Computer Aided Design of Thermoplastic Profile Extrusion Forming Tools

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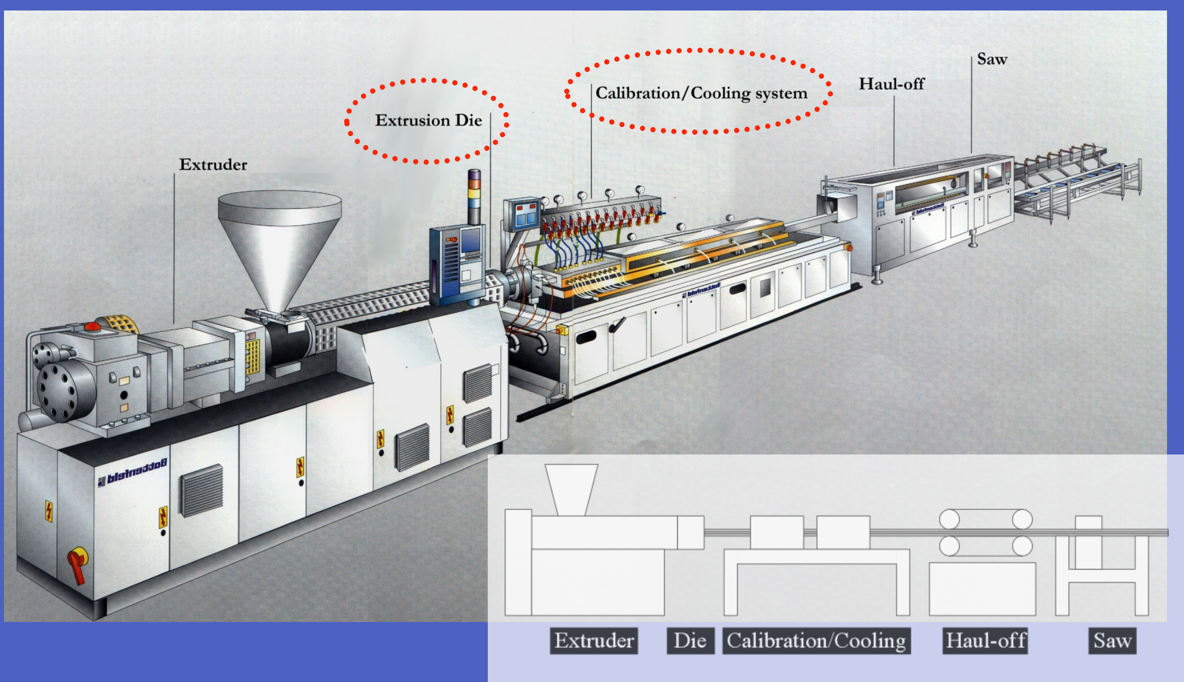
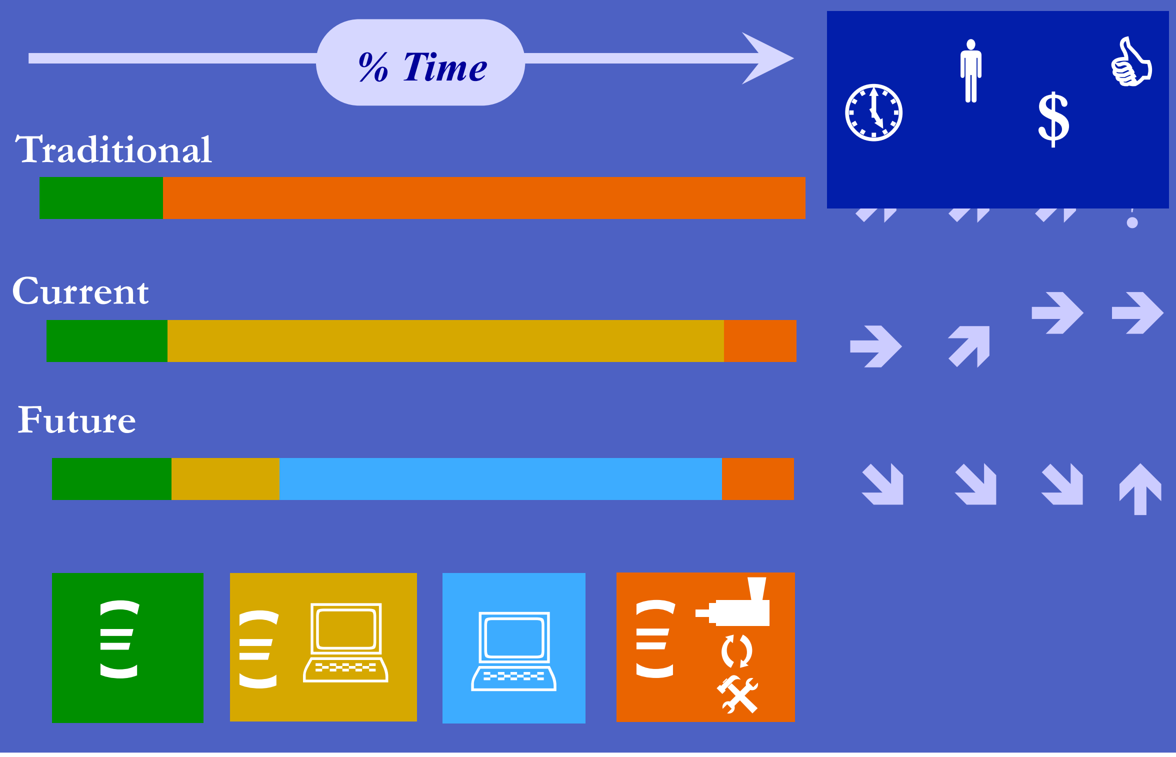
Introduction - *Profile Extrusion*



