



**CHARACTERIZATION OF FUSED DEPOSITION MODELLING
PRINTED KENAF FIBRE REINFORCED POLY-LACTIC ACID
COMPOSITES**



MASTER OF SCIENCE IN MECHANICAL ENGINEERING

2023



Faculty of Mechanical Engineering



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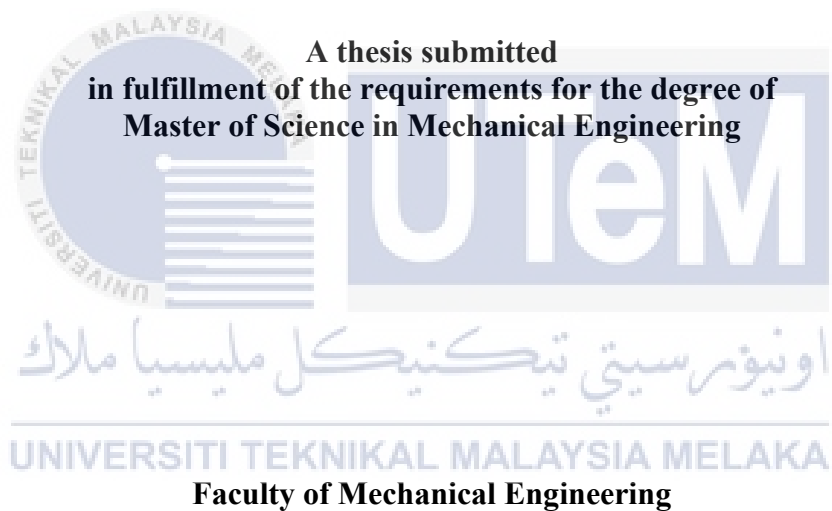
Aida Haryati Binti Jamadi

Master of Science in Mechanical Engineering

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**CHARACTERIZATION OF FUSED DEPOSITION MODELLING PRINTED
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AIDA HARYATI BINTI JAMADI



UNIVERSITI TEKNIKAL MALAYSIA MELAKA

2023

DECLARATION

I declare that this thesis entitled “Characterization of Fused Deposition Modelling Printed Kenaf Fibre Reinforced Poly-Lactic Acid Composites” 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.

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APPROVAL

I hereby declare that I have read this thesis and in my opinion, this thesis is sufficient in terms of scope and quality for the award of the degree of Master of Science in Mechanical Engineering.

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DEDICATION

In the name of Allah SWT and to my beloved mother and father



ABSTRACT

Natural fibre as a reinforcing agent has been widely used in many industrial applications. However, the reinforcing agent devotes a better strength when embedded with a polymer matrix. Nevertheless, the characteristic of natural fibre and polymer matrix are in contrast, as natural fibre is hydrophilic, while polymer is hydrophobic in nature. Natural fibre is highly hydrophilic due to the presence of a hydroxyl group (-OH), while polymer matrix has an inherent hydrophobic characteristic which repels water. This issue has been fixed by modifying the natural fibre's surface using a chemical treatment combining an alkaline treatment and a silane coupling agent. This modifying process of natural fibre might reduce the attraction of water and moisture content and increase natural fibre surface roughness, which improves the interfacial bonding between these two phases. Fused Deposition Modelling (FDM) gets the most attention in development and manufacturing industries. The demand for FDM in industries increases gradually over time and attracts many researchers to enhance the quality of the FDM's fillers. To overcome the issue and replace the current fibres and achieve the bio-composites fibre, researchers suggested using natural fibre to replace the synthetic and carbon fibres as the reinforcement, which is also combined with bio-polymer matrix such as thermoplastics as the polymer matrix in FDM's industries. The effect of alkaline and silane treatment has been proven by performing the mechanical test, 1.0% silane treatment displayed better strength performance (57.846MPa) and tensile modulus (1.174GPa) as compared to other composites, which was proven by performing Scanning Electron Micrograph (SEM). The composites properties have been obtained by performing Differential Scanning Calorimetry (DSC), Thermogravimetric Analysis (TGA) and capillary rheological tests. By claiming 1.0% as the optimum silane concentration that perform better in mechanical properties, several factors need to be considered such as size and dimensional of fibre in binding. This factor has been studied by varying the size of natural fibre as the responding variables with a fix weight percentage of fillers. This modifying process of natural fibre might increase the dispersion of filler towards polymer matrix and increase the internal strength of composites, subsequently improving the interfacial bonding between these two phases. As the results tensile test indicateds that $\leq 100\mu\text{m}$ have hisghest strength (45.578MPa) with highest tensile modulus (1.096GPa) which also has been proven under SEM. The surface quality has been visualize by using 3D profilometer As a conclusion, by reducing the size of fillers, kenaf fibre composites could develop high strength performance in industry applications.

