

Contents

1	Mechanical Behaviors of Natural Fiber-Reinforced Polymer Hybrid Composites	1
	<i>Adelani A. Oyeniran and Sikiru O. Ismail</i>	
1.1	Introduction	1
1.2	Concept of Natural Fibers and/or Biopolymers: Biocomposites	3
1.2.1	Natural Fiber-Reinforced Polymer Composites or Biocomposites	3
1.2.2	Polymer Matrices	4
1.3	Hybrid Natural Fiber-Reinforced Polymeric Biocomposites	7
1.4	Mechanical Behaviors of Natural Fiber-Reinforced Polymer-Based Hybrid Composites	10
1.4.1	Hybrid Natural FRP Composites	11
1.4.1.1	Bagasse/Jute FRP Hybrid Composites	11
1.4.1.2	Bamboo/MFC FRP Hybrid Composites	12
1.4.1.3	Banana/Kenaf and Banana/Sisal FRP Hybrid Composites	12
1.4.1.4	Coconut/Cork FRP Hybrid Composites	14
1.4.1.5	Coir/Silk FRP Hybrid Composites	15
1.4.1.6	Corn Husk/Kenaf FRP Hybrid Composites	16
1.4.1.7	Cotton/Jute and Cotton/Kapok FRP Hybrid Composites	16
1.4.1.8	Jute/OPEFB FRP Hybrid Composites	18
1.4.1.9	Kenaf/PALF FRP Hybrid Composites	18
1.4.1.10	Sisal/Roselle and Sisal/Silk FRP Hybrid Composites	19
1.5	Other Related Properties that Are Dependent on Mechanical Properties	20
1.5.1	Tribological Behavior	20
1.5.2	Thermal Behavior	21
1.6	Progress and Future Outlooks of Mechanical Behaviors of Natural FRP Hybrid Composites	21
1.7	Conclusions	22
	References	23

2 Mechanical Behavior of Additive Manufactured Porous Biocomposites 27

Ramu Murugan and Mohanraj Thangamuthu

- 2.1 Introduction 27
- 2.2 Human Bone 27
- 2.3 Porous Scaffold 29
- 2.4 Biomaterials for Scaffolds 30
 - 2.4.1 Required Properties of Biomaterials 30
 - 2.4.2 Types of Biomaterials 31
 - 2.4.2.1 Metals 31
 - 2.4.2.2 Polymers 31
 - 2.4.2.3 Ceramics 32
 - 2.4.2.4 Composites 32
- 2.5 Additive Manufacturing of Porous Structures 33
 - 2.5.1 Generic Process of AM 33
 - 2.5.2 Powder Bed Fusion Process 34
 - 2.5.3 Fused Deposition Modeling Process 35
 - 2.5.4 Additive Manufacturing of Porous Biocomposites 35
- 2.6 Design of Porous Scaffold 36
 - 2.6.1 Pore Size 36
 - 2.6.2 Pore Geometry 37
 - 2.6.3 Bioceramics as Reinforcement Material 37
- 2.7 Mechanical Characterization of Additive Manufactured Porous Biocomposites 38
- 2.8 Conclusion 41
- References 41

3 Mechanical and Dynamic Mechanical Analysis of Bio-based Composites 49

R.A. Ilyas, S.M. Sapuan, M.R.M. Asyraf, M.S.N. Atikah, R. Ibrahim, Mohd N.F. Norrahim, Tengku A.T. Yasim-Anuar, and Liana N. Megashah

- 3.1 Introduction 49
- 3.2 Mechanical Properties of Macro-scale Fiber 50
- 3.3 Mechanical Properties of Nano-scale Fiber 50
 - 3.3.1 Factors Affecting Mechanical Properties of Bionanocomposites 50
 - 3.3.1.1 Fabrication Method 51
 - 3.3.1.2 Nanocellulose Loading 53
 - 3.3.1.3 Nanocellulose Dispersion and Distribution 53
 - 3.3.1.4 Nanocellulose Orientation 53
 - 3.3.2 The Static Mechanical Properties of Bionanocomposites 54
- 3.4 Dynamic Mechanical Analysis (DMA) of Biocomposites 55
 - 3.4.1 Single Fiber 57
 - 3.4.1.1 Sugar Palm 57
 - 3.4.1.2 Bamboo 57

