



## **ENVIRONMENTAL PROPERTIES OF BIODEGRADABLE PACKAGING TRAY FROM COCONUT LEAF**



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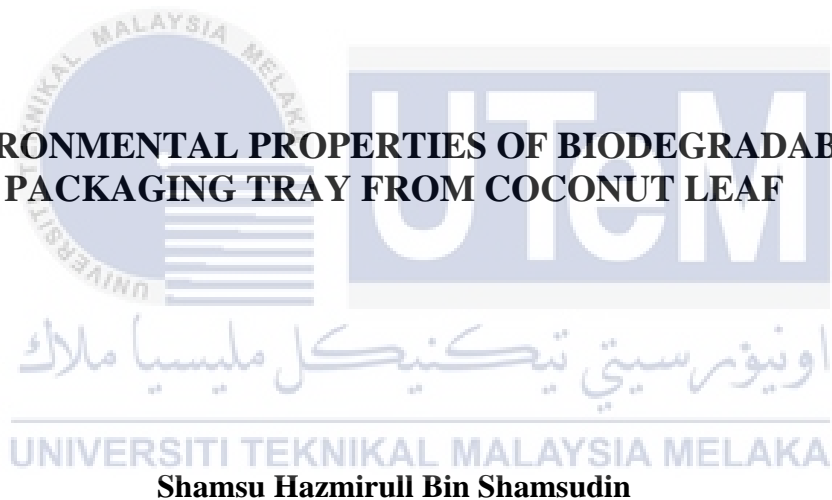
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**Faculty of Mechanical and Manufacturing Engineering  
Technology**

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PACKAGING TRAY FROM COCONUT LEAF**



**Shamsu Hazmirull Bin Shamsudin**

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Honours**

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FROM COCONUT LEAF**

**SHAMSU HAZMIRULL BIN SHAMSUDIN**

**A thesis submitted  
in fulfillment of the requirements for the degree of  
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Honours**



**Faculty of Mechanical and Manufacturing Engineering Technology**

**UNIVERSITI TEKNIKAL MALAYSIA MELAKA**

**UNIVERSITI TEKNIKAL MALAYSIA MELAKA**

**2022**

## DECLARATION

I declare that this thesis entitled “Environmental Properties of Biodegradable Packaging Tray From Coconut Leaf” is the result of my own research except as cited in the references. The thesis has not been accepted for any degree and is not concurrently submitted in candidature of any other degree.

Signature



Name

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Date

: 18/01/2022



## APPROVAL

I hereby declare that I have checked this thesis and in my opinion, this thesis is adequate in terms of scope and quality for the award of the Bachelor of Manufacturing Engineering Technology (Process & Technology) with Honours.

Signature :   
Supervisor Name : Dr. Ridhwan Bin Sumaidin  
Date : 18/01/2022



## DEDICATION

To Al-Quran, the greatest source of knowledge

آتُونِي زُبَرَ الْحَدِيدِ حَتَّى إِذَا سَاوَى بَيْنَ الصَّدَفَيْنِ قَالَ انْفُخُوا حَتَّى إِذَا جَعَلَهُ نَارًا قَالَ آتُونِي أُفْرِغَ عَلَيْهِ قِطْرًا

*Bring me sheets of iron" - until, when he had leveled [them] between the two mountains walls, he said, "Blow [with bellows]," until when he had made it [like] fire, he said,*

