

Table of Contents

Acknowledgements.....	i
Table of Contents.....	iii
List of Figures.....	ix
List of Tables.....	xv
List of Abbreviations and Symbols.....	xvii
Preface.....	xix
Chapter 1 INTRODUCTION AND LITERATURE REVIEW	1
1.1 INTRODUCTION	1
1.1.1 Composite	7
1.1.1.1 Types of Composite Materials	7
1.1.1.2 Fiberglass for reinforcement	11
1.1.1.3 Natural Fiber Reinforced Polymer Composites.....	13
1.1.1.4 Jute Fibers	16
1.1.1.5 Graphene-based polymer Nanocomposite materials	19
1.1.1.6 3D Printed CFRT composites	27
1.1.1.7 Methods for Synthesis of Nanoparticles and Nanocomposites	31
1.1.2 Machinability of composites.....	35
1.1.2.1 Modeling and Optimisation Techniques used for machining	36
1.1.2.2 Taguchi method	37

1.1.2.3	Taguchi analysis	39
1.1.2.4	ANOVA analysis.....	41
1.1.2.5	Response surface methodology (RSM).....	41
1.1.3	Finite Element Analysis (FEA)	42
1.1.3.1	FEM based analysis and water absorption profile	43
1.1.3.2	Vibrational Study using FEM	45
1.2	RESEARCH GAPS	48
1.3	AIMS AND OBJECTIVES	49
1.4	ORGANISATION OF THESIS	51
Chapter 2	Mechanical behaviour and machining of nanocomposites.....	53
2.1	INTRODUCTION:.....	53
2.2	MATERIALS AND COMPOSITE FABRICATIONS	54
2.2.1	Material details	54
2.2.2	Diffusion of Nano-filler in Epoxy	54
2.2.3	Fabrication of hybrid composites and Nanocomposites	55
2.3	CHARACTERIZATIONS AND MEASUREMENT	57
2.3.4	Resin Burning-off Method	57
2.3.5	Thermal Stability of Polymer Nanocomposites	58
2.3.6	Measurement of the porosity.....	60
2.3.7	Density and specific gravity of composites by displacement method.....	62
2.4	MECHANICAL PROPERTY	62
2.4.1	Tensile Test.....	62
2.5	IMPACT TEST	65

2.6	RESULTS AND DISCUSSION	67
2.6.1	Impact property	71
2.6.1.1	Izod impact	72
2.6.1.2	Effect of different reinforcement	72
2.6.1.3	Notch sensitivity	74
2.6.1.4	Impact strength or resilience.....	76
2.6.2	Charpy impact.....	78
2.6.2.1	Effect of different reinforcement	78
2.6.2.2	Notch sensitivity	80
2.7	MACHINING	81
2.7.1	Experimental Set-up	81
2.7.2	Experimental Design.....	83
2.8	RESULTS AND DISCUSSION	85
2.8.1	Taguchi Analysis and ANOVA	85
2.9	MODELING.....	86
2.10	RESPONSE OPTIMIZATION OF THE MRR OF THE HYBRID COMPOSITES	91
2.11	NANO-FILLERS' EFFECT ON THE MORPHOLOGY OF DAMAGED SURFACES.....	94
2.12	CONCLUSION	97
Chapter 3	Mechanical properties and machining of 3d printed composites.....	99
3.1	INTRODUCTION:	99
3.2	MATERIALS AND COMPOSITE FABRICATIONS	100
3.2.1	Material details	100
3.3	TENSILE TESTS	102

3.4	FLEXURAL (THREE POINT BENDING) TEST	105
3.5	IMPACT TESTS.....	108
3.6	MACHINING.....	111
3.6.1	Experimental Set-up.....	111
3.6.2	Experimental Design.....	112
3.7	DENSITY AND SPECIFIC GRAVITY OF COMPOSITES BY DISPLACEMENT METHOD	114
3.8	THERMAL STABILITY OF POLYMER NANOCOMPOSITES	115
3.9	RESULTS AND DISCUSSION.....	118
3.9.1	Stress–strain curves	118
3.9.2	Tensile strength	120
3.9.3	Ductility.....	120
3.9.4	Elastic modulus	121
3.9.5	Three point bending properties	122
3.9.6	Impact properties.....	124
3.9.6.1	Energy absorption capacity	124
3.9.6.2	Impact strength.....	126
3.9.7	Taguchi Analysis and ANOVA.....	126
3.9.8	Response Optimization of the MRR of the hybrid Composites.....	130
3.10	FRACTOGRAPHY AND FAILURE ANALYSIS	133
Chapter 4	Tribological behaviour of composites under dry environment	139
4.1	INTRODUCTION:.....	139
4.2	MATERIAL AND SYNTHESIS (HAND LAY-UP METHOD)	140
4.3	SLIDING WEAR TESTS (BALL ON DISC).....	140

