

## Contents

<b>1</b>	<b>Introduction to Epoxy Composites</b>	<b>1</b>
	<i>Harikrishnan Pulikkalparambil, Sanjay Mavinkere Rangappa, Suchart Siengchin, and Jyotishkumar Parameswaranpillai</i>	
1.1	Introduction	1
1.2	Manufacturing Methods for Fabrication of Epoxy Composites	2
1.3	Experimental Techniques for the Characterization of Epoxy Composites	3
1.4	Properties of Epoxy Composites	6
1.4.1	Mechanical Properties	6
1.4.2	Dielectric Properties	9
1.4.3	Water/Moisture Absorption	9
1.4.4	Morphology	11
1.5	Conclusion	13
	References	13
<b>2</b>	<b>Synthesis and Manufacturing of Epoxy Composites</b>	<b>23</b>
	<i>Turup P. Mohan and K. Kanny</i>	
2.1	Introduction	23
2.2	History of Epoxy Resin	23
2.3	Types of Epoxy Resins	24
2.3.1	Bisphenol-A Epoxy Resin	24
2.3.2	Bisphenol-F Epoxy Resin	24
2.3.3	Phenol Novolac Epoxy Resin	25
2.3.4	Cycloaliphatic Epoxy Resin	26
2.3.5	Epoxy Resin Diluents	26
2.3.6	Glycidylamine Epoxy Resin	27
2.4	Curing	27
2.4.1	Curing Agents	27
2.4.1.1	Polyaddition Reactions (Active Hydrogen Compounds)	28
2.4.1.2	Polyamide and Polyamine	28
2.4.1.3	Secondary and Tertiary Amines	30
2.4.2	Anionic and Cationic Initiators	31

2.4.2.1	Imidazole (Anionic Polymerizing)	31
2.4.2.2	Polymercaptan	31
2.4.2.3	Anhydrides	32
2.4.2.4	Canhydrides	32
2.4.2.5	Alicyclic Anhydrides	32
2.4.2.6	Aliphatic Anhydrides	32
2.4.3	Latent Curing Agents	32
2.4.3.1	Light-Curing and Ultraviolet-Curing Agents	33
2.4.3.2	Boron Trifluoride–Amine Complex	33
2.4.3.3	Dicyandiamide	33
2.4.3.4	Organic-Acid Hydrazide	33
2.4.4	Curing Conditions	34
2.4.4.1	Bisphenol-A Epoxy Resin	34
2.4.4.2	Bisphenol-F Epoxy Resin	34
2.4.4.3	Phenol Novolac Epoxy Resin	34
2.4.4.4	Cycloaliphatic Epoxy Resin	34
2.4.4.5	Glycidylamine Epoxy Resin	34
2.5	Reaction Mechanisms	34
2.5.1	Bisphenol-A Epoxy Resin	34
2.5.2	Bisphenol-F Epoxy Resin	35
2.5.3	Phenol Novolac Epoxy Resin	35
2.5.4	Cycloaliphatic Epoxy Resin	35
2.5.5	Epoxy Resin Diluents	36
2.6	Safety and Environmental Factors of Epoxy Resins	36
2.6.1	Bisphenol-A Epoxy Resin, Bisphenol-F Epoxy Resin, Glycidylamine Epoxy Resin, Epoxy Resin Diluents	36
2.6.1.1	Health Risks	36
2.6.1.2	Environmental Issues	36
2.6.2	Phenol Novolac Epoxy Resin	36
2.6.2.1	Health Risks	36
2.6.2.2	Environmental Issues	36
2.6.3	Cycloaliphatic Epoxy Resin	37
2.6.3.1	Health Risks	37
2.6.3.2	Environmental Issues	37
2.7	Manufacturing of Epoxy Composites	37
2.7.1	Open Molding	37
2.7.1.1	Hand Lay-Up	38
2.7.1.2	Spray-Up	39
2.7.1.3	Filament Winding	40
2.7.2	Closed Molding	41
2.7.2.1	Reinforced Reaction Injection Molding (RRIM)	41
2.7.2.2	Vacuum-Assisted Resin Transfer Molding Process (VARTM)	43
2.7.2.3	Light Resin Transfer Molding (LRTM)	44
2.7.2.4	Vacuum Infusion Process (VIP)	45
2.7.2.5	Pultrusion Process	46