*"Bring me, that I may pour over it molten copper." (Al-Kahf: Verse 96)*

&

To my beloved father and mother

&

To my beloved siblings



اونيورسيتي تيكنيكل مليسيا ملاك

UNIVERSITI TEKNIKAL MALAYSIA MELAKA

## ABSTRACT

In recent, the demand for biodegradable materials has become a significant challenge due to the accumulation of non-biodegradable plastic waste. Among several biodegradable materials, thermoplastic cassava starch has been identified as the renewable, biodegradable, also has low-cost resources. However, thermoplastic cassava starch has some drawback such as poor dimensional stability due to highly hydrophilic character. Meanwhile, extensive fall of coconut trees has resulted in waste since only certain parts of the coconut tree were utilised, while other part such as the leaf were often discarded as waste. Hence, the aim of this study is to utilised the coconut leaf in the development of a biodegradable packaging from thermoplastic cassava starch reinforced with coconut leaf fibre. In this study, coconut leaf fibre will be used to enhance the shortcomings of cassava starch biopolymer in various fiber content i.e 0 wt%, 10wt%, 20wt%, 30wt% and 40wt% . The effect of coconut leaf fibre on the environmental, water affinity, and morphological properties will be investigated. All of the materials were blended together uniformly before being manufactured by utilizing hot compression moulding. Following that, the properties of TPCS/coconut leaf fibre biopolymer composites were investigated in order to assess their potential as biodegradable reinforcements. The finding shows that the highest percentage of fibre at 40wt% shows the the lowest moisture content which indicates improvement in the stability of the materials. The incorporation of coconut leaf fiber was found to decrease the water absorption and thickness swelling of the composite. In terms of water solubility, it was discovered that the weight reduction decreases as the fibre content increases. Meanwhile, biodegradation was determined by the soil burial and results show decreased weight loss after increased loading of coconut leaf fiber in the polymeric matrix. According to the FTIR analysis, the result demonstrates the presence of bonding between the fiber and TPCS, while the SEM demonstrates the changing microstructure of the composite as the fibre concentration increases which is the appearance of more coconut leaf fibre and void on the surface. In term of development of packaging product, composite with fiber content of 20% was used. The product developed has length of 13 cm, thickness 0.3 cm and width of 8cm. Generally, the product was successfully developed and functioning as a tray. In conclusion, TPCS/coconut leaf fibre biopolymer composites have shown improved properties in terms of lower water affinity behavior and better dimensional stability compare to the TPCS matrix. This material has a wide range of potential particularly in packaging applications. Therefore, this material can become an alternative for non-biodegradable bioplastic in the future and the natural waste can be fully utilized.

## ABSTRAK

Sejak kebelakangan ini, permintaan untuk bahan biodegradasi telah menjadi cabaran besar kerana pengumpulan sampah plastik yang tidak terbiodegradasi. Di antara beberapa bahan terbiodegradasi, termoplastik kanji telah dikenalpasti sebagai bahan terbaru, terbiodegradasi, dan mempunyai sumber kos rendah. Walaubagaimanapun, pati ubi kayu termoplastik mempunyai beberapa kekurangan seperti kestabilan dimensi yang buruk kerana sifat hidrofilik yang sangat tinggi. Sementara itu, sisa pohon kelapa yang gugur mengakibatkan sampah tatkala hanya beberapa bahagian pokok kelapa yang digunakan, sementara beberapa bahagian lain seperti daun sering dibuang sebagai sampah. Oleh itu, tujuan kajian ini adalah untuk memanfaatkan daun kelapa dalam pengembangan kemasan yang dapat terurai dari pati ubi kayu termoplastik yang diperkuat dengan serat daun kelapa. Dalam kajian ini, serat daun kelapa akan digunakan untuk memperbaiki kekurangan biopolimer pati ubi kayu dalam pelbagai kandungan serat iaitu 0% berat, 10% berat, 20% berat, 30% berat dan 40% berat. Kesan serat daun kelapa terhadap persekitaran adalah seperti pertalian air, dan sifat morfologi akan diteliti. Semua bahan telah diadun bersama secara seragam sebelum dihasilkan menggunakan acuan mampatan panas. Berikutan itu, sifat-sifat komposit biopolimer gentian daun kelapa TPCS telah disiasat untuk menilai potensinya sebagai tetulang biodegradasi. Dapatan kajian menunjukkan peratusan tertinggi pada 40% berat menunjukkan kandungan lembapan yang paling rendah, yang menunjukkan peningkatan dalam kestabilan bahan. Penggabungan dengan serat daun kelapa didapati pengurangan penyerapan air dan bengkak ketebalan komposit. Dari segi ketelaruhan air, apabila ujian keterlarutan air dilakukan, didapati bahawa pengurangan berat berkurangan apabila kandungan serat meningkat. Sementara itu, biodegradasi telah ditentukan melalui pengebumian tanah dan hasilnya menunjukkan penurunan berat sampel selepas memuatkan serat daun kelapa dalam matriks polimer. Menurut analisis FTIR, menunjukkan kehadiran ikatan antara serat dan sampel, manakala SEM menunjukkan perubahan struktur mikro komposit apabila kepekatan gentian meningkat iaitu struktur penampilan serat daun kelapa yang lebih banyak dan lompong di permukaan sampel. Dari segi pembangunan produk pembungkusan komposit dengan, sebanyak 20% berat gentian digunakan. Produk yang dibangunkan mempunyai dalam ukuran panjang produk mempunyai 13cm, ketebalannya 0.3cm dan lebar 8cm. Secara amnya, produk in telah berjaya dibangunkan dan berfungsi sebagai dulang. Kesimpulannya, komposit biopolimer gentian serat daun kelapa TPCS/daun kelapa telah menunjukkan sifat yang lebih baik dari segi tingkah laku pertalian air yang lebih rendah dan kestabilan dimensi yang lebih baik berbanding dengan matrik TPCS. Bahan ini mempunyai potensi yang luas, terutamanya dalam aplikasi pembungkusan. Oleh itu, bahan ini boleh menjadi alternatif untuk bioplastik tidak terbiodegradasi pada masa hadapan dan sisa semula jadi boleh digunakan sepenuhnya.