4.4	DRY WEAR OF FRICTION MATERIAL.....	143
4.5	MATERIAL AND SYNTHESIS (3D PRINTING METHOD).....	143
4.6	SLIDING WEAR TESTS (PIN ON DISC).....	145
4.7	CONCLUDING REMARK.....	147

Chapter 5 Mechanical properties and water absorption profile of gfrp composites..149

5.1	INTRODUCTION:	149
5.2	PROBLEM DESCRIPTION	150
5.3	MICROMECHANICAL MODELING.....	150
5.3.1	Rule of mixture:	150
5.3.2	Nielsen Elastic [175] Model	151
5.3.3	The Halpin-Tsai [115] model.....	151
5.3.4	The Chamis micromechanical [176] model.....	152
5.4	FINITE ELEMENT ANALYSIS USING ABAQUS	152
5.5	COMPUTATIONAL RESULTS AND DISCUSSION.....	154
5.6	EXPERIMENTAL DETAILS	156
5.6.1	Materials and Fabrication of composite.....	156
5.6.2	Sample preparation	157
5.7	MATERIAL CHARACTERIZATION.....	158
5.8	ENERGY-DISPERSIVE X-RAY SPECTROSCOPY (EDS)	161
5.9	MICROSCOPIC EXAMINATION	162
5.10	RESULTS AND DISCUSSIONS.....	162
5.11	CONCLUSION	163

Chapter 6	Vibrational study of nanocomposites	167
6.1	INTRODUCTION.....	167
6.2	F.E. ANALYSIS WAVY CNTs-REINFORCED NANOCOMPOSITE STRUCTURE	169
6.3	MESH CONVERGENCE STUDY.....	172
6.4	RESULTS AND DISCUSSION.....	173
6.4.1	Von mises stress.....	173
6.4.2	Effect of waviness ratio.....	174
6.4.3	Resonance.....	175
Chapter 7	Conclusion and future work.....	185
7.1	SUMMARY OF THE PRESENT WORK	185
7.2	FUTURE WORK.....	194
References.....		197-226
List of Publications.....		227

LIST OF FIGURES

Figure No.	Caption	Page No.
Figure 1.1.	Sectors of the introduction.	7
Figure 1.2.	Classification of composites.....	8
Figure 1.3.	Types of polymer matrix composite based on geometry [13].....	9
Figure 1.4.	Types of ceramic matrix composites based on geometry [14].....	9
Figure 1.5.	Application and fabrication of high-strength aluminum–matrix composites (AMCs) [15].	10
Figure 1.6.	Mat fiber reinforced composites (randomly distributed).	11
Figure 1.7.	Natural fiber reinforcements [17].....	13
Figure 1.8.	Manufacturing of door from hemp fibre [24].....	15
Figure 1.9.	Structure of a jute plant and jute fiber [26].	16
Figure 1.10.	Different structures of carbon nanomaterials (CNMs) [41].	21
Figure 1.11.	Scotch tape method [43].....	22
Figure 1.12.	Additively manufactured composite drone [69].....	27
Figure 1.13.	Different types of 3D printed composites [77].....	28
Figure 1.14.	3D printed vehicles [79].....	29
Figure 1.15.	Hand lay-up method [90].	32
Figure 1.16.	Autoclave process [91].....	33
Figure 1.17.	Pressing process [91].....	34
Figure 1.18.	Main factors to consider when working with hard turning.	35
Figure 1.19.	Modeling and optimisation techniques used by various researches.....	36
Figure 1.20.	Flow chart showing the aims and objectives.....	50
Figure 2.1.	Flow chart for the synthesis of nanocomposites.	55
Figure 2.2.	(a) Woven Jute fiber mat, (b) Woven glass fiber mat, (c) Diameter of fiber calculated from SEM result (=10.16 micron) and with the help of software (=11.405), (d) A burnout tested sample.	56
Figure 2.3.	TGA curves of hybridcomposite and its nanocomposites.....	58
Figure 2.4.	TGA curves of hybridcomposite.	58

