

## Documents

Abu Ubaidah, A.S.<sup>a</sup>, Mohamad Puad, N.I.<sup>a</sup>, Hamzah, F.<sup>b</sup>, Azmi, A.S.<sup>a</sup>, Ahmad Nor, Y.<sup>a</sup>

**Synthesis of bioplastics and the effects of additives on the mechanical, thermal and biodegradable properties**  
(2024) *Polymers from Renewable Resources*, .

DOI: 10.1177/20412479241292148

<sup>a</sup> Department of Chemical Engineering and Sustainability, Kulliyah of Engineering, International Islamic University Malaysia (IIUM), Kuala Lumpur, Malaysia

<sup>b</sup> Faculty of Chemical Engineering, Universiti Teknologi MARA (UiTM), Shah Alam, Malaysia

**Abstract**

The mounting global concern over the environmental consequences of petroleum-based plastics has prompted significant research into sustainable alternatives, with bioplastics emerging as a forerunning solution. This systematic review elucidates the multifaceted synthesis processes of bioplastics, which are derived from renewable sources such as plant starches, cellulose, and waste materials. The synthesis encompasses stages from raw material selection, pre-treatment, to the incorporation of various additives, with the aim to achieve specific properties in the resultant bioplastics. A substantial focus of this review lies in comprehensively understanding the role of additives, which serve as the pivotal agents in tailoring the mechanical and thermal characteristics of bioplastics. Additives, including cross-linking agents, plasticizers, fillers, compatibilizers, and reinforcement agents, are critically examined for their influence on attributes such as tensile strength, flexibility, thermal stability, and biodegradability. Factors such as intermolecular interactions, hydrogen bonding, and moisture content, play a determining role towards the resultant properties. The prospects for bioplastics are rapidly expanding, signalling a transformative shift in various applications ranging from eco-friendly packaging to advanced biomedical devices. This article serves as a comprehensive guide to both researchers and industry stakeholders, providing deep insights into the synthesis of bioplastics and the transformative role additives play in their functional properties. © The Author(s) 2024.

**Author Keywords**

additives; biodegradable plastic; Bioplastic; properties; systematic review; thermoplastics

**Index Keywords**

Crosslinking, Gasoline, Petroleum additives, Plasticizers, Reinforced plastics; Bio-plastics, Biodegradable plastics, Environmental consequences, Mechanical, Property, Raw material selection, Renewable sources, Synthesis process, Systematic Review, Thermal; Tensile strength

**References**

- Geyer, R.  
**Production, use, and fate of synthetic polymers**  
(2020) *Plastic Waste and Recycling*, pp. 13-32.  
Academic Press
- Kibria, M.G., Masuk, N.I., Safayet, R.  
**Plastic waste: challenges and opportunities to mitigate pollution and effective management**  
(2023) *Int J Environ Res*, 17, p. 20.
- Ng, C.H., Mistoh, M.A., Teo, S.H.  
**Plastic waste and microplastic issues in Southeast Asia**  
(2023) *Front Environ Sci*, 11, p. 1142071.
- Yaashikaa, P.R., Senthil Kumar, P., Saravanan, A.  
**A biotechnological roadmap for decarbonization systems combined into bioenergy production: prelude of environmental life-cycle assessment**  
(2023) *Chemosphere*, 329, p. 138670.
- Ismail, N.A., Mohd Tahir, S., Yahya, N.  
**Synthesis and characterization of biodegradable starch-based bioplastics**  
(2016) *Materials Science Forum*, 846, pp. 673-678.

