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# Production of Enamel Stains from Igbokoda Silica Sand

Fatile  $B.O^1$  Lamidi  $Y.D^1$  Ogundare  $T.S^2$  Sanya,  $O.T^1$ 

1. Department of Glass and Ceramic Technology, Federal Polytechnic Ado-Ekiti

2. Industrial Design Department, Federal University Of Technology, Akure.

## ABSTRACT

Silica sand was sourced from Igbokoda, ondo state, this was washed, dried and the percentage clay and organic matter present in the silica sand determined. Some percentage of the silica sand was used to compose different batches of enamel compositio and was fired to a temperature of 1200°C. The compositions were fritted in metallic bucket and then pulverized to form powder. The powder was mix with gum arabic to form a paste and this was used to print on ceramic wares and glass cups. The printed wares were tested to determine the resistance of the wares to acid and base environment. From the test, the result showed that the enamel produced exhibit a good resistance to acid and base.

Keywords: Enamel, frits and Igbokoda silica

### Introduction

Silica sand is one of the most common mineral in the Earth Crust. It is made up of broken quartz crystals which has been broken down into tiny granules over years through the action of water and Weathering (Edem, 2014). Silica sand granules can be used for different purpose such as glass production, glass stains, enamel production and this is found deposited in most non tropical region of the world (Carr,1971;Hecketal,2002;Freestone,2005). In Africa, especially in Nigeria silica sand deposit are mostly found deposited in most parts of the country particularly in riverin ,estuaries and beaches(Chang, 1991; Claude, 2002;Malu and Bassey,2003). One of the major deposit of silica sand in Nigeria is Igbokoda.

Igbokoda is located in Ondo state . It has a river which is one of the major and important river in Nigeria which lies on latitude  $4^{\circ}.40-5^{\circ}.00N$  and  $6^{\circ}.00-60-20E$ . The river is noted for artisanal fishing activities, transportations and mining of silica sand (Olaniyan, 2016). The mineral resources department of Ondo state estimated that Ondo state silica sand has an estimated reserve of 3 billion MT where igbokoda is one of the principal location for the silica sand. Igbokoda silica sand is available for commercial exploration and exploitation for the production of glass and ceramic production. Igbokoda silica has been characterized by Ojuri 2015 to have about 94.24% SiO<sub>2</sub> content, this is an evident of a good silica for glass industries.

## **Research Objectives**

- i access Igbokoda silica sand for enamel stain composition.
- ii vary the different composition with metallic oxides.
- ii frit the various batches at melting temperature of the metallic oxides
- iii Pulverise the melted batch
- iv. mix the pulverized sample with mixing agent
- v examine he effect of the enamel produced wares at 600-700°C firing temperature;
- vi test the enamel produced to determine the resistance to acid and base.

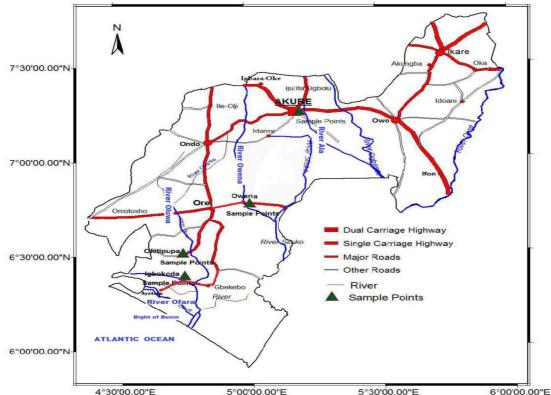


Fig. 1 Hydrological network within study area (Ondo State) showing where samples were taken (Adapted from Federal Surveys)

## **Materials and Equipment**

Washing and water bowl: This is a container used for holding materials e.g water or wet materials.

Pulverizer: This is used for the reduction of materials to a powdery form.

**Kiln:** The kiln is used for heating in the ceramic studio. This is used to fire to the required temperature before fritting

Screen/Mesh : This is used to transfer designs on the surface of the glass and ceramic wares.

Weighing balance(Electronic): A weighing balance allows to determine the mass of various materials used for the experiment.

**Crucibles:** These are used to hold materials to be fired. It is a refractory material that can withstand a very high temperature of above 1200°C.

**Design** : This is the printed on the glass and ceramic surface which is in form of logo or art work. This is done with the use of the computer.