Figure 2.5. TGA curves of nanocomposites.....	59
Figure 2.6. Tensile Specimen dimension as per standards ASTM D 638 type-I.....	63
Figure 2.7. Tensile test set-up for investigating the tensile property of nano- composite ...	63
Figure 2.8. Specimen for Tensile test as per standards ASTM D 638 A: Hybrid composites (60 ⁰ ,45 ⁰ ,30 ⁰ ,0 ⁰) _S B: Hybrid composites (0 ⁰ ,0 ⁰ ,0 ⁰ ,0 ⁰) _S C: Nanocomposites (0 ⁰ ,0 ⁰ ,0 ⁰ ,0 ⁰) _S ...	64
Figure 2.9. Different notches of impact test.....	65
Figure 2.10. Resil impact test set-up for investigating the impact behavior of composite. .	67
Figure 2.11. Effect of nano-fillers on tensile behaviour of nanocomposites	68
Figure 2.12. Stress–strain plot describing of a tensile behavior of nanocomposite.	69
Figure 2.13. Energy absorption charts showing the effect of different reinforcement.	73
Figure 2.14. Energy absorption charts showing the effect of different notch.	75
Figure 2.15. Comparison of impact strength of plain composite	76
Figure 2.16. Comparison of impact strength of plain composite and Nano composite	77
Figure 2.17. Energy absorption charts showing the effect of different reinforcement	78
Figure 2.18. Energy absorption charts showing the effect of different notch.	81
Figure 2.19. 3-axis micro CNC milling machine set-up	82
Figure 2.20. Main effect plot for S/N ratios for MRR.	86
Figure 2.21. Material removal rate residuals shown using a normal probability distribution.	87
Figure 2.22. Main effect plot of plain composites for S/N ratios for MRR.	88
Figure 2.23. Surface Plot of MRR (mg/min) vs feed (rev/min), tool speed (RPM)	92
Figure 2.24. Contour Plot of mrr Vs Speed and Feed.....	93
Figure 2.25. Interaction plot of MRR vs Speed, Feed and material.....	93
Figure 2.26. SEM image of Reinforcing fillers used in this study. As the size of graphene is smaller therefore there will be evenly distribution in the matrix and the rough surface of graphene ensures better interfacial bonding.....	94
Figure 2.27. SEM image of impact fracture surface of nanocomposites.	95
Figure 2.28. SEM image of Tensile fracture surface of nanocomposites	95
Figure 2.29. . SEM image of Tensile fracture surface of Hybrid composite (60,45,30,0) _S . 96	96
Figure 2.30. SEM image of Machined surface of nanocomposites	96
Figure 3.1. (a) General view and (b) detail view of the FDM 3D printer	100
Figure 3.2. Slicing and infill paprameters	101

Figure 3.3. Tensile test set-up for investigating the tensile property.....	103
Figure 3.4. Tensile Specimen dimension as per standards ASTM D 638 type-I where 1-KFRT, 2-GFRT and 3-HSHTRT yellow lines represents the fiber filaments and others are matrix (nylon).	104
Figure 3.5. Flexural test set-up.	105
Figure 3.6. Flexural Specimen as per ASTM D 790 where 3-HSHTRT, 4-KFRT	106
Figure 3.7. Resil impact test set-up for investigating the impact behavior of composites.	108
Figure 3.8. Impact Specimen as per ASTM D 256 where 3-HSHTRT(0 ⁰), 4-KFRT (0 ⁰) .	109
Figure 3.9. 3-axis micro CNC milling machine set-up	113
Figure 3.10. TGA curves of HSHTFRT (0 ⁰) versus KFRT (0 ⁰).....	115
Figure 3.11. TGA curves of KFRT (0 ⁰).....	116
Figure 3.12. TGA curves of HSHTFRT (0 ⁰).	117
Figure 3.13. Stress–strain plot describing of a tensile behavior of 3D printed composite.	118
Figure 3.14. Elastic modulus of 3D printed composites.....	121
Figure 3.15. Force-displacement curves and their failure mechanisms of bending specimens	123
Figure 3.16. Effect of different reinforcements on flexural properties.....	123
Figure 3.17. Energy absorption charts showing (a) the effect of different reinforcement (b) the effect of build plate orientation	125
Figure 3.18. Comparison of impact strength of (a) different 3d printed composite and	125
Figure 3.19. Main effect plot for S/N ratios for MRR.....	127
Figure 3.20. Surface Plot of MRR (mg/min) vs feed (rev/min), tool speed (RPM)	130
Figure 3.21. Contour Plot of mrr Vs Speed and Feed.....	132
Figure 3.22. Interaction plot of MRR vs Speed and Feed	132
Figure 3.23. Comparison of morphology of different 3D printed composite specimen after quasi-static tensile test	134
Figure 3.24. SEM image of impact fracture surface of different fiber reinforced 3D oriented composites.	135
Figure 3.25. SEM micrograph of bending fracture surface of cross specimen	136
Figure 3.26. SEM image of fiber pull out from 3D printed composite specimen after impact fracture test.	136
Figure 3.27. SEM image of the surface of HSHT glass fiber reinforced thermoplastic 3D printed composite after machining.	137

