



**INVESTIGATING THE EFFECT OF WALL LINE NUMBERS ON THE  
MECHANICAL PERFORMANCE OF DEVELOPED RPET/HDPE  
COMPOSITE FILAMENT IN FDM 3D PRINTING**



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**MASTER OF SCIENCE IN MANUFACTURING ENGINEERING**

**2025**



**Faculty of Industrial & Manufacturing Technology & Engineering**

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## DECLARATION

I declare that this thesis entitled “Investigating the Effect of Wall Line Numbers on the Mechanical Performance of Developed rPET/HDPE Composite Filament in FDM 3D Printing” 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 Master of Science in Manufacturing Engineering.



Signature

.....

Supervisor Name

. Ir. Ts. Dr. Lailatul Harina Binti Paijan

Date

. 24<sup>th</sup> February 2025

UNIVERSITI TEKNIKAL MALAYSIA MELAKA

## DEDICATION

All the praises and thanks to Allah S.W.T for His Guidance and Enlightenment.

This thesis is dedicated to my beloved parents and my siblings,

Also to my hardworking and knowledgeable supervisor and co-supervisor,

Thank you very much for your understanding and encouragement.



## ABSTRACT

Fused Deposition Modelling (FDM) is considered as the most common 3D printing technique for manufacturing 3D models. The mechanical properties of 3D-printed parts using FDM process can be affected with different printing parameters. However, the investigation on printing parameters of wall line count influencing mechanical properties is limited. In addition, waste plastic bottles contribute to plastic pollution, affecting humans and the environment, and by upcycling into 3D printing material, it can create a sustainable environment, which protect natural resources. For that reason, plastic bottles are recycled and developed as a potential bioplastic for 3D printing applications, known as recycled Polyethylene Terephthalate (rPET). Therefore, this study aims to fabricate 3D filament using blended rPET + High Density Polyethylene (HDPE) with two composition ratios of 1:99 and 5:99, respectively. The 3D filaments were produced with different ratios of rPET:HDPE through single screw extrusion process. Then, the thermal properties for 3D filament were characterised using differential scanning calorimetry (DSC) and thermogravimetric analysis (TGA) to determine the thermal temperature of rPET and observe any shifts due to blending with HDPE. Meanwhile, the mechanical properties were analyzed using tensile, flexural, and impact strength to evaluate how the addition of rPET affects strength and overall performance of material, especially in the context of FDM 3D printing. The thermal properties of 3D filaments were analyzed to understand the melting temperature of blended materials for 3D printing process. After thermal analysis, surface morphology was conducted to observe surface quality on the 3D filaments. Next, the 3D filaments were used to manufacture 3D-printed samples using FDM process with varying wall counts of 5, 10, and 15 layers for evaluating the mechanical properties. Based on the result, it is found that the addition of 5 % rPET produced higher melting temperature at 132.1 °C compared to 131.1 °C, exhibited by the 1 % rPET. It can be observed with the increase of rPET from 1 % to 5 % exhibits 0.76 % increment in melting temperature. However, the degradation temperature shows a 0.42 % reduction with increasing in rPET. From the surface morphology observation, the addition of 1 % and 5 % rPET of 3D filaments exhibits a smooth and uniform surface. The mechanical properties demonstrate that the 5 % rPET with 10 wall line counts exhibits the best mechanical properties. It was found that 5 % rPET with 10 wall line counts exhibits two times higher tensile strength at 28.34 MPa compared to the 1 % rPET with 5 wall line counts, which resulted at 14.32 MPa. From the fracture surface image under microscopy observation, it shows ductile characteristic with the 10 wall line counts sample, revealing fibrous strand of the fracture after tensile test, which supported by the tensile strength. Overall, the result shows that the addition of 5 % rPET into HDPE was comparable with PLA, indicating the 3D filament using rPET and HDPE with 10 wall line counts produce the best result and feasible for FDM process, with significantly contributing for the sustainability of the environment.

