xii
CHAPTER 1: INTRODUCTION	
1.0 Research Background	1
1.1 Problem Statement	2
1.2 Objective	3
1.3 Scope of Study	3
1.4 Structure of Study	4
CHAPTER 2: LITERATURE REVIEW	
2.0 Introduction	6
2.1 Bio-composite	6
2.1.1 Advantages and Disadvantages of Bio-composite	7
2.1.2 Classification of Bio-composite	8
2.2 Natural Fibre	9
2.2.1 Plant Fibre	10

2.2.2	Application of Plant Fibre	11
2.2.3	Fiber Loading	12
2.2.4	Natural Fiber Composite (NFC)	12
2.2.5	Kenaf Fiber Composite	13
2.3	Polymer Matrix	14
2.3.1	Thermoplastic	15
2.3.2	Polylactic Acid (PLA)	16
2.3.3	Acrylonitrile Butadiene Styrene (ABS)	16
	2.3.3.1 Properties of ABS	17
	2.3.3.2 Application of ABS	18
2.4	Thermal Properties	20
2.4.1	Differential Scanning Calorimetry (DSC) Analysis	21
	2.4.1.1 Glass Transition	21
	2.4.1.2 Melting Temperature	22
	2.4.1.3 Heat of Fusion	23
	2.4.1.4 Degree of Crystallinity	23
2.5	Rheological Properties	24
2.5.1	Capillary Rheometer	24
	2.5.1.1 Non-Newtonian	25
	2.5.1.2 High Shear Rates	26
2.6	Physical Properties	26
2.6.1	Water Absorption	27
2.6.2	Moisture Content	27
2.7	Additive Manufacturing	27
2.7.1	Fused Filament Fabrication (FFF)	28
2.7.2	Selective Laser Melting (SLM)	29
2.7.3	Stereolithography (SLA)	30
2.8	Plastic Extrusion	31
2.8.1	Filament Extruder	33
2.9	Summary	33
 CHAPTER 3: METHODOLOGY		
3.0	Research Methodology	34

3.1	Flow Chart Project Planning Process	35
3.2	Flow Chart Research Planning Process	36
3.3	Gantt Chart	37
3.3.1	Bachelor Degree Project I	37
3.3.2	Bachelor Degree Project II	38
3.4	Fabrication of Specimen	39
3.4.1	Fiber Loading Percentage	39
3.4.2	Sieve Shaker	39
3.4.3	Alkali Treatment	41
3.4.3.1	Sodium Hydroxide (NaOH)	41
3.4.4	Coupling Agent	41
3.4.4.1	Silane Treatment Solution	41
3.5	Plastic Extrusion	42
3.5.1	Twin Screw Extruder Machine Specification	42
3.5.2	Process Parameter Setup	43
3.5.3	Filament Extruder Process Setup	43
3.6	Experimental and Analysis	45
3.6.1	Differential Scanning Calorimetry (DSC) Analysis	45
3.6.1.1	DSC Machine Specification	46
3.6.1.2	Parameter Method	46
3.6.1.3	Experimental Setup	47
3.6.2	Capillary Rheometer Analysis	47
3.6.2.1	Capillary Rheometer Machine Specification	48
3.6.2.2	Parameter Method	49
3.6.2.3	Experimental Setup	49
3.6.3	Physical Properties Experimental	50
3.6.3.1	Water Absorption Experimental Setup	50
3.6.3.2	Moisture Content Experimental Setup	51
3.7	Preliminary Results	52
 CHAPTER 4: RESULTS AND DISCUSSION		
4.0	Introduction	53
4.1	Physical Properties	53

4.1.1	Water Absorption	53
4.1.2	Moisture Content	56
4.2	Thermal Properties	58
4.2.1	Differential Scanning Calorimetry (DSC)	58
4.3	Rheology Properties	60
4.3.1	Capillary Rheometer	61
 CHAPTER 5: CONCLUSION AND RECOMENDATION		
5.0	Introduction	66
5.1	Conclusion	66
5.2	Recommendation	68
 REFERENCES		69
APPENDICES		73
Appendix A		
Appendix B		
Appendix C		
Appendix D		
Appendix E		
Appendix F		
Appendix G		

LIST OF TABLES

	Page
Table 2.1: Classification of Bio Composite	8
Table 2.2: Properties of ABS	18
Table 3.1: Specification of Twin Screw Extruder Machine	43
Table 3.2: Twin Screw Extruder parameter setup	43
Table 3.3: Properties of ABS Pellets	45
Table 3.4: Specification of DSC 4000 System 100 – 240 V / 50 – 60 Hz	46
Table 3.5: Parameter Setup for DSC	47
Table 3.6: Specification of CEAST SmartRHEO20	48
Table 3.7: Parameter Setup for Capillary Rheometer	49
Table 4.1: Results from Water Absorption Test Method	55
Table 4.2: Thermal Properties of the Bio-Composite from DSC Test	59
Table 4.3: Result of Capillary Rheometer on 5 mm Capillary Dies	62
Table 4.4: Result of Capillary Rheometer on 20 mm Capillary Dies	63
Table 4.5: Result of Capillary Rheometer on 30 mm Capillary Dies	65