Figure 4.1. Ball on disc tribometer.....	140
Figure 4.2. Effect of load on wear loss (a) Angle hybrid composite [60,45,30,0] _s (b) Zero hybrid composite [0,0,0,0] _s (c) GFRP composite [0,0,0,0] _s	142
Figure 4.3. Effect of Material composition on wear loss.....	144
Figure 4.4. Pin on disc tribometer.....	145
Figure 4.5. . Effect of Kevlar fiber and concentric filler on wear loss.....	145
Figure 4.6. Effect of HSHT-Glass fiber and concentric filler on wear loss.....	146
Figure 5.1. 3D RVE loading and boundary condition.....	153
Figure 5.2. The final mesh of 3D RVE of Neat Composite.....	154
Figure 5.3. Variation of (a) longitudinal modulus and (b) Transverse modulus of elasticity versus fiber volume fraction.....	154
Figure 5.4. Shear modulus (b) Poisson’s ratio versus volume percent of fiber.....	155
Figure 5.5. Poissons ratio variation against volume fraction of fiber.....	156
Figure 5.6. (a) Woven E-glass (b) Composite plate (0 ⁰ ,0 ⁰ ,0 ⁰ ,0 ⁰) _s (c) Geometry of the test specimen [177].....	157
Figure 5.7. The flask containing Acidic water, distilled water and seawater.....	158
Figure 5.8. Neat composite having 90 Degree ply orientation.....	159
Figure 5.9. Neat composite having 0 Degree ply orientation.....	160
Figure 5.10. EDS elemental spectrum and quantification results.....	161
Figure 5.11. Cross sectional identical distribution of Glass fibers inside the epoxy matrix.....	162
Figure 5.12. Longitudinal identical distribution of Glass fibers inside the epoxy matrix..	162
Figure 6.1. Approximate values for the wavelength ratio= λ/d and waviness, $w=a/\lambda$ [130]	168
Figure 6.2. The model of the C.N.T.s reinforced composite.....	170
Figure 6.3. Von mises stress contour plot under load $U_3 = 10$	171
Figure 6.4. (a) Effect of meshing on the Frequency (b) Fundamental Frequency as a function of nanotube waviness ratio ($w=a/L$).....	172
Figure 6.5. 3D plots of first six mode shapes of wavy C.N.T.s reinforce nano composite micro-beams with encastre boundary condition.....	177
Figure 6.6. (a) Encastre and axisymmetric boundary condition (b) Transverse and lateral loading.....	177
Figure 6.7. The frequency response of the structure made up of sinusoidal wave C.N.T.s inside the matrix.....	178

Figure 6.8. 3D plots of first six mode shapes of wavy C.N.T.s reinforce nano composite micro-beams with encastre boundary condition. 178

Figure 6.9. (a) Transverse and lateral loading (b) Encastre and axisymmetric boundary condition. 179

Figure 6.10. The frequency response of the structure (with damper) made up of sinusoidal wave C.N.T.s inside the matrix..... 179

Figure 6.11. The frequency response of the structure (without damper) made up of sinusoidal wave C.N.T.s inside the matrix..... 180

Figure 6.12. 3D plots of first six mode shapes of wavy C.N.T.s reinforce nano composite micro-beams with encastre boundary condition. 180

Figure 6.13. (a) Encastre and axisymmetric boundary condition (b) Transverse and lateral loading. 181

