Preparation Method of Carbon Composite Specimens for Various Capability Tests

Khemnar Vijaykumar Haushabapu[1] Department of Mechanical Engineering DVVP COE, Vilad Ghat, Ahmednagar Ahmednagar, Maharashtra, India

Aher Amrut Sahebrao[2] Department of Mechanical Engineering DVVP COE, Vilad Ghat, Ahmednagar Ahmednagar, Maharashtra, India

Ghorpade Dattatray Sopan[3] Department of Mechanical Engineering DVVP COE, Vilad Ghat, Ahmednagar Ahmednagar, Maharashtra, India

Patekar Vivek Popat[4] Department of Mechanical Engineering DVVP COE, Vilad Ghat, Ahmednagar Ahmednagar, Maharashtra, India

ABSTRACT: At present Carbon/Glass fiber composite structure are generally utilized with Epoxy Resin. Epoxy gum is utilized fundamentally to manufacture elite composites with best physical properties, erosion properties, unrivaled electrical properties, keen execution at lifted temperatures, and savvy bond to a substrate or a blend of these edges. Epoxy tars are utilized with assortment of sinewy fortifying materials just as glass, carbon. Epoxies are good with most composite delivering forms essentially different kinds of embellishment, fiber winding and hand lay-up.

Light weight and high strength composite material thus made promotes aerospace and missile industries to replace metallic structure. However, there are limitations on their use in thermal environment having maximum temperature range of 120-1500C. Also glass fiber composites are subject to considerable water absorption. This limitation is imposed by Epoxy matrix in composite structure. A new indigenous herbal matrix/resin named 'BRAMHA' has been developed for fabrication of glass/carbon fiber reinforced composite materials. Since it is made from wheat, cereals, proteins, starch mixed with natural gum, it is categorized as "Herbal" resin. Vacuum Assisted Resin Transfer molding (VARTM) composite fabrication process is used for preparation of carbon & glass fiber laminates. This resin is then compared with epoxy for its various physical & mechanical properties such as pure resin shear strength, water absorption, and sand erosion. The strength tests like tensile at room and at elevated temperatures; compression test and inter-laminar shear strength are conducted

Keywords: *Fiber Reinforced Composites, Herbal Resin, Desirable Physical, Mechanical Properties and High Temperature Strength*

I. INTRODUCTION

Presently multi day's Epoxy pitch is utilized essentially to create elite composites with prevalent mechanical properties, protection from destructive fluids and situations, predominant electrical properties, great execution at raised temperatures, great attachment to a substrate or a mix of these advantages. Epoxy pitches are utilized with various stringy strengthening materials including glass, carbon. Epoxies are perfect with most composite assembling forms especially vacuum-pack shaping, autoclave shaping, weight sack shaping, pressure forming, fiber winding and hand lay-up. Little weight and high quality composite materials in this way made advances aviation and rocket businesses to supplant metallic structure. Be that as it may, there are constraints on utilization of epoxy in warm condition having greatest temperature scope of 120-1500C. Likewise glass fiber epoxy composites are liable to impressive water assimilation. Low warmth twisting temperature (HDT) and glass change temperature (Tg) likewise

confines the utilization of epoxy composites in aviation applications like space transports, flame resistant materials in military and ballistics, below zero and cryogenic applications. [2]

As of late, another indigenous home grown network/pitch named 'BRAMHA' has been produced for manufacture of glass/carbon fiber strengthened composite materials. Since it is produced using wheat, grains, proteins, starch blended with characteristic gum, it is named as "Home grown" gum or bio-composite. From primer assessment it has been seen that this sap, when joined with the carbon and glass filaments to shape the composite structures, has some physical and mechanical properties unrivaled than the epoxy composites. Hence the point of this paper is to put some light on different alluring properties of this new 'home grown' tar and its plausibility for aviation, ballistic and marine applications

II. MANUFACTURING METHOD ADAPTED FOR BRAMHA RESIN

The way toward relieving of ordinary gum, for example, epoxy takes long stretches of time and a great many temperature to fix prepegs or composite cover. For the planning of Brahma tar, a novel technique is adjusted. In this technique, wheat or some other material referenced above is bubbled persistently for least 40 minutes by blending with water. At that point the blend is sustained to the devastating machine where it is smashed consistently for 10 minutes. Subsequent to squashing, the blend is taken into the squeezing machine where it is squeezed with the goal that the unadulterated dissolvable or stick is isolated from the strong or un-broke down buildup. This procedure is conveyed for about 10 minutes. At that point the unadulterated dissolvable isolated from it which is semi fluid in state is taken to another pot. It is blended with water and kept for what it's worth for 1 day. The blend is on the other hand bolstered to the devastating with the goal that intensive blending happens and at last we get the paste or gum as a concentrate.