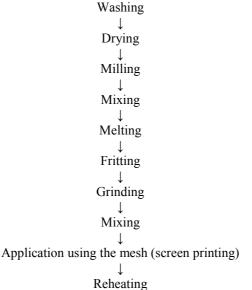
**Silica Sand:** The silica sand is the major raw material required for the stain production. It is the glass former hence increases the mechanical strength of the stain and gives the stain a higher

Ceramic metallic oxides : These are the oxides that are responsible for the various types of colourations in stains.

Mixing agent: This is the medium that allows the enamel to flow so that it will be able to stay on the printed material.

Auxilliary materials: These are the other raw materials added to the composition to aid the melting process.

## Flow chart of the production process.



## PROCEDURE

The samples of the silica sand was gotten from the site, these were poured in a bowl and washed using water. This is done in order to remove the impurities that might be present in the silica sand from the deposit, it was then air dried and stored in a sack.

The silica sand was weighed and combined in various ratios with other fluxes, opacifiers and metallic oxides respectively. The fluxes, opacifiers and the metallic oxides were to reduce the melting temperature of the silica sand, make the enamel stain translucent and to add colourants respectively. The samples were weighed in different proportion according to the tables below and then poured into different crucibles and fired to a temperature of 1200°C in a muffle kiln. At that temperature, most of the batches had form glass. The various crucibles were removed from the kiln and poured differently into an Iron container in order to frit the composition.

The various fritted batches were then put in a pallet and labeled accordingly. The pallets were later taken to the workshop to pulverize the samples so as to have a powder form of the frit.

The powder was mix with gum arabic for it to form a paste, the paste was necessary so that the enamel stain produce can stick to the body of the glass and ceramic wares. Various tests were then carried out on the wares to know the acid and base resistant of the enamel produced.

#### Table 1 Composition A1

Composition A1		
Oxides	Percentage Composition	Weight in Gramme
Silica sand	15%	75g
Feldspar	10%	70g
Calcium Oxide	8%	40g
Zirconium Oxide	5%	25g
Sodium Oxide	44%	220g
Cullet	14%	70g
Iron Oxide	4%	10g
	100%	500g

## Table 2

Table 2		
Composition B2		
Oxides	Percentage Composition	Weight in Gramme
Silica sand	20%	100g
Feldspar	9%	70g
Calcium Oxide	8%	40g
Zirconium Oxide	5%	25g
Sodium Oxide	40%	220g
Cullet	14%	70g
Cobalt	4%	10g
cooun	100%	500g
Chromium	2%	-
Chronnum		10g
<b></b>	100%	500g
Table 3		
Composition A2		
Oxides	Percentage Composition	Weight in Gramme
Silica sand	15%	75g
Feldspar	10%	70g
Calcium Oxide	8%	40g
Zirconium Oxide	5%	25g
Sodium Oxide	44%	220g
Cullet	14%	70g
Manganese oxide		10g
Wanganese Oxide	100%	500g
Table 4	100%	300g
Table 4		
Composition B2		
Oxides	Percentage Composition	Weight in Gramme
Silica sand	20%	100g
Feldspar	9%	70g
Calcium Oxide	8%	40g
Zirconium Oxide	5%	25g
Sodium Oxide	40%	220g
Cullet	14%	70g
Copper oxide	4%	10g
11	100%	500g
Table 5	100,0	5 ° ° 8
Composition A3		
Oxides	Percentage Composition	Weight in Gramme
Silica sand	15%	
		75g
Feldspar	10%	70g
Calcium Oxide	8%	40g
Zirconium Oxide		25g
Sodium Oxide	44%	220g
Cullet	14%	70g
Cobalt Oxide	4%	10g
	100%	500g
Table 6		
<b>Composition B3</b>		
Oxides	Percentage Composition	Weight in Gramme
Silica sand	20%	100g
Feldspar	9%	70g
Calcium Oxide	8%	40g
Zirconium Oxide		40g 25g
Sodium Oxide	40%	23g 220g
Cullet	14%	70g
Cobalt	4%	10g
	100%	500g