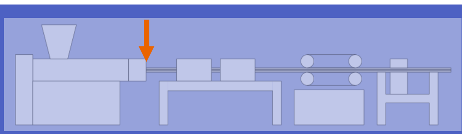
Introduction - *Design Approaches*

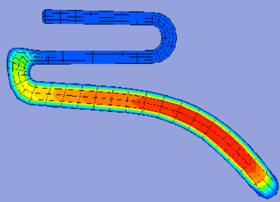
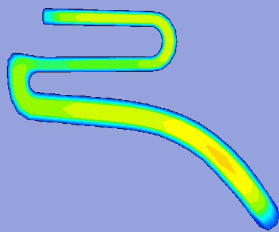


Outline

- Extrusion Dies
  - Problem Statement
  - Flow Distribution Optimisation
  - Flow Balance Strategies
  - Optimisation
  - Length vs Thickness Optimisation
  - Conclusion
- Calibrators
  - Problem Statement
  - System Behaviour
  - Optimisation Methodology
  - Case Study
  - Conclusion
- Conclusion
- Ongoing Work

Extrusion Dies – *Problem Statement*

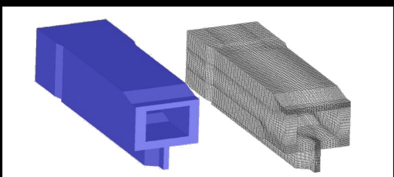


	Unbalanced	Balanced
Extrusion run		
Numerical Velocity contours		

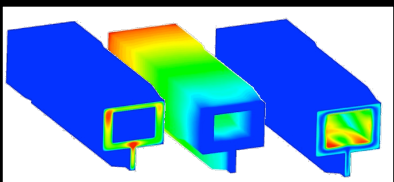
Extrusion Dies – *Flow Distribution Optimisation*

Trial Parameters

Pre-Processor



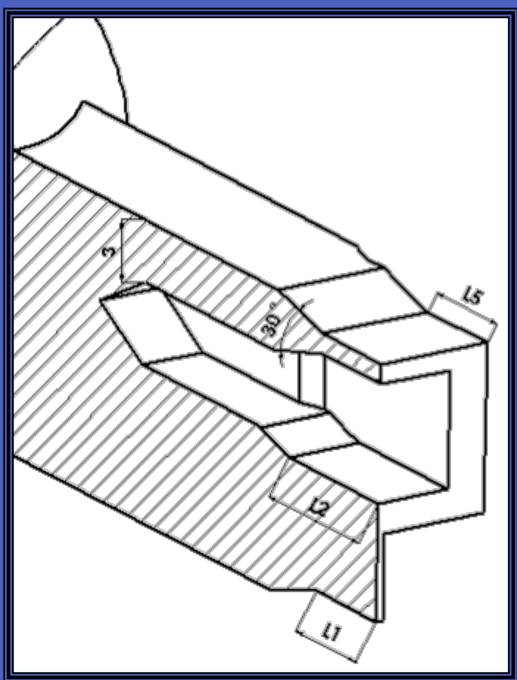
3D non-isothermal flow field calculation (FVM)



