

CONTENTS

	PAGE
ABSTRACT (THAI).....	iv
ABSTRACT (ENGLISH).....	v
ACKNOWLEDGEMENTS.....	vi
CONTENTS	vii
LIST OF TABLES.....	x
LIST OF FIGURES.....	xi
CHAPTER I INTRODUCTION.....	1
CHAPTER II LITERATURE SURVEY.....	4
2.1 Composite Material.....	4
2.2 Classification of Composites.....	5
2.2.1 Metal Matrix Composites (MMCs).....	5
2.2.2 Ceramic Matrix Composites (CMCs).....	5
2.2.3 Polymer Matrix Composite (PMCs).....	6
2.3 Fiber Reinforced Composites (Fibrous Composites).....	13
2.3.1 Type of Fiber Reinforcements.....	13
2.3.2 Geometry and Form of Fiber Reinforcement.....	15
2.4 Characteristic and Applications of Fibrous Composite	17
2.5 Fibrous Composite Wastes Management.....	17
2.5.1 Disposal by Landfill.....	17
2.5.2 Mechanical Recycling.....	18
2.5.3 Chemical Recycling.....	18
2.5.4 Thermal Recycling (Thermochemical Conversion Process).....	19
2.5.4.1 Combustion Process.....	19
2.5.4.2 Pyrolysis Process.....	20
2.5.4.3 Gasification Process.....	21
2.6 Thermochemical Products and Applications.....	22

	PAGE
2.6.1 Gases.....	22
2.6.2 Liquid.....	23
2.6.3 Solid Char.....	26
CHAPTER III EXPERIMENTAL.....	27
3.1 Material and Chemical.....	27
3.2 Instruments and Equipments.....	29
3.3 Methodology.....	33
3.3.1 Preparation of Composite Waste Samples.....	34
3.3.2 Thermal Conversion by a Fixed Bed Pyrolysis	34
3.3.3 Preparation of new composite.....	35
3.4 Characterizations and Testing.....	37
3.4.1 Characterization of Composite Waste Samples.....	37
3.4.2 Characterization products from Thermochemical Conversion by Pyrolysis Process.....	40
3.4.3 Characterization of Composite Prepared from Original Glass Fiber and Recycled Fiber.....	43
CHAPTER IV RESULTS AND DISCUSSIONS.....	46
4.1 Characteristic of Composite Waste Sample.....	46
4.2 Thermal Conversion by Pyrolysis Process.....	68
4.2.1 Product Distribution.....	68
4.2.2 Characteristic of Pyrolysis Products.....	73
4.3 Characteristic of Composite Prepared from Original Glass Fiber and Recycled Glass Fiber.....	97
CHAPTER V CONCLUSIONS.....	115
REFERENCES.....	120
BIOGRAPHY.....	125

LIST OF TABLES

Table		Page
2.1	Component of distillation crude oil.....	23
2.2	Typical properties of commercial fuels oil.....	25
3.1	Characteristics of composite waste samples.....	28
3.2	Listed of resin, and chemical for composite preparation.....	29
3.3	List of experimental instruments for characterization.....	29
3.4	Compositions of 100 g unsaturated polyester composite.....	36
3.5	Compositions of 100 g unsaturated polyester composite.....	37
4.1	The Glass fiber content (wt. %) containing in composite waste samples..	47
4.2	Elemental analysis of composite waste samples.....	52
4.3	Proximate analysis of composite waste samples.....	53
4.4	Summarization of TGA thermograms of unsaturated polyester composite waste samples.....	58
4.5	Summarization of TGA thermograms of epoxy composite waste samples	62
4.6	The activation energies (KJ/mol) of unsaturated polyester and epoxy reinforced with 30 and 60 wt% glass fiber composite waste samples.....	67
4.7	Elemental analysis (wt.%) of solid residues obtained from pyrolysis process of composite wastes with 30 and 60 wt% glass fiber.....	80
4.8	Proximate analysis (wt.%) of solid residues obtained from pyrolysis process of composite wastes with 30 and 60 wt% glass fiber.....	81
4.9	Elemental, water content, and gross calorific value (GCV) of condensable liquids obtained from pyrolysis process of composite wastes with 30 wt.% glass fiber.....	87
4.10	Elemental, water content, and gross calorific value (GCV) of condensable liquids obtained from pyrolysis process of composite wastes with 30 wt.% glass fiber.....	88