# **SIASATAN rPET CAMPURAN DENGAN HDPE TERHADAP SIFAT MEKANIKAL UNTUK PROSES FDM**

## **ABSTRAK**

Pemodelan Pemendapan Bersatu (FDM) dianggap sebagai teknik pencetakan 3D yang paling biasa untuk pembuatan model 3D. Sifat mekanikal bahagian cetakan 3D menggunakan proses FDM boleh dipengaruhi dengan parameter pencetakan yang berbeza. Walau bagaimanapun, penyiasatan ke atas parameter pencetakan kiraan garisan dinding yang mempengaruhi sifat mekanikal adalah terhad. Di samping itu, botol plastik sisa menyumbang kepada pencemaran plastik, menjejaskan manusia dan alam sekitar, dan dengan mengitar semula ke dalam bahan cetakan 3D, ia boleh mewujudkan persekitaran yang mampan, yang melindungi sumber semula jadi. Atas sebab itu, botol plastik dikitar semula dan dibangunkan sebagai bioplastik yang berpotensi untuk aplikasi percetakan 3D, yang dikenali sebagai Polyethylene Terephthalate (rPET) kitar semula. Oleh itu, kajian ini bertujuan untuk menghasilkan filamen 3D menggunakan rPET campuran + Polietilena Ketumpatan Tinggi (HDPE) dengan dua nisbah komposisi masing-masing 1:99 dan 5:99. Filamen 3D dihasilkan dengan nisbah rPET:HDPE yang berbeza melalui proses penyemperitan skru tunggal. Kemudian, sifat terma untuk filamen 3D telah dicirikan menggunakan kalorimetri pengimbasan pembezaan (DSC) dan analisis termogravimetrik (TGA) untuk menentukan suhu terma rPET dan memerhati sebarang anjakan akibat pengadunan dengan HDPE. Sementara itu, sifat mekanikal dianalisis menggunakan kekuatan tegangan, lenturan dan hentaman untuk menilai bagaimana penambahan rPET mempengaruhi kekuatan dan prestasi keseluruhan bahan, terutamanya dalam konteks percetakan 3D FDM. Sifat terma filamen 3D dianalisis untuk memahami suhu lebur bahan campuran untuk proses pencetakan 3D. Sifat terma filamen 3D dianalisis untuk memahami suhu lebur bahan campuran untuk proses pencetakan 3D. Selepas analisis haba, morfologi permukaan telah dijalankan untuk melihat kualiti permukaan pada filamen 3D. Seterusnya, filamen 3D digunakan untuk mengeluarkan sampel cetakan 3D menggunakan proses FDM dengan bilangan dinding yang berbeza-beza 5, 10, dan 15 lapisan untuk menilai sifat mekanikal. Berdasarkan keputusan, didapati penambahan 5% rPET menghasilkan suhu lebur yang lebih tinggi pada 132.1 °C berbanding 131.1 °C bagi 1% rPET. Peningkatan rPET daripada 1% ke 5% menunjukkan kenaikan suhu lebur sebanyak 0.76%. Walau bagaimanapun, suhu degradasi menunjukkan penurunan sebanyak 0.42% dengan peningkatan kandungan rPET. Daripada pemerhatian morfologi permukaan, penambahan 1% dan 5% rPET pada filamen 3D mempamerkan permukaan yang licin dan seragam. Sifat mekanikal menunjukkan bahawa 5% rPET dengan 10 kiraan garisan dinding memberikan sifat mekanikal terbaik. Ditemui bahawa 5% rPET dengan 10 kiraan garisan dinding menunjukkan kekuatan tegangan dua kali ganda iaitu 28.34 MPa berbanding 1% rPET dengan 5 kiraan garisan dinding yang mencatatkan 14.32 MPa. Dari imej permukaan patah di bawah pemerhatian mikroskop, ia menunjukkan ciri mulur pada sampel dengan 10 kiraan garisan dinding, memperlihatkan untaian gentian patah selepas ujian tegangan, yang disokong oleh kekuatan tegangan tersebut. Secara keseluruhan, keputusan menunjukkan penambahan 5% rPET ke dalam HDPE adalah setanding dengan PLA, menunjukkan filamen 3D menggunakan rPET dan HDPE dengan 10 kiraan garisan dinding menghasilkan keputusan terbaik dan sesuai untuk proses FDM, serta memberi sumbangan penting kepada kelestarian alam sekitar.