3.4.1.3	Kenaf	59
3.4.1.4	Alfa	59
3.4.1.5	Carnauba	59
3.4.1.6	Pineapple Leaf Fiber (PALF)	60
3.4.1.7	Oil Palm Fiber (OPF)	60
3.4.1.8	Red Algae	60
3.4.1.9	Banana	61
3.4.1.10	Flax	62
3.4.1.11	Jute	62
3.4.1.12	Hemp	63
3.4.1.13	Waste Silk Fiber	63
3.4.1.14	Henequen	64
3.4.2	Hybrid Fiber	64
3.4.2.1	Sisal/Oil Palm	64
3.4.2.2	Coir/PALF	65
3.4.2.3	Kenaf/PALF	65
3.4.2.4	Palmyra Palm Leaf Stalk Fiber (PPLSF)/Jute	66
3.4.2.5	Oil Palm Empty Fruit Bunch (OPEFB)/Cellulose	66
3.5	Dynamic Mechanical Properties of Bionanocomposites	66
3.5.1	The Dynamic Mechanical Properties of Bionano composites	67
3.6	Conclusion	68
	References	68

4 Physical and Mechanical Properties of Biocomposites Based on Lignocellulosic Fibers 77

Nadir Ayrlmis, Sarawut Rimdusit, Rajini Nagarajan, and M.P. Indira Devi

4.1	Introduction	77
4.2	Major Factors Influencing Quality of Biocomposites	82
4.2.1	Selection of Natural Fibers	82
4.2.2	Effect of Fiber/Particle Size on the Physical and Mechanical Properties of Biocomposites	85
4.2.3	Effect of Filler Content on the Mechanical Properties of Biocomposites	88
4.2.4	Compatibility Between Natural Fiber/Polymer Matrix and Surface Modification	91
4.2.5	Type of Polymer Matrix	95
4.2.6	Processing Conditions in the Manufacture of Biocomposite	96
4.2.7	Presence of Voids and Porosity	98
4.2.8	Nanocellulose-Reinforced Biocomposites	98
4.2.8.1	Preparation and Properties of Cellulose Nanofibers	101
4.2.8.2	Industrial Applications of Cellulose Nanofibers	101
4.3	Conclusions	103
	References	103

- 5 Machinability Analysis on Biowaste Bagasse-Fiber-Reinforced Vinyl Ester Composite Using S/N Ratio and ANOVA**
Method 109
Balasubramaniam Stalin, Ayyanar Athijayamani, and Rajini Nagarajan
- 5.1 Introduction 109
- 5.2 Experimental Methodology 111
- 5.2.1 Materials 111
- 5.2.2 Specimen Preparation 111
- 5.2.3 Machining of the Composite Specimen 111
- 5.2.4 Selection of Orthogonal Array 111
- 5.2.5 Development of Multivariable Nonlinear Regression Model 113
- 5.3 Results and Discussion 114
- 5.3.1 Influence of Machining Parameters on Thrust Force and Torque 114
- 5.3.2 S/N Ratio 115
- 5.3.3 ANOVA 115
- 5.3.4 Correlation of Machining Parameters with Responses 116
- 5.3.5 Confirmation Test 117
- 5.4 Conclusions 118
- References 118
- 6 Mechanical and Dynamic Properties of Kenaf-Fiber-Reinforced Composites** 121
Brijesh Gangil, Lalit Ranakoti, and Pawan K. Rakesh
- 6.1 Introduction 121
- 6.2 Mechanical Properties of Kenaf-Fiber-Reinforced Polymer Composite 122
- 6.3 Dynamic Mechanical Analysis 124
- 6.4 Storage Modulus (E') of Kenaf Fiber–Polymer Composite 125
- 6.5 Loss Modulus (E'') of Kenaf Fiber–Polymer Composite 125
- 6.6 Damping Factor ($\tan \delta$) 126
- 6.7 Glass Transition Temperatures (T_g) 127
- 6.8 Conclusion 130
- References 131
- 7 Investigation on Mechanical Properties of Surface-Treated Natural Fibers-Reinforced Polymer Composites** 135
Sabarish Radoor, Jasila Karayil, Aswathy Jayakumar, and Suchart Siengchin
- 7.1 Introduction 135
- 7.2 Mechanical Properties of Natural Fibers 135
- 7.3 Drawbacks of Natural Fibers 136
- 7.4 Surface Modification of Natural Fibers 137
- 7.4.1 Chemical Treatment 137
- 7.4.2 Alkaline Treatment 137
- 7.4.3 Silane Treatment 140
- 7.4.4 Acetylation Treatment 143