- An, B., Wang, Y., Huang, Y.  
**Engineered living materials for sustainability**  
(2023) *Chem Rev*, 123, pp. 2349-2419.
- Tsang, Y.F., Kumar, V., Samadar, P.  
**Production of bioplastic through food waste valorization**  
(2019) *Environ Int*, 127, pp. 625-644.
- Rosenboom, J.G., Langer, R., Traverso, G.  
**Bioplastics for a circular economy**  
(2022) *Nat Rev Mater*, 7, pp. 117-137.
- Andrady, A.L., Neal, M.A.  
**Applications and societal benefits of plastics**  
(2009) *Philos Trans R Soc B Biol Sci*, 364, pp. 1977-1984.
- Millet, H., Vangheluwe, P., Block, C.  
**The nature of plastics and their societal usage**  
(2019) *Issues Environ Sci Technol*, 2019, pp. 1-20.
- Nasir, N.N., Othman, S.A.  
**The physical and mechanical properties of corn-based bioplastic films with different starch and glycerol content**  
(2021) *J Phys Sci*, 32, pp. 89-101.
- Oluwasina, O.O., Akinyele, B.P., Olusegun, S.J.  
**Evaluation of the effects of additives on the properties of starch-based bioplastic film**  
(2021) *SN Appl Sci*, 3, p. 421.
- Felix, M., Perez-Puyana, V., Romero, A.  
**Development of protein-based bioplastics modified with different additives**  
(2017) *J Appl Polym Sci*, 134, p. 45430.
- Asgher, M., Qamar, S.A., Bilal, M.  
**Bio-based active food packaging materials: sustainable alternative to conventional petrochemical-based packaging materials**  
(2020) *Food Res Int*, 137, p. 109625.
- Coppola, G., Gaudio, M.T., Lopresto, C.G.  
**Bioplastic from renewable biomass: a facile solution for a greener environment**  
(2021) *Earth Systems and Environment*, 5, pp. 231-251.
- Lim, C., Yusoff, S., Ng, C.G.  
**Bioplastic made from seaweed polysaccharides with green production methods**  
(2021) *J Environ Chem Eng*, 9, p. 105895.
- Schlemmer, D., Sales, M.J.A., Resck, I.S.  
**Preparation, characterization and degradation of PS/TPS blends using glycerol and buriti oil as plastiscizers**  
(2010) *Polim E Technol*, 20, pp. 6-13.
- Gabriel, A.A., Solikhah, A.F., Rahmawati, A.Y.  
**Tensile strength and elongation testing for starch-based bioplastics using melt intercalation method: a review**  
(2021) *J Phys: Conf Ser*, 1858, p. 012028.
- Sabbatini, B., Cambriani, A., Cespi, M.  
**An overview of natural polymers as reinforcing agents for 3D printing**  
(2021) *ChemEngineering*, 5, p. 78.

- Gandhi, D., Sethuraman, R.  
**Comparative evaluation of tensile strength, tear strength, color stability and hardness of conventional and 1% trisnorbornenylisobutyl polyhedralsilsesquioxane modified room temperature vulcanizing maxillofacial silicone after a six month artificial aging period**  
(2022) *J Indian Prosthodont Soc*, 22, pp. 328-337.
- Azeredo, H.M.C., Waldron, K.W.  
**Crosslinking in polysaccharide and protein films and coatings for food contact - a review**  
(2016) *Trends Food Sci Technol*, 52, pp. 109-122.
- Devi, L.S., Purkayastha, M.D., Mukherjee, A.  
**Biopolymer-based films and coatings: emerging technologies to extend shelf-life of fruits and vegetables**  
(2021) *Pray Rasayan*, 5, pp. 82-91.
- Mahcene, Z., Khelil, A., Hasni, S.  
**Development and characterization of sodium alginate based active edible films incorporated with essential oils of some medicinal plants**  
(2020) *Int J Biol Macromol*, 145, pp. 124-132.
- Reshmy, R., Philip, E., Vaisakh, P.H.  
**Development of an eco-friendly biodegradable plastic from jack fruit peel cellulose with different plasticizers and *Boswellia serrata* as filler**  
(2021) *Sci Total Environ*, 767, p. 144285.
- Tan, S.X., Andriyana, A., Ong, H.C.  
**A comprehensive review on the emerging roles of nanofillers and plasticizers towards sustainable starch-based bioplastic fabrication**  
(2022) *Polymers*, 14, p. 664.
- Valdés, A., Mellinas, A.C., Ramos, M.  
**Natural additives and agricultural wastes in biopolymer formulations for food packaging**  
(2014) *Front Chem*, 2, p. 6.
- Goswami, P., O'Haire, T.  
**Developments in the use of green (biodegradable), recycled and biopolymer materials in technical nonwovens**  
(2015) *Advances in Technical Nonwovens*, pp. 97-114.
- Tahri, N., Bahafid, W., Sayel, H.  
**Biodegradation: involved microorganisms and genetically engineered microorganisms**  
(2013) *Biodegradation - Life of Science*, Academic Press
- Varyan, I., Kolesnikova, N., Xu, H.  
**Biodegradability of polyolefin-based compositions: effect of natural rubber**  
(2022) *Polymers*, 14, p. 530.
- Moshood, T.D., Nawanir, G., Mahmud, F.  
**Sustainability of biodegradable plastics: new problem or solution to solve the global plastic pollution?**  
(2022) *Current Research in Green and Sustainable Chemistry*, 5, p. 100273.
- Page, M.J., McKenzie, J.E., Bossuyt, P.M.  
**The PRISMA 2020 statement: an updated guideline for reporting systematic reviews**  
(2021) *Syst Rev*, 10, pp. 1-11.