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## TABLE OF CONTENTS

|                                                        | PAGES      |
|--------------------------------------------------------|------------|
| <b>DECLARATION</b>                                     |            |
| <b>APPROVAL</b>                                        |            |
| <b>DEDICATION</b>                                      |            |
| <b>ABSTRACT</b>                                        | <b>i</b>   |
| <b>ABSTRAK</b>                                         | <b>ii</b>  |
| <b>ACKNOWLEDGEMENT</b>                                 | <b>iii</b> |
| <b>TABLE OF CONTENTS</b>                               | <b>iv</b>  |
| <b>LIST OF TABLE</b>                                   | <b>vii</b> |
| <b>LIST OF FIGURES</b>                                 | <b>ix</b>  |
| <b>LIST OF ABBREVIATIONS</b>                           | <b>xii</b> |
| <b>LIST OF SYMBOLS</b>                                 | <b>xiv</b> |
| <b>LIST OF APPENDICES</b>                              | <b>xv</b>  |
| <b>LIST OF PUBLICATIONS/INNOVATIONS</b>                | <b>xvi</b> |
| <b>1 INTRODUCTION</b>                                  | <b>1</b>   |
| 1.1 Background                                         | 1          |
| 1.2 Problem Statement                                  | 2          |
| 1.3 Research Question                                  | 3          |
| 1.4 Research Objective                                 | 4          |
| 1.5 Scope of Research                                  | 4          |
| 1.6 Thesis Outline                                     | 5          |
| <b>2 LITERATURE REVIEW</b>                             | <b>7</b>   |
| 2.1 Introduction                                       | 7          |
| 2.2 Additive Manufacturing                             | 7          |
| 2.3 Types of Additive Manufacturing                    | 8          |
| 2.3.1 Fused Deposition Modelling (FDM)                 | 8          |
| 2.3.2 Stereolithography (SLA)                          | 10         |
| 2.3.3 Selective Laser Sintering (SLS)                  | 11         |
| 2.3.4 Selective Laser Melting (SLM)                    | 13         |
| 2.4 Filament Materials used in FDM Process             | 14         |
| 2.4.1 Polylactic Acid (PLA)                            | 14         |
| 2.4.2 High Density Polyethylene (HDPE)                 | 16         |
| 2.4.3 Acrylonitrile Butadiene Styrene (ABS)            | 17         |
| 2.4.4 Thermoplastic Polyurethane (TPU)                 | 18         |
| 2.4.5 Polypropylene (PP)                               | 19         |
| 2.5 Recycled Material used for Filament in FDM Process | 21         |
| 2.5.1 Recycled PET                                     | 21         |

|          |                                                                         |           |
|----------|-------------------------------------------------------------------------|-----------|
| 2.5.2    | Polyethylene Terephthalate Glycol (PETG)                                | 24        |
| 2.5.3    | Waste Plastic Filament                                                  | 25        |
| 2.5.4    | Recycled PET + HDPE                                                     | 26        |
| 2.6      | Manufacturing of 3D Filament using Extrusion Process                    | 28        |
| 2.6.1    | Single Screw Extruder                                                   | 37        |
| 2.6.2    | Twin Screw Extruder                                                     | 39        |
| 2.6.3    | Comparison between Single Screw Extruder and Twin Screw Extruder        | 41        |
| 2.7      | Common Defects in Surface Morphology                                    | 42        |
| 2.8      | Thermal Properties Analysis                                             | 45        |
| 2.8.1    | Differential Scanning Calorimetry (DSC)                                 | 45        |
| 2.8.2    | Thermogravimetric Analysis (TGA)                                        | 47        |
| 2.9      | FDM Process                                                             | 48        |
| 2.9.1    | Process Parameters for FDM process & Influence on Mechanical Properties | 48        |
| 2.9.1.1  | Nozzle Temperature                                                      | 48        |
| 2.9.1.2  | Layer Height                                                            | 49        |
| 2.9.1.3  | Infill Density                                                          | 51        |
| 2.9.1.4  | Infill Pattern                                                          | 52        |
| 2.9.1.5  | Printing Speed                                                          | 53        |
| 2.9.1.6  | Raster Angle                                                            | 54        |
| 2.9.1.7  | Build Orientation                                                       | 56        |
| 2.9.1.8  | Wall Line Count                                                         | 58        |
| 2.10     | Mechanical Properties of 3D-printed Parts                               | 28        |
| 2.10.1   | Density Test                                                            | 29        |
| 2.10.2   | Tensile Test                                                            | 30        |
| 2.10.2.1 | Field Emission Scanning Electron Microscopy (FE-SEM)                    | 32        |
| 2.10.3   | Flexural Test                                                           | 33        |
| 2.10.4   | Impact Test                                                             | 35        |
| 2.11     | Applications of 3D Printing Material                                    | 60        |
| 2.12     | Previous Studies                                                        | 62        |
| 2.13     | Summary on Research Gap                                                 | 71        |
| <b>3</b> | <b>METHODOLOGY</b>                                                      | <b>72</b> |
| 3.1      | Introduction                                                            | 72        |
| 3.2      | Workflow Chart                                                          | 72        |
| 3.3      | Materials Preparation                                                   | 74        |
| 3.4      | Fabrication Process of 3D filament using rPET and HDPE                  | 74        |
| 3.4.1    | Crushing Process                                                        | 76        |
| 3.4.2    | Drying Process                                                          | 77        |
| 3.4.3    | Extrusion Process                                                       | 78        |
| 3.5      | Surface Morphology Characterization                                     | 79        |
| 3.6      | Thermal Analysis                                                        | 80        |
| 3.6.1    | DSC Analysis                                                            | 80        |
| 3.6.2    | TGA Analysis                                                            | 81        |
| 3.7      | 3D Printing Process                                                     | 82        |
| 3.7.1    | Design of 3D-Printed Samples                                            | 83        |
| 3.7.2    | FDM Printing Parameters                                                 | 84        |
| 3.7.3    | Development of 3D-Printed Samples                                       | 86        |
| 3.8      | Mechanical Properties of 3D printed                                     | 86        |
| 3.8.1    | Density Test                                                            | 87        |

