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Revolutionizing applications: the impact of controlled surface chemistry on marble powder

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A large amount of marble powder is abundantly available as a byproduct and waste in the marble industry, and its reinforcement has been attempted in several applications through surface modification. This article examines the use of MP in the production of rubber, paper, foam stabilizers, asphalt, paint, textiles, and adhesives. This article aims to provide a foundation for the surface modification of MP to enhance its properties and broaden its range of applications. Data on modifiers such as organic acids, coupling agents, polymers, and surfactants have been gathered, along with comprehensive reaction details for various techniques, including wet modification, dry modification, *in situ* modification, ultrasonication, and sol-gel methods. A general overview of MP modification and its impact on composite properties is provided in this review paper, mainly focusing on the distinctive features of composites, contemporary field challenges, and the correlation between the properties and applications of MP.

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1. Introduction

Marble is a metamorphic rock that is primarily made of recrystallized calcite (CaCO_3) and additional minerals whose compositions might vary (Table 1). Marble is highly demanded in the construction business owing to its strength, adaptability, and aesthetic qualities. The largest centers for producing marble are in China, Italy, India, Turkey, Egypt, Iran, Brazil, and Sweden.⁵ A substantial amount of MP is produced while shaping, slicing, and polishing marble blocks. MP produced

during marble processing constitutes greater than 60% of the total marble extract.⁶ Pakistan produced 350 million tons of MP in 2022.⁷ Every year, 140 billion tons of marble is manufactured worldwide.⁸ MP from building sites pollutes the environment on a global scale. Discarded MP can endanger people's health and agricultural soil.⁹ MP increases alkalinity, reducing soil fertility and exerting harmful environmental effects.¹⁰

1.1 MP chemistry

MP is a finely ground powder obtained from marble. Its composition varies based on its origin and processing techniques. A comprehensive analysis of the standard composition of MP is outlined in Table 1. Generally, MP comprises approximately 80–95% calcium carbonate (CaCO_3), 2–5% silica (SiO_2), 0.5–2% aluminium oxide (Al_2O_3), 0.2–1% iron oxide (Fe_2O_3),

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Table 1 Chemical composition of MP

	CaO	SiO ₂	Al ₂ O ₃	Fe ₂ O ₃	MgO	SO ₃	K ₂ O	Na ₂ O	Ref.
Percentage (%)	64.7	23.9	5.4	3.6	3.5	2.9	2.4	1.3	1
	55.30	1.47	0.35	0.14	0.01	0.01	0.04	0.12	2
	40.22	5.04	0.05	0.16	13.22	—	0.03	0.01	3
	54.08	0.77	0.24	0.05	0.94	—	0.02	0.39	4

0.5–2% magnesium carbonate (MgCO₃), 0.5–2% dolomite (CaMg(CO₃)₂), and 1–3% additional minerals (such as quartz, feldspar, and mica). The precise composition of MP may differ based on the particular marble origin, processing techniques, and any supplementary treatments or additives.

Calcium carbonate (CC), a significant constituent of MP, has widespread application as a reinforcing agent in a wide variety of manufacturing sectors, including asphalt,¹¹ rubber,^{12,13} paper,¹⁴ foam stabilizer,¹⁵ textile,¹⁶ paint,¹⁷ cosmetic,¹⁸ and adhesive¹⁹ sectors. It serves as an optimal filler and reinforcement across several sectors owing to its low hardness, affordability, non-toxicity, and thermal and chemical stability.²⁰ CC is a biogenic mineral obtained from marble and a wide variety of natural ores, including calcite, limestone, chalk, and precipitated CC, as well as eggshells, pearls, rocks, and microbial shells.^{21,22} Rather than relying on chemically synthesized or

extracted CC, MP can be utilized with various morphologies, including spherical, cubic, rhombic, and polygonal shapes.²³

2. Modification

MP surface modification refers to an alteration of its surface properties, either chemically or physically.²⁴

2.1 Modification material

Various materials have been utilized for surface modification of MP, as reported in the literature (Table 2). Broad categories of materials include modifiers (the MP surface functionality enhancer) and additives (supporting modifiers).

2.1.1 Modifiers. MP modifier attaches to the MP surface through a range of modification processes. A modifier changes



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Table 2 Commonly used modifiers and additives for MP

Modifier	Additives	Ref.
Silane coupling agent	Ammonium zirconium	25
Stearic acid (SA)	Isopropyl tristearyltitanate (ITT)	26
	Citric acid (CA)	27
	Titanate and aluminate	28
Sodium stearate (SS)	Starch	29
Oleic acid (OA)	<i>n</i> -Hexane	30

the material's quality and often makes it react as a reinforcing agent. Different kinds of modifiers, such as silicone-based molecules, organic acids, and esters, have been reported for the surface modification of MP (Table 2).

2.1.1.2 Additives. MP additives refer to metal-based or organic moiety compounds that facilitate the reactivity of modifiers to the surface of MP. These additives introduce structural changes in the modifier that enter into the MP surface, hence accelerating the modification process and altering reaction kinetics. Different additives have been reported for MP modification (Table 2).