- Belur, J., Tompson, L., Thornton, A.  
**Interrater reliability in systematic review methodology: exploring variation in coder decision-making**  
(2021) *Sociol Methods Res*, 50, pp. 837-865.
- Jahan, N., Naveed, S., Zeshan, M.  
**How to conduct a systematic review: a narrative literature review**  
(2016) *Cureus*, 8, p. e864.
- accessed 29 December 2022
- **Biodegradable and compostable plastics - challenges and opportunities**  
*Resour Effic waste*,
- **Recent study reveals more than a third of global consumers are willing to pay more for sustainability as demand grows for environmentally-friendly alternatives**  
*Business Wire*,
- Atiwesh, G., Mikhael, A., Parrish, C.C.  
**Environmental impact of bioplastic use: a review**  
(2021) *Heliyon*, 7, p. e07918.
- Awadhiya, A., Kumar, D., Rathore, K.  
**Synthesis and characterization of agarose–bacterial cellulose biodegradable composites**  
(2017) *Polym Bull*, 74, pp. 2887-2903.
- Dyshlyuk, L., Babich, O., Belova, D.  
**Comparative analysis of physical and chemical properties of biodegradable edible films of various compositions**  
(2017) *J Food Process Eng*, 40, p. e12331.
- Yu, Z., Li, B., Chu, J.  
**Silica in situ enhanced PVA/chitosan biodegradable films for food packages**  
(2018) *Carbohydr Polym*, 184, pp. 214-220.
- Ramakrishnan, N., Sharma, S., Gupta, A.  
**Keratin based bioplastic film from chicken feathers and its characterization**  
(2018) *Int J Biol Macromol*, 111, pp. 352-358.
- Sinha, P., Mathur, S., Sharma, P.  
**Potential of pine needles for PLA-based composites**  
(2018) *Polym Compos*, 39, pp. 1339-1349.
- Neto, B.A.M., Fornari, C.C.M., Silva, E.G.P.  
**Biodegradable thermoplastic starch of peach palm (*Bactris gasipaes kunth*) fruit: production and characterisation**  
(2018) *Int J Food Prop*, 1, p. 12.
- Padil, V.V.T., Senan, C., Waclawek, S.  
**Bioplastic fibers from gum Arabic for greener food wrapping applications**  
(2019) *ACS Sustain Chem Eng*, 7, pp. 5900-5911.
- Marichelvam, M.K., Jawaid, M., Asim, M.  
**Corn and rice starch-based bio-plastics as alternative packaging materials**  
(2019) *Fibers*, 7, p. 32.
- Krishnamurthy, A., Amritkumar, P.  
**Synthesis and characterization of eco-friendly bioplastic from low-cost plant resources**  
(2019) *SN Appl Sci*, 1, p. 1432.

