

FABRICATION AND MECHANICAL TESTING OF POLYMER COMPOSITE MATERIALS

Abhinav Kumar Singh¹, Rohit Shrivastava²,

¹M.Tech. Production Engineering Scholar, Department of Mechanical Engineering, S. R. Institute of Management & Technology

²Assistant Professor, Department of Mechanical Engineering, S. R. Institute of Management & Technology
Lucknow, Uttar Pradesh, India

Abstract— High rigidity and a high strength to weight ratio are benefits of polymeric materials reinforced with synthetic fibers like glass, carbon, and aramid over traditional building materials like steel, concrete, and wood. Despite these benefits, synthetic fiber-reinforced polymer composites are becoming less and less common due to their high starting prices, inefficient structural forms, and—most importantly—disastrous environmental effects. On the other hand, one of the key reasons to investigate the possibility of employing natural fibers as reinforcement for polymers is the growing interest in using them as reinforcement in plastics to replace traditional synthetic fibers in several structural applications. Due of this, scientists have concentrated on studying natural fiber composites, also known as bio-composites, which are made of natural or synthetic resins and reinforced with natural fibers. Because renewable raw materials are healthy and do not harm the environment, researchers from all over the globe have been pursuing the production of high-performance engineered materials from renewable resources.

Index Terms— Composite materials, Polymer composite material, tensile test, impact test etc.

I. INTRODUCTION

A composite is mixture of two materials in which one of the materials, known as the reinforcing phase, is in the structure of fibers, sheets, or particles, and is embedded in the other materials known as the matrix phase. The reinforcing fabric and the matrix material can be metal, ceramic, or polymer. Composites usually have a fiber or particle segment that is stiffer and more suitable than the continuous matrix segment and serve as the primary load carrying members. The matrix acts as a load switch medium between fibers. The matrix is greater ductile than the fibers and thus acts as a source of composite toughness. The matrix additionally serves to guard the fibers from environmental damage before, for the duration of and after composite processing. When designed properly, the new mixed material reveals higher strength than would each character material. Composites are used now not only for their structural properties, however additionally for electrical, thermal, tribological, and environmental applications.

A. CLASSIFICATION OF COMPOSITES

Composite materials are commonly classified at following two distinct levels

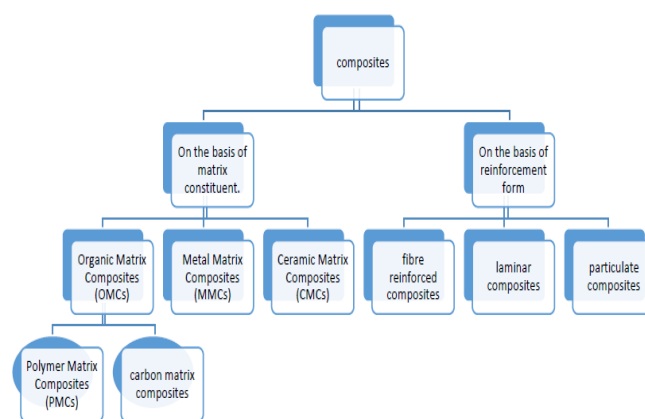


Fig.1.1- Classification of composite materials

B. OBJECTIVE OF THE STUDY

The main objective is to study and evaluate the mechanical and physical properties of polycarbonate granules as a reinforcement material in the epoxy resin matrix. A series of composite material will be developed by varying the weight% of polycarbonate granules that is 2%, 3%, 4% & 5%. And testing will be performed in order to analyze the mechanical properties of the developed material. The various tests include tensile test, impact test & bending test,

- To develop a series of polymer composite material by varying percentage of polycarbonate granules.
- To evaluate the physical mechanical characterization for the developed composite materials.
- Based on the strength of the composites suitable application will be predicted for automobile applications.

II. METHODOLOGY AND EXPERIMENTATION

A. MATERIAL SELECTED

a. Polycarbonate:

Polycarbonates (PC) are a crew of thermoplastic polymers containing carbonate agencies in their chemical structures. Polycarbonates used in engineering are strong, challenging materials, and some grades are optically transparent. They are without difficulty worked, molded, and thermoformed. Because of these properties, polycarbonates discover many applications.