There are all out 11 fixings in the arrangement of this Bramha pitch which absolutely produced using normal natural materials. For any pitch to fix it inside a specific time some extra synthetics are should be included. They are as per the following,

Hardeners

These are the chemicals, which react with resin to form a perfect solid mass or cure the resin according to the required shape of mold. For this resin as it is found as a kind of polyester, MEKP (methyl ethyl ketone peroxide) is used as a hardener.

Accelerators

Accelerators are nothing but the chemicals, which enhance or promote the speed of chemical reaction between resin and hardener depending on the size and shape of mold. For this Bramha resin, cobalt octoate is used as an accelerator. Both hardener and accelerator are required in a proportion of very small quantities as within range of 1% to 5% of quantity of resin

III. CARBON & GLASS FIBERS AS REINFORCEMENT

The theoretical strength of a given type of solid is determined by the strengths of the atomic or molecular bonds that hold the solid together. Although the practical strengths of solids are determined by the defects, which they contain, it is necessary to seek materials with the strongest chemical bonds if we are to have the best chance of exploiting the principle of composite materials construction

Glass fibers

Glass fibers are manufactured by drawing molten glass into very fine threads and then immediately protecting them from contact with the atmosphere or with hard surfaces in order to preserve the defect-free structure that is created by the drawing process. Glass fibers are as strong as any of the newer inorganic fibers but they lack rigidity on account of their molecular structure. The properties of glasses can be modified largely in composite materials is ordinary borosilicate glass, known as E-glass. The largest volume usage of composite materials involves E-glass as the reinforcement. S-glass has somewhat better properties than E-glass, including higher thermal stability, but its higher cost has limited the extent of its use [1]

Carbon fibers

By oxidizing and pyrolysing a highly drawn textile fiber such as polyacrylonitrile (PAN), preventing it from shrinking in the early stages of the degradation process. Subsequently hot stretching it, it is possible to convert it to a

carbon filament with an elastic modulus that approaches the value we would predict from a consideration of the crystal structure of graphite, although the final strength is usually well below the theoretical strength of the ca rbon- carbon chain. Thickness of carbon fibers used in preparation of laminates is 0.3mm. [1]

IV. FABRICATION OF COMPOSITES

To consolidate the Bramha pitch for VARTM process, a few examinations are performed identified with restoring time, strain to be connected on real cover. 3 distinct examples A, B, C of 100gm gum with 1% hardener and 0.5% quickening agent in test „A", 1% quickening agent in test „B" and 1.5% quickening agent in test „C" on weight premise are blended and kept for relieving. At the point when time taken for restoring by these 3 tests is estimated, it is discovered that example „A" accepts 2 hours to solution, test „B" took 45 minutes and test „C" took 30 minutes. Contingent upon these outcomes test „A" is picked for VARTM process since longer restoring time is most basic if there should arise an occurrence of VARTM process

Hand layup method:

For readiness of overlays from Brahma gum at first "hand layup", a basic and simple strategy is utilized. This strategy is utilized, as we required just restricted no. of example of settled size and geometry. For making these examples, molds are set up from 10 mm thickness and 2 inch width aluminum plate. Aluminum plates are chosen because of the reason that they don't get hold fast to the paste or sap from which we will set up the overlays and example can be expelled effectively from the form in the wake of restoring. Extra 2 inches separation along length is included for simple dealing with, expulsion and legitimate grasping of example. Carbon and glass filaments are utilized in the structure takes cut from mats. Molds are set on impeccably flat surface to have uniform gum stream and congruity all through the length of the example.

Initial, a slight layer of tar is put consistently in shape. At that point first piece of fiber tangle is set over the sap. Of course, second layer of tar is set over the primary layer of strands. Second portion of fiber tangle is then set over the main layer of pitch. This procedure is proceeded until required thickness is accomplished. The highest point of the shape is then secured by another consummately level aluminum plate and a heap of 10-15 kg is connected on it so splendidly conservative example can be arranged and air cavities or air pockets get expelled. Likewise extra paste is getting evacuated.