- 7.4.5 Benzylation Treatment 145
- 7.4.6 Peroxide Treatment 146
- 7.5 Maleated Coupling Agents 147
- 7.5.1 Isocyanate 148
- 7.5.2 Permanganate Treatment 150
- 7.5.3 Stearic Acid Treatment 151
- 7.5.4 Physical Treatment 152
- 7.5.5 Plasma Treatment 152
- 7.5.6 Corona Treatment 154
- 7.5.7 Ozone Treatment 155
- 7.6 Summary 156
- References 156

8 Mechanical and Tribological Characteristics of Industrial Waste and Agro Waste Based Hybrid Composites 163

Vigneswaran Shanmugam, Uthayakumar Marimuthu, Veerasimman Arumugaprabu, Sundarakannan Rajendran, and Rajendran Deepak Joel Johnson

- 8.1 Introduction 163
- 8.2 Materials and Methods 164
- 8.2.1 Scanning Electron Microscopy (SEM) 166
- 8.3 Result and Discussion 166
- 8.3.1 Effect of Chemical Treatment on Fiber 166
- 8.3.2 Mechanical Behavior 167
- 8.3.3 Erosion Behavior 169
- 8.3.3.1 Effect of Fiber Treatment on Erosion Rate 169
- 8.3.3.2 Effect of Red Mud Addition on Erosion Rate 170
- 8.3.3.3 Effect of Impact Angle on Erosion Rate 170
- 8.4 Conclusion 173
- References 173

9 Dynamic Properties of Kenaf-Fiber-Reinforced Composites 175

Rashed Al Mizan, Nur N. Akter, and Mohammad I. Iqbal

- 9.1 Introduction 175
- 9.2 Manufacturing Techniques for Kenaf-Fiber-Reinforced Composites 176
- 9.3 Characterization 177
- 9.3.1 Dynamic Mechanical Analysis (DMA) 178
- 9.3.2 Thermogravimetric Analysis (TGA) 178
- 9.3.3 Vibration-Damping Testing 178
- 9.3.4 Acoustic Properties 179
- 9.4 Overview of the Dynamics Properties of Kenaf-Fiber-Reinforced Composite 179
- 9.4.1 Dynamic Mechanical Properties (DMA) 180
- 9.4.2 TGA Analysis of Composites 184

- 9.4.3 Acoustic Properties 186
- 9.5 Conclusion 187
- References 187

10 Effect of Micro-Dry-Leaves Filler and Al-SiC Reinforcement on the Thermomechanical Properties of Epoxy Composites 191

Mohit Hemath, Govindrajulu Hemath Kumar, Varadhappan Arul Mozhi Selvan, Mavinkere R. Sanjay, and Suchart Siengchin

- 10.1 Introduction 191
- 10.2 Materials and Methods 193
 - 10.2.1 Materials 193
 - 10.2.2 Production of Al-SiC Nanoparticles 193
 - 10.2.3 Fabrication of Epoxy Composites 194
 - 10.2.4 Epoxy Composite Characterization 194
 - 10.2.4.1 Porosity, Density, and Volume Fraction 194
 - 10.2.4.2 Tensile Properties 194
 - 10.2.4.3 Flexural Properties 194
 - 10.2.4.4 Impact Strength 195
 - 10.2.4.5 Dynamic Mechanical Analysis (DMA) 195
 - 10.2.4.6 Morphological Properties 195
- 10.3 Results and Discussion 195
 - 10.3.1 Quality of Fabrication and Volume Fraction of Epoxy Composites 195
 - 10.3.2 Tensile Characteristics 196
 - 10.3.3 Flexural Characteristics 197
 - 10.3.4 Impact Characteristics 198
 - 10.3.5 Dynamic Mechanical Analysis 199
 - 10.3.5.1 Storage Modulus 199
 - 10.3.5.2 Loss Modulus 200
 - 10.3.5.3 Damping Factor 201
 - 10.3.6 Morphological Characteristics 201
- 10.4 Conclusion 201
- References 202

11 Effect of Fillers on Natural Fiber–Polymer Composite: An Overview of Physical and Mechanical Properties 207

Annamalai Saravanakumar, Arunachalam Senthilkumar, and Balasundaram Muthu Chozha Rajan

- 11.1 Introduction 207
- 11.2 Influence of Cellulose Micro-filler on the Flax, Pineapple Fiber-Reinforced Epoxy Matrix Composites 208
- 11.3 Influence of Sugarcane Bagasse Filler on the Cardanol Polymer Matrix Composites 208
- 11.4 Influence of Sugarcane Bagasse Filler on the Natural Rubber Composites 209
- 11.5 Influence of Fly Ash on Wood Fiber Geopolymer Composites 210

