EFFECT OF FIBER ORIENTATION ON TENSILE PROPERTIES OF SHORT GLASS FIBER REINFORCED INJECTION MOLDING POLYPROPYLENE COMPOSITE

ABDUL MALEK YA'ACOB

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By

ABDUL MALEK YA’ACOB

Thesis Submitted to the School of Graduate Studies, Universiti Putra Malaysia, in Fulfilment of Requirements for the Degree of Master of Science

May 2004
To my parents...
Abstract of thesis presented to the Senate of Universiti Putra Malaysia in fulfilment of the requirements for the degree of Master of Science

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May 2004

Chairman: Associate Professor Mansor Ahmad, Ph.D.

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The objective of this study is to examine the behaviour of composites and to provide an overview of short glass fiber reinforced injection-moulded thermoplastic, SgFRIMT in relation to the fiber orientation direction. In this study, the relationship between the mechanical properties of samples containing longitudinal and transverse direction was studied in terms of the effects of injection speed, fiber concentration and fiber length on the mechanical properties of SgFRIMT. The orientation of fiber distribution in longitudinal and transverse direction was measured according to the gate position and samples taken from identified position were investigated and tested at an angle relative to the fiber direction.

The composite consisting of 5, 10, 15% wt of glass fiber was prepared using single screw extruder model Brabender Plasticoder PL 2000, a compression molding machine and an 80-tonne Toshiba injection molding machine. The tensile properties were evaluated by
Instron testing machine model 4301. The discussion focuses on the effects of fiber concentration, injecting speed and fiber length on tensile properties of a SgFRIMT.

Tensile strength shows a steady decrease with increasing percentage of fiber loadings. In contrast, the tensile modulus increases significantly with an increase in the fiber loadings. At higher fiber concentration, the values of the modulus were higher than those of the unfilled polypropylene. The fiber breakage that occurs during sample preparation reduces the overall tensile strength significantly.

Additional investigation was carried out on the effect of fiber breakage using 6 and 12 mm fiber length, where it was observed that the fiber breakage occurs during compounding stages with approximately 80% reduction in initial fiber length. Observation on the extrudates reveals that poor fiber matrix interaction causes the failure of the prepared samples. The presence of void and the agglomeration inside the samples considerably affects the mechanical properties of the composites. The results indicate that the stiffness and toughness of the SgFRIMT generally are influenced by the addition of glass fibers. In this study the influence of the injection speed was insignificant.

The results of average fiber length agree with the results of other previous studies on SgFRIMT materials, indicating that the fiber length has major influence on the tensile properties of the prepared samples.
Abstrak tesis yang dikemukakan kepada Senat Universiti Putra Malaysia sebagai memenuhi keperluan untuk ijazah Master Sains

KESAN PENGHALAAN GENTIAN TERHADAP KELAKUAN KETEGANGAN BAGI KOMPOSIT POLIPROPILENA PENGACUAN SUNTIKAN BERTETULANG GENTIAN KACA PENDEK

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Objektif kajian ini adalah untuk menyelidik kelakuan komposit dan juga menyediakan gambaran keseluruhan umum berkenaan dengan komposit plastik haba pengacuan suntikan bertetulang gentian kaca pendek (SgFRIMT) berhubung dengan arah penghalaan gentian. Dalam kajian ini hubungan antara ciri-ciri mekanikal daripada sampel yang mengandungi arah gentian melintang dan membujur dikaji dari segi kesan kelajuan penyuntikan, kepekatan gentian dan panjang gentian kepada ciri-ciri mekanikal komposit plastik haba pengacuan suntikan bertetulang gentian kaca pendek (SgFRIMT). Taburan penghalaan gentian dari arah melintang dan membujur telah diukur menurut posisi gate dan sample-sampel yang diambil dari posisi yang dikenalpasti telah diselidik dan diuji pada sudut yang berhubung dengan arah gentian.

Komposit yang terdiri daripada 5,10 dan 15% berat gentian telah disediakan menggunakan mesin penyemperitan skru tunggal model Brabendar Plasticoder PL 2000, mesin pengacuan mampatan dan mesin pengacuan suntikan Toshiba 80 ton. Ciri-ciri
ketegangan dinilai menggunakan sebuah mesin penguji Instron model 4301. Perbincangan ini menumpukan kepada kesan kepekatan gentian, kelajuan penyuntikan dan panjang gentian terhadap ciri-ciri ketegangan komposit plastik haba pengacuan suntikan bertetulang gentian kaca pendek (SgFRIMT).