- Muralidharan, V., Arokianathan, M.S., Balaraman, M.  
**Tannery trimming waste based biodegradable bioplastic: facile synthesis and characterization of properties**  
(2020) *Polym Test*, 81, p. 106250.
- Yamada, M., Morimitsu, S., Hosono, E.  
**Preparation of bioplastic using soy protein**  
(2020) *Int J Biol Macromol*, 149, pp. 1077-1083.
- Azevedo, L.C., Rovani, S., Santos, J.J.  
**Biodegradable films derived from corn and potato starch and study of the effect of silicate extracted from sugarcane waste ash**  
(2020) *ACS Appl Polym Mater*, 2, pp. 2160-2169.
- Abdullah, A.H.D., Putri, O.D., Fikriyyah, A.K.  
**Harnessing the excellent mechanical, barrier and antimicrobial properties of zinc oxide (ZnO) to improve the performance of starch-based bioplastic**  
(2020) *Polym Technol Mater*, 59, pp. 1259-1267.
- Abdullah, A.H.D., Putri, O.D., Fikriyyah, A.K.  
**Effect of microcrystalline cellulose on characteristics of cassava starch-based bioplastic**  
(2020) *Polym Technol Mater*, 59, pp. 1250-1258.
- Tran, T.N., Mai, B.T., Setti, C.  
**Transparent bioplastic derived from CO<sub>2</sub>-based polymer functionalized with oregano waste extract toward active food packaging**  
(2020) *ACS Appl Mater Interfaces*, 12, pp. 46667-46677.
- Kusumastuti, Y., Putri, N.R.E., Timotius, D.  
**Effect of chitosan addition on the properties of low-density polyethylene blend as potential bioplastic**  
(2020) *Heliyon*, 6, p. e05280.
- Yaradoddi, J.S., Banapurmath, N.R., Ganachari, S.V.  
**Bio-based material from fruit waste of orange peel for industrial applications**  
(2021) *J Mater Res Technol*, 17, pp. 3186-3197.
- Singha, S., Mahmutovic, M., Zamalloa, C.  
**Novel bioplastic from single cell protein as a potential packaging material**  
(2021) *ACS Sustain Chem Eng*, 9, pp. 6337-6346.
- Dawam, A.A.H., Firdiana, B., Nissa, R.C.  
**Effect of  $\kappa$ -carrageenan on mechanical, thermal and biodegradable properties of starch-carboxymethyl cellulose (CMC) bioplastic**  
(2021) *Cellul Chem Technol*, 55, pp. 109-1117.
- Ungprasoot, P., Muanrukxa, P., Tanamool, V.  
**Valorization of aquatic weed and agricultural residues for innovative biopolymer production and their biodegradation**  
(2021) *Polymers (Basel)*, 13, p. 2838.
- Chen, Q., Chang, C., Zhang, L.  
**Surface engineering of cellulose film with myristic acid for high strength, self-cleaning and biodegradable packaging materials**  
(2021) *Carbohydr Polym*, 269, p. 118315.
- Lal, S., Kumar, V., Arora, S.  
**Eco-friendly synthesis of biodegradable and high strength ternary blend films of**

- PVA/starch/pectin: mechanical, thermal and biodegradation studies**  
(2021) *Polym Polym Compos*, 29, pp. 1505-1514.
- Nigam, S., Das, A.K., Patidar, M.K.  
**Synthesis, characterization and biodegradation of bioplastic films produced from Parthenium hysterophorus by incorporating a plasticizer (PEG600)**  
(2021) *Environ Challenges*, 5, p. 100280.
  - Furutate, S., Kamoi, J., Nomura, C.T.  
**Superior thermal stability and fast crystallization behavior of a novel, biodegradable  $\alpha$ -methylated bacterial polyester**  
(2021) *NPG Asia Mater*, 13, p. 31.
  - Piemonte, V.  
**Bioplastic wastes: the best final disposition for energy saving**  
(2011) *J Polym Environ*, 19, pp. 988-994.
  - Chen, J., Wang, Y., Liu, J.  
**Preparation, characterization, physicochemical property and potential application of porous starch: a review**  
(2020) *Int J Biol Macromol*, 148, pp. 1169-1181.
  - Alonso-González, M., Ramos, M., Bengoechea, C.  
**Evaluation of composition on processability and water absorption of wheat gluten-based bioplastics**  
(2021) *J Polym Environ*, 29, pp. 1434-1443.
  - Udenni Gunathilake, T.M.S., Ching, Y.C., Ching, K.Y.  
**Biomedical and microbiological applications of bio-based porous materials: a review**  
(2017) *Polymers*, 9, p. 160.
  - Zhao, X., Cornish, K., Vodovotz, Y.  
**Narrowing the gap for bioplastic use in food packaging: an update**  
(2020) *Environmental science & technology*, 54, pp. 4712-4732.
  - Umiyati, R., Millati, R., Ariyanto, T.  
**Calophyllum inophyllum extract as a natural enhancer for improving physical properties of bioplastics and natural antimicrobial**  
(2020) *Biodiversitas*, 21, pp. 3294-3302.
  - Thiebaud, S., Aburto, J., Alric, I.  
**Properties of fatty-acid esters of starch and their blends with LDPE**  
(1997) *J Appl Polym Sci*, 65, pp. 705-721.
  - Shi, R., Zhang, Z., Liu, Q.  
**Characterization of citric acid/glycerol co-plasticized thermoplastic starch prepared by melt blending**  
(2007) *Carbohydr Polym*, 69, pp. 748-755.
  - Jiugao, Y., Ning, W., Xiaofei, M.  
**The effects of citric acid on the properties of thermoplastic starch plasticized by glycerol**  
(2005) *Starch/Staerke*, 57, pp. 494-504.
  - Yang, J., Ching, Y.C., Chuah, C.H.  
**Synthesis and characterization of starch/fiber-based bioplastic composites modified by citric acid-epoxidized palm oil oligomer with reactive blending**  
(2021) *Ind Crops Prod*, 170, p. 113797.