Major Defects Found in the Laminates Prepared By Hand Layup:

While making covers outer power or burden was not connected on it. Because of this, impeccable compaction or connection of filaments to the pitch was not accomplished. Existences of air cavities or little gaps which are framed because of the arrival of unstable gases amid restoring have decreased the quality of the overlays. These gaps are caught in the overlays and furthermore going about as break advancing zones which thus advances the disappointment of example before coming to its definitive elasticity conveying limit

Vacuum assisted resin transfer molding (VARTM):

The laminates are fabricated by Vacuum infusion widely known as Vacuum Assisted Resin Transfer Molding (VARTM). The main advantages of VARTM, compared to open molding process such as hand lay-up or spray-up, are higher fiber content and an improvement of the laminate quality due to a better impregnation of the perform

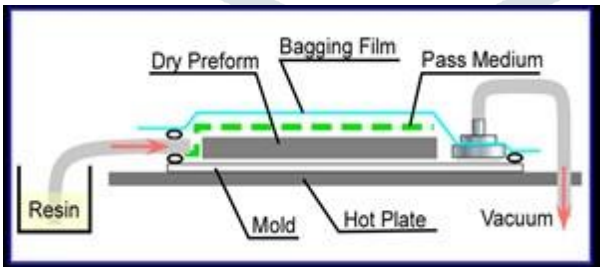

Figure: VARTM Process

Vacuum implantation broadly known as Vacuum Assisted Resin Transfer Molding (VARTM) is a generally utilized embellishment process for the assembling of huge composite structures. Its prevalence is mostly because of the

minimal effort of the tooling and the natural wellbeing, the procedure takes out over 90% of the unstable natural compound produced by unsaturated polyester pitches. Moreover, low administrator association expands the repeatability of the procedure contrasted with open form strategies, for example, hand lay-up or splash up and the parts are of generally high fiber content, up to 60% by volume. It is progressively mainstream in the transportation, marine and wind control age businesses

VARTM is a piece of a group of embellishment strategies called fluid composite trim. It includes the imbuement of a low consistency tar into a dry sinewy preform put on a firm shape and secured by an adapta ble film. The principle preferences of VARTM, contrasted with open embellishment procedure, for example, hand lay-up or splash up, are higher fiber content and an enhancement of the cover quality because of a superior impregnation of the preform. Administrator inclusion is less basic, prompting higher quality and consistency. Existing hand lay-up – shower up molds can be changing for use in VARTM. There is no confinement partially measurements and it is conceivable to create segments from 1 mm thick to in excess of 100 mm thick.

In this procedure, the pitch is driven by a vacuum to fill the form. A wide assortment of items is currently produced utilizing this technique, running from little armrests for transports to substantial parts for water -treatment plants. In shut form VARTM handling, the tar is infused into a shut depression containing a fiber preform. The impregnation of the gum is an intricate procedure and is enormously affected by a few variables, for example, the introduction of the stringy preform, shape temperature, pitch thickness, and infusion weight, and so on.
During laminate fabrication by this process, resin is transferred by vacuum pressure. Release film is used
before fiber kept on the mould, so that the composite laminate would not be stick to the mold plate. Peel ply is applied on the release film to remove laminate easily after curing. Layers of fiber of required quantity and orientation is sandwiched in peel plies and kept on the mould. Mesh is applied on the peel ply so that the uniform distribution of resin could be achieved during infusion. Vacuum pump is attached to create vacuum force at one end. Resin is supplied from another end, so that resin can be flow with the force of vacuum. This whole process is covered with vacuum bag and the vacuum bag is sealed to mould by using sealant as shown in Figure.[3]

DISCUSSIONS

As we probably am aware in the event that some of imperfections that are as yet present in the present overlays, at
that point will give an attempt on new mixes of strands, their introductions, hardener and quickening agents, relieving time and so on. Ductile, compressive and bury laminar shear properties of unidirectional fiber covers according to ASTM principles will discover.

Results got will be contrast with as of now utilized epoxy. In any case, this is just the starting stage or essential stage toward last focused on application. To utilize this gum for aviation applications, marine or at business level for autos some more tests must be accepted, for example, ductile test at high temperature and different capability tests.

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