Kekuatan ketegangan menunjukkan penurunan yang stabil dengan peningkatan peratus pengisian gentian. Sebagai perbandingan, pemalar ketegangan meningkat dengan jelasnya dengan peningkatan dalam pengisian gentian. Pada kepekatan gentian yang lebih tinggi nilai pemalar adalah lebih tinggi berbanding polipropilena tidak berpengisi. Pematahan gentian yang berlaku semasa penyediaan sampel dengan jelasnya menurunkan keseluruhan kekuatan ketegangan.

Penyelidikan tambahan telah dijalankan untuk mengkaji kesan pematahan gentian tersebut menggunakan panjang gentian 6 dan 12 mm di mana ianya telah diperhatikan bahawa pematahan gentian berlaku semasa peringkat pencampuran dengan anggaran 80% penurunan dalam panjang asal. Pemerhatian terhadap hasil penyemperitan mendedahkan bahawa interaksi gentian matrik yang lemah menyebabkan kegagalan sampel yang disediakan tersebut. Kehadiran lompang dan timbunan gentian dalam sampel sangat memberi kesan kepada ciri-ciri mekanikal komposit tersebut. Keputusan menunjukkan bahawa kelakuan dan keliatan bagi komposit plastik haba pengacuan suntikan bertetulang gentian kaca pendek (SgFRIMT) secara umumnya dipengaruhi oleh penambahan gentian kaca. Dalam kajian ini pengaruh kelajuan penyuntikan adalah tidak ketara.
Keputusan purata panjang gentian bersetuju dengan keputusan-keputusan kajian terdahulu yang lain terhadap bahan komposit plastik haba pengacuan suntikan bertetulang gentian kaca pendek (SgFRIMT) yang menunjukan bahawa panjang gentian tersebut mempunyai pengaruh yang lebih besar terhadap ciri-ciri ketegangan bagi sampel yang disediakan.
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I certify that an Examination Committee met on 13th May 2004 to conduct the final examination of Abdul Malek Ya'acob on his Master of Science thesis entitled “Effect of Fiber Orientation on Tensile Properties of Short Glass Fiber Reinforced Injection Molding Polypropylene Composite” in accordance with Universiti Pertanian Malaysia (Higher Degree) Act 1980 and Universiti Pertanian Malaysia (Higher Degree) Regulations 1981. The Committee recommends that the candidate be awarded the relevant degree. Members of the Examination Committee are as follows:

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x
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DECLARATION

I hereby declare that the thesis is based on my original work except for quotations and citations which have been duly acknowledged. I also declare that it has not been previously or concurrently submitted for any other degree at UPM or other institutions.

ABDUL MALEK YA’ACOB

Date: 2/8/2014
TABLE OF CONTENTS

DEDICATION ii
ABSTRACT iii
ABSTRAK v
ACKNOWLEDGEMENTS viii
APPROVAL x
DECLARATION xii
LIST OF TABLES xv
LIST OF FIGURES xvii
LIST OF ABBREVIATIONS/NOTATIONS/GLOSSARY OF TERMS xxiii

CHAPTER

1. INTRODUCTION 1.1 Overview 1.1
1.2 Objective of the research 1.4
1.3 Significant of study 1.5

2. LITERATURE REVIEW 2.1 Overview of current research 2.1
2.2 Material Selection 2.5
2.3 Polypropylene 2.8
2.4 Glass fibers 2.10
2.5 Effect of fiber Concentration 2.17
2.6 Fiber orientation in injection molding 2.21
2.7 Effects of injection speed 2.32
2.8 Effects of fiber length 2.33
2.9 Summary of literature review 2.35

3. METHODOLOGY 3.1 Introduction 3.1
3.2 Material 3.2
3.2.1 Polypropylene resins 3.2
3.2.2 Glass fiber 3.2
3.3 Experimental design 3.3
3.4 Material preparation 3.4
3.4.1 Preparation of samples 3.4
3.5 Melt flow index (MFI) determination 3.9
3.6 Experiment 3.12
3.6.1 Injection molding 3.12
3.6.2 Molding operation 3.15
3.6.3 Preparation of specimen 3.18

xiii
3.6.4 Test specimen
3.7 Tensile testing
3.8 Burning testing
3.9 Compression molding
3.10 Fiber length measurement
3.11 Preliminary experiment
  3.11.1 Compounding
  3.11.2 Melt flow index