- Yan, L., Lu, G., Abdalkarim, S.Y.H.  
**Multiple noncovalent interactions tailored crystallization and performance reinforcement mechanisms of Biopolyester Composites with functional Cellulose Nanocrystals**  
(2024) *Int J Biol Macromol*, 255, p. 128264.
- Vieira, M.G.A., Da Silva, M.A., Dos Santos, L.O.  
**Natural-based plasticizers and biopolymer films: a review**  
(2011) *Eur Polym J*, 47, pp. 254-263.
- Tyagi, V., Bhattacharya, B.  
**Role of plasticizers in bioplastics**  
(2019) *MOJ Food Process Technol*,
- Shimazu, A.A., Mali, S., Grossmann, M.V.E.  
**Efeitos plastificante e antiplastificante do glicerol e do sorbitol em filmes biodegradáveis de amido de mandioca**  
(2007) *Semin Ciências Agrárias*, 28, pp. 79-88.
- Chantawee, K., Riyajan, S.A.  
**Effect of glycerol on the physical properties of carboxylated styrene-butadiene rubber/cassava starch blend films**  
(2019) *J Polym Environ*, 27, p. 1.
- Havstad, M.R.  
**Biodegradable plastics**  
(2020) *Plastic Waste and Recycling: Environmental Impact, Societal Issues, Prevention, and Solutions*, pp. 97-129.  
Academic Press
- Lee, Y., Thompson, D.H.  
**Stimuli-responsive liposomes for drug delivery**  
(2017) *Wiley Interdiscip Rev: Nanomed and Nanobi*, 9, p. e1450.
- Baiardo, M., Frisoni, G., Scandola, M.  
**Thermal and mechanical properties of plasticized poly(L-lactic acid)**  
(2003) *J Appl Polym Sci*, 90, pp. 1731-1738.
- Zhang, K., Nagarajan, V., Misra, M.  
**Supertoughened renewable PLA reactive multiphase blends system: phase morphology and performance**  
(2014) *ACS Appl Mater Interfaces*, 6, pp. 12436-12448.
- Taguet, A., Cassagnau, P., Lopez-Cuesta, J.M.  
**Structuration, selective dispersion and compatibilizing effect of (nano)fillers in polymer blends**  
(2014) *Prog Polym Sci*, 39, pp. 1526-1563.
- Wang, H., Dong, W., Li, Y.  
**Compatibilization of immiscible polymer blends using in situ formed janus nanomicelles by reactive blending**  
(2015) *ACS Macro Lett*, 4, pp. 1398-1403.
- Muthuraj, R., Misra, M., Mohanty, A.K.  
**Biodegradable compatibilized polymer blends for packaging applications: a literature review**  
(2018) *J Appl Polym Sci*, 135, p. 45726.
- Meenakshisundaram, V., Hung, J.H., Patra, T.K.  
**Designing sequence-specific copolymer compatibilizers using a molecular-**

**dynamics-simulation-based genetic algorithm**

(2017) *Macromolecules*, 50, pp. 1155-1166.