2.2 MP morphology: surface, interior, and pores

The surface, interior, and pores of MP are essential factors in determining their modification and sorption characteristics. Surface properties, such as area, roughness, and functional groups, influence adsorption and reaction kinetics.^{31,32} MP interior affects diffusion and sorption rates. Pores control the accessibility and capacity of sorption. Modifications (functionalization, coating, or doping) can enhance or reduce sorption capabilities. Understanding the interplay between surface, interior, and pores is essential for tailoring MP's properties for specific applications.³³

The section below presents an examination of the roles of the surface, interior, and pores of MP, together with their linkages to sorption and reactions.

The surface is the primary site for sorption and modification reactions. It influences wettability, dispersibility, and reactivity. The surface can be modified through functionalization, coating, or grafting.³⁴

The interior represents bulk properties and affects overall performance. An interior structure can influence diffusion and sorption rates. Interior modification protocols involve doping, impregnation, or solid-state reactions.³⁵

Pores relate to porosity and pore size distribution, impacting sorption capacity and rate. Depending on the application, pores can be modified to enhance or reduce sorption. Modification methods include pore expansion, contraction, or surface functionalization within pores.²⁴

2.3 Types of modifications

MP utilization as filler and reinforcement requires surface functionalization to change the properties of the composite material. Depending on the purpose for which it is used, various properties can be achieved, such as reinforcement (by

enhancing filler and matrix interactions)³⁵ and compatibility (by better dispersion with minimal oligomerization).³⁶ To improve the thermal stability of composite materials, enhanced adhesion and rheological properties are also influenced by surface modification.^{31,37,38} Surface modification is enhanced by employing various modifiers through a range of modification processes.

(1) Wet modification: it entails the use of liquid or solution for surface modification,³⁹ *e.g.* chemical,^{24,39} surfactant,⁴⁰ polymer,⁴¹ or sol-gel^{37,42} treatments.

(2) Dry modification: it modifies the material surface without using liquids or solutions,²⁷ *e.g.* mechanical,²⁴ thermal,⁴³ plasma,⁴⁴ radiation,⁴⁵ and mechanochemical⁴⁶ treatments.

(3) Ultrasonication treatment refers to the use of high-frequency sound waves and ultrasonic waves, usually ranging from 20 kHz to 40 kHz, to modify the surface properties of materials. It enhances modifier dispersion by applying sound waves.^{47,48}

(4) *In situ* modification means changing the surface characteristics of MP while it is being applied, rather than doing it in a separate processing step. It enhances surface functionalities during chemical reactions.⁴⁹ *In situ* modification techniques for MP include *in situ* polymerization,⁵⁰ *in situ* coating (depositing thin films or coatings directly onto MP),⁵¹ *in situ* functionalization (introducing functional groups on MP surface),⁵² and *in situ* dispersion⁵³ (Table 3 and Fig. 1).

Although several investigations have been reported regarding the reuse of MP for various applications, no specific report has been found that investigated the purity of MP before modification. MP throughout the world contains the same chemistry/composition. All the studies performed on MP have particularly focused on modification rather than purity. However, researchers have reported the purification of artificial MP (AMP) through thermos-chemical treatment under pressure. Purification was done using methanol at different temperature and pressure ranges.⁵⁹ The literature has reported surface modification of MP waste for air quality improvement,⁶⁰ polymeric composites,⁶¹ the mechanical strength of artificial stoneware,^{55,62} and super-hydrophobic coating,⁶³ but none of these studies considered the impact of impurities on MP modification. A range of modifiers have been investigated for the surface modification of MP waste with TiO_2 ,⁶⁰ organic acids,⁶¹ and ethoxy silane,⁶³ but any effect of impurity on MP modification has not been reported.⁶¹ Researchers have also reported typical sample preparation techniques, such as physical sieve and calcination (thermal process), to remove impurities.⁶⁴ This might be attributed to the fact that inherent impurities in MP have a chemical nature similar to that of CC; therefore, no specific studies have been conducted to evaluate their impact on the modification protocols being applied to MP.

2.3.1 Wet modification. Wet modification involves a solid-liquid interaction between the modifier and particle, followed by stirring and dispersal at a predetermined temperature to produce the changed particles. Because the modifier and particle are in constant, close contact during wet modification, they have received more attention than dry modification. Silicone-based coupling agents, natural organic acids, organic

Table 3 Survey of application-based modification of MP

Application	Modification		Ref.
	Method	Reagent	
Paper industry	Wet modification	Carboxymethyl cellulose (CMC)/poly aluminum chloride	35
Rubber industry		Sodium oleate (SO)	54
Construction industry		Glycidoxypopy trimethoxysilane (GPTMS)	55
Microwavable packaging	Dry modification	SA	56
Reinforcement		SO	57
Protective textile/hydrophobic material	<i>In situ</i> modification	SA	49 and 58
Paint industry	Ultrasonication	Triethoxy vinyl silane (TEVS)	47



Fig. 1 Types of MP surface modification.

and inorganic modifiers, and others were used to boost surface functionalities.