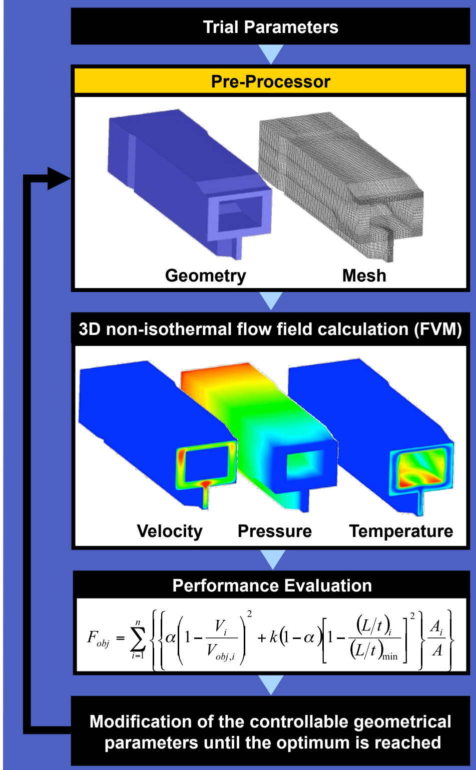
Performance Evaluation

$$F_{obj} = \sum_{i=1}^{n} \left\{ \left[\alpha \left(1 - \frac{V_i}{V_{obj,i}} \right)^2 + k(1-\alpha) \left[1 - \frac{(L/t)_i}{(L/t)_{\min}} \right]^2 \right] \frac{A_i}{A} \right\}$$

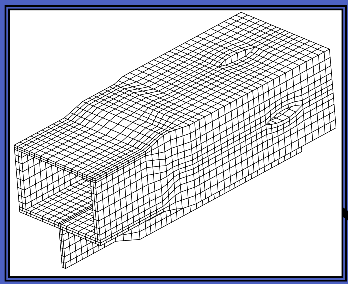
Modification of the controllable geometrical parameters until the optimum is reached

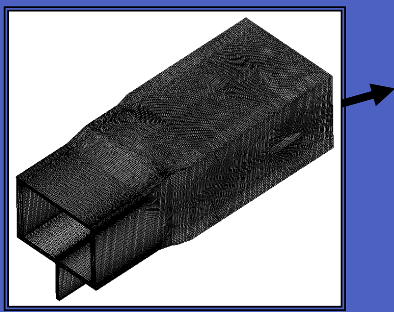


Extrusion Dies – *Flow Distribution Optimisation*



Progressive mesh refinements

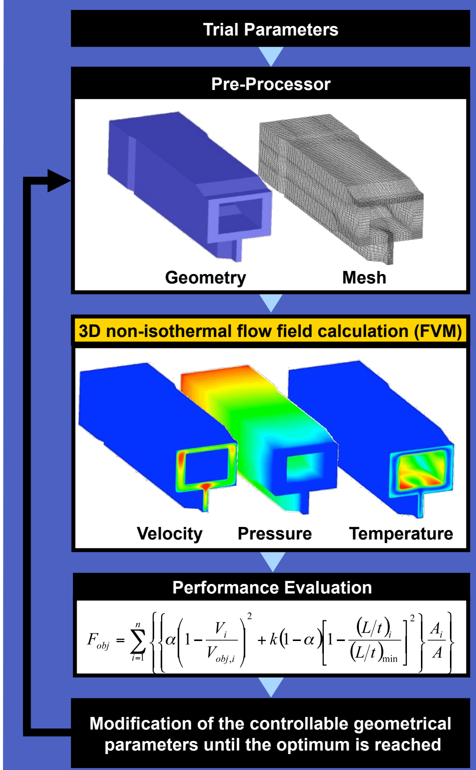




Cells along Thickness	Number of Cells	Time [h:m:s]
2	15 496	0:00:36
4	92 248	0:12:15
6	272 220	1:12:17
8	593 928	4:28:36
10	688 024	6:43:42