- 11.6 Influence of Eggshell Powder/Nanoclay Filler on the Jute Fiber Polyester Composites 211
- 11.7 Influence of *Portunus sanguinolentus* Shell Powder on the Jute Fiber-Epoxy Composite 212
- 11.8 Influence of Nano-SiO₂ Filler on the *Phaseolus vulgaris* Fiber-Polyester Composite 214
- 11.9 Influence of Aluminum Hydroxide (Al(OH)₃) Filler on the Vulgaris Banana Fiber-Epoxy Composite 215
- 11.10 Influence of Palm and Coconut Shell Filler on the Hemp-Kevlar Fiber-Epoxy Composite 216
- 11.11 Influence of Coir Powder Filler on Polyester Composite 217
- 11.12 Influence of CaCO₃ (Calcium Carbonate) Filler on the Luffa Fiber-Epoxy Composite 217
- 11.13 Influence of Pineapple Leaf, Napier, and Hemp Fiber Filler on Epoxy Composite 218
- 11.14 Influence of Dipotassium Phosphate Filler on Wheat Straw Fiber-Natural Rubber Composite 220
- 11.15 Influence of Groundnut Shell, Rice Husk, and Wood Powder Fillers on the *Luffa cylindrica* Fiber-Polyester Composite 220
- 11.16 Influence of Rice Husk Fillers on the *Bauhinia vahlii* – Sisal Fiber-Epoxy Composite 221
- 11.17 Influence of Areca Fine Fiber Fillers on the *Calotropis gigantea* Fiber Phenol Formaldehyde Composite 221
- 11.18 Influence of Tamarind Seed Fillers on the Flax Fiber-Liquid Thermoplastic Composite 223
- 11.19 Influence of Walnut Shell, Hazelnut Shell, and Sunflower Husk Fillers on the Epoxy Composites 223
- 11.20 Influence of Waste Vegetable Peel Fillers on the Epoxy Composite 224
- 11.21 Influence of *Clusia multiflora* Saw Dust Fillers on the Rubber Composite 224
- 11.22 Influence of Wood Flour Fillers on the Red Banana Peduncle Fiber Polyester Composite 225
- 11.23 Influence of Wood Dust Fillers (Rosewood and Padauk) on the Jute Fiber-Epoxy Composite 225
- 11.24 Summary 226
- 11.25 Conclusions 226
- References 231
- 12 Temperature-Dependent Dynamic Mechanical Properties and Static Mechanical Properties of *Sansevieria cylindrica* Reinforced Biochar-Tailored Vinyl Ester Composite 235**
Rajendran Deepak Joel Johnson, Veerasimman Arumugaprabu, Rajini Nagarajan, Fernando G. Souza, and Vigneswaran Shanmugam
- 12.1 Introduction 235
- 12.2 Materials and Method 236

12.2.1	Materials	236
12.2.2	Biochar Characterization	238
12.2.2.1	Particle Size Analyzer	238
12.2.2.2	X-ray Diffraction	238
12.2.2.3	FTIR Spectroscopy	238
12.2.3	Composite Fabrication	239
12.2.4	Dynamic Mechanical Analysis (DMA)	239
12.2.5	Tensile Testing	239
12.2.6	Flexural Testing	240
12.2.7	Impact Testing	240
12.2.8	Scanning Electron Microscopy	240
12.3	Results and Discussion	240
12.3.1	Biochar Characterization	240
12.3.1.1	Particle Analyzer	240
12.3.1.2	Fourier Transform (InfraRed) Spectroscopy	240
12.3.1.3	X-ray Diffraction	242
12.3.2	Dynamic Mechanical Analysis	243
12.3.3	Tensile Tests	247
12.3.4	Flexural Tests	248
12.3.5	Impact Tests	249
12.4	Conclusions	251
	References	251