|          |                                                                           |            |
|----------|---------------------------------------------------------------------------|------------|
| 3.8.2    | Tensile Test                                                              | 88         |
| 3.8.3    | Flexural Test                                                             | 89         |
| 3.8.4    | Impact Test                                                               | 90         |
| 3.9      | Fracture Morphology Characterization                                      | 91         |
| 3.10     | Limitation of Proposed Methodology                                        | 92         |
| 3.11     | Summary                                                                   | 93         |
| <b>4</b> | <b>RESULT AND DISCUSSION</b>                                              | <b>94</b>  |
| 4.1      | Introduction                                                              | 94         |
| 4.2      | Fabrication of 3D Printing Filament                                       | 94         |
| 4.3      | Surface Morphology of 3D Filament Blended Materials                       | 98         |
| 4.4      | Thermal Properties of Blended Materials                                   | 102        |
| 4.4.1    | DSC Analysis for Blended Materials                                        | 102        |
| 4.4.2    | TGA Analysis for Blended Materials                                        | 105        |
| 4.5      | Mechanical Properties Test for 3D-printed Materials                       | 107        |
| 4.5.1    | Density Value of 3D-Printed Parts                                         | 108        |
| 4.5.2    | Tensile Strength of 3D-Printed Materials                                  | 110        |
| 4.5.2.1  | Elongation at Break of 3D-Printed Materials                               | 112        |
| 4.5.2.2  | Morphology of Fracture Surface after Tensile Test of 3D-Printed Materials | 114        |
| 4.5.3    | Flexural Strength of 3D-Printed Materials                                 | 117        |
| 4.5.4    | Impact Strength of 3D-Printed Materials                                   | 119        |
| 4.6      | Summary                                                                   | 121        |
| <b>5</b> | <b>CONCLUSION AND RECOMMENDATION FOR FUTURE RESEARCH</b>                  | <b>124</b> |
| 5.1      | Introduction                                                              | 124        |
| 5.2      | Summary of Research Objective                                             | 124        |
| 5.3      | Research Contributions                                                    | 126        |
| 5.4      | Practical Implication and Beneficiaries                                   | 126        |
| 5.5      | Limitation of Present Study                                               | 127        |
| 5.6      | Recommendation for Future Works                                           | 127        |
|          | <b>REFERENCES</b>                                                         | <b>129</b> |
|          | <b>APPENDICES</b>                                                         | <b>149</b> |