PENCIRIAN PENCETAKAN PEMODELAN PEMENDAPAN BERCANTUM KOMPOSIT ASID POLI LAKTIK DIPERKUAT GENTIAN KENAF

ABSTRAK

Serat asli sebagai agen penguat telah digunakan secara meluas dalam banyak industri pada era ini. Walau bagaimanapun, agen penguat memperincikan kekuatan yang lebih baik apabila dicampurkan dengan matriks polimer. Namun begitu, ciri gentian asli dan matriks polimer adalah berbeza, kerana gentian semula jadi adalah bersifat hidrofilik, manakala polimer bersifat hidrofobik. Serat semulajadi bersifat sangat hidrofilik kerana kehadiran kumpulan hidroksil (-OH), manakala matriks polimer mempunyai ciri hidrofobik yang melekat dan menolak air. Isu ini telah diselesaikan dengan mengubah suai permukaan gentian semula jadi menggunakan rawatan kimia yang menggabungkan rawatan alkali dan agen gandingan silane. Proses pengubahsuaian gentian semula jadi ini mungkin mengurangkan daya tarikan air dan kandungan lembapan dan meningkatkan kekasaran permukaan gentian semula jadi, yang meningkatkan ikatan antara muka antara dua fasa ini. Pemodelan Pemendapan Bercantum (FDM) mendapat perhatian ketara dalam pembangunan dan industri pembuatan. Permintaan untuk FDM dalam industri meningkat secara beransur-ansur dari semasa ke semasa dan menarik ramai penyelidik untuk meningkatkan kualiti pengisi FDM. Untuk mengatasi isu ini dengan mencapai pengisi biokomposit, penyelidik mencadangkan menggunakan gentian semula jadi untuk menggantikan gentian sintetik dan karbon sebagai tetulang, yang juga digabungkan dengan matriks bio-polimer seperti termoplastik sebagai matriks polimer dalam industri FDM. Kesan rawatan alkali dan silane telah dibuktikan dengan melakukan ujian mekanikal. Rawatan silane 1.0% menunjukkan prestasi kekuatan yang lebih baik dengan mencapai kekuatan tegangan sebanyak (57.846MPa) dan tegangan modulus (1.174GPa) berbanding dengan komposit lain, yang dibuktikan dengan melakukan Pengimbasan mikroskop elektron (SEM). Sifat komposit telah diperolehi dengan melakukan ujian Perbezaan Pengimbasan Kalorimetri (DSC), Analisis Termogravimetrik (TGA) dan kapilari reometer. Dengan mendakwa 1.0% sebagai kepekatan silan optimum yang berprestasi lebih baik dalam sifat mekanikal, beberapa faktor perlu dipertimbangkan seperti saiz dan dimensi pengisi dalam pengikatan. Faktor ini telah dikaji dengan mengubah saiz gentian semula jadi sebagai pembolehubah bergerak balas dengan peratusan berat yang tetap. Proses pengubahsuaian gentian asli ini mungkin meningkatkan isipadu pengisi ke dalam matriks polimer dan meningkatkan kekuatan komposit, dan meningkatkan ikatan antara dua fasa ini. Keputusan ketegangan kekuatan menunjukkan bahawa ia mempunyai daya kekuatan yang lebih tinggi (45.578MPa) dengan kekuatan modulus (1.096GPa) yang telah dibuktikan di bawah SEM. Kualiti permukaan telah digambarkan dengan menggunakan profilometer 3D. Kesimpulannya, saiz gentian $\leq 100\mu\text{m}$ menunjukkan prestasi kekuatan yang lebih baik berbanding dengan komposit lain.