2.3.1.1 Silicone-based coupling agents. Silylether has been used as a modifier most frequently because it broadens the application range of filler particles. CC's surface modification has been reported with aminopropyl trimethoxysilane (APTS) to improve hydrophobicity.⁶⁵ To improve APTS adhesion to the particles, CC particles were modified to increase the surface hydroxyl content; after that, these hydroxyl functionalities were used to attach multiple modifier molecules to the CC (Fig. 2). Contact angles were 99 and 110° when CC-APTS and CC-OH-APTS were compared, with CC-OH-APTS having the highest tensile strength (49.6 MPa). APTS modification has also been reported to improve the mechanical properties of CC.⁶⁶ Modified CC demonstrated a maximum tensile strength of 497.28 ± 24.86 MPa and a maximum flexural strength of 19.91 ± 0.59 MPa at 3% loading. Wondur and coworkers⁶⁷ used APTS as a coupling agent for CC surface modification. Thermal treatment of CC with silylether as a coupling agent produced 10 μm sized modified particles with a 58° contact angle. Modified particles alone disintegrated at 460 °C but upon mixing with the matrix demonstrated excellent thermal stability along with adhesion and dispersion.

MP modification with GPTMS has been reported⁵⁵ for increased strength of artificial stoneware, with 2–5 μm particle size and 34.4 MPa flexural strength. The SA-supported GPTMS

modification of CC has been reported⁶² for the improved mechanical strength of polyurethane (PU) composites. GPTMS modification reduces CC hydrophobicity, while SA modification augments it. With modified CC, an augmentation in PU composite elongation at break (196.4%) and tensile modulus (0.16 MPa) was reported. According to another study,⁶⁸ GPTMS modification produced 45 nm-sized particles with enhanced surface functionalities and particle–matrix interaction. With 3 and 5 wt% of modified CC, the compression modulus, flexural, and tensile strength rose by 30/36/14% and 65/31/26%, respectively. Additives have also been reported with GPTMS to advance the modification process and properties of materials. Evidence suggests that adding ammonium zirconium to GPTMS-modified CC used as a paper filler improves both the strength and retention of the paper.²⁵ Treating CC with 4% starch and 1% ammonium zirconium enhanced burst and tensile strength to 4.58 kPa m² g^{−1} and 74.9 N m g^{−1}, respectively.

A further investigation⁶⁹ detailed the modification of CC using methyltrimethoxysilane (MTMS) to improve foam stability, which was demonstrated by 15 wt% emulsions of MTMS-CC. This method produced particles of 78.40 nm size and increased the contact angle from 18° to 89.6°.

2.3.1.2 Natural organic acid. Numerous studies have documented the utilization of organic acids as modifiers for MP, aimed at altering their surface chemistry and expanding their range of applications. A brief description is presented in Table 4.

Given its significant commercial relevance, SA finds application across various industries, prompting researchers to investigate it for CC surface modification. SA-modified CC has been reported⁷⁰ for 70 nm-sized particles with improved mechanical strength and a water contact angle of 140°. Composite with 30% modified CC showed 19.21 MPa tensile strength, while adding more filler lowered the composite's mechanical characteristics. However, below the threshold, the incorporation of filler significantly improved the mechanical properties of the composite. Above the threshold concentration of CC, modification induced particle aggregation instead of improving the mechanical performance of the composites. Similarly, SA for better mechanical and thermal properties of polyvinyl chloride (PVC) composites has been reported,⁸¹ with two-phase compatibility. Thermal treatment (105 °C) of CC particles with the SA addition resulted in 65–135 nm-sized



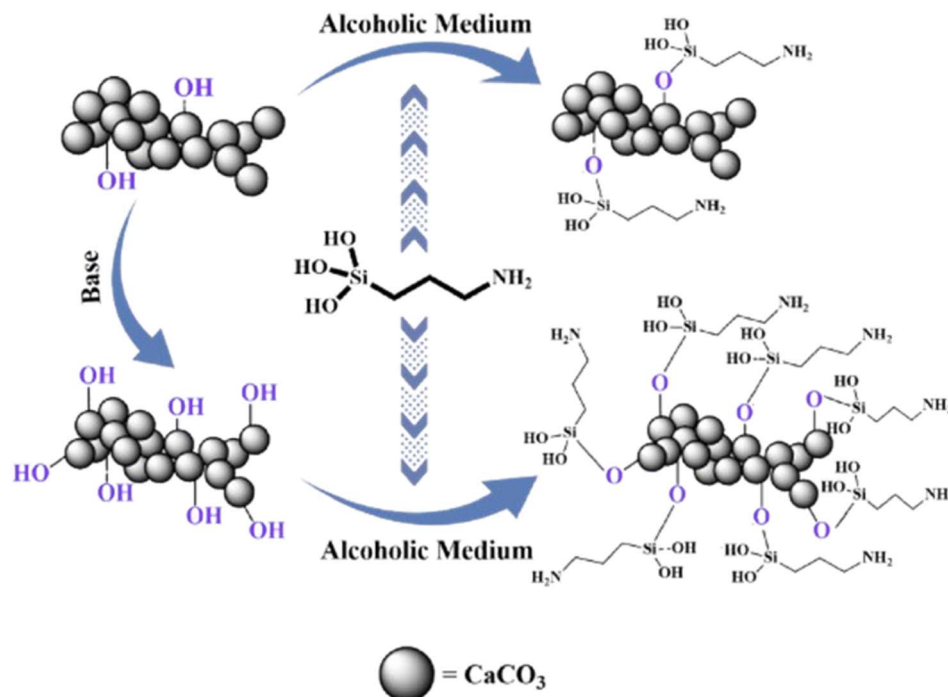


Fig. 2 Surface modification of CC with ATPS.