Fig. 2.1- Polycarbonate granules

Properties of Polycarbonate:-

Physical properties-

- Density- 1.2- 1.22 g/cc
- Refractive index- 1.584-1.586

Mechanical properties:

- Young's modulus- 2.0-2.4 Gpa
- Tensile strength- 55-75 Mpa

Thermal properties:

- Melting temperature- 155 degrees
- Thermal conductivities- 0.19- 0.22 W/(m-K)

b. Epoxy:

Epoxy may be a term used to denote each the fundamental parts and therefore the cured finish products of epoxy resins, further as a conversational name for the epoxide functional group. Epoxy resins, additionally called poly epoxides area unit a category of reactive pre- polymers and polymers that contain epoxide teams. Epoxy resins are the foremost ordinarily used resins. they're low relative molecular mass organic liquids containing epoxide groups. Epoxide has 3 members in its ring: one atomic number 8 and 2 carbon atoms. The reaction of epichlorohydrin with phenols or aromatic amines makes most epoxies and fillers are supplemental to provide epoxies with a large vary of properties of consistence, impact, degradation, etc. the room temperature properties of a typical epoxy. though epoxy is costlier than different polymer matrices, it's the foremost common PMC matrix. over two- thirds of the

compound matrices utilized in region applications are epoxy based mostly.

Properties of epoxy:

- Better adhesive properties
- Superior mechanical homes (strength and stiffness)
- Improved resistance to fatigue and micro-cracking
- Highly water resistant
- Increased resistance to osmosis
- No unstable products & exothermic response
- Due to polarity of aliphatic hydroxyl crew and ether group promotes electromagnetic bonding
- High strength

c. Epoxy hardener (Araldite HY 951):

Hardener is used as solvent in this project EH-9510 hardener is used. Hardeners are Substances that are added to polymers for aiding in curing of composites. Hardeners are used to enhance the physical properties of epoxy resins such as adhesion, impact strength and to alter the viscosity of the polymer matrix. It also improves the life, lower exothermic and reduce shrinkage.

Applications of epoxy hardeners –

- Solvent free, high coatings.
- Pipeline & tank coatings.
- Adhesives
- Surface tolerant primers for metallic substrate.
- Marine & industrial coatings.

d. Filler:

Fillers are the particles added to materials to:

- Lower the consumption of expensive binder material.
- Better the properties of the mixture material.
- Filler has two types:

Natural filler: Sugarcane – Rice husk, wheat husk, coconut coir.

Synthetic filler: Glass, carbon

Advantages of natural filler over synthetic filler:

- Availability of renewable natural resources
- Satisfactory high specific strength and light weight
- Low cost and bio-degradability
- Eco-friendly

e. Sugar cane waste:

Sugar will used filler material. Sugarcane trash (or cane trash) is a wonderful biomass resource in sugar- producing countries worldwide. the number of cane trash manufacture depends on the plant selection, age of the crop at harvest and soil and weather. Cane waste bin doubtless be reborn into heat and electricity. This trash contains twenty eight.6%- organic carbon, 0.35 to 0.42% N, 0.04 to 0.15% phosphorus, 0.50 to 0.42% atomic number 19. The sugarcane trash incorporation

within the soil influences physical, chemical and biological properties of the soil.

B. CALCULATIONS

- Volume of specimen = 25 x 20 x 0.4 cc
- Density of natural fiber = 0.904 gm/cc
- Density of epoxy = 1.2 gm/cc
- Density of polycarbonate = 1.8 gm/cc
- Volume of specimen = 25x20 x .4 cc
- Density of natural fiber = 0.904 gm/cc
- Density of epoxy = 1.2 gm/cc
- Density of polycarbonate = 1.8 gm/cc

1) Table of calculation:

The following table represents the percentage composition of material taken for the preparation of the different samples

Table 1- Percentage Composition

Sample No	Epoxy	Natural fiber	Polycarbonate
1	83%	15 %	2%
2	82%	15 %	3%
3	81%	15 %	4%
4	80%	15 %	5%

The following four table represents the mass of the different material taken for the preparation of the different specimen (calculated according to their density and percentage composition)

Table 2-Mass Calculation For Different Samples

SAMPLE NO- 1

	Epoxy	Natural fiber	Polycarbonate	methyl chloride
Volume (cc)	166	30	4	50 ml
Mass (gm.)	199.7	27.12	7	
Mass with allowance (10%)	219.12	29.83	7.92	

SAMPLE NO- 2

	Epoxy	Natural fiber	polycarbonate	methyl chloride
Volume (cc)	164	30	6	50 ml
Mass (gm.)	196.8	27.12	10.8	
Mass with allowance (10%)	216.48	29.93	11.89	

SAMPLE No. 3

	Epoxy	Natural fiber	polycarbonate	Methylchloride
Volume	162	30	8	50 ml
Mass	194.4	27.12	14.4	
Mass with allowance (10%)	213.84	29.83	15.84	

III. FABRICATION OF COMPOSITE

- Compression moulding process
- Hand lay-up method

A. Compression moulding process

Compression molding is a method of moulding in which the moulding material, usually preheated, is first positioned in an open, heated mold cavity. The mold is closed with a top pressure or plug member, pressure is applied to pressure the material into contact with all mould areas, while heat and stress are maintained until the molding material has cured.