## LIST OF TABLE

| <b>TABLE</b> | <b>TITLE</b>                                                                                                                                              | <b>PAGE</b> |
|--------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|
| Table 2.1    | Summary of thermal and mechanical properties of materials by past researchers (Zhang et al., 2023; Vaucher et al., 2022; Techawinyutham et al., 2021)     | 28          |
| Table 2.2    | Density results for kenaf/PLA specimens Shahar et al. (2022)                                                                                              | 30          |
| Table 2.3    | Single screw extrusion parameters used by past researcher for filament fabrication (Hamat et al., 2022; Maldonado-García et al., 2021; Tipu et al., 2023) | 39          |
| Table 2.4    | Twin screw extrusion parameters used by past researcher for filament fabrication (Voorde et al., 2022; Fekete et al., 2021; Tabary et al., 2025)          | 41          |
| Table 2.5    | The mechanical properties of 3D-Printed PLA with varying raster angle (Huang & Lin., 2022)                                                                | 55          |
| Table 2.6    | Mechanical properties with varying build orientation (Lokesh et al. 2022)                                                                                 | 57          |
| Table 2.7    | Summary of previous studies on varying wall line counts affect mechanical properties of 3D-printed parts (Mazlan et al. 2023; Eryildiz. 2023)             | 60          |
| Table 2.6    | Summary of related literature review based on the process parameters used in 3D printing process                                                          | 62          |
| Table 3.1    | List of equipment used for this work                                                                                                                      | 75          |
| Table 3.2    | Mechanical properties of rPET, HDPE and PLA (Vaucher et al., 2022; Techawinyutham et al., 2021; Patti et al., 2022)                                       | 75          |
| Table 3.3    | Composition of 3D filament with different ratios of rPET to HDPE fabricated by extrusion process and PLA                                                  | 79          |
| Table 3.4    | Printing process parameters for FDM process                                                                                                               | 85          |
| Table 3.5    | List of experimental runs with different materials with varying wall line count                                                                           | 87          |
| Table 4.1    | Trial run using single screw extruder                                                                                                                     | 96          |
| Table 4.2    | Summary of DSC curve and TGA thermogram data of PLA, HDPE, E1:99, and E5:95 samples                                                                       | 102         |
| Table 4.3    | Summary of mechanical properties results with different compositions of rPET and HDPE and PLA at varying wall line count                                  | 108         |

|           |                                                                                                                                           |     |
|-----------|-------------------------------------------------------------------------------------------------------------------------------------------|-----|
| Table 4.4 | Summary of density value, tensile strength, and elongation at break of different compositions of rPET and HDPE at varying wall line count | 109 |
| Table 4.5 | Summary of flexural strength and impact strength with different compositions of rPET and HDPE at varying wall line count                  | 117 |



## LIST OF FIGURES

| FIGURE      | TITLE                                                                                                                          | PAGE |
|-------------|--------------------------------------------------------------------------------------------------------------------------------|------|
| Figure 1.1  | Piles of waste plastic bottle in the landfill                                                                                  | 3    |
| Figure 2.1  | Market segments of plastic production in Malaysia (Kaur., 2021).                                                               | 22   |
| Figure 2.2  | Trend of waste plastic generated, discarded, incinerated, and recycled predicting globally by 2050 (Mousavi & Dehaghani, 2024) | 23   |
| Figure 2.3  | Operational schematic of single screw extruder (Abeykoon et al., 2021)                                                         | 38   |
| Figure 2.4  | Schematic of a twin screw extruder (Mishra et al., 2023)                                                                       | 40   |
| Figure 2.5  | FE-SEM images of CNC/PLA bionanocomposites with varying CNC content; (a) 3 % and (b) 5 % (Trivedi & Gupta. 2024)               | 43   |
| Figure 2.6  | Filament surface morphology of PLA (left) and PLA-flax (right) (Belarbi et al., 2022)                                          | 44   |
| Figure 2.7  | DSC curves of FDM-produced specimens with different materials (Cao et al., 2022)                                               | 46   |
| Figure 2.8  | TGA thermograms of blended material (Pereira et al., 2023)                                                                     | 47   |
| Figure 2.9  | Schematic Diagram of FDM (Doshi et al., 2021)                                                                                  | 9    |
| Figure 2.10 | Schematic Diagram of SLA (Al Rashid et al., 2021)                                                                              | 11   |
| Figure 2.11 | Schematic illustrations of the SLS 3D printer (Gueche et al., 2021)                                                            | 12   |
| Figure 2.12 | Schematic illustration on SLM process (Razavykia et al., 2020)                                                                 | 13   |
| Figure 2.13 | Grid infill at varying infill densities (Galvez et al., 2023)                                                                  | 51   |
| Figure 2.14 | Various infill pattern used in FDM 3D printing (Srinivasan et al., 2020)                                                       | 53   |
| Figure 2.15 | Raster angle developed in 3D printing (Huang & Lin., 2022)                                                                     | 55   |
| Figure 2.16 | Schematic of build orientation (Feng et al., 2019)                                                                             | 57   |
| Figure 2.17 | Wall line count: 1, 2, and 3 (left to right)                                                                                   | 58   |
| Figure 2.18 | Tensile strength with varying raster angle and layer thickness (Gajjar et al., 2024)                                           | 31   |
| Figure 2.19 | SEM Images of fracture surface: (a) PLA, (b) 15 % PBS/PLA, and (c) 30 % PBS/PLS (Yu et al., 2023)                              | 33   |
| Figure 2.20 | Flexural strength of 3D-printed samples with different levels of printing parameters (Bardiya et al., 2021)                    | 35   |

