

Contents

1	Introduction.....	1
1.1	Research Variables	2
1.2	Research Objectives	5
1.3	Research Questions	5
1.4	Thesis Structure.....	7
1.5	Methodology	8
2	State of the Art.....	11
2.1	Cellulose	11
2.2	The Use of Cellulose in AM.....	14
2.2.1	Thermoplastic Cellulosic Composites in AM.....	14
2.2.2	Cellulose Use in Inks, Gels, and Suspension Concentrations.....	15
2.3	Synthesis of the state of art.....	17
2.4	Motivation of the Research	19
3	Printing Configuration & Performance.....	21
3.1	3D Printing Configuration and its Quality.....	21
3.2	Input Parameters.....	21
3.2.1	Raw Material and its Selectivity	22
3.2.2	Formulation and Mixture Design.....	30
3.2.3	Mixing Process Procedure	34
3.2.4	Rheology.....	36
3.2.5	Adopted Technology & Print Resolution	58
3.3	Process Parameters & Geometry Configuration	60
3.3.1	Nozzle Move-Speed.....	61
3.3.2	Extrusion Speed and Layer Height.....	63
3.3.3	Process Parameters Optimization	65
3.3.4	Extrusion Width & Coalescence of Layers and Walls	65

3.3.5 Filling	68
3.3.6 Air Pressure	70
3.3.7 G-code Optimization	71
3.3.8 Post Processing	71
3.4 Curing Process	73
3.4.1 Shrinkage Outcomes During Drying.....	74
4 Printing Quality Assessment	87
4.1 Cellulose Solution	87
4.2 Optimal Mixtures.....	88
4.3 Printability & Geometry Calibration	90
4.4 Optimized Printing Parameters	93
4.5 Shape-Retention & Stability Ability	97
4.6 Mixture-Validity Time Before Printing.....	103
4.7 Recyclability	105
4.8 Overhang Slope	107
4.9 Removal from the Print-Bed.....	110
4.10 Surfaces Topography	111
4.11 Dimensional Accuracy	114
4.11.1 Production Process Effect.....	114
4.11.2 Material Behavior Effect (Feedstock)	115
4.11.3 Shrinkage Measurement for 3D Volumes	119
4.11.4 Drying Rate & Uniformity Issues.....	127
4.11.5 Zits & Blobs	130
4.11.6 Corner Angle.....	131
4.11.7 Layering Shifting	134
5 Material & Mechanical Characteristics	137
5.1 Density.....	137
5.2 Compression Strength	138
5.3 Tensile Strength.....	141
5.3.1 Filaments Orientation Effect (0- , 90- , 45-) Degree	142
5.3.2 Adhesion Properties	144
5.3.3 Effect of Nozzle Size.....	149
5.3.4 Effect of Wood Fiber.....	152

6	3D Models as Cases Study	159
6.1	Acoustical Purposes & Interior Decoration	160
6.1.1	Coral Panel.....	161
6.1.2	Tides Panel (Ebb & Flow)	166
6.1.3	Gills 3D Model	169
6.1.4	3D Map Panel	174
6.1.5	Triangular Seashell Panel.....	178
6.1.6	Bubbles Panel	181
6.1.7	Acoustic Reef	185
6.1.8	Inverted Crowned Buffel	188
6.2	Sunshade 3D Models	192
6.2.1	Cell Shade Panel	192
6.2.2	Shadow from Floral Leaf Buffel	198
6.2.3	Shading Tree Wall.....	203
6.2.4	Honeycomb Panel.....	207
6.3	Summary	210
7	Conclusion and Recommendation.....	213
7.1	Dimensional Accuracy And Geometrical Integration	213
7.1.1	Mixture Formulation	213
7.1.2	Rheology Behavior.....	214
7.1.4	Cellulose Privilege.....	215
7.1.5	Printing Parameters.....	216
7.1.6	Shrinkage Outcomes.....	216
7.2	Design Considerations and Limitations	218
7.3	Recommendation & Prospects	220
	Reference	227
	Appendix A: Material properties and preparations	239
	A.1 Cellulose	239
	A.2 Chalk.....	244
	A.3 Peel ply fabric.....	244
	A.4 Wood fibers.....	245
	Appendix B: Used Devices	246
	B.1 Microscope	246

B.2 Rheometer.....	246
Appendix C: WRV-Test Procedure	247
Appendix D: Design Details	248
Appendix E: Adhesion Property of the Mixture to Other Surfaces	250
Appendix F: Acoustic Performance for AM Paper Material by Experimental Device.....	253
Appendix G: 3D Models Details.....	255
G.1 Acoustic Simulation.....	255
G1.1 Gills panel.....	257
G1.2 Coral Panel	266
G1.3 Tides panel	268
G1.4 3D map panel	270
G1.5 Shell/floral leaf shape of triangles	271
G1.6 Bubbles panel.....	272
G1.7 3D crowned Buffel model	274
G1.8 Acoustic reef	276
G.2 Sun Shading elements details (Solar radiation analysis).....	279
G2.1 Cell Design.....	282
G2.2 3D honeycomb model.....	286
G2.3 String wall partition.....	288
G2.4 Tree Shade panel	289
G2.5 Mais panel.....	291
G2.6 Floral leaf Buffel	297