Table		Page
4.11	The Distillated products of pyrolysis liquid oil obtained from pyrolysis of unsaturated and epoxy reinforced with 30 wt.% glass fiber composite waste at temperature of 600 °C.....	90
4.12	Fuel properties of pyrolysis liquid oil obtained from pyrolysis of unsaturated and epoxy reinforced with 30 wt.% glass fiber composite waste at temperature of 600°C compared to other conventional fuels....	92

LIST OF FIGURES

Figure	Page
2.1	Classification of matrix composites..... 5
2.2	Synthesis of orthophthalic polyester resin..... 7
2.3	Synthesis of isophthalic polyester resin..... 8
2.4	Synthesis of vinyl ester resin..... 9
2.5	Chemical crosslinked reaction of unsaturated polyester resin..... 9
2.6	Synthesis of epoxy resin (diglycidyl ether bisphenol A;DGEPA)..... 10
2.7	Chemical structure of amine curing agent..... 11
2.8	Chemical reaction of epoxy cure with MDA..... 12
2.9	Chemical structure of anhydride curing agent..... 12
2.10	Chemical reaction of epoxy cured with PA..... 13
2.11	Example of fiber geometry in composites..... 16
3.1	Tubular tube reactor (a), quart sample boat (b), and horizontal electrical furnace with temperature controller and thermocouple (c), silicone rubber line(d), borosilicate glass condenser (e), and balloon foil gas sampling bag (f).. 31
3.2	Conventional mixer (a) and Teflon mold (b)..... 32
3.3	Conventional oven (FAGOR Innovation)..... 32
3.4	The flow chart of experimental procedure..... 33
3.5	Schematic diagram of a horizontal fixed bed pyrolysis system..... 34
3.6	Thermogravimetric Analyzer (TGA), SDTA 851e ,Mettler Toledo..... 38
3.7	Fourier Transform Infrared Spectrophotometer (FTIR) Spectrum one..... 38
3.8	Elemental Analyzer, PE 2400 Series II, Perkin Elmer..... 39
3.9	Temperature profile for proximate analysis of composite waste samples..... 39
3.10	Scanning Electron Microscope (SEM) JSM 6480LV, JEOL,..... 41
3.11	Centrifuge C-28, BOECO, Germany..... 42
3.12	Simulated Distillation GC-Simdist, CP-3800, Varian Les 42
3.13	Automatic Bomb Calorimeter, AC-350, LECO, Orissa..... 42

Figure	Page
3.14 Gas Chromatography (GC),8610C, SRI Instrument, California,	43
3.15 Universal Testing Machine, LR 100 N, LLOYD Instrument.....	44
3.16 Pendulum Impact Tester, B5102.202 2 J, Swick.....	45
4.1 FTIR spectra of unsaturated polyester composite waste samples : (a) 30 wt% glass fiber, and (b) 60 wt% glass fiber.....	48
4.2 FTIR spectra of epoxy reinforced with amine (MDA) and anhydride (MTHPA) composite waste samples: (a) 30 wt.% glass fiber, and (b) 60 wt.% glass fiber	49
4.3 Chemical structure of unsaturated polyester resin: (a) orthophthalic polyester resin, (b) isophthalic polyester resin, and (c) vinyl ester resin.....	50
4.4 Chemical structure of epoxy cured resin: (a) Epoxy/amine (MDA), and (b) Epoxy/anhydride (MTHPA).....	51
4.5 TGA and DTG thermograms of orthophthalic polyester, isophthalic polyester, and vinyl ester composite wastes reinforced with 30 wt.% glass fiber at three different heating rates : (a) 5°C/min, (b) 10°C/min, and (c)15°C/min.....	56
4.6 TGA and DTG thermograms of orthophthalic polyester, isophthalic polyester, and vinyl ester composite wastes reinforced with 60 wt.% glass fiber at three different heating rates : (a) 5°C/min, (b) 10°C/min, and (c)15°C/min.....	57
4.7 TGA and DTG thermograms of epoxy composite wastes cured with amine (MDA) and anhydride (MTHPA) reinforced with 30 wt.% glass fiber at three different heating rates : (a) 5°C/min, (b) 10°C/min, and (c)15°C/min.....	60
4.8 TGA and DTG thermograms of epoxy composite wastes cured with amine (MDA) and anhydride (MTHPA) reinforced with 60 wt.% glass fiber at three different heating rates : (a) 5°C/min, (b) 10°C/min, and (c)15°C/min.....	61
4.9 Arrhenius kinetic plot derived from TGA pyrolysis of unsaturated polyester reinforced with 30 and 60 wt.% glass fiber.....	65
4.10 Arrhenius kinetic plot derived from TGA pyrolysis of epoxy cured with amine and anhydride reinforced with 30 and 60 wt.% glass fiber.....	66