|             |                                                                                                                                                                                                                          |     |
|-------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----|
| Figure 2.21 | Impact strength for PLA and recycle PLA (*LH: layer height; I: infill density; NT: nozzle temperature) (Hasan et al., 2024)                                                                                              | 36  |
| Figure 2.22 | Different practices of polymeric materials used in 3D printing (Arora et al., 2024)                                                                                                                                      | 61  |
| Figure 3.1  | Workflow chart                                                                                                                                                                                                           | 73  |
| Figure 3.2  | Summary workflow of 3D printing filament through extrusion process                                                                                                                                                       | 76  |
| Figure 3.3  | Industrial plastic crushing machine                                                                                                                                                                                      | 77  |
| Figure 3.4  | Drying oven                                                                                                                                                                                                              | 77  |
| Figure 3.5  | Extrusion machine                                                                                                                                                                                                        | 79  |
| Figure 3.6  | FE-SEM machine                                                                                                                                                                                                           | 80  |
| Figure 3.7  | DSC machine                                                                                                                                                                                                              | 81  |
| Figure 3.8  | TGA machine                                                                                                                                                                                                              | 82  |
| Figure 3.9  | Workflow chart of 3D printing process                                                                                                                                                                                    | 83  |
| Figure 3.10 | Dimension size for mechanical properties test of (a) dumbbell specimen for tensile test, (b) flexural test and (c) impact test                                                                                           | 84  |
| Figure 3.11 | The illustration of wall line count arrangement for tensile test specimen with wall line count of (a) 5 layers, (b) 10 layers, and (c) 15 layers                                                                         | 85  |
| Figure 3.12 | 3D printing of FDM machine                                                                                                                                                                                               | 87  |
| Figure 3.13 | Densimeter machine                                                                                                                                                                                                       | 88  |
| Figure 3.14 | Tensile testing machine                                                                                                                                                                                                  | 89  |
| Figure 3.15 | Flexural testing machine                                                                                                                                                                                                 | 90  |
| Figure 3.16 | Impact machine                                                                                                                                                                                                           | 91  |
| Figure 4.1  | FE-SEM images of (ai) 25 % rPET + 75 % HDPE (magnification x100), (aii) 25 % rPET + 75 % HDPE ( magnification x500), (bi) 5 % rPET + 95 % HDPE (magnification x100), and (bii) 5 % rPET + 95 % HDPE (magnification x500) | 99  |
| Figure 4.2  | FE-SEM images of (ai) 1 % rPET + 95 % HDPE (magnification x100), (aii) 1 % rPET + 95 % HDPE ( magnification x500), (bi) 5 % rPET + 95 % HDPE (magnification x100), and (bii) 5 % rPET + 95 % HDPE (magnification x500)   | 100 |
| Figure 4.3  | DSC curve for PLA and blended materials ratio of rPET/HDPE with 1:99 and 5:99                                                                                                                                            | 104 |



