

## CERTIFICATION OF APPROVAL

### **Study of Drop Impact Resistance on Fiber Reinforced Composite Plates**

by

Wong Chung Hoong

A project dissertation submitted to the  
Mechanical Engineering Programme  
Universiti Teknologi PETRONAS  
in partial fulfilment of the requirement for the  
BACHELOR OF ENGINEERING (Hons)  
(MECHANICAL ENGINEERING)

Approved by,

---

(Mr.Kee Kok Eng)

UNIVERSITI TEKNOLOGI PETRONAS

TRONOH, PERAK

December 2008

## CERTIFICATION OF ORIGINALITY

This is to certify that I am responsible for the work submitted in this project, that the original work is my own except as specified in the references and acknowledgements, and that the original work contained herein have not been undertaken or done by unspecified sources or persons.

---

WONG CHUNG HOONG

## **ABSTRACT**

Lightweight materials are much used in many engineering application such as automotive and aircraft parts and building structure. So the rise of fiber reinforced composite had answered the call whereby these materials can provide lightweight and strength to withstand the force. Low impact velocity damage normally cannot be detected by visual inspection have becomes an issue because the material may fail without any notice or precautions to users.

The project has improved the testing jig by adding guiding tubes, release mechanism and other support structures. Three different fiber reinforced composite plates are glass fiber woven & chopped and carbon woven undergo a series of impact test by using a 25 Joule and 50 Joule impact energies. Ultrasonic test trace the damage area of the composite plate by variation of sound waves which cause by internal delamination and data transfer from transparent grid to CATIA to compute the damage area.

Glass chopped fiber composite show the best impact resistance in both 25 J and 50 J impact energy and following by glass woven and carbon woven fiber. Glass woven composite sustain greater impact damage compare to glass chopped composite is because the brittle characteristic of epoxy resin has reduce the fiber woven composite ductility and become brittle and less resistance to impact. Carbon fiber composite sustain unpredictable collapse when increasing of impact energy or fiber content so it's not suitable for aerospace and automotive parts.

## ACKNOWLEDGEMENT

First and foremost, this is a great opportunity to express my deepest appreciation for my supervisor, **Mr. Kee Kok Eng** whom has given me continuous support throughout my time under his supervise. I am truly fortunate to have his guidance through the tough times.

To my **examiners, Dr Faiz Ahmad, Dr Saravanan and Dr Azmi**, whom have given me advice and feedback throughout the FYP I & FYP II that have assist me in completing this project.

To the **technicians** at the mechanical lab and material lab that have given me advise and assistance in the their respective arenas.

To **En.Azuan** (post graduate), whom have share his experience in composite fabrication lab work.

Last but not least, to the **Mechanical Department FYP Coordinator, Dr Puteri** , whom has work so hard to plan and schedule all the FYP related activity.

## TABLE OF CONTENTS

<b>CERTIFICATION</b>	<b>i</b>
<b>ABSTRACT</b>	<b>iii</b>
<b>ACKNOWLEDGEMENT</b>	<b>iv</b>
<b>TABLE OF CONTENTS</b>	<b>v</b>
<b>LIST OF FIGURES.</b>	<b>vii</b>
<b>LIST OF TABLE.</b>	<b>viii</b>
<b>CHAPTER 1: INTRODUCTION</b>	<b>1</b>
1.1 Project Background	1
1.1.1 Jig Modification.	1
1.1.2 Samples Fabrication	1
1.1.3 Experimental Works & Data Collection	1
1.1.4 Computer Software Simulation	1
1.2 Problem Statement	1
1.3 Objectives	2
1.4 Scope of Study	3
1.4.1 Final Year Project I	3
1.4.2 Final Year Project II	3
<b>CHAPTER 2: LITERATURE REVIEW AND THEORY.</b>	<b>4</b>
2.1 Reviews on Past Research.	4
2.2 Theory	5
2.2.1 Fundamentals of Fibers and Matrix	5
2.2.2 Impact on Composition Structure.	6
2.3 ASTM D5628	7
2.3.1 Summary of Test Method	7
2.3.2 Significance of Use	8
2.3.3 Interferences and Apparatus	8
2.3.4 Safety Precaution	9
2.3.5 Test Specimen	9
2.4 Hand Lay-up Process	9
<b>CHAPTER 3: METHODOLOGY</b>	<b>11</b>
3.1 Process Flow Chart	11
3.2 Rules of Mixture.	12
3.3 Ultrasonic Testing.	13
3.4 ASTM D5628-96 Test Procedure.	14
<b>CHAPTER 4: DESIGN AND TESTING JIG FABRICATION WORKS..</b>	<b>15</b>
4.1 Overview	15
4.2 Existing Jig Design.	15
4.3 Testing Jig Design & Fabrication.	16
4.3.1 Part Fabrication	17