PIV / 2.4 GHz

Extrusion Dies – *Flow Distribution Optimisation*



Equations to Solve

Conservation of mass:

$$\frac{\partial \rho u_j}{\partial x_j} = 0$$

Conservation of linear momentum:

$$\frac{\partial \rho u_i}{\partial t} + \frac{\partial \rho u_j u_i}{\partial x_j} = -\frac{\partial p}{\partial x_i} + \frac{\partial \tau_{ij}}{\partial x_j}$$

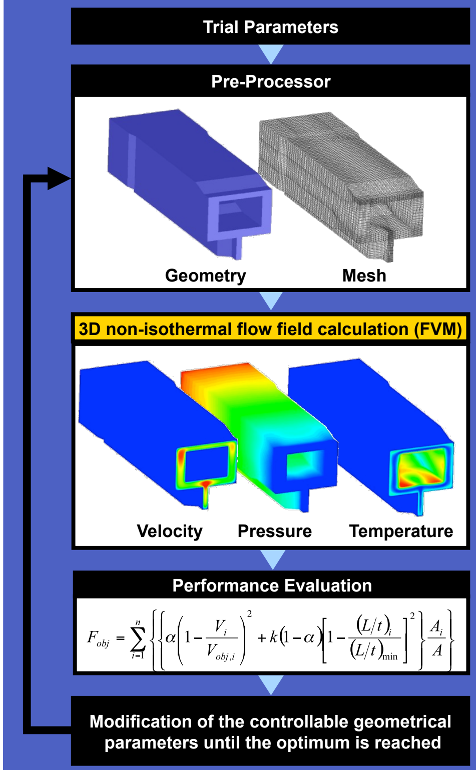
Conservation of energy:

$$\frac{\partial \rho c T}{\partial t} + \frac{\partial \rho c u_i T}{\partial x_i} = \frac{\partial}{\partial x_i}\left(k \frac{\partial T}{\partial x_i}\right) + \tau_{ij}\frac{\partial u_i}{\partial x_j}$$

Constitutive equation (Gen. Newtonian):

$$\tau_{ij} = \eta(\dot{\gamma})\left(\frac{\partial u_i}{\partial x_j} + \frac{\partial u_j}{\partial x_i}\right)$$

Extrusion Dies – *Flow Distribution Optimisation*



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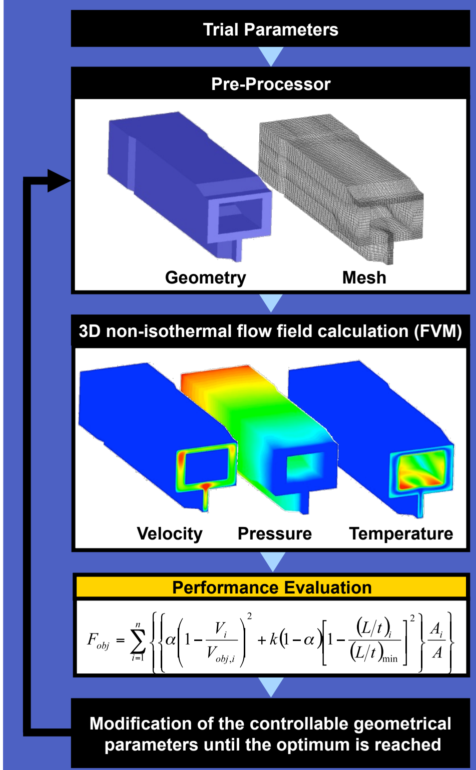
Conservation of energy:

$$\frac{\partial \rho c T}{\partial t} + \frac{\partial \rho c u_i T}{\partial x_i} = \frac{\partial}{\partial x_i}\left(k \frac{\partial T}{\partial x_i}\right) + \tau_{ij}\frac{\partial u_i}{\partial x_j}$$

Constitutive equation (viscoelastic):

$$\tau_{ij} + \lambda\left(\frac{\partial \tau_{ij}}{\partial t} + \frac{\partial\left(u_k \tau_{ij}\right)}{\partial x_k}\right) = \eta_p\left(\frac{\partial u_i}{\partial x_j} + \frac{\partial u_j}{\partial x_i}\right) + \lambda\left(\tau_{jk}\frac{\partial u_i}{\partial x_k} + \tau_{ik}\frac{\partial u_j}{\partial x_k}\right)$$