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In the Name of Allah, the Most Gracious, the Most Merciful

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## TABLE OF CONTENTS

	<b>PAGE</b>
<b>DECLARATION</b>	
<b>APPROVAL</b>	
<b>DEDICATION</b>	
<b>ABSTRACT</b>	<b>i</b>
<b>ABSTRAK</b>	<b>ii</b>
<b>ACKNOWLEDGEMENTS</b>	<b>iii</b>
<b>TABLE OF CONTENTS</b>	<b>iv</b>
<b>LIST OF TABLES</b>	<b>vii</b>
<b>LIST OF FIGURES</b>	<b>ix</b>
<b>LIST OF APPENDICES</b>	<b>xvi</b>
<b>CHAPTER 1 INTRODUCTION</b>	<b>1</b>
1.1 Background	1
1.2 Problem Statement	3
1.3 Research Objective	5
1.4 Significance of Study	5
1.5 Scope of Research	5
1.6 Structure of Thesis	6
<b>CHAPTER 2 LITERATURE REVIEW</b>	<b>8</b>
2.1 Introduction	8
2.2 Polymer	8
2.2.1 Synthetic Polymer	9
2.2.2 Application of Polymer	14
2.2.3 Biopolymer	14
2.3 Composite	16
2.3.1 Polymer Matrix Composite	19
2.3.2 Application of Composite	19
2.4 Coconut	20
2.5 Coconut Leaf	22
2.6 Coconut Leaf Fiber	23
2.6.1 Properties of coconut leaf fiber	25
2.6.2 Application of coconut leaf fiber	27
2.7 Starch	28
2.7.1 Starch Composition	29
2.7.2 Application of starch	32
2.7.3 Cassava Starch	33
2.7.4 Potato Starch	36
2.8 Thermoplastic Starch	41

2.8.1	Polymerization of starch	42
2.8.2	Thermoplastic Potato Starch	45
2.8.3	Thermoplastic Cassava Starch	47
2.8.4	Application of Thermoplastic	58
2.9	Thermoplastic Starch Composites	59
2.10	Waxes	61
2.10.1	Synthetics Waxes	64
2.10.2	Natural Waxes	65
2.10.3	Application of Waxes	68
2.11	Plasticizer	70
2.11.1	Glycerol	71
2.11.2	Sorbitol	74
2.12	Packaging Material	77
2.12.1	Packaging Material Types	79
2.13	Summary	81
<b>CHAPTER 3 METHODOLOGY</b>		<b>82</b>
3.1	Introduction	82
3.2	Material	84
3.2.1	Coconut Leaf Fiber	84
3.2.2	Cassava Starch	85
3.2.3	Glycerol	86
3.2.4	Beeswax	87
3.3	Preparation of Sample	88
3.3.1	Preparation of Thermoplastic Cassava Starch	88
3.3.2	Preparation of Thermoplastic Cassava Starch with Beeswax	90
3.3.3	Preparation of Thermoplastic Cassava Starch with Beeswax Reinforced by Coconut Leaf Fiber	91
3.4	Characterization of Samples	93
3.4.1	Moisture of Content	93
3.4.2	Water Absorption	94
3.4.3	Thickness Swelling	95
3.4.4	Water Solubility	96
3.4.5	Soil Burial	97
3.4.6	Fourier Transform Infrared Spectroscopy (FTIR)	98
3.4.7	Scanning Electron Microscopy (SEM)	99
3.4.8	Density	99
3.5	Summary	100
<b>CHAPTER 4 RESULTS AND DISCUSSION</b>		<b>101</b>
4.1	Introduction	101
4.2	Moisture Content	101
4.3	Water Absorption	103
4.4	Thickness Swelling	105
4.5	Water Solubility	108
4.6	Soil Burial	109
4.7	Fourier-Transform Infrared Spectroscopy (FTIR)	111
4.8	Scanning Electron Microscopy (SEM)	114
4.9	Density	118
4.10	Fabrication of Product	120
4.11	Summary	122