4.3.1.1 Part's Detail	. . . . .	17
4.4 Material's Selection	. . . . .	22
4.5 Material's Cost	. . . . .	23
4.6 Manufacturing Process	. . . . .	23
4.7 Engineering Calculation	. . . . .	23
4.7.1 Guiding Tube Length	. . . . .	23
4.7.2 Bending Calculation	. . . . .	25
<b>CHAPTER 5: COMPOSITE PLATE FABRICATION WORKS</b>	. . . . .	<b>27</b>
5.1 Overview	. . . . .	27
5.2 Composite Plate Configuration	. . . . .	27
5.2.1 Sample Calculation	. . . . .	28
5.3 Composite Plate Fabrication Procedure.	. . . . .	29
5.4 Fabricated Fiber Plate	. . . . .	31
5.5 Visual Inspection	. . . . .	32
<b>CHAPTER 6: RESULT AND DISCUSSION.</b>	. . . . .	<b>33</b>
6.1 Overview	. . . . .	33
6.2 Result	. . . . .	33
6.3 Discussion.	. . . . .	36
6.3.1 Visual Inspection	. . . . .	36
6.3.2 Damage Area	. . . . .	37
<b>CHAPTER 7: CONCLUSION</b>	. . . . .	<b>40</b>
7.1 Conclusions	. . . . .	40
7.2 Next Step	. . . . .	40
<b>REFERENCES.</b>	. . . . .	<b>41</b>
<b>APPENDICES</b>	. . . . .	<b>43</b>

## LIST OF FIGURES

Figure 2.1	Unidirectional Ply	5
Figure 2.2	Woven Fabric	5
Figure 2.3	Reinforcement and Resin Mixing Process	6
Figure 2.4	Hand Lay-up Moulding	10
Figure 3.1	Process Flow Chart	11
Figure 3.2	Ultrasonic Testing Setting	13
Figure 3.3	Straight Beam Transducer	14
Figure 4.1	Current testing jig's component, a) Interface Frame, b) impactor	15
Figure 4.2	Full view of Testing Jig (Impactor Release Mechanism)	16
Figure 4.3	Full view of Testing Jig (Body)	17
Figure 4.4	Base, (a) Catia drawing, (b) & (c) Actual Part	18
Figure 4.5	a) Interface Frame & b) Centering Plate	18
Figure 4.6	Impactor Holder, (a) Catia drawing, (b) Actual Part	19
Figure 4.7	Impact System Assembly, (a) Catia drawing, (b) Actual Part	20
Figure 4.8	Guiding Frame Structure Full View, (a) Catia drawing, (b) Actual Part	20
Figure 4.9	Guiding Frame Structure Top Part, (a) Catia drawing, (b) Actual Part	21
Figure 4.10	Guiding Frame Structure Bottom Part, (a) Catia drawing, (b) Actual Part	21
Figure 4.11	Drop Tube	21
Figure 4.12	Tube length calculation diagram	24
Figure 4.13	Releasing Pin Bending Calculation	25
Figure 5.1	Mold	29
Figure 5.2	Grove & Apron	30
Figure 5.3	Mixture	30
Figure 5.4	Release Agent	30
Figure 5.5	Pre cut Fiber sheet	30
Figure 5.6	Roller	31
Figure 5.7	Glass Fiber Woven plate	31
Figure 5.8	Glass Fiber Chopped plate	32

Figure 5.9	Carbon Fiber Woven plate	32
Figure 6.1	Damage Area traced by UT for 25J 20% Glass Woven	33
Figure 6.2	Damage Area traced by UT for 50J 20% Glass Woven	33
Figure 6.3	Damage Area traced by UT for 25J 40% Glass Woven	34
Figure 6.4	Damage Area traced by UT for 50J 40% Glass Woven	34
Figure 6.5	Damage Area traced by UT for 25J 20% Glass chopped	34
Figure 6.6	Damage Area traced by UT for 50J 20% Glass chopped	34
Figure 6.7	Damage Area traced by UT for 25J 30% Glass chopped	35
Figure 6.8	Damage Area traced by UT for 50J 30% Glass chopped	35
Figure 6.9	Damage Area traced by UT for 25J 20% Carbon Woven	35
Figure 6.10	Damage Area traced by UT for 50J 20% Carbon Woven	35
Figure 6.11	Damage Area traced by UT for 25J 40% Carbon Woven	36
Figure 6.12	Damage Area traced by UT for 50J 40% Carbon Woven	36
Figure 6.13	Damage Area Vs Impact Energy	39
Figure A1	GTAW Weld Area	43
Figure A2	ISO Socket Head Screw Engineering Size Data	46
Figure A3	Machinist Metric ISO Screw Thread Tap – Drill Size Chart	47
Figure A4	Impactor Holder	50
Figure A5	Impactor	51
Figure A6	Interface Frame	52
Figure A7	Centering Plate	53
Figure A8	Frame	54
Figure A9	Base	55

## LIST OF TABLES

Table 4.1	Material's Cost	23
Table 4.2	Manufacturing Process Summary	23
Table 5.1	Composite Plate Configuration	27
Table 5.2	Composite Plate Fabrication Procedure	29
Table 5.3	Composite Plate Thickness	31
Table 6.1	Result	33
Table 6.2	Summary of Damage Area	37