LIST OF FIGURES

	Page
Figure 2.1: Structure of Natural Fibre (Plant)	9
Figure 2.2: Acrylonitrile Butadiene Styrene Raw Material	17
Figure 2.4: Schematic Diagram Fused Filament Fabrication (FFF)	29
Figure 2.5: Schematic Diagram Selective Laser Melting (SLM)	30
Figure 2.6: Schematic Diagram Stereolithography (SLA)	31
Figure 2.7: Schematic Diagram of Plastic Extrusion	32
Figure 3.1: Flow Chart for Process Planning	35
Figure 3.2: Flow Chart PSM 1 and PSM 2 for Research Planning	36
Figure 3.3: Gantt chart for Bachelor's Degree Project I	37
Figure 3.4: Gantt chart for Bachelor's Degree Project II	38
Figure 3.5: 240 g of Kenaf Powder to Be Sieve in 150 μ m	40
Figure 3.6: GM/ZTS Series Standard Sieve Shaker	40
Figure 3.7: Twin Screw Extruder Machine	42
Figure 3.8: Process of Making Bio composite filament	44
Figure 3.9: ABS Pellets	44
Figure 3.10: DSC 4000 System 100 – 240 V / 50 – 60 Hz	46
Figure 3.11: CEAST SmartRHEO20	48
Figure 3.12: Capillary Die Length of 5 mm, 20 mm, 30 mm	49
Figure 3.13: Water Absorption Experimental Test	51
Figure 3.14: Granule shape sample in Drying Oven	52
Figure 4.1: The Water Absorption and Thickness Swelling with Varying Fiber Loading	56
Figure 4.2: Results of Test Method for Determination Moisture Content in Kenaf Fiber by Loss in Weight	57
Figure 4.3: Graph of DSC Heat Flow versus Temperature	60

Figure 4.4:	Comparison of Viscosity against Shear Rate for Kenaf Fiber with 5 mm Capillary Dies	62
Figure 4.5:	Comparison of Viscosity against Shear Rate for Kenaf Fiber with 20 mm Capillary Dies	64
Figure 4.6:	Comparison of Viscosity against Shear Rate for Kenaf Fiber with 30 mm Capillary Dies	65

LIST OF APPENDICES

	Page
Appendix A: Application Letter for Laboratory Purpose Fakulti Kejuteraan Pembuatan	74
Appendix B: Approve Letter from Fakulti Kejuteraan Pembuatan	75
Appendix C: 5 mm Raw Data for Rheological Test	76
Appendix D: 20 mm Raw Data for Rheological Test	77
Appendix E: 30 mm Raw Data for Rheological Test	78
Appendix F: DSC Testing Parameter Setup at Fakulti Kejuteraan Pembuatan	79
Appendix G: Capillary Rheometer Parameter Setup	80

LIST OF SYMBOLS

%	-	percentage
°C	-	Celcius
mm	-	Millimetre
In	-	Inch
kg	-	Kilogram
g	-	Gram
PSI	-	Pounds per Square Inch
MPa	-	Megapascal
RPM	-	Revolution per Minutes
A	-	Ampere
μL	-	Microlitre
μg	-	Microgram
s ⁻¹	-	Shear Rates
kN	-	Kilonewton
Pa.s	-	Pascal-second

LIST OF ABBREVIATIONS

NFC	-	Natural Fiber Composite
PLA	-	Polylactic Acid
ABS	-	Acrylonitrile Butadiene Styrene
PVC	-	Polyvinyl Chloride
PE	-	Polyethylene
PP	-	Polypropylene
TGA	-	Thermogravimetric Analysis
DSC	-	Differential Scanning Calorimetry
T _g	-	Glass Transition Temperature
H _f	-	Heat of Fusion
AM	-	Additive Manufacturing
FFF	-	Fused Filament Fabrication
SLM	-	Selective Laser Melting
SLA	-	Stereolithography
NaOH	-	Sodium Hydroxide
N ₂	-	Nitrogen Gas
O ₂	-	Oxygen Gas
ASTM E1131	-	Standard Test Method for Compositional Analysis by Thermogravimetric
ASTM D3418	-	Standard Test Method for Transition Temperatures and Enthalpies of Fusion and Crystallization of Polymers
ASTM D3835	-	Standard Test Method for Determination of Properties of Polymeric Materials
ASTM D570	-	Standard Test Methods for Water Absorption of Plastic
ASTM D6980	-	Standard Test Methods for Determination of Moisture in Plastic By Loss in Weight

CHAPTER 1

INTRODUCTION

1.0 Research Background

Since the advent of the moment, natural fibers have occurred in human existence. A Composite material is one of the combination of two different materials with proper properties and produced with the reinforcement of matrix structure. This type of material can be performed in the consuming of less energy than any other fibers therefore they can initiate less pollution for this world. For the past year, many researchers have done their attentiveness in the process of bio-composite. Which are the current industries offers high technology machine also had been attracted to this bio-composite material.