2.7.2.6	Vacuum Bag Molding (Wet Bagging)	47
2.7.2.7	Centrifugal Casting	48
2.7.3	Natural Fiber Reinforced Epoxy Composites	49
2.7.3.1	Manufacturing of Natural Fiber Reinforced Epoxy Composites	49
2.8	Preparing of Particulate Filled Epoxy Composites	51
2.8.1	Particle Reinforced Epoxy Composites	51
2.8.2	Nanoparticle-Filled Epoxy Composite	51
2.8.2.1	Method 1	52
2.8.2.2	Method 2	52
2.9	Futuristic Processing of Epoxy-Based Composites	52
2.9.1	Fast Curing Powder Adhesive Epoxy Resin	52
2.9.2	3D Printing	53
2.9.3	Adhesive Method	53
2.9.4	Ultrasonic Fabrication Method for Epoxy Resin/SbSI Nanowire Composites	54
2.9.5	Electron-Beam (E-Beam) Curing	54
2.9.6	Automated Fiber Placement (AFP) Epoxy Resin Composite	54
2.10	Conclusion	54
	References	55
<b>3</b>	<b>Micro- and Nanoscale Structure Formation in Epoxy-Clay Nanocomposites</b>	<b>61</b>
	<i>Seno Jose, V. K. Smitha, Sanjay M. Rangappa, Senthilkumar Krishnasamy, Debabrata Nandi, Suchart Siengchin, and Jyotishkumar Parameswaranpillai</i>	
3.1	Introduction	61
3.2	Micro and Nanoscale Structures of Polymer/Clay Nanocomposites	62
3.3	Evolution of Epoxy-Clay Nanocomposite Structure	65
3.4	Mechanism of Nanocomposite Formation	67
3.5	Conclusion and Future Outlook	72
	References	73
<b>4</b>	<b>Long Fiber-Reinforced Epoxy Composites</b>	<b>83</b>
	<i>Ayesha Kausar</i>	
4.1	Introduction	83
4.2	Long Fiber Fillers	84
4.3	Long Fiber-Reinforced Epoxy Composite	84
4.3.1	Epoxy and Long Glass Fiber Composite	84
4.3.2	Epoxy and Long Carbon Fiber Composite	87
4.3.3	Epoxy and Natural Fiber Composite	90
4.4	Applications, Future Prospective, and Summary	90
	References	92
<b>5</b>	<b>Eco-Friendly Epoxy-Based Composites</b>	<b>97</b>
	<i>Vivek Mishra and Alok Agrawal</i>	
5.1	Introduction	97

5.2	Physical Behavior of Natural Fiber/Filler-Reinforced Epoxy Composites	100
5.3	Mechanical Properties of the Epoxy-Based Composites	103
5.3.1	Tensile Properties	104
5.3.2	Impact Properties	106
5.4	Thermal Behavior of Natural Fiber/Filler-Reinforced Epoxy Composites	108
5.5	Wear Behavior of Natural Fiber/Filler-Reinforced Epoxy Composites	115
5.5.1	Erosive Wear	115
5.5.2	Adhesive Wear	115
5.5.3	Abrasive Wear	116
5.6	Bioepoxy Composites	118
5.7	Conclusion	119
	References	119
<b>6</b>	<b>Processing of Epoxy Composites Based on Carbon Nanomaterials</b>	<b>125</b>
	<i>Lourdes Ramos-Galicia, Juventino López-Barroso, Julio Alejandro Rodríguez-González, Carlos Velasco-Santos, Carlos Rubio-González, and Ana Laura Martínez-Hernández</i>	
6.1	Introduction	125
6.2	Epoxy Nanocomposites Reinforced with 1D and 2D Carbon Materials, Mechanical and Thermomechanical Performance	126
6.3	Tracing of Cure Reaction	136
6.3.1	1D Carbon Nanostructures Influence over the Epoxy Cure Reaction	137
6.3.2	Influence of 2D Carbon Nanostructures Over the Cure Reaction	139
6.3.3	3D Hybrid Carbon Nanostructures over Cure Reaction of Epoxy Nanocomposites	143
6.4	Improved Mechanical Properties of Carbon Fiber Reinforced Polymers (Epoxy) through the Incorporation of Carbon Nanostructures	146
6.4.1	CFRPs (Based Epoxy) Modified with Carbon Nanotubes	147
6.4.2	CFRPs (Based Epoxy) Modified with Graphene-Based Materials	154
6.4.3	CFRPs (Based Epoxy) Modified with Hybrids (Carbon Nanotubes and Graphene)	158
6.5	Concluding Remarks	160
	References	161
<b>7</b>	<b>Thermal Stability and Flame Retardancy of Epoxy Composites</b>	<b>177</b>
	<i>Mohamedismail Fathima Rigana, Tharakan Simi Anne, Sadhasivam Balaji, Shanmugam Chandrasekar, and Muthusamy Sarojadevi</i>	
7.1	Introduction	177
7.2	Effects of Micro Fillers on Thermal Properties of Epoxy Resin	178
7.2.1	Epoxy/Glass Fiber Composites	178