- Li, X., Tabil, L.G., Panigrahi, S.  
**Chemical treatments of natural fiber for use in natural fiber-reinforced composites: a review**  
(2007) *J Polym Environ*, 15, pp. 25-33.
- Folino, A., Karageorgiou, A., Calabrò, P.S.  
**Biodegradation of wasted bioplastics in natural and industrial environments: a review**  
(2020) *Sustainability*, 12, p. 6030.
- Nanda, S., Patra, B.R., Patel, R.  
**Innovations in applications and prospects of bioplastics and biopolymers: a review**  
(2022) *Environ Chem Lett*, 20, pp. 379-395.
- Lai, Y.H., Kuo, M.C., Huang, J.C.  
**On the PEEK composites reinforced by surface-modified nano-silica**  
(2007) *Mater Sci Eng A*, 458, pp. 158-169.
- Gutiérrez, T.J., Seligra, P.G., Jaramillo, C.M.  
**Effect of filler properties on the antioxidant response of thermoplastic starch composites**  
(2017) *Handbook of Composites from Renewable Materials*, pp. 337-370.  
Scrivener Publishing LLC
- Maryam, M., Senjawati, M.I., Akli, K.  
**Application of nano crystalline cellulose (NCC) from oil palm empty fruit bunch as reinforcement of bioplastic nanocomposite with polyvinyl alcohol (PVA) matrix**  
(2021) *Andalasian Int J Agric Nat Sci*, 2, pp. 38-49.
- Tyagi, U., Sarma, A.K.  
**Perspectives of biomass based lignin to value added chemicals in biorefineries: challenges, extraction strategies and applications**  
(2022) *Biofuels, Bioproducts and Biorefining*, 16, pp. 1869-1892.
- Gu, J., Cai, X., Chen, C.  
**Study on the impact of a biopolymer-fiber combination on soil reinforcement**  
(2022) *Adv Eng Technol Res*, 3, p. 65.
- Dziike, F., Linganiso, L.Z., Mpongwana, N.  
**Biomass conversion into recyclable strong materials**  
(2022) *S Afr J Sci*, 118, pp. 7-8.
- Söğüt, E., Seydim, A.C.  
**Characterization of cyclic olefin copolymer-coated chitosan bilayer films containing nanocellulose and grape seed extract**  
(2018) *Packag Technol Sci*, 31, pp. 499-508.  
Epub ahead of print 2018
- Söğüt, E., Seydim, A.C.  
**Development of chitosan and polycaprolactone based trilayer biocomposite films for food packaging applications**  
(2021) *Politek Derg*, 24, pp. 263-273.
- Díez-Pascual, A.M.  
**Effect of graphene oxide on the properties of poly(3-Hydroxybutyrate-co-3-Hydroxyhexanoate)**  
(2021) *Polymers (Basel)*, 13, p. 2233.



- Zandraa, O., Ngwabebhoh, F.A., Patwa, R.  
**Development of dual crosslinked mumio-based hydrogel dressing for wound healing application: physico-chemistry and antimicrobial activity**  
(2021) *Int J Pharm*, 607, p. 120952.
- Dintcheva, N.T., Infurna, G., Baiamonte, M.  
**Natural compounds as sustainable additives for biopolymers**  
(2020) *Polymers*, 12, p. 732.
- Gamero, S., Jiménez-Rosado, M., Romero, A.  
**Reinforcement of soy protein-based bioplastics through addition of lignocellulose and injection molding processing conditions**  
(2019) *J Polym Environ*, 27, pp. 1285-1293.
- Mathew, A.P., Oksman, K., Sain, M.  
**Mechanical properties of biodegradable composites from poly lactic acid (PLA) and microcrystalline cellulose (MCC)**  
(2005) *J Appl Polym Sci*, 97, pp. 2014-2025.
- Ferreira, A.R.V., Alves, V.D., Coelho, I.M.  
**Polysaccharide-based membranes in food packaging applications**  
(2016) *Membranes*, 6, p. 22.
- Somvanshi, K.S., Gope, P.C.  
**Effect of ultrasonication and fiber treatment on mechanical and thermal properties of polyvinyl alcohol/cellulose fiber nano-biocomposite film**  
(2021) *Polym Compos*, 42, pp. 5310-5322.
- Lopes, J., Malheiro, C., Prodana, M.  
**Locust bean milling-derived dust as a raw material for the development of biodegradable bioplastics with antioxidant activity**  
(2023) *J Sci Food Agric*, 103, pp. 1088-1096.
- Rhim, J.W., Kuzeci, S., Roy, S.  
**Effect of free volume on curcumin release from various polymer-based composite films analyzed using positron annihilation lifetime spectroscopy**  
(2021) *Materials*, 14, p. 5679.
- Yan, L., Abdalkarim, S.Y.H., Chen, X.  
**Nucleation and property enhancement mechanism of robust and high-barrier PLA/CNFene composites with multi-level reinforcement structure**  
(2024) *Compos Sci Technol*, 245, p. 110364.
- Santana, I., Félix, M., Guerrero, A.  
**Processing and characterization of bioplastics from the invasive seaweed *rugulopteryx okamurae***  
(2022) *Polymers (Basel)*, 14, p. 355.
- Jiménez-Rosado, M., Rubio-Valle, J.F., Perez-Puyana, V.  
**Comparison between pea and soy protein-based bioplastics obtained by injection molding**  
(2021) *J Appl Polym Sci*, 138, p. 50412.
- Alonso-González, M., Castro-Criado, D., Félix, M.  
**Evaluation of rice bran varieties and heat treatment for the development of protein/starch-based bioplastics via injection molding**  
(2023) *Int J Biol Macromol*, 253, p. 127503.
- Barletta, M., Puopolo, M.  
**Thermoforming of compostable PLA/PBS blends reinforced with highly hygroscopic**