<b>CHAPTER 5</b>	<b>CONCLUSION AND RECOMMENDATION</b>	<b>123</b>
5.1	Conclusion	123
5.2	Recommendation for Future Research	125
5.3	Project Potential	126
<b>REFERENCES</b>		<b>130</b>
<b>APPENDICES</b>		<b>139</b>



## LIST OF TABLES

<b>TABLE</b>	<b>TITLE</b>	<b>PAGE</b>
Table 2.1	Comparison between Thermoplastic and Thermosets	12
Table 2.2	The properties of commonly available thermosetting polymers	14
Table 2.3	The coconut fiber characteristic	26
Table 2.4	The several fibral/synthetic composite resin	26
Table 2.5	Amylose and amylopectin in starch	29
Table 2.6	Sources of starch corresponding to the amylose/amylopectin ratio and crystallinity	31
Table 2.7	The commercially available starch and function	32
Table 2.8	The summary of the study from Thermoplastic Cassava Starch from various sources of analysis.	35
Table 2.9	The Summary of Thermoplastic Potato Starch Composite from various resource of references	41
Table 2.10	The most common polymers used in blends with thermoplastic	44
Table 2.11	Thermoplastic potato starch of composites from various resource of references	47
Table 2.12	Thermoplastic cassava starch of composites from various resource of references	49
Table 2.13	Analysis content of cassava roots from variety resources	50
Table 2.14	The main chemical composition of jute fiber and kapok fiber	52
Table 2.15	The general specifications of cassava starch are summarized	58
Table 2.16	The thermoplastic starch composites from various resource of references	60
Table 2.17	Characteristic beeswax	67

Table 2.18	Composition of unhydrolyzed beeswax	67
Table 2.19	The approximate composition of carnauba wax	68
Table 2.20	The classification of waxes	69
Table 2.21	The range of bio glycerol composition	71
Table 2.22	The Different physical and chemical glycerine properties	72
Table 2.23	The properties of sorbitol	75
Table 3.1	General properties of cassava starch	86
Table 3.2	The extracted starch composition	86
Table 3.3	Chemical composition of glycerol from QReC Chemical	87
Table 3.4	Provide general beeswax characteristics.	88
Table 3.5	The calculation for preparation of fiber and thermoplastic cassava starch with beeswax at various percentages	92
Table 4.1	The analysis of variance (ANOVA) of moisture content	103
Table 4.2	The analysis of variance (ANOVA) of water absorption	105
Table 4.3	The analysis of variance (ANOVA) of thickness swelling	107
Table 4.4	The analysis of variance (ANOVA) of water solubility	109
Table 5.1	Material prices of biodegradable coconut leaf tray	127