- 7.2.1.1 Bis(4-cyanato-3,5-dimethylphenyl) Naphthyl Methane/Epoxy/Glass Fiber Composites 178
- 7.2.1.2 Epoxy (DGEBA) Resin + CSE (Chlorinated Soy Oil) – Based Epoxy/Glass Fiber Composites 179
- 7.2.1.3 Novolac-Type Epoxy and Isocyanate-Modified Epoxy/Glass Fiber Composites 182
- 7.2.2 Epoxy/Natural Fiber Composites 182
  - 7.2.2.1 Epoxy (DER 331)/Kenaf Fiber Composites 182
  - 7.2.2.2 Epoxy (Ampreg 26)/*Phormium tenax* Composites 185
- 7.2.3 Epoxy/Natural Fiber Hybrid Composites 186
  - 7.2.3.1 Epoxy (Araldite M)/Jute–Glass Fiber Hybrid Composites 186
  - 7.2.3.2 Epoxy/Flax and Sisal–Glass Fiber Composites 186
  - 7.2.3.3 Epoxy (DER 331)/MH (Magnesium Hydroxide)-Kenaf Fiber Composites 187
- 7.3 Effect of Nanofillers on Thermal Properties of Epoxy Resin 188
  - 7.3.1 Epoxy/Clay Nanocomposites 188
    - 7.3.1.1 Epoxy (DGEBA)/Clay Nanocomposites 188
    - 7.3.1.2 Epoxy (E51)/D-clay (Na<sup>+</sup>-MMT) Nanocomposites 189
    - 7.3.1.3 Epoxy (DGEBA)/Cloisite Na+, Cloisite 10A, Cloisite 15, Cloisite 93A Nanocomposites 190
      - 7.3.1.4 Organo Phosphorus Epoxy/Clay Nanocomposite 190
      - 7.3.1.5 Epoxy (DGEBA)/DNA-Modified MMT Clay Nanocomposites 191
  - 7.3.2 Epoxy/CNF Nanocomposites 192
    - 7.3.2.1 Epoxy (SC-15)/Carbon Nano Fiber (PR-24) Nanocomposites 192
  - 7.3.3 Epoxy/CNT Nanocomposites 194
    - 7.3.3.1 CNT/Epoxy Nanocomposites 194
  - 7.3.4 Epoxy/Cellulose Nanofiber Nanocomposites 196
    - 7.3.4.1 Epoxy (D.E.R. 331)/Cellulose Nanofiber Nanocomposites 196
  - 7.3.5 Epoxy/Spherical Metal Oxide Nanocomposites 196
    - 7.3.5.1 Epoxy (Epon 862)/Coreshell Fe@FeO Nanocomposites 196
    - 7.3.5.2 Epoxy (Epon 862)/Polyaniline-Stabilized Silica Nano Composites 199
  - 7.3.6 Epoxy Based Hybrid Nanocomposites 201
    - 7.3.6.1 Epoxy (DGEBA)/CNT/OMPOSS/APP Hybrid Nanocomposite 201
    - 7.3.6.2 Acrylonitrile–Butadiene–Styrene/Brominated Epoxy–Antimony Oxide/Organo Montmorillonite (ABS/BER-AO/OMT) Nanocomposites 202
    - 7.3.6.3 Epoxy/Ag@Cu–Ag@rGO Nanocomposite-Based Conductive Adhesives 203
    - 7.3.6.4 Epoxy/HM-SiO<sub>2</sub>@CeO<sub>2</sub>/NiO Nanocomposites 203
    - 7.3.6.5 Epoxy (Araldite)/Microsilica/Nanoalumina Nanocomposites 204
- 7.4 Epoxy-Based Hybrid Micro and Nanocomposites 204
  - 7.4.1 Epoxy (LY556)–Cloisite 25A OMMT/Glassfiber Micro Nano Composite 204
  - 7.4.2 Epoxy/Glass Fiber (GE) Composites, Epoxy/Glass Fiber/FGO Nanocomposites 205