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TABLE OF CONTENTS

	PAGE
DECLARATION	
APPROVAL	
DEDICATION	
ABSTRACT	ii
ABSTRAK	iii
ACKNOWLEDGEMENTS	iv
TABLE OF CONTENTS	v
LIST OF TABLES	vii
LIST OF FIGURES	ix
LIST OF SYMBOLS AND ABBREVIATIONS	xii
LIST OF APPENDICES	13
LIST OF PUBLICATIONS	14
CHAPTER 1 INTRODUCTION	15
1.1 Background	15
1.2 Problem Statement	17
1.3 Research Objective	18
1.4 Scope of Research	19
1.5 Contribution of Study	19
1.6 Thesis Outline	20
CHAPTER 2 LITERATURE REVIEW	22
2.1 Introduction	22
2.2 Natural Fibres	24
2.2.1 Physical, mechanical and thermal properties of natural fibres	28
2.3 Potential Polymer Composites of Fused Deposition Modelling	32
2.4 Enhanced Bonding between Fibres and Matrix	37
2.5 Filament for Fused Deposition Modelling	41
2.5.1 Biodegradable Natural Fibre Composites as Filament Fused Deposition Modelling (FDM)	46
2.5.2 Extrusion of Filament	50
2.5.3 Parameters of Printing Process	55
2.6 Summary	63

CHAPTER 3	METHODOLOGY	65
3.1	Introduction	65
3.2	Research Design	66
3.3	Experimental Setup	67
	3.3.1 Materials Preparation	67
	3.3.2 Sample Characterisation	74
3.4	Summary	78
CHAPTER 4	RESULTS AND DISCUSSION	79
4.1	Introduction	79
4.2	Results and Analysis of Effect Chemically Treated Kenaf Fibre	79
	4.2.1 Tensile and Flexural Properties	79
	4.2.2 Morphological Properties	85
	4.2.3 Thermogravimetric Analysis (TGA)	89
	4.2.4 Chemical Analysis by Using Fourier Transform Infrared Spectrometry (FTIR)	93
	4.2.5 Differential Scanning Calorimetry (DSC)	94
	4.2.6 Capillary Rheometry Test	96
	4.2.7 Water Absorption	100
4.3	Results and Analysis of Fibre Size Kenaf Fibre	103
	4.3.1 Tensile and Flexural Properties	103
	4.3.2 Morphological Analysis	107
	4.3.3 Surface Roughness	109
4.4	Summary	113
CHAPTER 5	CONCLUSION AND RECOMMENDATIONS	115
5.1	Conclusion	115
5.2	Recommendations	117
	REFERENCES	118
	APPENDICES	130

LIST OF TABLES

TABLE	TITLE	PAGE
2.1	Automotive company that use natural fibre in vehicle parts (Furtado et al., 2012)	26
2.2	Fibres characteristic values for the tensile strength (MPa), young's modulus (GPa), elongation (%) and density (g/cm ³) (Akil et al., 2011; S. Sreenivasan et al., 2013; Mahjoub et al., 2014; Saba et al., 2015; Siakeng et al., 2019)	27
2.3	Natural fibre classifications (Sreenivasan et al., 2013)	28
2.4	Natural fibres' mechanical properties (Sreenivasan et al., 2013; Nurul Fazita et al., 2017; Mohamed et al., 2018)	29
2.5	Thermal properties insulation materials	30
2.6	Natural fibres' chemical properties (Nurul Fazita et al., 2017; Maslinda et al., 2017; Balla et al., 2019)	30
2.7	Difference between thermoset and thermoplastic polymers (Kabir et al., 2012)	33
2.8	Thermoplastic and thermoset mechanical properties (Furtado, Silva, and Alves, 2012)	35
2.9	High temperature of several thermoplastics (Muzzy and Kays, 1984)	36
2.10	Parameters of alkaline treatment	39
2.11	Summary of several applications (Rahim et al., 2019)	49
2.12	Polymer classifications (Netravali, 2005)	54
2.13	Major factor of FDM parameters (Rahim et al., 2019)	56

2.14	Different fibre-reinforced PLA composites (Rahim et al., 2019)	60
2.15	Thermoplastic and its properties (Wa and Wa, 2017)	61
2.16	Printing parameters with different types of polymers and filler	62
2.17	Properties of printed polymer matrix (Rahim et al., 2019)	62
2.18	Properties of printed continuous filament (Rahim et al., 2019)	62
3.1	Sample classification objective one	68
3.2	Sample classification objective two	68
3.3	Composition of composites	69
3.4	Parameter of extrusion	70
4.1	Wavelength of FTIR varying silane concentration	94
4.2	DSC data at varying silane concentration	95
4.3	Kenaf fibre reinforced PLA composites shear rate at varying silane concentration	98
4.4	3D image profilometer for printed surface varying fibre size	112
4.5	Average value for Ra and Rz varying fibre size	113