## LIST OF FIGURES

<b>FIGURE</b>	<b>TITLE</b>	<b>PAGE</b>
Figure 2.1	Molecular Structure of Polypropylene	10
Figure 2.2	Molecular structure of thermoset resins	11
Figure 2.3	Molecular structure of thermoplastic resins	12
Figure 2.4	The difference between thermoplastic and thermoset	13
Figure 2.5	The advantages of using bacillus in the production of biopolymers	16
Figure 2.6	The Structural Composite Material (Continuous)	17
Figure 2.7	The Structural Composite Material (Discontinuous)	17
Figure 2.8	The Major polymer matrix composite fabrication process	17
Figure 2.9	A typical group of composite materials	18
Figure 2.10	Types of composite materials (a) Random fiber (short fiber) (b) Continuous fiber (long fiber) (c) Particlcers (Particulate composite) (d) Flat flakes (Flake composite) (e) Filler (Filler composite)	19
Figure 2.11	Scope of FDM based polymers/composites in various applications	20
Figure 2.12	The coconut tree (Cocos nucifera)	21
Figure 2.13	the content in coconut tree	21
Figure 2.14	The fibers treated with NaOCl, NaOCl / NaOH, treated with NaOCl (c), and treatment with H2O2 (d) obtained with 10x objective in an optical microscope	24
Figure 2.15	The stress-strain diagram of fibers of various coconut tree bits	24
Figure 2.16	The FTIR spectra of raw, H2O2-treated, NaOCl/NaOH-treated, and NaOCl-treated green coconut fibre: (a) natural, (b) H2O2-treated, (c) NaOCl/NaOH-treated, and (d) NaOCl-treated	25

Figure 2.17 The plant fiber classification	26
Figure 2.18 The surface of starch granules under scanning electron microscopy	29
Figure 2.19 The structure of amylose	30
Figure 2.20 The structure of amylopectin	30
Figure 2.21 A representation of starch structure (a) Corn-starch granules (30 $\mu\text{m}$ ), (b) semi-crystalline and amorphous starch growth rings (120–500 nm), (c) crystalline and amorphous lamellae (9 nm), (d) growth rings and blocks internal structures (20–50 nm) (e) Double helices of amylopectin, (f) starch nanocrystals or called crystalline lamellae when starch nanocrystal produced via acid hydrolysis, (g) the molecular structure of amylopectin (0.1–1 nm), (h) the molecular structure of amylose (0.1–1 nm)	31
Figure 2.22 (a) Cassava roots with conical, conical-cylindrical, cylindrical and fusiform shapes ; (b) cross-section of cassava roots; and (c) drawing of root cross-section containing different components including. (1) periderm or bark; (2) sclerenchyma; (3) cortical parenchyma; (4) phloem (1 to 4 = peel); (5) cambium; (6) parenchyma (starch reserves); (7) xylem vessels; and (8) xylem bundles and fibers and table 2.8 Analysis content of cassava roots from variety resources	34
Figure 2.23 Schematic diagram of the structures which (a) linear amylose while (b) branched of amylose and amylopectin	37
Figure 2.24 Illustrates the Scanning electron micrographs of starches separated from different sources: (a) rice, (b) wheat, (c) potato, and (d) maize (bar = 10 $\mu\text{m}$ )	38



Figure 2.25	The Scanning electron micrographs featuring (a) the presence of some small nodules or protuberances on some potato starch granules and (b) surface fragmentation on some potato starch granules	38
Figure 2.26	The structures in potato starch granules: (a) Potato starch granules observed under polarized light showing the characteristic Maltese crosses and alternating amorphous and semi-crystalline rings. (b) Enlargement shows the structure of a semi-crystalline ring with amylose molecules embedded inside the amorphous lamellae and between the double helices of the amylopectin in the crystalline lamellae. (c) Transmission electron microscopy image of the crystalline residue obtained after hydrolyzing amylopectin-rich native A-type waxy maize starch granules with 2.2 N HCl for 18 days at 36 °C, and (d) B-type potato amylopectin starch granules. The preparations were negatively stained with uranyl acetate. Scale bars = 50 nm	40
Figure 2.27	The abstract graphic of starch potato processing	40
Figure 2.28	Schematic representation of the phase transitions of starch during thermal processing and aging	42
Figure 2.29	The starch granules from sugar palm starch	43
Figure 2.30	The biodegradable polymers—classifications	44
Figure 2.31	Graph reading of FT-IR spectra of (a) Thermoplastic cassava starch and jute fiber composite and (b) Thermoplastic cassava starch and kapok fiber composite by different contents of fiber	53
Figure 2.32	Graph pattern of X-ray diffraction for thermoplastic cassava starch and jute fiber composites by different content of fiber	54