|             |                                                                                                                                            |     |
|-------------|--------------------------------------------------------------------------------------------------------------------------------------------|-----|
| Figure 4.4  | TGA graph for PLA and blended materials ratio of rPET/HDPE with 1:99 and 5:99                                                              | 107 |
| Figure 4.5  | Density values of blended materials at different rPET to HPDE ratios with different wall line counts                                       | 110 |
| Figure 4.6  | Tensile strength results of blended materials at different rPET to HPDE ratios with different wall line counts                             | 112 |
| Figure 4.7  | Elongation at break with different composition of rPET and HDPE at varying wall line count                                                 | 114 |
| Figure 4.8  | FE-SEM images of fractures surface after tensile test for E1:99 using different wall counts (a) 5 layers, (b) 10 layers, and (c) 15 layers | 115 |
| Figure 4.9  | FE-SEM images of fractures surface after tensile test for E5:95 using different wall counts (a) 5 layers, (b) 10 layers, and (c) 15 layers | 116 |
| Figure 4.10 | FE-SEM images of fractures surface after tensile test for PLA using different wall counts (a) 5 layers, (b) 10 layers, and (c) 15 layers   | 117 |
| Figure 4.11 | Flexural strength results of blended materials at different rPET to HPDE ratios with different wall line counts                            | 118 |
| Figure 4.12 | Impact strength results of blended materials at different rPET to HPDE ratios with different wall line counts                              | 121 |

## LIST OF ABBREVIATIONS

|        |   |                                             |
|--------|---|---------------------------------------------|
| UTeM   | - | Universiti Teknikal Malaysia Melaka         |
| 3D     | - | Three Dimensional                           |
| 2D     | - | Two Dimensional                             |
| rPET   | - | Recycled Polyethylene Terephthalate         |
| PET    | - | Polyethylene Terephthalate                  |
| HDPE   | - | High-Density Polyethylene                   |
| rHDPE  | - | Recycled High-Density Polyethylene          |
| PLA    | - | Polylactic Acid                             |
| FDM    | - | Fused Deposition Modelling                  |
| FFF    | - | Fused Filament Fabrication                  |
| DSC    | - | Differential Scanning Calorimetry           |
| TGA    | - | Thermogravimetric Analysis                  |
| FE-SEM | - | Field Emission Scanning Electron Microscopy |
| AM     | - | Additive Manufacturing                      |
| SLA    | - | Stereolithography                           |
| SLS    | - | Selective Laser Sintering                   |
| SLM    | - | Selective Laser Melting                     |
| CAD    | - | Computer Aided Design                       |
| ABS    | - | Acrylonitrile Butadiene Styrene             |
| TPU    | - | Thermoplastic Polyurethane                  |
| PP     | - | Polypropylene                               |
| PETG   | - | Polyethylene Terephthalate Glycol           |
| ASA    | - | Acrylonitrile Styrene Acrylate              |
| PEEK   | - | Polyether Ether Ketone                      |

|         |   |                                            |
|---------|---|--------------------------------------------|
| PEI     | - | Polyetherimide                             |
| PBS     | - | Poly (butylene succinate)                  |
| PC      | - | Polycarbonate                              |
| ASTM    | - | American Society for Testing and Materials |
| UTS     | - | Ultimate Tensile Strength                  |
| PE-g-MA | - | Polyethylene-grafted-maleic anhydride      |
| SEBS    | - | Styrene-Ethylene-Butylene-Styrene          |



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## LIST OF SYMBOLS

|                   |   |                             |
|-------------------|---|-----------------------------|
| +                 | - | Plus                        |
| °C                | - | Degree Celsius              |
| %                 | - | Percentage                  |
| °                 | - | Angle                       |
| mm                | - | Millimeter                  |
| mm/s              | - | Millimeter per Second       |
| g/cm <sup>3</sup> | - | Grams per Cubic Centimeter  |
| rpm               | - | Revolutions per Minute      |
| °C/min            | - | Degree Celsius per Minute   |
| mg                | - | Milligram                   |
| m l/min           | - | Milliliter per Minute       |
| mm/min            | - | Millimeter per Minute       |
| N                 | - | Newton                      |
| MPa               | - | Megapascals                 |
| GPa               | - | Gigapascals                 |
| kJ/m <sup>2</sup> | - | Kilojoules per Square Meter |
| wt. %             | - | Weight percent              |

## LIST OF APPENDICES

| APPENDIX   | TITLE           | PAGE |
|------------|-----------------|------|
| Appendix A | Ghantt Chart    | 141  |
| Appendix B | Turnitin Report | 142  |



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UNIVERSITI TEKNIKAL MALAYSIA MELAKA