Table 4 List of organic acids used for surface modification

Natural organic acid	Application	Ref.
CA	Oil absorption	27
SA	Microwavable packaging	56
	Reinforcement	70–72
	Corrosion inhibitor	33
Myristic acid (MA)	Reinforcement	73
OA	Stabilizer	74
Palmitic acid (PA)	Microwaveable packaging	75
Lauric acid (LA)	Hydrophobic	76
Tannic acid (TA)	Biomedical	77
Acrylic acid (AA)	Composites	78
Polylactic acid (PLA)	Composites	79
Amino hexanoic acid (AHA)	Reinforcement	80
Glutamic acid (GA)	Reinforcement	80
Antacid	Biomedical	77

modified particles. Modified CC at 3.75 wt% exhibited a tensile strength of 577 kg m^{-2} , whereas an increase in the modified CC percentage resulted in a decrease in the mechanical properties of the composite. The highest values for thermal stability, mechanical strength, and minimal elongation have been observed at 3.75% CC. SA modification has also been reported to affect CC interfacial structure and dispersion in thermoplastic composites.⁷² In dry treatment, 1.5 wt% SA and 98.5 wt% CC were mixed, while in wet treatment, SA was dissolved in NaOH at 75 °C, and CC was dispersed in distilled water; both solutions were mixed for 15 min at 75 °C. In the complex treatment, NaOH, SA, and CC were dissolved in water. The prepared particles were combined with high-density polypropylene (PP) to coat CC with a modifier. The maximum tensile

strength for modified CC has been reported to be 33.81 MPa, while neat, dry, and complex treatment particles had 29.82 MPa, 28.52 MPa, and 30 MPa, respectively. Complex method particles were densely packed with a matrix. Complex and wet-treated CC composites have far better mechanical properties than plain and dry composites. The complex approach reduced void coalescence, which improved previous methods. SA modification of CC for enhanced hydrophobicity has been reported.³³ The average diameters of the modified and unmodified particles were 4.09 μm and 8.30 μm , respectively, indicating the size reduction of the modified particles. The contact angles were 110° and 124° for modified and unmodified particles, respectively, indicating higher hydrophobicity and corrosion resistance. Modified particles resist pressure and heat well. Wet modification of SA-treated CC⁷¹ led to a reduction in particle size (0.08 μm), as well as a decrease in particle–particle and polymer–particle interactions, thereby enhancing particle dispersion within the polymer matrix.

There have been reports of using additives with acids to enhance the modification process, resulting in CC being an exceptional reinforcement agent. CC's surface modification, through adsorption, has been reported⁷³ with chloroform and 2-propanol solutions of SA, MA, OA, PA, and LA. This modification enhanced CC's suitability for industrial applications, such as rubber, paint, and plastic. Modified CC's interaction with various fatty acids has been optimized, considering variables, such as reaction speed, modifier concentration, temperature, solvent solubility, hydrophobic characteristics, and dispersibility. SA had the highest activation degree and dispersion ratio of all the fatty acids, at almost 95% and 67%, respectively. Another group presented enhanced matrix–filler compatibility²⁶



2.3.1.3 *Polybutylene adipate co-terephthalate (PBAT)*. Researchers have also worked on PBAT as a modifier to enhance the photocatalytic and mechanical responses of materials. Yang *et al.*⁹¹ utilized PBAT to improve the hydrolytic and photo-oxidative degradation of CC. This modification enhanced filler matrix interaction, resulting in improved CC shading, which subsequently postponed film deterioration, whereas the neat film exhibited faster degradation. A 2 wt% silane-coated CC film exhibited a maximum tensile strength of 210.51 MPa; however, its mechanical properties diminished when exposed to a water spray. Zhang *et al.*⁹² demonstrated that PBAT anchored to the CC surface enhanced the mechanical properties of the film while reducing its thermoplastic values. Tensile strength and break at elongation decreased with particle content but increased with particle size. Optimized conditions were 30% particle content, 5 μm particle size, and 2% silane modifier.

2.3.2 Dry modification. Dry modification involves the mechanical blending of modifiers with dry particles at predetermined temperatures to produce modified particles. Dry modification is an alternative to conventional ball milling due to some drawbacks associated with conventional methods. These drawbacks include low stirring, uneven mixing, and inadequate dispersion of materials and modified agents.

CC modification with AHA has been reported to enhance thermomechanical characteristics. SA, GA, caprolactam, and L-arginine have been compared against AHA⁸⁰ for CC activation through thermal treatment regarding the impact on its mechanical properties. Coated CC had superior tensile strength (66 MPa) and excellent elongation (610%), at just 2.5 mmol dose of 6-AHA/100 square feet CC. Additionally, CC dry modification through 6-AHA has been reported⁴³ for the mechanical and thermal properties of polyamide 12. The average particle size of CC was 9 μm with an irregular shape. Researchers reported an increase of 510% in elongation at the break, with 2–3 mmol AHA for 100 m^2 CC.