LIST OF FIGURES

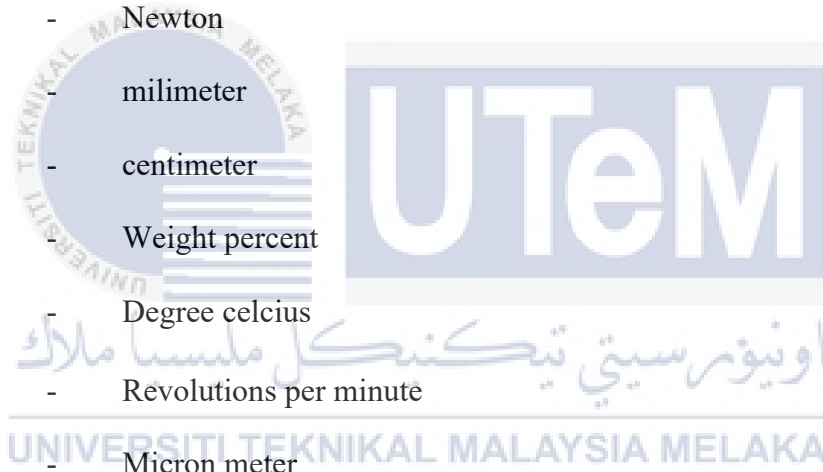
FIGURE	TITLE	PAGE
2.1	Europe's natural fibre usage in automotive production in 2012 (Peças et al., 2018)	25
2.2	Classification of natural fibres (Siakeng et al., 2019)	27
2.3	Kenaf fibre plants (Akil et al., 2011)	30
2.4	Structure of natural fibre (Kabir et al., 2012)	31
2.5	Polymer as a binder (McKeen, 2016)	32
2.6	NaOH solution SEM (Mohamed et al., 2018)	40
2.7	Rapid manufacturing methods using direct laser fabrication classification (Ahmed, 2019)	42
2.8	FDM process diagram (Wang et. al., 2017)	45
2.9	Neat polyether ether ketone (PEEK) (Wang et al., 2017)	45
2.10	Schematic of FDM (Nagaraju, 2019)	47
2.11	PLA polymer and PLA/hemp (Coppola et al., 2018)	48
2.12	Schematic diagram of extrusion of filament with fibre content (Wang et al., 2017)	53
2.13	Schematic diagram of fused deposition modelling (Rahim et al., 2019)	53
2.14	Modified printer (Lee and Liu, 2018)	54
2.15	PLA printing with different direction and speed of airflow (Lee and Liu, 2018)	55
2.16	Effect of clogged surface (Rahim et al., 2019)	57
2.17	Effects of shrinkage (Rahim et al., 2019)	58

3.1	Overall research flow chart	66
3.2	Twin screw extruder	71
3.3	Blending process kenaf and PLA	71
3.4	Filament jig	71
3.5	Filament pulling machine	72
3.6	Filament extrusion	72
3.7	Schematic diagram of a 3D printer	73
3.8	Tensile test specimens	73
3.9	Flexural test specimens	74
3.10	ASTM D790 illustration measurement (ASTM D790)	75
4.1	Kenaf reinforced PLA composites tensile properties at varying silane concentrations	80
4.2	Kenaf reinforced PLA composites flexural properties at varying silane concentrations	83
4.3	The overview reaction of surface modification (a) Silane reaction; (b) Mercerisation and silane treatment process	85
4.4	Scanning Electron micrograph (a,b) PLA; (c,d) Untreated fibre; (e,f) 0.5 wt% silane; (g,h) 1.0 wt% silane; (i,j) 2.0 wt% silane varying silane concentrations	88
4.5	Scanning Electron Micrograph on wood reinforced PLA composites (a,c) poor interfacial adhesion (b,d) good interfacial adhesion (Petchwattana et al., 2019)	89
4.6	The results of composites (a) TGA; (b) DTG	91
4.7	FTIR varying silane concentration	93