4. RESULTS AND DISCUSSION
4.1 Overview
4.2 Mechanical properties
4.3 Melt Flow Index study
4.4 Effect of fiber concentration
4.5 Injection speed factor
4.6 Fiber orientation observation after burning
4.7 Investigation on effect of fiber length
4.8 Effect of tensile properties using different method of samples preparation
  4.8.1 Compression molding tensile results using 3 mm glass fiber length
  4.8.2 Results comparison between injection molding and compression molding method

5. CONCLUSIONS AND RECOMMENDATIONS FOR FURTHER WORK
5.1 Conclusions
5.2 Recommendations

REFERENCES
APPENDIX
BIODATA OF THE AUTHOR
**LIST OF TABLES**

<table>
<thead>
<tr>
<th>Table</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.1</td>
<td>The composition of a typical E-glass fiber (Cooke, 1990)</td>
</tr>
<tr>
<td>2.2</td>
<td>Several types of glass fibers used in production and their composition for E-glass, S-glass, R-glass, A-glass and C-glass (Cooke, 1990)</td>
</tr>
<tr>
<td>2.3</td>
<td>The mechanical properties comparison between a neat polypropylene and glass reinforced polypropylene (Chiang, 1998)</td>
</tr>
<tr>
<td>2.4</td>
<td>The mechanical property comparison between injection molded of short fiber reinforced polypropylene and long fiber reinforced polypropylene (Gibson, 1995)</td>
</tr>
<tr>
<td>3.1</td>
<td>Typical properties of polypropylene grade 710</td>
</tr>
<tr>
<td>3.2</td>
<td>Properties of E-glass fiber</td>
</tr>
<tr>
<td>3.3</td>
<td>Variables used in study</td>
</tr>
<tr>
<td>3.4</td>
<td>Blending ratio for 1 kg of material</td>
</tr>
<tr>
<td>3.5</td>
<td>Parameters used for polypropylene processing</td>
</tr>
<tr>
<td>3.6</td>
<td>The MFI parameter used in study</td>
</tr>
<tr>
<td>3.7</td>
<td>Conditions for samples preparation using injection molding</td>
</tr>
<tr>
<td>3.8</td>
<td>Description for tensile specimen specifications</td>
</tr>
<tr>
<td>3.9</td>
<td>Details on tensile testing parameter</td>
</tr>
<tr>
<td>3.10</td>
<td>Overall MFI results for Titan Pro resin</td>
</tr>
<tr>
<td>3.11</td>
<td>Parameter for MFI determination</td>
</tr>
<tr>
<td>3.12</td>
<td>Overall MFI results for Polypropylene Malaysia resins</td>
</tr>
<tr>
<td>4.1</td>
<td>The tensile strength values for each compounded batch with different fiber loadings and injection speeds</td>
</tr>
<tr>
<td>4.2</td>
<td>Effect of tensile modulus at various glass fiber content and injection speed</td>
</tr>
</tbody>
</table>
4.3 Tensile strength at different glass fiber loadings for longitudinal flow
4.4 Tensile strength at different glass fiber loadings for transverse flow
4.5 Tensile modulus at different glass fiber loadings for longitudinal flow
4.6 Tensile modulus at different glass fiber loadings for transverse flow
4.7 Standards length for short fiber used in the industry Matthews (1994)
4.8 The advantages and disadvantages of molding operations according to Griskey (1995)
4.9 Overall length of fibers after processing Medalia (1990)
<table>
<thead>
<tr>
<th>Figure</th>
<th>Description</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.1</td>
<td>General properties of a fiber reinforced plastics</td>
<td>1.2</td>
</tr>
<tr>
<td>1.2</td>
<td>Overview of the flow of the research</td>
<td>1.6</td>
</tr>
<tr>
<td>2.1</td>
<td>Positions for measurement of fiber orientation (Edisyams, 2002)</td>
<td>2.2</td>
</tr>
<tr>
<td>2.2</td>
<td>Orientation tensor value ( a_{11} ) near the gate position A and position B for 2 mm plaque at 1 seconds fill time (Edisyams, 2002)</td>
<td>2.3</td>
</tr>
<tr>
<td>2.3</td>
<td>Orientation tensor value ( a_{11} ) near to the gate position A of the 2 mm and 4 mm plaque at 1 seconds fill time (Edisyams, 2002)</td>
<td>2.4</td>
</tr>
<tr>
<td>2.4</td>
<td>Orientation tensor value ( a_{11} ) far from the gate position B of the 2 mm and 4 mm plaque at 1 second fill time (Edisyams, 2002)</td>
<td>2.4</td>
</tr>
<tr>
<td>2.5</td>
<td>Reinforcement in thermoplastic matrix based composites (Jozsef, 2000)</td>
<td>2.6</td>
</tr>
<tr>
<td>2.6</td>
<td>Classification of plastics (Chiang, 1998)</td>
<td>2.7</td>
</tr>
<tr>
<td>2.7</td>
<td>PP monomer structure</td>
<td>2.8</td>
</tr>
<tr>
<td>2.8</td>
<td>Typical stress-strain curve for pure PP matrix material (Fu et al., 2000)</td>
<td>2.9</td>
</tr>
<tr>
<td>2.9</td>
<td>Glass fibers structure (Cooke, 1990)</td>
<td>2.11</td>
</tr>
<tr>
<td>2.10</td>
<td>Comparison of stress-strain curves of high strength and high modulus fibers (Cooke, 1990)</td>
<td>2.14</td>
</tr>
<tr>
<td>2.11</td>
<td>Stress-strain curves of commonly used fiber (Cooke, 1990)</td>
<td>2.15</td>
</tr>
<tr>
<td>2.12</td>
<td>Cross sectional diagram of an injection molding machine (Sheldon, 1982)</td>
<td>2.21</td>
</tr>
<tr>
<td>2.13</td>
<td>Diagram of mould filling process (Matthews and Rawlings, 1994)</td>
<td>2.22</td>
</tr>
<tr>
<td>2.14</td>
<td>Flow pattern (Powell and Housz, 1998)</td>
<td>2.26</td>
</tr>
<tr>
<td>2.15</td>
<td>Shear rate profile in the plane of the mould flow direction (Gibson, 1995)</td>
<td>2.27</td>
</tr>
</tbody>
</table>
2.16 A three layers model with two outer skin and one center core (Edisyams, 2002)