Extrusion Dies – *Flow Distribution Optimisation*



Objective Function

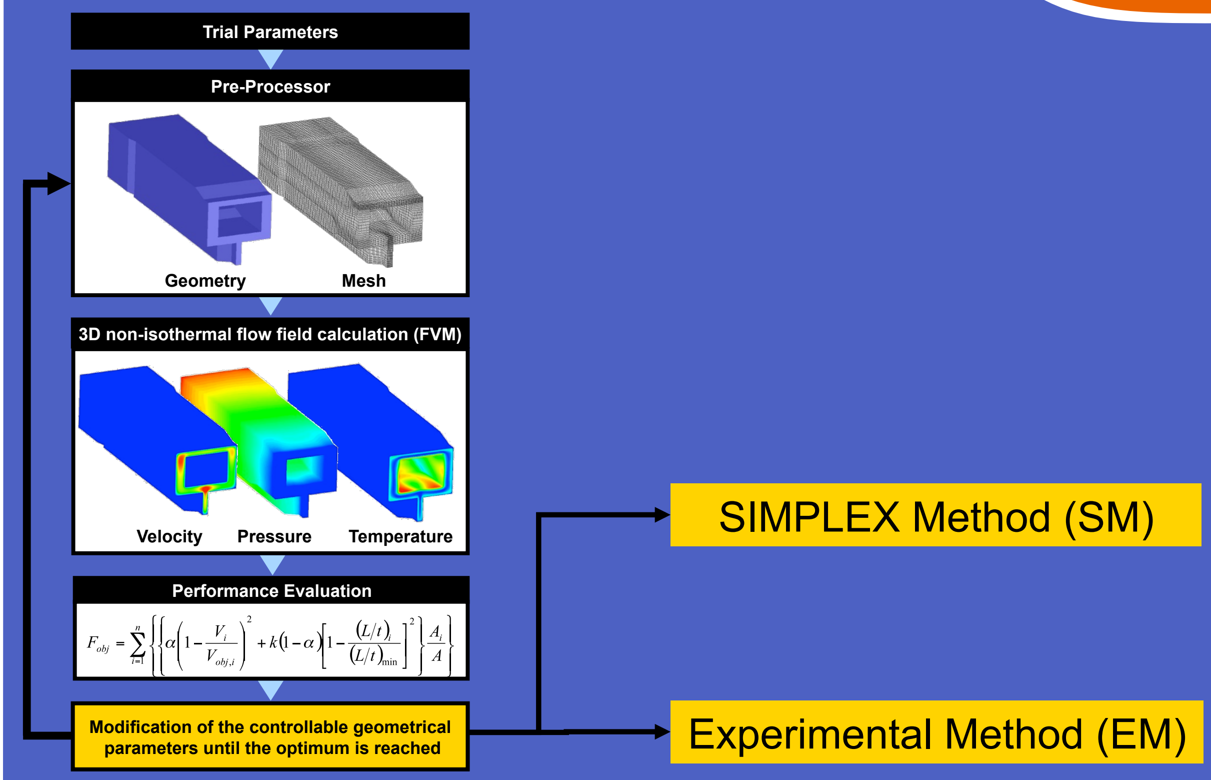
Area Weighting

$$F_{obj} = \sum_{i=1}^{n}\left\{\left\{\alpha\left(1-\frac{V_i}{V_{obj,i}}\right)^2 + k(1-\alpha)\left[1-\frac{(L/t)_i}{(L/t)_{min}}\right]^2\right\}\frac{A_i}{A}\right\}$$