Figure 6.14. The frequency response of the structure (with damper) made up of sinusoidal wave C.N.T.s inside the matrix..... 181

Figure 6.15. (a) Transverse loading (b) Encastre boundary condition 182

Figure 6.16. The frequency response of the Bridge made up of nano reinforced composite 182

LIST OF TABLES

Table No.	Caption	Page No.
Table 1.1.	Glass composition [16].....	12
Table 1.2.	Inherent properties of glass fibers [16].....	12
Table 2.1.	Properties of the constituent material.	56
Table 2.2.	Volume fraction of different composite	57
Table 2.3.	Calculation of specific surface area for the use of this materials as an adsorbent	59
Table 2.4.	Calculation of Apparent porosity of different composite material.	60
Table 2.5.	Calculation of density of different composite material using archimedes principle.	62
Table 2.6.	Tensile properties of different types of composites.....	68
Table 2.7.	Process variables for nanocomposites at various operating levels.	84
Table 2.8.	Process variables for plain composite at various operating levels.	84
Table 2.9.	Experimental results of nanocomposites for MRR.....	85
Table 2.10.	Response Table for Signal to Noise Ratios (Larger is better)	86
Table 2.11.	General Linear Model: MRR (mg/min) versus Tool speed, feed and material.	87
Table 2.12.	Experimental results of plain composites for MRR.	88
Table 2.13.	Response Table of plain composites for Signal to Noise Ratios (Larger is better)	89
Table 2.14.	General Linear Model for plain composites: MRR (mg/min) versus Tool speed, feed and material.....	89
Table 2.15.	Optimum levels of input parameters for response (nanocomposites).	90
Table 2.16.	Calculated and experimental values at optimum level (nanocomposites).....	91
Table 2.17.	Optimum levels of input parameters for response (plain composites).	91
Table 2.18.	Calculated and experimental values at optimum level (plain composites).....	91
Table 3.1.	Volume fraction of different 3D printed composite.	105
Table 3.2.	Volume fraction of composite for flexural property.....	107
Table 3.3.	Process parameters with different operating levels.	114

Table 3.4. The calculated density of different 3D printed composites. 115

Table 3.5. Calculation of specific surface area for the use of this materials as an adsorbent
..... 117

Table 3.6. Tensile properties of 3D printed composite. 119

Table 3.7. Experimental results for MRR 126

Table 3.8. Response Table for Signal to Noise Ratios (Larger is better)..... 127

Table 3.9. Analysis of variance for Material removal rate..... 128

Table 3.10. Optimum levels of input parameters for response. 129

Table 3.11. Calculated and experimental values at optimum level..... 129

Table 5.1. (a) Properties of the glass fiber (b) Properties of the Matrix (Epoxy) . 157

Table 5.2. The maximum moisture content, M_m (%) of GFRP composite. 160

Table 6.1. Mechanical Properties of the constituent material [184] 171

LIST OF ABBREVIATIONS AND SYMBOLS

3

3D printed composites.....	143
3D printing method.....	143

A

a	
= amplitude of wavy	170
Acidic solution	
pH-3	162
<i>Angle hybrid composite [60,45,30,0]_s</i>	142

C

carbon nanotube	
(C.N.T.).....	167

D

diffusion coefficient	
D 159	
distilled water	
pH-7	162

E

Energy-dispersive X-ray spectroscopy	
EDS.....	161

F

finite element method	
(F.E.M.)	168

G

GFRP composite [0,0,0,0] _s	142
glass fiber reinforced polymer	
GFRP	150

H

High strength high temperature glass fiber reinforced	
thermoplastic composites	
HSHT-GF-FRT	147

K

K	
= Stiffness matrix	174

Kevlar fiber reinforced thermoplastic composites
 K-FRT 147

L

longitudinal Young's modulus
 E1 150

M

M
 = Mass matrix..... 174

Maximum moisture content value
 Mm..... 149

maximum packing fraction
 ϕ_{max} 151

moistness content
 M (%)..... 159

R

Representative volume element
 RVE..... 152

S

seawater
 pH-8 162

V

volume fraction
 Vf 172

W

W is defined as
 (a/λ) 170
 wavelength ratio as
 (λ/d) 170
 wear volume loss is represented by VLS 141

X

x
 = global degree of freedom 174

Z

z
 = fiber axial direction..... 170

Zero *hybrid composite* [0,0,0,0]s 142

Λ

λ
 = wavelength..... 170