2.17 Fiber orientation states described by orientation parameter (Matsuoka, 1995)

2.18 Fiber orientation flow pattern (Matthews and Rawlings, 1994)

2.19 Predicted fiber orientation for samples (Lee, 1996)

2.20 Fiber orientation for injection molded rectangular shaped part with 50 wt% (Kim et al., 2001)

2.21 Modeling of mechanical performance (Thomason, 2002)

3.1 Drying oven machine

3.2 Samples drying method

3.3 Screw parameter for extruder type Brabender 19/25D, single screw 1:1

3.4 Extruder equipment

3.5 Palletizing equipment

3.6 Flow chart of melt flow index determination

3.7 Melt Flow Index apparatus

3.8 Injection samples

3.9 Overall stages of samples preparation

3.10 Stages in the injection molding process

3.11 Flow chart of injection processes

3.12 Flow of molding operation

3.13 Injection molding machine

3.14 Male and female mold

3.15 ASTM D 638, type V cutter

3.16 Cutter apparatus
3.17 Transverse specimen 3.19
3.18 Longitudinal specimen 3.19
3.19 Tensile test specimen type V 3.20
3.20 Instron machine used to determine the tensile properties 3.22
3.21 Compression molding machine 3.24
3.22 Compression molding samples 3.24
3.23 Light microscope for final fiber length verification 3.25
4.1 Longitudinal, A and transverse, B direction for fibers 4.5
4.2 Neat PP samples (1 secs) 4.5
4.3 Neat samples (3 secs) 4.5
4.4 5%wt GF loaded (1 secs) 4.6
4.5 5%wt GF loaded (3 secs) 4.6
4.6 10%wt GF loaded (1 secs) 4.6
4.7 10%wt GF loaded (3 secs) 4.6
4.8 15%wt GF loaded (1 secs) 4.7
4.9 15%wt GF loaded (3 secs) 4.7
4.10 Flow chart of samples preparation 4.9
4.11 Overall tensile strength with reference to percent glass fiber loaded, flow direction (longitudinal flow and transverse flow) and injection speed 4.14
4.12 Overall tensile modulus results 4.15
4.13 Samples of 12 mm length fibers with 15 %wt GF 4.21
4.14 Melt flow index results for polypropylene (14 g/10 minutes) 4.23
4.15 Melt flow index results for PP (24 g/10 minutes) 4.23
4.16 Summary of suggested failure factors with reference to melt flow index 4.24
4.17 Tensile strength for different injection speeds at longitudinal flow