**calcium carbonate**

(2020) *J Manuf Process*, 56, pp. 1185-1192.

- Wang, Y., Khan, M.A., Chen, K.  
**Electrospinning of natural biopolymers for innovative food applications: a review**  
(2023) *Food Bioprocess Technol*, 16, pp. 704-725.
- Yamagata, M., Nagakawa, Y., Irie, M.  
**Seawater-degradable, tough, and fully bio-derived nonwoven polyester fibres reinforced with mechanically defibrated cellulose nanofibres**  
(2022) *Environ Sci Nano*, 10, pp. 92-102.
- Serag, E., El-Aziz, A.M.A., El-Maghraby, A.  
**Electrospun non-wovens potential wound dressing material based on polyacrylonitrile/chicken feathers keratin nanofiber**  
(2022) *Sci Rep*, 12, p. 15460.
- Vaithanomsat, P., Kongsin, K., Trakunjae, C.  
**Biosynthesized poly(3-hydroxybutyrate) on coated pineapple leaf fiber papers for biodegradable packaging application**  
(2021) *Polymers (Basel)*, 13, p. 1733.
- Haque, A.N.M.A., Naebe, M.  
**Flexible water-resistant semi-transparent cotton gin trash/poly (vinyl alcohol) bioplastic for packaging application: effect of plasticisers on physicochemical properties**  
(2021) *J Clean Prod*, 303, p. 126983.
- Jeon, H., Son, J.H., Lee, J.  
**Preparation of a nanocellulose/nanochitin coating on a poly(lactic acid) film for improved hydrolysis resistance**  
(2024) *Int J Biol Macromol*, 254, p. 127790.
- Panariello, L., Coltelli, M.B., Hadrich, A.  
**Antimicrobial and gas barrier Crustaceans and fungal chitin-based coatings on biodegradable bioplastic films**  
(2022) *Polymers (Basel)*, 14, p. 5211.
- Jantanasakulwong, K., Homsaard, N., Phengchan, P.  
**Effect of dip coating polymer solutions on properties of thermoplastic cassava starch**  
(2019) *Polymers (Basel)*, 11, p. 1746.
- Phromsopha, T., Baimark, Y.  
**Study on phase compatibility and water resistance of thermoplastic starch foams coated with flexible poly(L-lactide)-b-polyethylene glycol-b-poly(L-lactide) bioplastics**  
(2021) *Mater Today Commun*, 26, p. 101844.
- Bozó, É., Ervasti, H., Halonen, N.  
**Bioplastics and carbon-based sustainable materials, components, and devices: toward green electronics**  
*ACS Appl Mater Interfaces*, 13, pp. 49301-49312.
- Diederichs, E., Picard, M., Chang, B.P.  
**Extrusion based 3d printing of sustainable biocomposites from biocarbon and poly(Trimethylene terephthalate)**  
(2021) *Molecules*, 26, p. 4164.
- Kim, Y., Park, G.  
**Biodegradation of 3D-printed biodegradable/non-biodegradable plastic blends**

(2022) *ACS Appl Polym Mater*, 4, pp. 5077-5090.