4.8	DSC results varying silane concentration	95
4.9	Kenaf fibre reinforced PLA composites viscosity properties at varying silane concentration	97
4.10	Kenaf fibre reinforced PLA composites shear stress properties at varying silane concentration	98
4.11	Percentage of water absorption of composites and PLA at 24 hours	101
4.12	Different penetration of water between treated and untreated composites	103
4.13	Kenaf reinforced PLA composites tensile properties at varying fibre size	104
4.14	Kenaf reinforced PLA composites flexural properties at varying fibre size	105
4.15	Scanning Electron micrograph (a,b) $\leq 100\mu\text{m}$; (c,d) $100\mu\text{m}$; (e,f) $250\mu\text{m}$; (g,h) $300\mu\text{m}$	108
4.16	Image analyser for printed surface (a) $\leq 100\mu\text{m}$; (b) $100\mu\text{m}$; (c) $250\mu\text{m}$; (d) $300\mu\text{m}$	110
4.17	Kenaf reinforced PLA composites 3D profilometer at varying fibre size size (a) $\leq 100\mu\text{m}$ (b) $100\mu\text{m}$ (c) $250\mu\text{m}$ (d) $300\mu\text{m}$	111
4.18	Mean value of surface roughness, Ra varying fibre size	112
4.19	Peak point on the surface, Rz varying fibre size	113

LIST OF SYMBOLS AND ABBREVIATIONS

3D	-	Three dimensional
APS	-	Aminopropyltriethoxysilane
FFF	-	Fused Filament Fabrication
CNT	-	Carbon Nano Tube
ASTM	-	American Society for Testing and Materials
Pa	-	Pascal
N	-	Newton
mm	-	milimeter
cm	-	centimeter
wt%	-	Weight percent
°C	-	Degree celcius
rpm	-	Revolutions per minute
μm	-	Micron meter
MPa	-	Mega Pascal
FDM	-	Fused Deposition Modeling
AM	-	Additive Manufacturing



LIST OF APPENDICES

APPENDIX	TITLE	PAGE
A	Natural fibre filament for Fused Deposition Modelling (FDM) : A Review	130
B	Effect of chemically treated kenaf fibre on mechanical and thermal properties of PLA composites prepared through Fused Deposition Modeling (FDM)	131
C	Correlation study on physical properties and mechanical properties of kenaf fibre composites	132
D	The impact of alkaline treatment on the mechanical and physical properties of kenaf core fibre reinforced vinyl ester composites	133
E	Copyright kenaf/PLA (Biodegradable Filament)	134
F	Jejak inovasi 2020 (Biodegradable filament)	135
G	Jejak inovasi 2020 eco-friendly (Food Packaging)	136
H	MERD 2020 certification	137
I	EREKA 2021 Kenaf/ PLA biodegradable filament	138
J	UTEMEX 2021 KePFIL	139
K	ASTM D570-98 water absorption	140
L	ASTM D638-14 tensile properties	141
M	ASTM D790-03 flexural properties	142
N	ASTM D3835-02 capillary rheometer	143
O	ASTM thermogravimetry method (TGA)	144

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Journal with Impact Factor

H. J. Aida, R. Nadlene, M.T. Mastura, L. Yusriah, D. Sivakumar and R. A. Ilyas (2021) ‘Natural fibre filament for Fused Deposition Modelling (FDM): a review Natural fibre filament for Fused Deposition Modelling (FDM): a review’, *International Journal of Sustainable Engineering. Taylor & Francis*, 00(00), pp. 1–21. doi: 10.1080/19397038.2021.1962426. (ISI indexed, Q2, IF= 2.30 (2021))

Aida Haryati Jamadi, Nadlene Razali, L. Michal Petr °u, Mastura Mohammad Taha, Noryani Muhammad and Rushdan Ahmad Ilyas (2021) ‘Effect of Chemically Treated Kenaf Fibre on Mechanical and Thermal Properties of PLA Composites Prepared through Fused’, *MDPI Polymer*, 13(19), p. 20. doi: <https://doi.org/10.3390/polym13193299>. (ISI indexed, Q1, IF= 4.329 (2020))

Conference Proceedings

Noryani, M., Aida, H. J., Nadlene, R., Mastura, M. T., and Shaharuzaman, M. A. (2021). Materials Today: Proceedings Correlation study on physical properties and mechanical properties of kenaf fibre composites. *Materials Today: Proceedings*, (2020). <https://doi.org/10.1016/j.matpr.2021.10.381>

Aida H. J, R. Nadlene, M. T Mastura, M. Noryani, S. H. S. M. Fadzullah, A. A. Kamarolzaman, M. A. Salim and Bushra Rashid (2022). The impact of Alkaline Treatment On The Mechanical and Physical Properties of Kenaf Core Fibre Reinforced Vinyl Ester Composites. *International Journal of Nanoelectrics and Materials: Proceedings*, (2021).

