

# EFFECT OF PARTICLE SIZE ON TENSILE PROPERTIES AND DENSITY OF *DELONIX REGIA* SEED PARTICLES FILLED UNSATURATED POLYESTER RESIN COMPOSITES

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## ABSTRACT

This study was aimed at examining the effect of particle size on the tensile properties and density of *Delonix regia* seed particles (DSP) filled unsaturated polyester resin (UPR) composites. The composites were fabricated using a glass mould via hand mixing, and the average DSP particle sizes of 100, 200, 300, 400, and 500 µm were used at 12 % filler loading. The effect of particle size on the tensile properties and density of DSP-filled unsaturated polyester resin was investigated. The results showed a decrease in tensile strength, tensile modulus, elongation at break, and density as the filler particle size increased. The smallest particle size (100 µm) has the highest values of tensile strength, tensile modulus, elongation at break (%) and density with the corresponding values of 35.43 MPa, 0.47 GPa, 7.09% and 1.22 g/cm<sup>3</sup> and the largest particle size (500 µm) with values of 15.25 MPa, 0.28 GPa, 5.17% and 1.12 g/cm<sup>3</sup> respectively.

**Keywords:** Density, DSP, Particle size, Tensile, and UPR

## INTRODUCTION

Globally, environmental awareness and government regulatory policies have brought a fundamental change in designing composites that conform to the environment (Mohammed et al., 2015; Al-Ogla and Oman, 2017; Shireesha et al., 2019; Karimah et al., 2021). Bio-fillers in the form of agricultural waste such as sugarcane bagasse, corn stalk, rice husk, etc. offer viable and naturally benign filling resources for polymeric materials (Adejumo and Adebisi, 2020). Plant-based natural fibres can be used in polymer composites, replacing more expensive and non-renewable synthetic fibres like glass (Sorench et al., 2013) and making lightweight composites with lower density (1.2 – 1.6 g/cm<sup>3</sup>) than glass fibre (2.4 – 2.5 g/cm<sup>3</sup>) (Jarwad and Abdul Khalil, 2011; Kabir et al., 2011; Mohammed et al., 2015).

The use of natural fibres would decrease waste disposal problems, and ease environmental pollution (Al-Ogla and Oman, 2017; Mohammed and Attallah, 2020; Karimah et al., 2021). They have high strength that can be used for many load-bearing applications. There are many potential natural resources in abundance in our environment, mostly from waste bio-mass. Recycling waste bio-mass reduces greenhouse gas emissions (Bhardwaj et al., 2021; Karimah et al., 2021; Bolou and St. Jansou, 2020) while also assisting in the development of new green markets, job creation, bio-energy production (Adejumo and Adebisi, 2020), and bio-composites (Bhardwaj et al., 2021). Waste natural fibre recycling is a viable option for the environment (Bhardwaj et al., 2021) and provides a solution to the reuse of agricultural wastes (Dong,

2017). This led to the idea of exploiting *Delonix regia* seed particles from its waste pods (bio-mass), thereby producing value-added products that are lightweight, non-toxic, low cost, and have good mechanical and biodegradable properties.

The *Delonix regia* plant is commonly found in our environment and when matured, the pods are mainly considered waste; a waste bio-mass deposited into the environment. Abulude et al. (2018), reported that *Delonix regia* is widely cultivated and found in parks and estates in tropical cities throughout the world. This study was aimed at the effective exploitation of waste *Delonix regia* seed particles as fillers in the modification of unsaturated polyester resin to improve its strength, and dimensional firmness and serve as an alternative and better way of disposing of waste *Delonix regia* pod.

## MATERIALS AND METHODS

### Materials

The raw materials used for the fabrication of the composites were Unsaturated Polyester Resin (UPR), cobalt naphthenate (promoter), Methyl Ethyl Ketone Peroxide (MEKP), and *Delonix regia* Seeds Particles (DSP).

### For Sample Preparation

The *Delonix regia* pods were slit-opened and the seeds collected, crushed using a Jaw Crusher (Retach mesh Nr.70992) and cleaned; this separated the hard seed coat (testa) from the soft inner part (endospermicotyledon). The seed coats were further washed with clean water to remove all the endosperm/cotyledon particles, air-dried for 48 hours, and then oven-dried at 60 °C for 48 h to ensure proper drying. The dried crushed seeds were ground with a ball mill grinding machine (Kera b.v. 052748) and then sieved to different particle sizes: 100, 200, 300, 400, and 500 (µm) using a standard sieve (Sieve-Tronic 150 33-10-1,2000, BS 410-1,2000). The microstructure observation of the seed particle sizes was studied using digital Dino – lite microscopy at 75X magnification.

### Composites Preparation

Composites were prepared using different filler sizes of DSP (100 – 500 µm). The mould for each casting was properly scraped, cleaned, and well lubricated with wax to ease removal, and then foil paper was placed on. The quantity of UPR required for each sample was measured and poured into a mug, and 12 % DSP was then added and mixed. 1 wt. % of the catalyst (MEKP) was added and stirred for 2 minutes, followed by 1 wt. % of the promoter (cobalt naphthenate) being added and stirred for an additional 3 minutes. The mixture was then carefully poured into the mould (100 mm x 100 mm x 3 mm), covered with another glass sheet of the

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