B. Mold Preparation

- We have prepared a mold of 25x20x0.4 cc
- We took a smooth tile and placed OHP sheet on that tile and draw a margin of 25x20 on the sheet and used 2mm thick double sided tape to provide thickness of 4mm.
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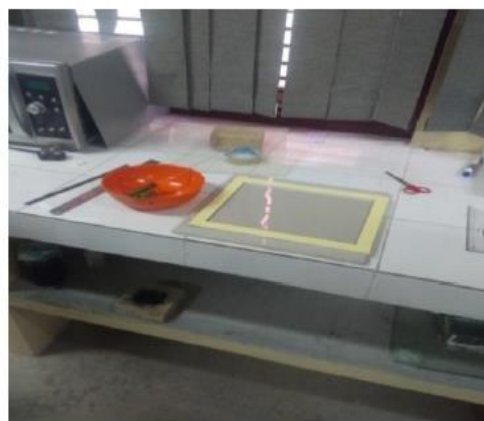


Figure 3.1- Mold preparation

C. Sheet Preparation:

- We took 50ml of methyl chloride and added mass of polycarbonate according to our calculations
- Then kept it for 30 minutes so that pc granules could dissolve in methyl chloride.

- Then we took epoxy natural fiber and previously dissolved pc granules in a beaker and mixed them with the help of blender.
- We put this mixture in mold that we had already prepared with appropriate dimensions.
- With the help of roller, we spread the mixture into the mold properly and took care of bubble formation.



Figure 3.2- Mixing of Epoxy polycarbonate



Figure 0.5- Dog-bone shape

F. Tensile test :

The tensile strength of a material is that the most quantity of tensile stress that it will take before failure. The usually used specimen for tensile check is that the dog-bone kind. throughout the check a uniaxial load is applied through each the ends of the specimen. The dimension of specimen is (17x2x2)cm. Typical purposes of interest once testing a material include: final durability (UTS) or peak stress; offset yield strength (OYS) that represents a degree simply on the far side the onset of permanent deformation; and therefore the rupture (R) or fracture point wherever the specimen separates into pieces. The tensile check is performed within the universal testing machine (UTM) Instron 1195 and results are analyzed to calculate the tensile strength of composites.

D. Curing Time:

- After preparing the mold we put it under room temperature up to 48 hours with some weight over weight it.
- After 48 hours it becomes flexible sheet and then we put it under furnace about 3 hours under temperature 65 degree Celsius.



Figure 3.3- Sample sheet

E. Cutting Of Sample in desired dimension:

A Rack saw blade was used to cut each laminate into smaller pieces, for various experiments

Tensile test sample details:

- Sample was cut into dog bone shape (17x2x2) cm

IV. RESULTS AND DISCUSSION

A. TENSILE TEST RESULTS

ASTM D638 is one of the most common plastic strength specification and cover the tensile properties of unreinforced and reinforced plastic this test approach uses wellknown “dumbbell” Or “dog bone” shape. A widespread checking out m/c is needed to perform this test.

Table 0-1-Tensile Tests Results

S.No.	Samples developed depending on percentage of Polycarbonate	Test Result (N/mm ²)			Aggregate Result
		Specimen 1	Specimen 2	Specimen 3	
1	Sample 1 (2%)	21.88	18.21	18.12	19.40
2	Sample 2 (3%)	19.05	18.48	13.72	17.08
3	Sample 3 (4%)	21.1	20.48	20.85	20.82
4	Sample 4 (5%)	17.45	18.22	12.83	16.16

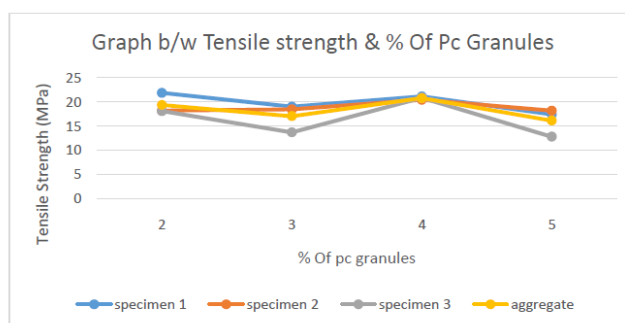


Figure 4.1- Graph between tensile strength & “percentage of pc granules”

B. FLEXURAL STRENGTH TEST RESULT

Bend test (also flex or flexural testing) is commonly performed to measure the flexural strength. This test is performed on universal testing machine with a 3 point or 4 point bend fixture.