CHAPTER 1

INTRODUCTION

1.1 Background

Nowadays, attention of engineers and professionals has been triggered regarding the increased consumption of petroleum and the depletion of these sources. In addition, the emission of harmful gas into the environment and the greenhouse effect during incineration produced an alternative in the development and sustainability of natural polymer composites (Fiore, Di Bella, and Valenza, 2015; Yucheng Liu, Lv et al., 2019). Aerospace, automotive, and construction industries have widely used advanced polymer composites, which contain carbon and glass fibre as the primary materials (Lee, Kim, Lee, Kim, Dorgan, 2009). It was found that these primary materials are hardly reusable and reutilised (Lee et al., 2009). Therefore, natural fibre has been introduced to replace the consumption of petroleum-based and synthetic fibres. Other than that, the characteristics between natural fibres and synthetic fibres are quite similar, such as low density, high stiffness, and good mechanical properties (Yucheng Liu, Lv et al., 2019). In comparison to the characteristics of other fibres such as synthetic, glass, and carbon, natural fibre (Van de Weyenberg et al., 2003) shows an advantage in biodegradability, renewability, non-toxicity, CO₂ neutral life cycle, degradability, sustainability, and environmentally friendliness (Edeerozey, Akil, Azhar, and Ariffin, 2007; Lee et al., 2009; V. S. Sreenivasan, Ravindran, Manikandan, & Narayanasamy, 2012; Asim, Jawaid, Abdan, and Ishak, 2016; Fiore et al., 2015; Yucheng Liu, Xie et al., 2019; Oushabi et al., 2017; Sreenivasan, Sujith, & Rajesh, 2019).

In advanced applications, thermoplastic polymers are widely used, but due to their disadvantages which are lower in thermal stability and strength, some applications might not be applicable (Manral and Bajpai, 2020). One of the renewable and biodegradable base polymers in the polyester group is Polylactic Acid (PLA) (Huda et al., 2008; Asumani et al., 2012; Ghaffar, Madyan, Fan, and Corker, 2018; Mazzanti, Salzano de Luna, Pariante, Mollica, and Filippone, 2020), which emits less CO₂ gas and shows that this material is not harmful to the greenhouse, humans, and animals (Huda et al., 2008). Overall, the production of natural fibre is a new issue that has been introduced by many researchers. Natural fibre-reinforced polymer biocomposites using environmentally friendly Fused Deposition Modelling (FDM) technology has attracted many industries and researchers. The implementation of natural fibres in the filament of FDM to replace the current fillers has attracted many competitors and market platforms (Milosevic, Stoof, and Pickering, 2020). However, the use of a thermoplastic polymer as the main material for FDM is still not recommended. The important elements of a polymer are its mechanical properties, which are strength and stiffness. As previously stated, the mechanical aspects of many bio-based polymers have been investigated to enhance the technology of FDM. Acrylonitrile butadiene styrene (ABS) and polylactic acid (PLA) are popular because they are stable. The most frequent thermoplastic that had been produced in this technology is PLA. The advantages of using PLA are that it is recyclable, biodegradable and has a temperature of 145–160 °C (Petchwattana et al., 2019). The fibre loading optimisation and also the chemical treatment of the reinforcement can affect the mechanical properties of the product. Therefore, the natural fibre that combines with the PLA is firm and requires dried feedstock and storage (Mazzanti et al., 2020).

1.2 Problem Statement

The usage of natural fibre in industry is a way to replace glass and also carbon fibre which have many disadvantages such as the price is high and it is not environmentally friendly. In other words, carbon and glass fibre can donate to pollution. The reason natural fibre is emphasized in production because the price range of the fibre is low compare to the glass and carbon fibre, low in weight, environmentally-friendly, easy to decompose, easy to manufactured and the properties of strength quite impressive.