Figure 2.33 Graph pattern of X-ray diffraction for thermoplastic cassava starch and kapok fiber composites by different fiber content	54
Figure 2.34 The Scanning Microscopy (SEM) of different composites ; (a) TPCSTPCS/5% jute fiber, (b) TPCS/10% jute fiber, (c) TPCS/15% jute fiber, (d) TPCS/5% kapok fiber, (e) TPCS/10% kapok fiber and (f) TPCS/15% kapok fiber composites	55
Figure 2.35 Mechanical properties of thermoplastic cassava starch reinforced by jute fiber and kapok fiber with different content of fibers (a) stress at maximum load (MPa), (b) Young's modulus (MPa) and (c) strain at maximum load (%)	56
Figure 2.36 Water absorption of (a) TPCS/jute fiber and (b) TPSC/kapok fiber composites	57
Figure 2.37 The classification of waxes	63
Figure 2.38 FTIR spectra reading of (i) CS, (ii) CS-Gly, (iii) CS-Thy and (iv) CS-Gly-Thy films	73
Figure 2.39 Glycerol and/or thymol mechanical properties of maize starch : (i) Tensile strength (MPa), (ii) Elongation at break (%) and (iii) Young's Modulus (MPa)	73
Figure 2.40 Thermogravimetric curves of CS, CS-Gly, CS-Thy and CS-Gly-Thy films	74
Figure 2.41 Thickness screen for glycerol or sorbitol sugar palm starch	75
Figure 2.42 Glycerol and sorbitol impact on the density of PLC films	76
Figure 2.43 The glycerol and sorbitol impact on plasticized SPS films' solubility	76
Figure 2.44 The glycerol and sorbitol effect on plasticized SPS film moisture content	77

Figure 2.45 SPS films plasticized by TGA curves of glycerol and sorbitol	77
Figure 2.46 The standard features required to pack foodstuffs	78
Figure 2.47 The packaging features include innovative packaging, active and smart packaging	79
Figure 2.48 The various types of food packaging products flexibility	80
Figure 3.1 The Research Methodology's Flow	83
Figure 3.2 Process of extracting coconut leaf fiber	85
Figure 3.3 Cassava Starch	85
Figure 3.4 Glycerol contained 99.5% AR grade	86
Figure 3.5 Beeswax	87
Figure 3.6 Preparation The Mixture of Thermoplastic Cassava Starch (TPCS)	89
Figure 3.7 Fabrication The Mixture of Thermoplastic Cassava Starch (TPCS)	89
Figure 3.8 Process Preparation The Mixture of Thermoplastic Cassava Starch with Beswax (TPCS)	91
Figure 3.9 Fabrication The Mixture of Thermoplastic Cassava Starch with Beswax (TPCS)	91
Figure 3.10 Fabrication of Thermoplastic Cassava Starch with Beeswax Reinforced by Coconut Leaf Fiber	93
Figure 3.11 Methodology of Moisture Content	94
Figure 3.12 Methodology of Water Absorption	95
Figure 3.13 Methodology of Thickness Swelling	96
Figure 3.14 Methodology of Water Solubility	97
Figure 3.15 Methodology of Soil Burial	98
Figure 3.16 FTIR Spectroscopy Machine	99
Figure 3.17 Scanning Electron Microscopy (SEM) Machine	99

Figure 3.18 Methodology of Density	100
Figure 4.1 Percentage of Moisture Content of TPCS/Coconut Leaf Fiber with Different Fiber Loading	103
Figure 4.2 Percentage of Water Absorbed of TPCS/Coconut Leaf Fiber with Different Fiber Loading for 0.5 hour and 2 hours	105
Figure 4.3 Percentage of Thickness Swelling of TPCS/Coconut Leaf Fiber with Different Fiber Loading for 0.5 hour and 2 hours	107
Figure 4.4 Result of Water Solubility of TPCS/Coconut Leaf Fiber with different percentage of fiber loading	109
Figure 4.5 Percentage of mass reduction for soil burial testing of TPCS/Coconut Leaf Fiber in 4 weeks and 8 weeks	111
Figure 4.6 FTIR Spectroscopy of TPCS/Coconut Leaf Fiber composite with different percentage of fiber loading	113
Figure 4.7 SEM Micrograph of coconut leaf fiber	116
Figure 4.8 SEM Micrograph of TPCS with 0% coconut leaf fiber (A) 21X Magnification and (B) 100X Magnification	117
Figure 4.9 SEM Micrograph of TPCS with 10% coconut leaf fiber (A) 19X Magnification and (B) 300X Magnification	117
Figure 4.10 SEM Micrograph of TPCS with 30% coconut leaf fiber (A) 100X Magnification and (B) 100X Magnification	117
Figure 4.11 SEM Micrograph of TPCS with 40% coconut leaf fiber (A) 22X Magnification and (B) 100X Magnification	118
Figure 4.12 Density of TPCS/Coconut leaf fiber composite with different percentage of fiber loading	119
Figure 4.13 TPCS/Coconut leaf fiber sample tray	121