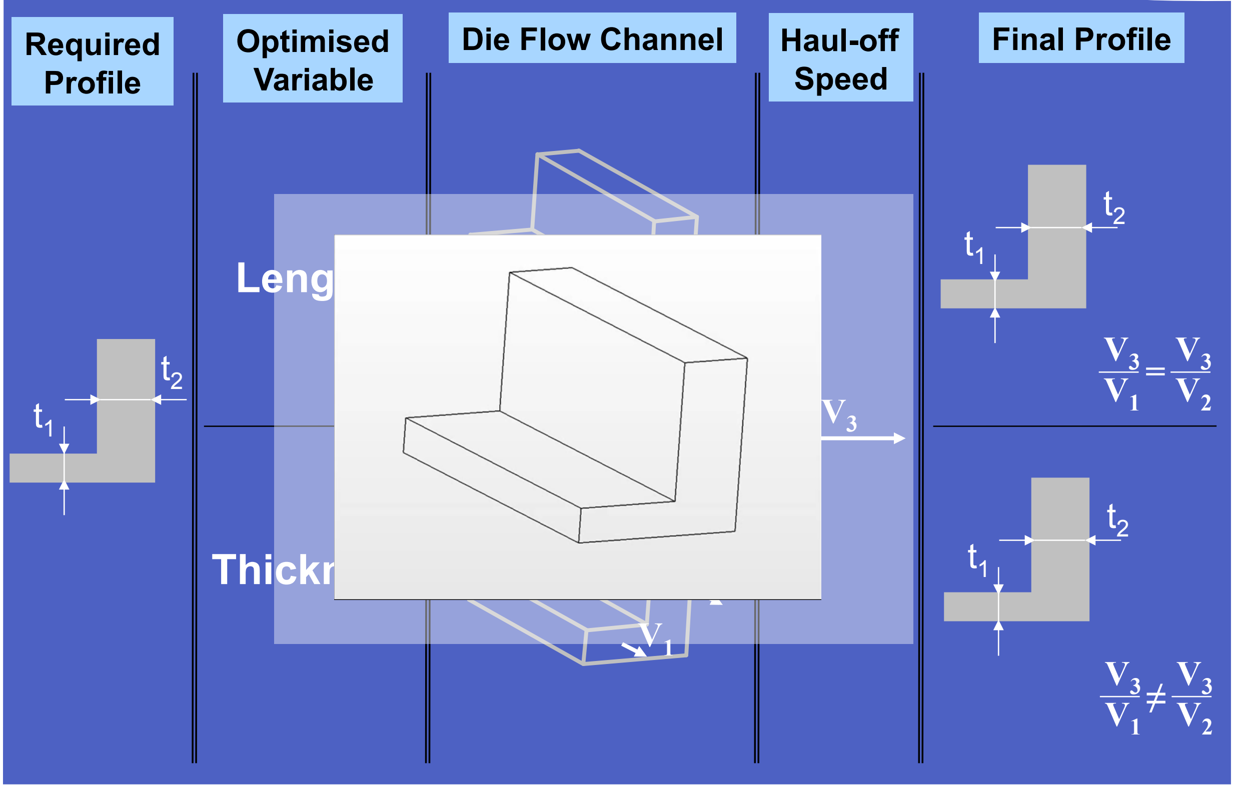
Flow Balance

Admissible L/t value

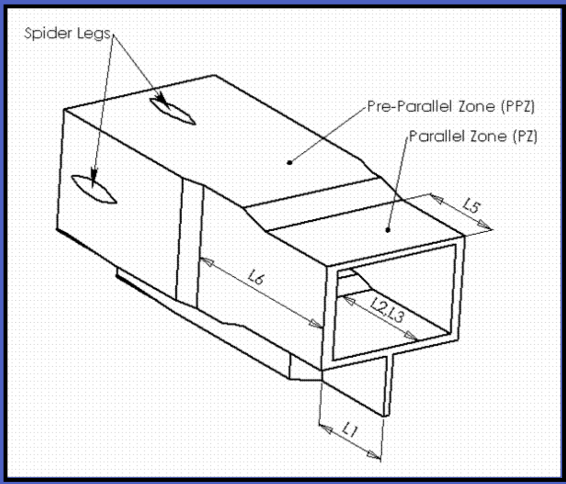
Extrusion Dies – *Flow Distribution Optimisation*