Another modifier, SA, has also been used commonly for CC. SA-based surface medication of CC through tumbling ball milling has been reported,⁹³ resulting in an 18 μm particle size with a 34% oil absorption ratio. Additives have also been reported with SA to enhance the surface chemistry of CC. Anhydrous CA has been documented²⁷ as an additive for SA-based CC modification, with modified CC exhibiting thermal decomposition at 350 $^{\circ}\text{C}$. The oil absorption values for the unmodified and modified particles were 33.9 ml/100 g and 19 ml/100 g, respectively. Oil absorption value decreased due to the presence of SA on the surface of CC.

Another modifier reported is SO, which is used to improve the hydrophobic character of CC.⁵⁷ This work was performed on calcite through ball milling. The average particle size of the CC was 7.32 μm . The contact angles for the unmodified and

into it. The average size of modified particles increased from 80 to 90 nm, with square crystal morphology, and 152° contact angle. Improved particle dispersion in the polymeric matrix was a result of sonication-based modification, which also reduced processing time and increased yield.

3. Comparison of MP modification methods

The surface modification process is a crucial step in tailoring material properties to meet a wide range of application requirements. Several techniques are used to modify surface characteristics, including wet and dry treatments, chemical grafting, and *in situ* modification. Wet modification involves the utilization of liquid or solution-based treatments that are both simple to execute and cost-effective. Dry modification necessitates the deposition of gas or vapor onto a surface that is suitable for high-temperature procedures. It is important to note that the deposition rate in dry treatment is generally slower than that in wet treatment and is limited to the modification of thin layers. Wet modification treatment can be preferred over dry modification for the following reasons: wet modification provides stronger mechanical properties to materials than dry modification by increasing the adsorption density of the modifier, which in turn enhances filler-matrix interaction, increasing mechanical properties. Another benefit of wet modification over dry modification is that wet modification provides less void content due to the good dispersion of particles, which makes the dense and closed internal structure of the composite and enhances adhesion impact.^{72,96} Dry modification provides numerous advantages in contrast to wet modification, especially when it comes to material processing. First, it significantly decreases the requirement for large amounts of water, which not only benefits the environment but also proves to be cost-effective by reducing expenses associated with water treatment and disposal. Additionally, it improves process efficiency by decreasing drying time and energy usage.⁷² The phenomenon of chemical grafting refers to the movement of atoms or molecules across a material surface, leading to changes in its composition. However, the treatment process mentioned above requires specialized equipment and expertise, and managing the diffusion profile may present a challenging task. The *in situ* surface modification process involves the alteration of surface properties during the synthesis or processing phases of a material. This approach allows for greater control over the final material properties and facilitates the surface modification of bulk materials. This specific treatment requires complex and specialized processing techniques, which in turn require a substantial investment of time. Numerous surface modification techniques, including wet, dry, chemical grafting, and *in situ* modifications, offer a diverse array of options for tailoring material surfaces to meet specific requirements. The choice of a suitable technique depends on the desired modifications, substrate properties, and intended application. The data for the modification methods, modifiers, properties, and their applications are summarized in Table 5.

2.3.5 Ultrasonication. Ultrasonication modifies the physical and chemical properties of the materials using high-frequency sound vibrations. Ultrasound-assisted surface modification of CC has been reported for the paint industry⁴⁷ through precipitation using TEVS as a coupling agent. Ultrasound cavitation was used for better mixing and dispersion, where the ultrasonic probe was immersed in CC/acetone solution to produce sonic waves; then, TEVS was added dropwise