Table 7		
Composition A4 Oxides	Percentage Composition	Waight in Gramma
Silica sand	15%	Weight in Gramme
		75g
Feldspar	10%	70g
Calcium Oxide	8%	40g
Zirconium Oxide		25g
Sodium Oxide	44%	220g
Cullet	14%	70g
Cobalt	4%	10g
	100%	500g
Table 8		
<b>Composition B4</b>		
Oxides	Percentage Composition	Weight in Gramme
Silica sand	20%	100g
Feldspar	9%	70g
Calcium Oxide	8%	40g
Zirconium Oxide	5%	25g
Sodium Oxide	40%	220g
Cullet	14%	70g
Cobalt	4%	10g
coount	100%	500g
Table 9		
Table 9 Composition A5		
<b>Composition A5</b>		Weight in Gramme
<b>Composition A5</b> Oxides	Percentage Composition	Weight in Gramme
<b>Composition A5</b> Oxides Silica sand	Percentage Composition 15%	75g
<b>Composition A5</b> Oxides Silica sand Feldspar	Percentage Composition 15% 10%	75g 70g
<b>Composition A5</b> Oxides Silica sand Feldspar Calcium Oxide	Percentage Composition 15% 10% 8%	75g 70g 40g
Composition A5 Oxides Silica sand Feldspar Calcium Oxide Zirconium Oxide	Percentage Composition 15% 10% 8% 5%	75g 70g 40g 25g
Composition A5 Oxides Silica sand Feldspar Calcium Oxide Zirconium Oxide Sodium Oxide	Percentage Composition 15% 10% 8% 5% 44%	75g 70g 40g 25g 220g
Composition A5 Oxides Silica sand Feldspar Calcium Oxide Zirconium Oxide Sodium Oxide Cullet	Percentage Composition 15% 10% 8% 5% 44% 14%	75g 70g 40g 25g 220g 70g
Composition A5 Oxides Silica sand Feldspar Calcium Oxide Zirconium Oxide Sodium Oxide	Percentage Composition 15% 10% 8% 5% 44% 14% 4%	75g 70g 40g 25g 220g 70g 10g
Composition A5 Oxides Silica sand Feldspar Calcium Oxide Zirconium Oxide Sodium Oxide Cullet Cobalt	Percentage Composition 15% 10% 8% 5% 44% 14%	75g 70g 40g 25g 220g 70g
Composition A5 Oxides Silica sand Feldspar Calcium Oxide Zirconium Oxide Sodium Oxide Cullet Cobalt Table 10	Percentage Composition 15% 10% 8% 5% 44% 14% 4%	75g 70g 40g 25g 220g 70g 10g
Composition A5 Oxides Silica sand Feldspar Calcium Oxide Zirconium Oxide Sodium Oxide Cullet Cobalt Table 10 Composition B5	Percentage Composition 15% 10% 8% 5% 44% 14% 4% 100%	75g 70g 40g 25g 220g 70g 10g 500g
Composition A5 Oxides Silica sand Feldspar Calcium Oxide Zirconium Oxide Sodium Oxide Cullet Cobalt Table 10 Composition B5 Oxides	Percentage Composition 15% 10% 8% 5% 44% 14% 4% 100% Percentage Composition	75g 70g 40g 25g 220g 70g 10g 500g Weight in Gramme
Composition A5 Oxides Silica sand Feldspar Calcium Oxide Zirconium Oxide Sodium Oxide Cullet Cobalt Table 10 Composition B5 Oxides Silica sand	Percentage Composition 15% 10% 8% 5% 44% 14% 4% 100% Percentage Composition 20%	75g 70g 40g 25g 220g 70g 10g 500g Weight in Gramme 100g
Composition A5 Oxides Silica sand Feldspar Calcium Oxide Zirconium Oxide Sodium Oxide Cullet Cobalt Table 10 Composition B5 Oxides Silica sand Feldspar	Percentage Composition 15% 10% 8% 5% 44% 14% 4% 100% Percentage Composition 20% 9%	75g 70g 40g 25g 220g 70g 10g 500g Weight in Gramme 100g 70g
Composition A5 Oxides Silica sand Feldspar Calcium Oxide Zirconium Oxide Sodium Oxide Cullet Cobalt Table 10 Composition B5 Oxides Silica sand	Percentage Composition 15% 10% 8% 5% 44% 14% 4% 100% Percentage Composition 20%	75g 70g 40g 25g 220g 70g 10g 500g Weight in Gramme 100g
Composition A5 Oxides Silica sand Feldspar Calcium Oxide Zirconium Oxide Sodium Oxide Cullet Cobalt Table 10 Composition B5 Oxides Silica sand Feldspar	Percentage Composition 15% 10% 8% 5% 44% 14% 4% 100% Percentage Composition 20% 9% 8%	75g 70g 40g 25g 220g 70g 10g 500g Weight in Gramme 100g 70g 40g 25g
Composition A5 Oxides Silica sand Feldspar Calcium Oxide Zirconium Oxide Sodium Oxide Cullet Cobalt Table 10 Composition B5 Oxides Silica sand Feldspar Calcium Oxide	Percentage Composition 15% 10% 8% 5% 44% 14% 4% 100% Percentage Composition 20% 9% 8%	75g 70g 40g 25g 220g 70g 10g 500g Weight in Gramme 100g 70g 40g
Composition A5 Oxides Silica sand Feldspar Calcium Oxide Zirconium Oxide Sodium Oxide Cullet Cobalt Table 10 Composition B5 Oxides Silica sand Feldspar Calcium Oxide Zirconium Oxide	Percentage Composition 15% 10% 8% 5% 44% 14% 4% 100% Percentage Composition 20% 9% 8% 5%	75g 70g 40g 25g 220g 70g 10g 500g Weight in Gramme 100g 70g 40g 25g
Composition A5 Oxides Silica sand Feldspar Calcium Oxide Zirconium Oxide Sodium Oxide Cullet Cobalt Table 10 Composition B5 Oxides Silica sand Feldspar Calcium Oxide Zirconium Oxide Sodium Oxide	Percentage Composition 15% 10% 8% 5% 44% 14% 4% 100% Percentage Composition 20% 9% 8% 5% 40%	75g 70g 40g 25g 220g 70g 10g 500g Weight in Gramme 100g 70g 40g 25g 220g