Figure	Page
4.11 Effect of pyrolysis temperature on product yields from pyrolysis unsaturated polyester and epoxy reinforced with 30 wt% glass fiber; (a) orthophthalic, (b) isophthalic, (c) vinyl ester, (c) amine cured epoxy, and (d) anhydride cured epoxy composite waste.....	70
4.12 The products distribution of three types unsaturated polyester matrix and epoxy cured with amine (MDA) and anhydride (MTHPA) at pyrolysis temperature of (a) 600°C, (b) 700°C, and (c) 800°C.....	71
4.13 The comparison solid (a), liquid (b), and gas (c) fraction derived from pyrolysis of composite waste consisted of 30 and 60 wt% glass fiber at pyrolysis temperature of 600°C.....	73
4.14 SEM micrograph of solid residues from pyrolysis of unsaturated polyester and epoxy reinforced with 60 wt.% glass fiber at temperature of 600°C: (a) orthophthalic, (b) isophthalic, (c) vinyl ester, (d) epoxy/MDA, and (e) epoxy/MTHPA.....	75
4.15 SEM micrograph of solid residues from pyrolysis of unsaturated polyester and epoxy reinforced with 60 wt.% glass fiber at temperature of 800°C: (a) orthophthalic, (b) isophthalic, (c) vinyl ester, (d) epoxy/MDA, and (e) epoxy/MTHPA.....	76
4.16 FTIR spectra of solid residues obtained from pyrolysis of three types unsaturated polyester reinforced with 30 wt.% glass fiber composite waste at temperature of (a) 600 °C, and (b) 800°C.....	77
4.17 FTIR spectra of solid residues char obtained from pyrolysis of epoxy cured with amine and anhydride composite waste at temperature of (a) 600 °C, and (b) 800°C.....	78
4.18 Condensable liquid obtained from pyrolysis composite wastes.....	82
4.19 FTIR spectra of pyrolysis liquid oil obtained from pyrolysis of unsaturated polyester reinforced with 30 wt.% glass fiber composite waste at temperature of (a) 600 °C, and (b) 800°C.....	83