7.4.3	Epoxy/Glass Fiber (GE) Composites and Epoxy/Glassfiber/Nano Al <sub>2</sub> O <sub>3</sub> Nanocomposites	205
7.4.4	Epoxy/CF/DWCNT-NH <sub>2</sub> Micro-Nanocomposites	206
7.4.5	Epoxy/Carbon Fiber Composites, Epoxy/Carbon Nanotube Membrane/Carbon Nanofiber (CNF) Paper Micro-Nanocomposites	207
7.5	Conclusions	211
	Acknowledgments	212
	References	212
<b>8</b>	<b>Spectroscopy and X-ray Scattering Studies of Epoxy Composites</b>	<b>217</b>
	<i>P. Poornima Vijayan</i>	
8.1	Introduction	217
8.2	In situ Cure Monitoring	218
8.3	Characterization of Interface in Fiber-Reinforced Epoxy Composites	225
8.4	Determination of Residual Stress Developed During Cure	228
8.5	Stress Transmission Studies in Particulate Filled Epoxy Composite	231
8.6	Water Diffusion Studies	232
8.7	Morphological Analysis in Epoxy Composites	233
8.8	Conclusion	236
	References	236
<b>9</b>	<b>Water Absorption Studies in Epoxy Nanocomposites</b>	<b>241</b>
	<i>Bejoy Francis</i>	
9.1	Introduction	241
9.2	Factors Affecting Water Absorption	242
9.3	Effect of Water Absorption on Mechanical Properties	247
9.4	Effect of Water Absorption on Dynamic Mechanical Properties	251
9.5	Effect of Water Absorption on Thermomechanical Properties	253
9.6	Effect of Water Absorption on Dielectric Properties	254
9.7	Conclusion	255
	References	255
<b>10</b>	<b>Fracture Surface and Mechanical Properties of Epoxy Composites</b>	<b>259</b>
	<i>Mehdi Naderi and Farnaz Ebrahimi</i>	
10.1	Introduction	259
10.2	Morphology	266
10.2.1	Dispersion and Interfacial Adhesion	266
10.2.2	Fracture Surface Morphology	273
10.3	Mechanical Properties	278
10.3.1	Stress–Strain Behavior	278
10.3.2	Fracture Toughness	281
10.3.3	Impact Properties	282

10.3.4	Dynamic Mechanical Properties	284
10.3.5	Lap Shear Properties	288
10.4	Conclusions and Outlooks	290
	References	292
<b>11</b>	<b>Dielectric and Conductivity Studies of Epoxy Composites</b>	<b>299</b>
	<i>Anastasios C. Patsidis and Georgios C. Psarras</i>	
11.1	Introduction	299
11.2	Experimental Techniques and Data Interpretation	300
11.2.1	Experimental Techniques	300
11.2.2	Dielectric and Conductivity Data Interpretation	300
11.3	Electrical Properties of Epoxy Resins	302
11.4	Epoxy/Nonconductive Reinforcing Phase Composites	306
11.4.1	Epoxy/Nonconductive Filler Micro-composites	306
11.4.2	Epoxy/Nonconductive Filler Nanocomposites	312
11.5	Epoxy/Conductive Reinforcing Phase Composites	317
11.5.1	Epoxy/Conductive Filler Micro-composites	317
11.5.2	Epoxy/Conductive Filler Nanocomposites	325
11.6	Epoxy-Based Hybrid Composites – Targeting Multifunctionality	332
11.7	Conclusions and Future Trends	343
	References	343
<b>12</b>	<b>Smart Epoxy Composites</b>	<b>349</b>
	<i>Reza Eslami-Farsani and Hossein Ebrahimnezhad-Khaljiri</i>	
12.1	Introduction	349
12.2	Shape Memory Epoxy Polymers and their Composites	350
12.2.1	The Creation of Shape Memory Behavior into Epoxy	350
12.2.2	Shape Memory Behavior in Epoxy-Based Nanocomposites	354
12.2.3	Shape Memory Behavior in Epoxy-Based Composite Structures	358
12.2.4	Shape Memory Wires in the Epoxy Composites	360
12.3	Smart Epoxy Composite Coating	360
12.3.1	Carbon-Based Nanomaterials–Epoxy Coating	364
12.3.2	Clay-Based Nanomaterials–Epoxy Coating	365
12.3.3	Silica-Based Nanomaterials–Epoxy Coating	366
12.3.4	Layered Double Hydroxide-Based Nanomaterials–Epoxy Coating	367
12.3.5	Other Nanoparticles–Epoxy Coating	367
12.3.6	Polymer Micro-/Nanocontainer–Epoxy Coating	368
12.4	Self-Healing Epoxy Polymers and their Composites	371
12.4.1	Self-Healing Behavior	371
12.4.2	Intrinsic Healing System	372
12.4.3	Vascular Healing System	375
12.4.4	Microcapsule Healing System	377
12.5	Future Trends	380
12.6	Conclusion	380
	References	381

**13 Projects Using Composite Epoxy Materials: Applications, Recycling Methods, Environmental Issues, Safety, and Future Directions 395**

*Alencar Bravo and Darli Vieira*

13.1 Introduction and Context of ECM Projects 395

13.2 Different Applications for ECMs 397

13.3 Safety and Environmental Issues of ECM Projects 400

13.4 Recycling Options for ECMs and Pollution Mitigation by Early Design 405

13.5 The Future for ECM Projects and Conclusions 410

References 412

**Index 421**