Table 5 Surface modification of CC

Method	Modifier	Matrix	Reaction condition	Particle size (µm)	Tensile strength (MPa)	Contact angle	Application	Ref.
Wet modification	APTS	Epoxy resin	95% ethanol, 10 m ultrasonication, 8 h reflux (80 °C), pH 4–5	N/R	497.28 ± 24.86	N/R	Industrial	66
		PVC	2 h stirring, 1.5% mass ratio of CC: APTS, 125 °C drying (8 h)	N/R	49.60	110.0°	Reinforcement	65
		PLA	Ethanol, 80 °C (6 h)	10	N/R	58.0°	Water soluble PU composite	67
	SLS	Epoxy resin	Soaked in 15 wt% SLS, 50 °C	2–10	N/R	N/R	Corrosion inhibitor	89
		PP	Coupling agent (1 wt% of CC), 2000 rpm/5 m	2.98 2.73	15.80 ± 0.60 23.40 ± 1.00	155 ± 5.0° 136 ± 3.0°	Reinforcement	26
	ITT			2.68	34.70 ± 0.70			
	TA	N/R	CaCl ₂ /TA, Na ₂ CO ₃ , 5 m stirring, 1200 rpm	3–6	N/R	N/R	Biomedical	77
	SS	N/R	SS, 80 °C, 1 h stirring	2.39	N/R	118.9°	Hydrophobic materials	84
	SA	PVC	CC preheating 105 °C; SA	0.06–0.14	56.58	N/R	PVC composite reinforcement	81
		Polycaprolactone PP	N/R	0.07	19.21	140.0°	Reinforcement	70
		High-density PE	1.5 h stirring, 5 h (100 °C)	0.08	N/R	N/R		71
		Epoxy resin	SA, NaOH, 75 °C	N/R	33.81	78.8°		72
		Poly lactide	N/R	0.90	54.00	N/R		97
		Isotactic PP	SA in ethanol by ultrasonication (10 m), 300 rpm for 6 h	5.00	N/R	110.0°	Corrosion inhibitor	33
	PAC & CMC	N/R	CC preheated at 60 °C. SA in aqueous NaOH	N/R	26.93	N/R	Microwavable packaging	56
			Stirred CC/water (15 m), water/CMC heated at 60 °C, mixed and then added 10% PAC, and dried 4 days in the oven	N/R	6.63 × 10 ^{−3}	N/R	Paper industry	35
	SAPE and SA	PP	SAPE sprayed on CC, ultrasonicated (10 m), then stirrer at 300 rpm for 2 h (80 °C)	0.12	37.50 ± 2	N/R	Polymer composite reinforcement	41
	Silane coupling agent	PBAT	CC/modifier stirrer at high speed for 3–5 m (100 °C)	5.00	21.00 ± 0.51	N/R	Biodegradable mulching film	91
			CC/modified mixed with high-speed mixer at 100 °C for 3–5 m	5.00–12.00	21.00	N/R		92
		Polyimide Epoxy resin	CC/95% ethanolic solution/modifier, stirrer for 12 h at 80 °C	0.02–0.03 0.04	N/R 11 150.00 ± 15	75.6° N/R	Reinforcement	98 68
	GPTMS	N/R	Methanol/distilled water/silane mixed, and then added MP	2.00–5.00	34.40	N/R	Construction industry	55
	MTMS	N/R	CC/aqueous solution containing silane stirrer 24 h	7.80 × 10 ^{−2}	N/R	89.6°	Emulsion and foam stabilizer	69
	SO	Organic		10.75	N/R	108.0°		54



Table 5 (Contd.)

Method	Modifier	Matrix	Reaction condition	Particle size (µm)	Tensile strength (MPa)	Contact angle	Application	Ref.
	Oleate Starch, SS, SHMP	N/R Polyacrylamide	CC/SO/water mixed constantly, filtered and dried				Rubber industry Paper industry	99 29 and 85
			N/R	0.01–2.50	N/R	N/R		
			15% starch/CC dispersed in cool water at 200 rpm for 10 m, heated at 95 °C/50 m, and added SS/SHMP for 30 m at 200 rpm	2.00	N/R	N/R		
			15% starch/CC added in water for 10 m at 200 rpm, heated at 95 °C/50 m, then added SS temp. decrease to 60 °C, SHMP for 30 m/200 rpm	N/R	N/R	115.7°		100
	Anionic fluorinated surfactant EG & PLL	N/R Polyester	CC/aqueous solution of surfactant stirrer for 25 m, heated at 25 °C for a day	7.80×10^{-2}	N/R	115.1°	Foam stabilizer Bone regeneration	88 90
			CC was added in DMFA and HMDI for 8 h at 50 °C, added EG at 60 °C/12; PLL dissolved in xylene (60 °C) and then CC was added for 24 h at 120 °C (under N ₂ protection)	20.00–30.00	27.40	64.6°		
			Lanthanum dissolved in water, then added in CC suspension at rt, followed by alkali solution, washed, and dried 70–80 °C	0.04	36.00 ± 1.00	N/R		
			CC/isopropyl alcohol stirrer for 10 m, added coupling agent at stirrer for 30 m, and oven dried at 100 °C for 24 h	3.50	0.16 ± 0.10	N/R		62
	Sodium dodecyl sulfonate	N/R	CC/sodium dodecyl sulfonate mixed at 220 rpm, heated for 4 h at 80 °C, filtered, washed and dried	2.70	N/R	N/R	Hydraulic oil additive	102
			CC preheated at 60 °C for 24 h, PA dispersed in NaOH, then added CC for 30 m, and dried for 24 h at 100 °C	N/R	28.38	N/R		
			Ethanol/water/NH ₃ mixed together, CC/silica then added to the above solution and stirred at 200 rpm for 24 h	0.05–0.09	3.60 ± 0.20	N/R		
			CC/methacrylate/poly-propylene mixed in twin-screw extruder CC/SO/grinding media mixed at 1000 rpm, and then filtered	3.00	40.09 ± 0.80	N/R		31
Sol gel	Silica	Acrylonitrile butadiene		7.32	N/R	$109.6 \pm 3.0^\circ$	Rubber industry	57
Dry modification	MAA	PP					Reinforcement	
	SO							

Table 5 (Contd.)