Figure	Page
4.20 FTIR spectra of pyrolysis liquid oil obtained from pyrolysis of unsaturated polyester composite waste at temperature of 700°C: (a) 30 wt.% glass fiber, and (b) 60 wt.% glass fiber.....	84
4.21 FTIR spectra of pyrolysis liquid oil obtained from pyrolysis of amine and anhydride cured epoxy reinforced with 30 wt.% glass fiber composite waste at temperature of (a) 600 °C, and (b) 800°C.....	85
4.22 FTIR spectra of pyrolysis liquid oil obtained from pyrolysis of amine and anhydride cured epoxy composite at temperature of 700 °C: (a) 30 wt.% glass fiber composite waste, and (b) 60 wt.% glass fiber.....	86
4.23 Distillated fractions of pyrolysis liquid oils obtained from pyrolysis of unsaturated and epoxy reinforced with 30 wt.% glass fiber composite waste at temperature of 600 °C.....	89
4.24 Gaseous product (nitrogen free) involved from pyrolysis process of three type unsaturated polyester reinforced with 30 wt% glass fiber composite wastes.....	94
4.25 Gaseous product (nitrogen free) involved from pyrolysis process of three type unsaturated polyester reinforced with 60 wt% glass fiber composite wastes.....	93
4.26 Gaseous product (nitrogen free) involved from pyrolysis process of amine and anhydride cured epoxy reinforced with 30 wt% glass fiber cured composite wastes.....	96
4.27 Gaseous product (nitrogen free) involved from pyrolysis process of amine and anhydride cured epoxy reinforced with 60 wt% glass fiber cured composite wastes.....	97
4.28 The comparison of nitrogen free gross calorific value (GCV) of gaseous products obtained from pyrolysis of unsaturated polyester and epoxy reinforce with 30 and 60 wt% glass fiber at pyrolysis temperature of (a) 600°C, (b) 700°C, and (c) 800°C.....	98

Figure	Page	
4.29	Effect of glass fiber content on flexural strength of unsaturated polyester resin and BMC composite: (a) orthophthalic polyester, (b) isophthalic polyester, and (c) vinyl ester composites.....	100
4.30	SEM micrographs of fracture surface from three point bending test specimens of unsaturated polyester resin: (a) orthophthalic polyester, (b) isophthalic polyester, and (c) vinyl ester resin.....	101
4.31	Chemical structure of three types unsaturated polyester resin: (a) orthophthalic polyester, (b) isophthalic polyester resin, and (c) vinyl ester resin.....	100
4.32	Effect of glass fiber content on flexural strength of epoxy resin and BMC composite: (a)epoxy/MDA, and (b) epoxy/MTHPA composites.....	103
4.33	SEM micrographs of fracture surface from three point bending test specimens of of epoxy resin: (a) epoxy/MDA and (b)epoxy/MTHPA.....	104
4.34	Chemical structure of Methanediamine (MDA) and Methyltetra hydrophthalic anhydride (MTHPA).....	104
4.35	SEM micrographs of fracture surface from three point bending test specimens of unsaturated polyester composite: (a)orthophthalic polyester with 15 wt%. original glass fiber	105
4.36	SEM micrographs of fracture surface from three point bending test specimens of epoxy composite: (a)Epoxy/MDA with15 wt% original glass fiber, (b) Epoxy/MTHPA with15 wt% original glass fiber composites.....	106
4.37	SEM micrographs of fracture surface from three point bending test specimens of (a) orthophthalic polyester with 15 wt% recycled glass fiber (600°C) composite and (b) orthophthalic polyester with 15 wt% recycled glass fiber (600°C) composite.....	107
4.38	SEM micrographs of fracture surface from three point bending test specimens of (a) epoxy/MDA with 15 wt% recycled glass fiber (600°C) composite and (b) epoxy/MDA with 15 wt% recycled glass fiber (800°C) composite.....	107

Figure		Page
4.39	Typical coupling agent for unsaturated polyester and epoxy resin base.....	108
4.40	Effect of glass fiber content on flexural modulus of unsaturated polyester resin and BMC composite:(a) orthophthalic polyester, (b) isophthalic polyester, and (c) vinyl ester composites.....	109
4.41	Effect of glass fiber content on flexural modulus of epoxy resin and BMC composite: (a) epoxy/MDA and (b) epoxy/MTHPA composites.....	111
4.42	Impact strength of unsaturated polyester resin and BMC composites in relation to weight fraction of glass fiber (a) orthophthalic polyester, (b) isophthalic polyester, and (c) vinyl ester composite.....	113
4.43	Impact strength of epoxy resin and BMC composites in relation to weight fraction of glass fiber (a) epoxy cured with amine (MDA), (b) epoxy cured with anhydride (MTHPA).....	114