4.18 Tensile strength at different injection speeds for transverse flow

4.19 Tensile modulus at different injection speeds for longitudinal flow

4.20 Tensile modulus at different injection speeds for transverse flow

4.21 Fiber residual for 3 mm fiber length using injection molding molding method

4.22 Fiber residual for 12 mm fiber length, 5% GF using compression molding method

4.23 Effect of fiber orientation on tensile strength of PP/sisal fiber composites (Joseph et al., 1999)

4.24 Effect of fiber orientation on Young’s modulus of PP/sisal composites (Joseph et al., 1999)

4.25 Fiber breakage occurs approximately 75% for each batch of injection molding samples

4.26 Stages of samples preparation using compression molding method

4.27 Average fiber length residual results using compression molding for 6 mm and 12 mm glass fiber lengths

4.28 Tensile strength results for 6 mm fiber lengths using compression molding with different fiber loadings

4.29 Tensile strength results for 12 mm fiber length using compression molding with different fiber loadings

4.30 Stress/strain curve of solution mixed PP/sisal composites of different fiber lengths for fiber content 20% (Joseph et al., 1999 (a))

4.31 Tensile modulus for 6 mm fiber length using compression molding with different fiber loadings

4.32 Tensile modulus for 12 mm fiber length using compression molding with different fiber loadings

4.33 Tensile strength results for 3 mm glass fiber length using compression molding method
4.34 Tensile modulus results for 3 mm glass fiber length using compression molding method

4.35 Average glass fiber length results after processing using injection molding and compression molding method

4.36 Fiber length results before and after processing for different types of fibers according to Medalia (1990)

4.37 Tensile strength results for both injection molding method at longitudinal direction and compression molding method

4.38 Tensile strength results for both injection molding method at transverse direction and compression molding method

4.39 Tensile modulus results for both injection molding method at longitudinal direction and compression molding method

4.40 Tensile modulus results for both injection molding method at transverse direction and compression molding method
LIST OF ABBREVIATIONS/NOTATIONS/GLOSSARY OF TERMS

$a_{ij}$  First order of orientation tensor

FOD  Fiber orientation distribution

MPI  Molflow Plastics Inside

MFI  Melt Flow Index

PP  Polypropylene

GF  Glass fiber


S-glass  High strength and high modulus glass to improve stiffness.

A-glass  Soda-lime glass with low thermal constants and poor chemical durability

C-glass  Soda-lime borosilicate glass with excellent chemical durability.

OPWF  Oil palm wood flour

SgFRIMT  Short glass fiber reinforced injection-moulded thermoplastic

ASTM  American standards testing method

JIS  Japan international standards

$f_r$  Orientation parameter

$\sigma$  Stress

$E$  Strain

$\varnothing$  Fiber plain angle

Nm  Newton meter

$\%\text{wt}$  Percent by weight
CHAPTER 1
INTRODUCTION

1.1 Overview

Composites and specifically fiber-reinforced plastics have been used as structural material for a wide range of applications in several fields of technology because of their low overall cost performance and long term durability during services and have a long history of proven performance. Hence the use of composite materials has been widespread for various industries such as aircraft manufacturing, medical and automotive. Composite materials are recognized as the most advanced materials for fabrication. The success of these composite parts in services leads to the increased use of composites in various fields of application because of the advantage of this material to withstand stresses during services. Fiber reinforced composites provide a wide range of properties and behaviors and are stiffer than conventional un-reinforced composites and are superior compared to those of other materials such as steel and aluminum. Generally a composite material is a material that combined two or more materials to form a much stronger structure. Figure 1.1 shows a typical fiber reinforced composites properties.
The most known advantage a composites part is the high strength-to-weight ratio. A composites part can be designed as strong as a metal part. Generally composites utilize other advanced material such as metal alloys and are processed to achieve reduced weight, increased strength and improve wear resistance to the part structure.

Several other advantages of a composite structure include;

1. Can be designed to be very flexible.
2. Does not corrode like metal
3. Complex shapes may be molded in a part
4. Composites are very durable.
5. Light weight and more cost effective then the metal counterparts.

The experimental studies of fiber orientation direction are described in this study for an actual specimen prepared by injection molding machine. The concept used in this study followed the work of Edisyams (2002). Generally the purpose of carrying out the experimental study is to predict the effects of fiber orientation for composite samples.