Table 0-2 – Flexural test Results

S.No.	Samples developed depending on percentage of Polycarbonate	Test Result (N/mm ²)			Aggregate Result
		Specimen 1	Specimen 2	Specimen 3	
1	Sample 1 (2%)	66.27	57.10	39.84	54.40
2	Sample 2 (3%)	38.38	38.91	34.02	35.44
3	Sample 3 (4%)	40.11	30.09	28.00	24.06
4	Sample 4 (5%)	35.76	38.18	36.95	36.96

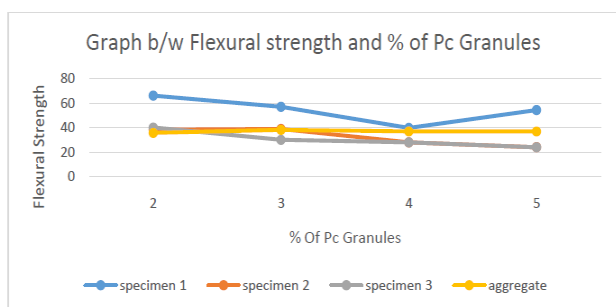


Figure 4.2- Graph between flexural strength and % of pc granules

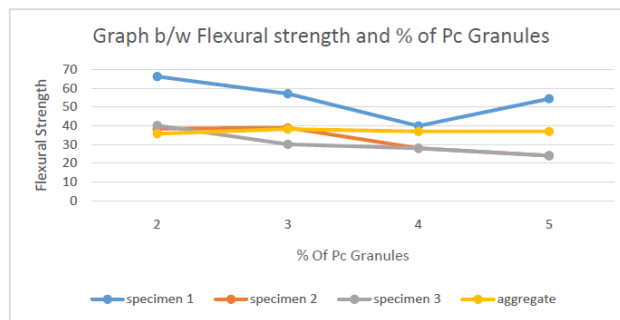


Figure- 4.3 Graph between impact strength & “percentage of pc granules”

V. CONCLUSION:

- A series of polymer composites material has been successfully developed by varying % of polycarbonate.
- Mechanical tests such as tensile, elongation, flexural and impact test were successfully carried as per the ASTM standard.
- Physical characterization such as density and particle size test were carried out successfully.
- Developed composite having 4% polycarbonate is showing good results in tensile test.
- Developed composite having 2% filler by weight is showing good results in flexural strength.
- It is observed that when percentage polycarbonate increases, tensile strength of the specimen increases up to 4% and then it shows decline.
- The impact strength comes out to be maximum at 4% filler content and then it starts decreasing when the percentage of polycarbonate content increases

VI. FUTURE SCOPE:

- As we all know waste management is one of the biggest challenges of the future. As population is increasing rapidly we have to be ready for an alternative resource which can fulfill the demand of people. Sugarcane trash is an agricultural waste material which can be utilized in the development of material. This will minimize the deposition of waste material which is produced by industries and help in waste management.
- Since the strength of developed composite material obtained is low, it can be increased by silage treatment of filler material or by using hybrid filler. We can add thermoplastic like poly carbonate for increasing the toughness of the material, the flexural strength increases by adding the pc and now the flexibility of the sheet has increased and it is no longer brittle and now can bear more load.

C. IMPACT TEST RESULT:

Izod Impact is single point test that measure a substances resistance to have an effect on from a swinging pendulum. Izod influence is defined as the kinetic energy needed to initiate fracture and continue the fracture till the specimen is broken. Izod specimen are notched to prevent deformation of the specimen upon impact. This check can be used as a quick and easy quality manage test to determine if a material meets specific impact residences or to evaluate materials for ordinary toughness.

Table 0-3- Impact Test Results

S.No.	Samples developed depending on percentage of Polycarbonate	Test Result Joules / M			Aggregate Result
		Specimen 1	Specimen 2	Specimen 3	
1	Sample 1 (2%)	6.2	6.1	8.2	6.83
2	Sample 2 (3%)	5.4	7.2	12.5	8.36
3	Sample 3 (4%)	13.1	5.7	15.1	11.3
4	Sample 4 (5%)	5.9	7.3	6.1	6.4

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