Figure 4.14 Application as container for tissue organizers	121
Figure 5.1 TPCS/Beeswas with 20% coconut leaf fiber sample tray	127
Figure 5.2 Application of Thermoplastic Cassava Starch/Beeswax with coconut leaf fiber as skin care, make up and tissue organisers	127
Figure 5.3 Survey on Potential Product at Sayur & Buah (Himalaya & Frozen)	128
Figure 5.4 Survey on Potential Product at TM Jaticraf Group	129



## LIST OF APPENDICES

APPENDIX	TITLE	PAGE
Appendix 5.1	Gantt Chart for PSM 1 Semester 2 2020/2021	139
Appendix 5.2	Gantt Chart for PSM 2 Semester 2 2020/2021 and Semester 2	140
Appendix 5.3	Turnitin Report	142



# CHAPTER 1

## INTRODUCTION

### 1.1 Background

In recent years, the environmental awareness and concern are spreading rapidly throughout the world. One of the factors that contributed to these changes was the enforcement of environmental law regulations (Prachyawarakorn et al.,2013). The use of non-biodegradable plastic contributes to environmental challenges such as water pollution, air pollution, and landfill problems. All of these difficulties have prompted fresh research into the production of biodegradable materials such as thermoplastic starch (TPS), which is derived from natural resources and is easily degradable.

Marichelvam et al., (2019), stated the plastic is widely employed in various industries, particularly the packaging industry; annual production of petroleum-based plastic reached more than 300 million tonnes until 2015, with just around one percent being bioplastic. Recently, around 50% of bioplastic preparations are made from starch because bioplastic-based starch is easy to manufacture and is frequently used in packaging applications. Due to the qualities of starch, as well suited for use in bioplastic manufacturing when combined with glycerol as a plasticizer (Marichelvam et al., 2019). The development of bioplastic has a favourable influence on the environment by lowering the use of fossil fuels and plastic waste, as well as the emission of carbon dioxide.

The usage of conventional thermoplastics has resulted in environmental issues, which has accelerated the development of biodegradable thermoplastic materials. Biodegradable materials are both safe for consumers and environmentally friendly. As a result, the

commendable attempt to limit the use of non-biodegradable plastic and promote the use of biodegradable plastic.

Neat starch has several disadvantages, including a high solubility in water, brittleness, a low melting temperature, and inferior mechanical qualities when compared to synthetic polymer-based materials. Numerous physical and chemical modifications, including as plasticisation, mixing, derivation, and graft copolymerisation, were researched to improve the characteristics of starch. TPS is produced by infusing starch granules with mechanical and thermal energy and a plasticizer. Plasticisers are critical in the production of thermoplastic starch because they enhance starch behaviour by decreasing internal hydrogen bonding between polymer chains while increasing free volume. This results in increased flexibility and processability, as well as increased mobility of molecular chains. Plasticisers' effectiveness is dependent on the similarity of the polymer employed. Plasticisers are available in a variety of different forms, including glycerol, sorbitol, urea, fructose, sucrose, and glycol. However, the most often used plasticisers are those classified as polyols, including glycerol and sorbitol. Numerous studies have been undertaken recently to investigate the potential of specific ionic liquids (ILs) as new starch plasticisers (Jian et al., 2013) . Additionally, in a recent study, fried sunflower oil was used as a plasticiser in thermoplastic starch composites. The characteristics of starch-based materials are improved, demonstrating that they are the most environmentally friendly option for bio-composites (Diyana et al., 2021).