Furthermore, the achievability of manufacturing for the bio-composite products can be throughout for the use of Fused Filament Fabrication (FFF). The using of kenaf fiber composite with a combination of other material such as Acrylonitrile Butadiene Styrene (ABS), as Bio-composite is to produce a sustainable material for the additive manufacturing industry. In the automotive and mechanical sectors, the use of natural fibers has grown significantly. Thus, one of the most commonly used kenaf fibers effectively integrated into a multitude of apps that are becoming progressively essential for the use of kenaf fibers, particularly for plastic strengthening. The environmental and financial benefits of bio-composite are so appealing that countless study has been carried out to enhance the setbacks with these benefits but a few disadvantages of this bio-composite with small mechanical characteristics, heat instability and notable humidity tolerance.

The thermal and rheological properties of a bio-composite are the result of both matrix and fiber properties that depend heavily on the matrix or fiber interface. Furthermore, the mass or volume fraction of the fibers, the fiber aspect ratio of which the length to width ratio is a crucial factor in the properties of natural fibers strengthened by bio-composites. Bio-composite heat disturbance involves degradation of crystallinity, mass and organoleptic degradation characteristics such as odor and color, and can result in gaseous goods at elevated temperature degradation that can produce elevated porosity, low density and decreased mechanical characteristics.

1.1 Problem Statement

The reinforcing effects of kenaf fibers were evaluated at various fiber loadings. This is due to the gradual increase in cellulose and hemicellulose components in the composites, resulting in greater energy loss at the starting temperature. Kenaf fiber has reduced heat strength than the polypropylene (PP) matrix, resulting in a reduced starting temperature and greater weight loss at the starting point. The effect of fiber loading is depending on the weight percent of the kenaf fiber composite which a comparison of the previous study is effected to the weight percent of the kenaf fiber composite that had selected to increase the cellulose and hemicellulose substances.

A disadvantage of this bio-composite material is its poor mechanical characteristics, heat instability and notable resistance to humidity. For all that, to investigate the suitability combination of natural fiber and polymer of kenaf fiber and ABS for 3D printer which the clarification is to experiment on degradation temperature of the material using the thermogravimetric analysis and the melting temperature of the material by differential scanning calorimetry analysis. Despite that, to study the best composition of kenaf fiber with

ABS is based on the viscosity and shear rate which to running an experiment on the capillary rheometer to figure out. This is related to the function of 3D printing to create 3D solid objects from a digital file to produce a product from biodegradable filaments through the additive process.

1.2 Objective

The purpose of this study is to be the focal point on the manufacturing of FFF for the bio composite material. These are the major objective for this study:

- i. To study the effect of fiber loading on natural fiber composite characteristics.
- ii. To investigate the physical, thermal and rheological behavior of natural fiber composite in 3D printed.

1.3 Scope of Study

This study is to complete acknowledge of the experimental for the material testing to create a filament and using on the FFF for making any product to the industry. The combination of kenaf and ABS will produce a bio composite material which more affable surrounding with improve of physical properties as experimental on the material has been done. Furthermore, as the attainment that need to be achieve for this study, an assorted scope of study have been outlined.

- i. Enlargement made in the texture of the kenaf fiber composite powder.
- ii. Differentiate the thermal properties of thermal degradation, glass transition, melting temperature and heat of fusion using DSC analysis.
- iii. Identify the true viscosity and high shear rate using capillary rheometer analysis.

- iv. Fabrication of filament for kenaf fiber with ABS composite through Fused Filament Fabrication.

1.4 Structure of Study

Chapter 1: Briefly explain on the introduction of fibre loading effect on thermal and rheological properties of bio composite fused filament fabrication. An objective is emphasize to be a focal point for this study and scope of the study is determined in order to be a guidelines to complete this study.

Chapter 2: The study of researcher paper for the specific title that related to the scope of study from the journal articles, review study that obtained from online resources. This research will be a benchmark for this study purpose. In short, the aim of a literature review is to provide the reader with information and thoughts on a subject.

Chapter 3: This chapter consist of the methodology for this study which consist guidance to complete this study with the information of material properties, procedure, parameter setup for an experiment process and analysis of the bio composite material.

Chapter 4: This significance result of experiment is stated in this chapter as a discussion to be made with several calculations and theory to determine the thermal and rheological properties of the material.

Chapter 5: Contention on this conclusion of the study that consists and improvement for the future use of bio composite material. A several recommendation is stated to consider the different clarification for this study.