Method	Modifier	Matrix	Reaction condition	Particle size (μm)	Tensile strength (MPa)	Contact angle	Application	Ref.
Ultrasonication	SA	High density PE	CC/SA mixed through screw extruder (16 mm diameter)	N/R	28.52	75.3°		72
	TEVS	Polymer	CC dispersed in acetone under ultrasound, modifier dissolved in acetone, ultrasound probe added in CC suspension, and added modifier solution in it	0.05–0.08	N/R	152.0°	Paint industry	47
<i>In situ</i> modification	CS	N/R	CC/CS heated	3.40×10^{-2}	N/R	107.8°	Industrial application	95
	SA	Polyester	SA mixed with isopropyl alcohol, then added CC with stirring (10 m), washed with water, and dried	1.00	N/R	150.2°	Protective textile	49
		Polymer	SA dissolved in ethanol; CC mixed with the solution through a homogenizer at 20 000 rpm for 1 m	3.26	N/R	130.2 $\pm$ 1.2°	Hydrophobic material	58

Regardless of the modification process, the size of the modified CC particles ranges from nanometers to micrometers (Table 5). Evidence clearly demonstrates that the modification technique does not impact particle size. Instead, the modifier is responsible for individual particle sizes. The thickness of the modifier coating is an important factor that affects the size of the modified particle although not very promising.^{104,105} A mechanistic explanation is required to discuss the significant disparity in particle size after modification. This mechanistic explanation can be provided by examining the distinctions among particle, aggregate, and agglomerate sizes.¹⁰⁶ Particulate size represents the size of individual crystallites, while aggregates refer to several particles linked together by modifier crosslinking. Agglomerates, however, reflect the connection of aggregates through covalent bonding, physical contact, or adsorption.

4. Applications

A comparison of modification techniques based on the applications of the materials revealed certain facts. An increase in the tensile strength of a material typically results in more brittleness and less potential for deformation, while a decrease in tensile strength correlates with enhanced plasticity, more prone to deformation, and greater ductility.¹⁰⁷ A contact angle exceeding 90° suggests that the material surface exhibits hydrophilic characteristics, which is attributed to the presence of polar surface groups and higher surface energy.^{108,109} Conversely, a contact angle below 90° signifies a hydrophobic nature linked to non-polar surface groups and lower surface energy.^{63,110} The sizes of the particles significantly affect the material's surface area and the quantity of pores present on that surface. A smaller particle size suggests an increased surface area, whereas particles exhibiting a larger surface area demonstrate a reduced surface size.^{26,54} The surface modification of CC for industrial applications is illustrated in Fig. 3.

4.1 Plastic industry

CC is frequently used as a filler for plastics, such as PLA, PVC, PP, and PE, to create polymer-based composite materials. This practice may lower costs while simultaneously enhancing the strength and toughness of plastics and extending the range of applications. Piekarska *et al.*⁹⁷ produced PLA films containing CC modified with SA. The results showed that using 5 wt% of modified CC as filler increased the elongation at break and tensile toughness by about two times (Fig. 4). Composite films in food packaging and biomedical applications are gaining popularity because PLA is a biodegradable polymer.

Due to its many advantageous qualities, such as low cost, ease of production, high strength and toughness, and resistance to environmental stress cracking, PP is one of the three most commonly used plastics. The mechanical strength (about 65%) and hardness (about 5%) of a PP-based composite filled with SA-modified CC have recently been shown to be significantly improved by Buasri *et al.*¹¹¹ Additionally, it was found that adding less than 10 wt% of modified CC to both high- and low-



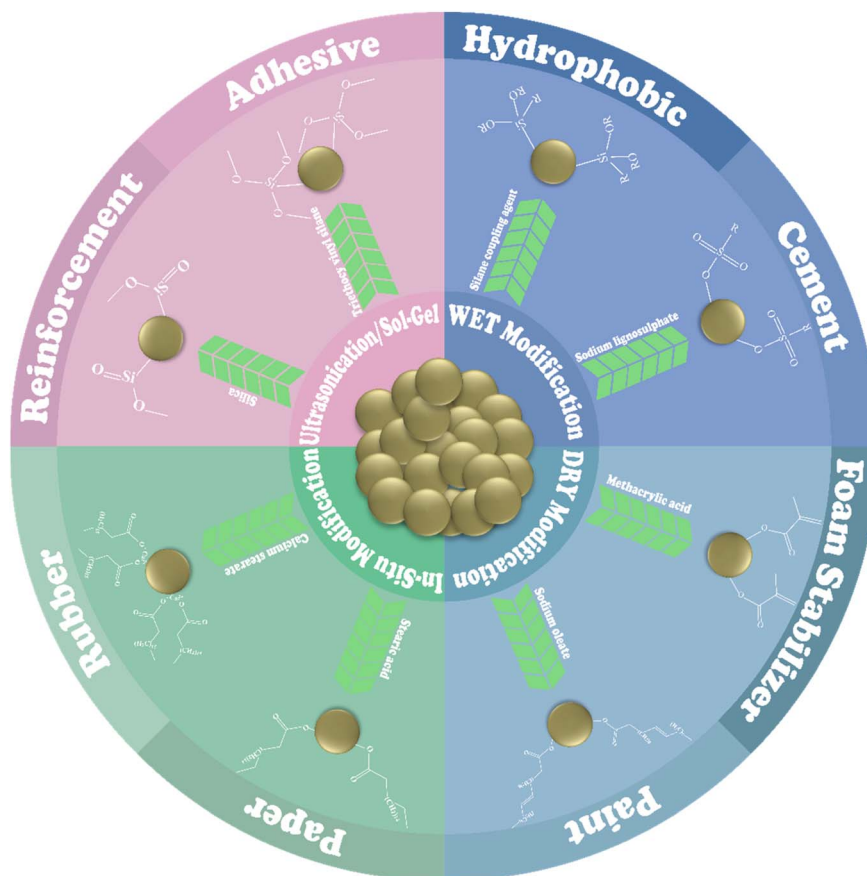


Fig. 3 Industrial application of modified CC.