Hydrophilic means the tendency to absorb more water which specifically define as one of the disadvantages of using natural fibre. Major effect that can show from this problem such as wetting problem of the composites, the tendency of water absorption, instability of composites and also the changing of dimension. However, this issue can handle by modify the surface of the fibres by using pre-treatment process. Alkalization or known as mercerization is one of the famous pre-treatments that widely used onto the natural fibre. Many researchers claimed that alkaline treatment can enhance the bonding between fibre and polymer matrix. By using alkali solution and immersion of natural fibre with certain value of concentration and time, in can increase the aspect ratio and roughens the surface of natural fibre which can have better result in mechanical properties. After the alkaline treatment, the impurities on the fibre might been reduced. Specifically, by doing this treatment, the bonding between two phases can be enhanced instead the interfacial bonding can be improved. In addition with several pre-treatment process, by adding the silane coupling agent steps also can increase the enhancement bonding between fibre and polymer matrix (Xie et al., 2010).

Other critical issues of developing filament polymer composites are the uniformity of the mixing between fibre and polymers. From the literature reviews, the fibre size needs

to control in order to improve the filament dimension stability (Ferreira, Capela and Costa, 2010, Ramanaiah, Prasad and Chandra, 2013, Sapuan, Jawaid and Al-shuja, 2014, Pandian et al., 2014). It is important since the nozzle of FDM is sensitive on the diameter of the filament that can cause the clogged of the nozzle and effect the finishing of products. In natural fibre reinforced composites or known as NFRP, fillers such as short, particles nor nano fibre are widely used in way to improve the mechanical properties of printed product. Next, the mixture of fibres and matrix is more at ease when use the smaller size of fibre (Rahim, Abdullah, & Md Akil, 2019). It made the blend process become more easier and also save much time in fabricating the composites. So, many experimental used nano size, particles or powder state in producing the 3D printing filament for extrusion process.

In this study, fibres is uniquely treated with silane coupling agent. The novelty of using silane coupling agent treatment towards kenaf fibre and PLA polymer composite were explored in order to observe the mechanical and physical properties of kenaf fibres. Other than that, by achieve a good result towards kenaf composites, the effect of fibre sieze toward composites also has been studied to discover the strength and surface finishing of the data samples. The motivation of this research is to establish the development of degradable filament since the information through the research publication is very limited.

1.3 Research Objective

Kenaf fibre reinforced PLA composite's filament has been extruded regarding this study. Therefore, there are two objectives that need to consider in while the experiment is being operate.

The first is to evaluate the optimum concentration of of silane coupling agent with three different concentration (0.5 wt%, 1.0 wt% and 2.0 wt%) towards the mechanical,

thermal, rheological and physical properties of kenaf fibre reinforced PLA composites fabricated by using FDM method. By referring the optimum of silane concentration obtained from first objective, the second objective to study the effect of varying fibre size ($\leq 100\mu\text{m}$, $100\mu\text{m}$, $250\mu\text{m}$ and $300\mu\text{m}$) towards mechanical properties and surface roughness.

1.4 Scope of Research

Two types of cleaning process that had been done in this experiment which are by using alkaline treatment with constant concentration of alkali solution is 6% at 24 hours in room temperature, followed by silane treatment with three different weight percentage. 0.5 wt%, 1.0 wt% and 2.0 wt% of silane was dissolved in 30 wt% of water and 70 wt% of ethanol and fibres were soaked at three hours in room temperature. The mechanical properties covered tensile test and flexural test to check the bonding between fibre and matrix, rheological test to check the viscosity of the composites and thermal test to check the glass temperature (T_g) of the composites in various types of environment. Next by obtaining the optimum concentration from the previous experiment, new samples have been subjected with fibre loading 2.5 wt% with 4 different size of fibre which are $\leq 100\mu\text{m}$, $100\mu\text{m}$, $250\mu\text{m}$ and $300\mu\text{m}$.

Both experimental process used FDM method to produce the testing sample. The filament was extruded by using twin screw extruder with specific parameter machine extrusion. Data analysis then has been interpreted to obtain the results for further discussion.

1.5 Contribution of Study

The contribution of these study is to develop a composites that can be commercialized and also environmental friendly. On the other hand, in way to produce an applicable product, many factor need to consider.