## LIST OF PUBLICATIONS/INNOVATIONS

### List of Journal Publication

1. **A. H. Hamzah**, L. H. Paijan, M. H. A. Bakar, M. F. Mamat, N. A. Maidin, and S. I. Musa, 2024, Effect of Wall Line Count on the Mechanical Properties of FDM 3D-printed PLA Parts, Malaysian Journal of Microscopy, Vol 20, No 2, pp 1-11. **(Published-Scopus Indexed Q4)**
2. **A. H. Hamzah**, L. H. Paijan, and M. H. A. Bakar, 2025, Effect of Wall Line Count on the Mechanical Properties and Wear Performance of FDM 3D- Printed Recycled PET Parts, MYTRIBOS International Symposium. **(Submitted-Scopus Indexed Q3)**

### List of Innovation and Competitions

1. L. H. Paijan and **A. H. Hamzah**, 2024, Investigation of Recycled PET based on Mechanical Properties through FDM Process, Material Lecture Competition 2024 – National Level. **(Third Place)**
2. **A. H. Hamzah**, L. H. Paijan, M. H. A. Bakar, M. F. Mamat, and N. Ab. Wahab, 2023, Private Eye 3D Scanner, Jejak Inovasi UTeM. **(Gold Award)**
3. L. H. Paijan, M. H. A. Bakar, M. F. Mamat, N. Ab. Wahab, and **A. H. Hamzah**, 2023, Tracker 3D Scanner, International Research & Innovative Technology Competition (i-RITEC 2023) UTHM. **(Gold Award)**
4. L. H. Paijan, **A. H. Hamzah**, and A. Q. Shamsuri, 2024, Techno Sight 3D Scanner, International Innovative Research & Industrial Dialogue (IIRID 24) UTeM. **(Gold Award)**
5. **A. H. Hamzah**, A. Q. Shamsuri, N. A. M. Yusof, L. H. Paijan, and M. F. Mamat, 2024, Tech Vision 3D Scanner, Johor International Innovation Invention Competition and Symposium (JIICaS 2024), UiTM Pasir Gudang. **(Gold Award)**
6. L. H. Paijan, **A. H. Hamzah**, and A. Q. Shamsuri, 2024, QuantumSight 3D, Hari Inovasi Negeri Melaka, UTeM. **(Gold Award)**

7. L. H. Paijan, **A. H. Hamzah**, and A. Q. Shamsuri, 2024, Private Eye 3D Scanner (PE3DS), Infineon Week FYP Innovation Competition, UTeM. **(Consolation Prize)**
8. **A. H. Hamzah**, L. H. Paijan, A. Q. Shamsuri, 2024, Hyper Vision 3D Scanner, Texas Instrument – UTeM Innovation Competition (TUIC 2024), UTeM. **(Certificate of Participant)**
9. **A. H. Hamzah**, and L. H. Paijan, 2024, Effect of Wall Line Count on the Mechanical Properties of FDM 3D-printed PLA Parts, 32<sup>nd</sup> Scientific Conference of Microscopy Society of Malaysia (SCMSM2024). **(Travel Grant Award)**



# CHAPTER 1

## INTRODUCTION

### 1.1 Background

3D printing, also known as additive manufacturing, is a revolutionary technology that enables the creation of three-dimensional objects from digital designs. Among various types of 3D printing process, Fused Deposition Modeling (FDM) is the most commonly known additive manufacturing process that creates layer by layer using thermoplastic materials. In this process, a filament is fed into a heated nozzle, where it melts and extruded into thin strands following a predetermined path onto the build platform. The material maintains the intended shape as it cools and hardens, while the newly deposited layer will thermally bonds with the previous one. Moreover, due to its low cost and user friendly, FDM is widely used in medical, engineering, and other industries (Kumari et al., 2024). Based on the current technology, the 3D printing industry is currently expanding. Although 3D printing technology is expanding, there are critical concerns related to 3D printing parameters that need to be considered, which can affect mechanical properties (Zubrzycki et al., 2022). However, the influence of wall line count still remains limited in this area, despite the possibilities of affecting mechanical properties of 3D printed parts. Several studies highlighted that the changes in printing parameters such as layer height, infill density, and nozzle temperature can affect the mechanical properties of 3D-printed parts (Bhushan et al., 2024). Other than that, the investigation of using recycled bottles (Polyethylene Terephthalate) as filament material for 3D printing is significantly lacking. Therefore, this research aims to investigate the effect of varying wall line count based on the mechanical properties with the comparison of blended material consisting of recycled Polyethylene Terephthalate (rPET) with High Density Polyethylene (HDPE) and Polylactic