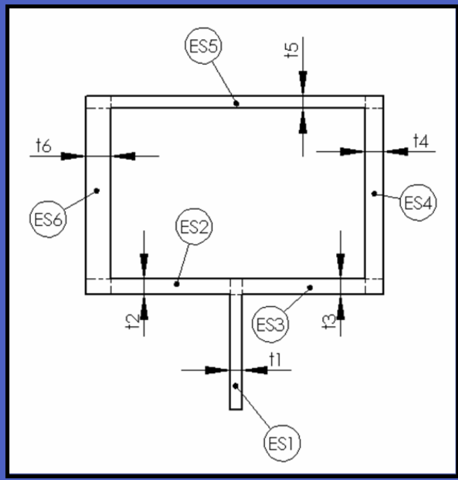


Extrusion Dies – *Flow Balance Strategies*



Extrusion Dies – *Optimisation*





Initial flow channel dimensions

ES	1	2	3	4	5	6
t_i[mm]	2.0	2.5	2.5	3.0	2.0	4.0
L_i [mm]	30.0	37.5	37.5	45.0	30.0	60.0
L_i/t_i	15.0	15.0	15.0	15.0	15.0	15.0

Extrusion Dies – *Optimisation*

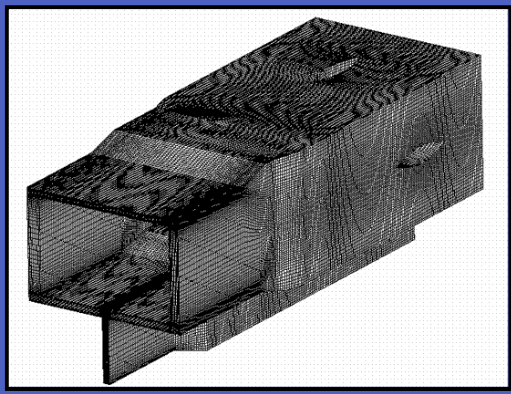
Extrusion Dies – *Optimisation*

Constitutive equation

$$\eta(\dot{\gamma},T)=F(\dot{\gamma}\times H(T))H(T)$$

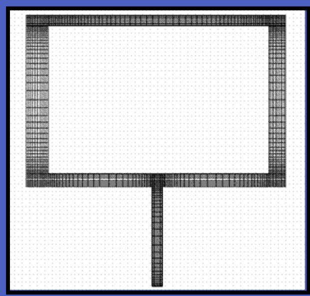
$$F(\dot{\gamma})=\eta_\infty+\frac{\eta_0-\eta_\infty}{\left(1+(\lambda\dot{\gamma})^2\right)^{\frac{1-n}{2}}} \qquad H(T)=\exp\left[\alpha\left(\frac{1}{T}-\frac{1}{T_\alpha}\right)\right]$$

Mesh



Operating and thermal boundary conditions

Flow rate	20 kg/h
Melt inlet temperature	230 ºC
Outer die walls temperature	230 ºC
Inner (mandrel) die walls	Adiabatic

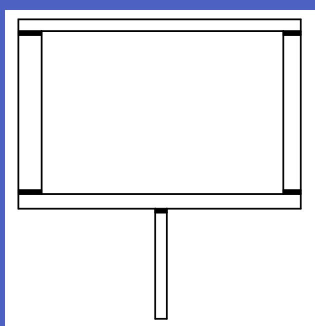


Extrusion Dies – *Optimisation*

DieINI – Initial trial

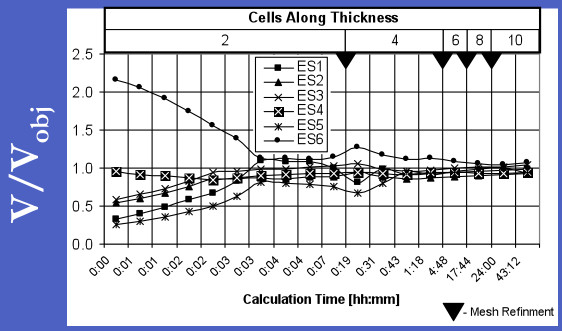
Optimizations performed

DieL – Length optimisation
DieT – Thickness optimisation
DieLS – Length optimisation + Flow separators