- Tey, J.Y., Yeo, W.H., King, Y.J.  
**3D printing of polylactic acid bioplastic–carbon fibres and twisted kevlar composites through coextrusion using fused deposition modeling**  
(2020) *J Renew Mater*, 8, pp. 1671-1680.
- Sanchez-Rexach, E., Smith, P.T., Gomez-Lopez, A.  
**3D-Printed bioplastics with shape-memory behavior based on native bovine serum albumin**  
(2021) *ACS Appl Mater Interfaces*, 13, pp. 19193-19199.
- Smith, P.T., Narupai, B., Tsui, J.H.  
**Additive manufacturing of bovine serum albumin-based hydrogels and bioplastics**  
(2020) *Biomacromolecules*, 21, pp. 484-492.
- Vaidya, A.A., Collet, C., Gaugler, M.  
**Integrating softwood biorefinery lignin into polyhydroxybutyrate composites and application in 3D printing**  
(2019) *Mater Today Commun*, 19, pp. 286-296.
- Yu, Z., Li, B., Chu, J.  
**Silica in situ enhanced PVA/chitosan biodegradable films for food packages**  
(2018) *Carbohydr Polym*, 184, pp. 214-220.
- Ji, H., Yassin, S., Chen, X.  
**Deep insights into biodegradability mechanism and growth cycle**  
(2024) *International J Biol Macromol*, 254, p. 127866.
- Fernández-d'Arlas, B.  
**Tough and functional cross-linked bioplastics from sheep wool keratin**  
(2019) *Sci Rep*, 9, p. 14810.
- Jin, S., Xiong, L., Yu, Y.  
**Structural design of a hyperbranched chitosan-based bioplastic with excellent strength, antibacterial, and UV shielding performance**  
(2023) *Chem Eng J*, 471, p. 144687.
- Heredia-Guerrero, J.A., Benítez, J.J., Porras-Vázquez, J.M.  
**Plasticized, greaseproof chitin bioplastics with high transparency and biodegradability**  
(2023) *Food Hydrocoll*, 145, p. 109072.
- Li, K., Jin, S., Jiang, S.  
**Bioinspired mineral–organic strategy for fabricating a high-strength, antibacterial, flame-retardant soy protein bioplastic via internal boron–nitrogen coordination**  
(2022) *Chem Eng J*, 428, p. 132616.
- Abdelwahab, M.A., Jacob, S., Misra, M.  
**Super-tough sustainable biobased composites from polylactide bioplastic and lignin for bio-elastomer application**  
(2021) *Polymer (Guildf)*, 212, p. 123153.
- Aldas, M., Ferri, J.M., Lopez-Martinez, J.  
**Effect of pine resin derivatives on the structural, thermal, and mechanical properties of Mater-Bi type bioplastic**  
(2020) *J Appl Polym Sci*, 137, p. 48236.
- Peydayesh, M., Bagnani, M., Mezzenga, R.  
**Sustainable bioplastics from amyloid fibril-biodegradable polymer blends**  
(2021) *ACS Sustain Chem Eng*, 9, pp. 11916-11926.

- Da Róz, A.L., Carvalho, A.J.F., Gandini, A.

**The effect of plasticizers on thermoplastic starch compositions obtained by melt processing**

(2006) *Carbohydr Polym*, 63, pp. 417-424.

**Correspondence Address**

Mohamad Puad N.I.; Department of Chemical Engineering and Sustainability, Malaysia; email: illi@iiu.edu.my

**Publisher:** SAGE Publications Ltd

**ISSN:** 20412479

**Language of Original Document:** English

**Abbreviated Source Title:** Polym. Renew. Resour.

2-s2.0-85206920123

**Document Type:** Review

**Publication Stage:** Article in Press

**Source:** Scopus

---

**ELSEVIER**

Copyright © 2024 Elsevier B.V. All rights reserved. Scopus® is a registered trademark of Elsevier B.V.

 **RELX Group™**