100% 500g The various materials were ground, weighed in the various proportions and mix in various crucibles, theses were then fired to a temperture of  $1200^{\circ}$ C in a muffle kiln.



Plate 1: The crucibles were placed in the mufffle kiln for firing



Plate 2: the process of firing the samples



Plate 3: Fritting of the melt Results of frit

Figure A1, A2, A3, A4 and A5 represent composition A with different metallic oxides. The result showed that the composition required a melting temperature of  $1150^{\circ}$ C to melt than sample B.

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FIGURE A1: Iron oxide



FIGUREA3: Manganese oxide





FIGUREA2: Chromium Oxide



FIGURE A4: Copper Oxide FIGURE A5: Torques Cobalt Oxide Figure B1, B2, B3, B4 and B5 represent composition B with various metallic oxide. The compositions required a higher temperature to melt than composition A, the required melting temperature was 1250.



FIGURE B1: Iron Oxide



FIGURE B2: Iron Oxide

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FIGURE B3: Manganese oxide



FIGURE B4: Copper oxide



FIGURE B5: Copper oxide The various samples were later pulverized to obtain the various enamel stain.



Plate4: Pulveriser



### Plate 5: Pulverised frit Testing of the enamel stain

**Mixing agent:** The mixing agent allows the powder material to flow so that it can stick to the body of the ware. It also allows the powdery enamel to pass through the mesh used.

**Reheating**: To make the enamel permanent on the glass surface, there is need to reheat the enamel in the kiln to a certain temperature. This involved placing the decorated item in the kiln and reheating to a temperature of  $680^{\circ}$ C.





Plate6: The kiln and the test samples





## Plate7: The result of some of the test piece.

The various results gotten from the experiment was used to print on a glass and ceramic cup using a mesh of size 100.. A print out logo was designed on a com puter system and transferred to the mesh using the required transfer technique.

## DESIGN OF A LOGO TO PRINT ON A CUP USING THE ENAMEL

The various stages involved in the design of the logo on the cup are:-

Design of the logo on the computer: The logo was designed on the computer system and reduced to the size of 2cm by 2cm.

Expose of the design on the mesh: The design from the computer system was transferred to a fine mesh.



**Plate8:** The fine mesh **Printing on the cups**: The produced enamel was placed on the mesh and printed on the ceramic and cups.



### DISCUSSION

From samples A1, A2, A3, A4, A5, the result showed that the enamel required a lower temperature to melt than sample B. The reheating melting temperature of the enamel was 680°C compared to that of B1,B2, B3, B4 and B5 which was 790°C. The colours of composition A came out on the wares brighllaintly than that of composition B which is matt in colour. The sagging of the glass panel was as a result of the reheating temperature of sample B being too high in an attempt to fuse the enamel unto the glass surface.

### CONCLUSION

The use of silica from Igbokoda for the production of enamel was discovered to make the production of enamel cheaper in term of procurement of raw material and the fuel cost compared to some other methods of enamel production. It can be inferred from the experiment that the silica can be used for commercial production of enamel of a lower melting temperature with good resistance to acidic and basic attack.

### RECOMMENDATION

I hereby recommend the use of Igbokoda silica for the production of enamel stain in Nigeria.

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