13	Development and Sustainability of Biochar Derived from Cashew Nutshell-Reinforced Polymer Matrix Composite	255
	<i>Rajendren Sundarakannan, Vigneswaran Shanmugam, Veerasimman Arumugaprabu, Vairavan Manikandan, and Paramasivan Sivaranjana</i>	
13.1	Introduction	255
13.2	Materials and Methods	257
13.2.1	Biochar Preparation	257
13.2.2	Composite Preparation	257
13.2.3	Mechanical Testing	258
13.3	Results and Discussion	258
13.3.1	Tensile Strength	258
13.3.2	Flexural Strength	259
13.3.3	Impact Strength	260
13.3.4	Hardness	260
13.3.5	Failure Analysis of Cashew Nutshell Waste Extracted Biochar-Reinforced Polymer Composites	261
13.3.5.1	Tensile Strength Failure Analysis	261
13.3.5.2	Flexural Strength Failure Analysis	262
13.3.5.3	Impact Strength Failure Analysis	262
13.4	Conclusion	263
	References	263

- 14 Influence of Fiber Loading on the Mechanical Properties and Moisture Absorption of the Sisal Fiber-Reinforced Epoxy Composites** 265
Banisetti Manoj, Chandrasekar Muthukumar, Chennuri Phani Durga Prasad, Swathi Manickam, and Titus I. Benjamin
- 14.1 Introduction 265
- 14.1.1 Sisal Fibers 265
- 14.1.2 Fiber Parameters Affecting Mechanical Properties of the Composite 266
- 14.2 Materials and Methods 266
- 14.2.1 Materials 266
- 14.2.2 Fabrication Method 266
- 14.2.3 Characterization 266
- 14.2.3.1 Tensile Test 266
- 14.2.3.2 Flexural Test 267
- 14.2.3.3 Moisture Diffusion 267
- 14.3 Results and Discussion 267
- 14.3.1 Tensile Properties 267
- 14.3.2 Flexural Properties 269
- 14.3.3 Water Absorption 271
- 14.4 Conclusion 272
- References 272
- 15 Mechanical and Dynamic Properties of Ramie Fiber-Reinforced Composites** 275
Manickam Ramesh, Lakshminarasimhan Rajeshkumar, and Devarajan Balaji
- 15.1 Introduction 275
- 15.2 Mechanical Strength of Ramie Fiber Composites 277
- 15.3 Dynamic Properties of Ramie Fiber Composites 281
- 15.3.1 Temperature Influence 283
- 15.3.2 Storage Modulus 283
- 15.3.3 Viscous Modulus 284
- 15.3.4 Damping Factor 284
- 15.4 Conclusion 288
- References 289
- 16 Fracture Toughness of the Natural Fiber-Reinforced Composites: A Review** 293
Haasith Chittimenu, Monesh Pasupureddy, Chandrasekar Muthukumar, Senthilkumar Krishnasamy, Senthil Muthu Kumar Thiagamani, and Suchart Siengchin
- 16.1 Introduction 293
- 16.1.1 Fracture Toughness Tests 294
- 16.1.2 Mode-I Loading 296
- 16.1.2.1 Double Cantilever Beam Method (DCB) 296

16.1.2.2	Compact Tensile Method (CT)	296
16.1.2.3	Single-Edge Notch Bend Test (SENB)	296
16.1.3	Mode-II Loading	297
16.1.3.1	End-Notched Flexure Test (ENF)	297
16.1.4	Mode-III Loading	297
16.1.4.1	Split Cantilever Beam Method (SCB)	297
16.1.4.2	Edge Crack Torsion Test (ECT)	298
16.1.4.3	Mixed Mode Bend Test (MMB)	298
16.2	Factors Affecting the Fracture Energy of the Biocomposites	298
16.2.1	Fiber Parameters	298
16.2.2	Hybridization	299
16.2.3	Fiber Treatment	299
16.2.4	Aging	301
16.3	Conclusion	302
	Acknowledgments	302
	References	302

17 Dynamic Mechanical Behavior of Hybrid Flax/Basalt Fiber Polymer Composites 305

Arun Prasath Kanagaraj, Amuthakkannan Pandian, Veerasimman Arumugaprabu, Rajendran Deepak Joel Johnson, Vigneswaran Shanmugam, and Vairavan Manikandan

17.1	Introduction	305
17.2	Materials and Methods	307
17.2.1	Materials	307
17.2.2	Fabrication of Composites	307
17.2.3	Dynamic Mechanical Analysis	307
17.3	Result and Discussion	308
17.3.1	Damping Factor ($\tan \delta$) Response of Basalt/Flax Fiber Composite	308
17.3.2	Storage Modulus (E') Response of Basalt/Flax Fiber Composite	308
17.3.3	Loss Modulus Performance of Basalt/Flax Fiber Composites	309
17.4	Conclusions	309
	Acknowledgments	310
	References	310

Index 313