Fig. 4 Tensile strength and strain at break at different wt% values for filler content, adopted from ref. 97 with license 5513130080154.

density PE when creating composite materials could significantly increase their tensile and impact strengths.^{112,113} The mechanical properties of PVC-based composites with CC as a filler improved similarly. The toughness of CC/PVC composite materials can be increased using ultrafine CC with excellent dispersibility as a filler because previous studies suggest that the debonding of particles and matrix can absorb stress.¹¹⁴ As modifier particle size decreases, the impact strength of composites containing CC increases.¹¹⁵ Elastic modulus, tensile yield strength, and elongation at break of CC/PVC composite

material were found to be best at 5 wt% CC. Due to the modified CC's high dispersion and ability to scatter UV light, PVC-based composites have improved their antiaging capabilities.¹¹⁶ Recently, there has been much interest in superhydrophobic materials due to their distinct characteristics and exceptional performance. This implies that a superhydrophobic-modified CC coating has a wide range of potential applications. With the aid of epoxy resins containing epoxidized fatty acid-modified CC,¹¹⁷ a superhydrophobic coating that makes steel waterproof and self-cleaning has been created. This coating has a sliding angle of 1.3° and a water contact angle of 160.5°.

4.2 Paper industry

In modern paper manufacturing, the filler's significance has grown over time. Because of its high surface area, porosity, and whiteness, among other advantages, CC is frequently used to replace fiber in the production of paper. Studies have been conducted on the modification of CC particles with oleate and cetrimonium bromide (CTAB) for use in wet-end papermaking. Because adding more fillers did not affect the paper's tensile strength, the cost was reduced. Additionally, apparent density, opacity, and mechanical properties are factors that the oleate modifier affects more strongly than CTAB.¹¹⁸ Fan *et al.* also conducted several studies on using CC-modified composites in the papermaking process.^{29,100} Initially, researchers investigated



the impact of starch/SS composite-modified CC on the strength attributes of paper. Particle size ranging from 35.2 to 54.0 μm was shown to be excellent for paper strength, and paper filled with modified CC outperformed unmodified CC in terms of tensile index, tear index, and burst index. Additional research on CC modified with starch, SS, and sodium hexametaphosphate revealed that adding CC modified at a lower temperature of 60 $^{\circ}\text{C}$, 1.5 wt% of sodium hexametaphosphate, and 4.0 wt% of SS significantly improved paper strength performance.^{29,100} In addition to its application as a colored coating on dry-formed paper, CC may also be used as a filler in papermaking processing. Consequently, the paper acquires preferable properties, such as specific weight, air permeability, surface smoothness, opacity, and ink absorption rate. An anionic surfactant (*i.e.*, SO) modified CC was shown to increase color dispersion and coating stability by Barhoum *et al.*⁹⁹ The results showed 23.0%, 1.3%, 2.8%, and 2.3% improvements in the paper's smoothness, brightness, whiteness, and opacity, respectively. The paper's air permeability decreased by 26.0% when covered with the modified CC-pigmented coating. The enhanced CC-colored coating can help improve the paper's resistance to water. Surface coating and impregnation with fatty acids can give super hydrophobic paper (Fig. 5), resulting in the production of inexpensive paper with a water contact angle greater than 150 $^{\circ}$.¹¹⁹

4.3 Rubber industry

Elastomers, such as butadiene rubber, silicone rubber, ethylene-propylene-diene mischpolymer, fluoro-rubber, and styrene-butadiene rubber, have advantageous properties for use in tires, gaskets, gloves, and assorted other items. Rubber can be reinforced and filled with CC and other inorganic fillers to increase volume, decrease costs, and improve processing performance without significantly affecting product efficacy. Jin *et al.*¹²⁰ discovered that adding CC to a composite material



Fig. 6 Elongation and strength at different wt% values for modified CC content, adopted from ref. 120 with license 5514630500751.

significantly improved its tensile strength (Fig. 6), ductility, and thermal stability. Additionally, the improved interfacial compatibility of the CC particles with the rubber matrix significantly positively impacted the thermal stability and mechanical qualities of the composite material, particularly when CC was modified before being incorporated into the matrix. For instance, silane coupling agents may be used to treat CC particles to increase their hydrophobicity, dispersibility, and ability to reduce viscosity.¹²¹

4.4 Environmental protection

There will always be new sources of pollution, but as society and humans face more severe problems over time, environmental protection becomes more and more critical for the planet's long-term progress. For example, waste marble from various processing techniques can have disastrous effects on people and the environment when working with marble resources. Lu *et al.*⁵⁵ enhanced the properties of waste marble-derived CC



Fig. 5 Superhydrophobic modification of paper, adopted from ref. 119 with license 5523500888812.



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