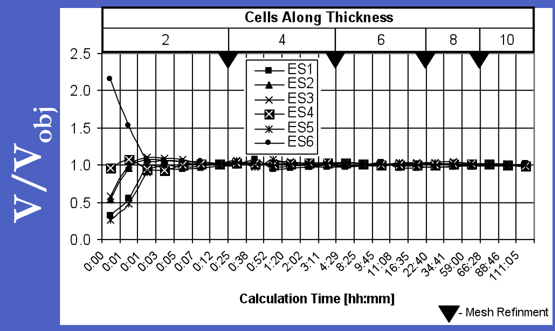


Extrusion Dies – *Optimisation*

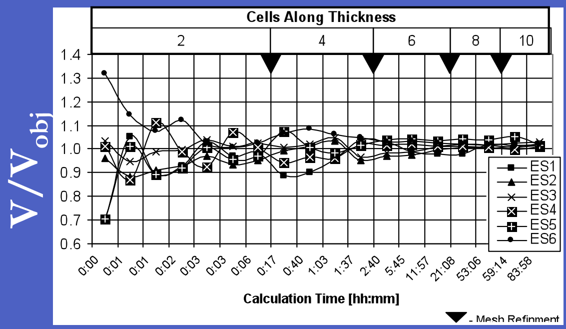
DieL



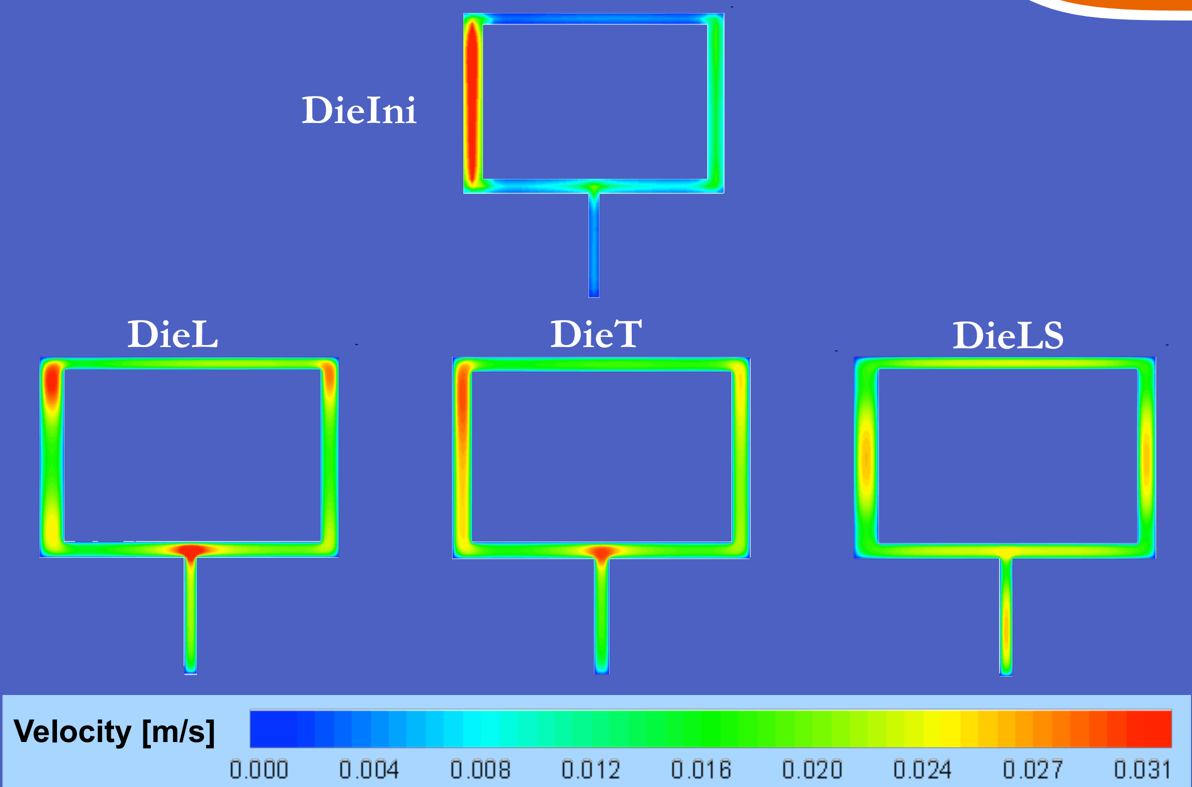
DieT



DieLS



Extrusion Dies – *Optimisation*



Extrusion Dies – ***Optimisation***

DieIni

DieL

DieT

Extrusion Dies – ***Optimisation***

Results

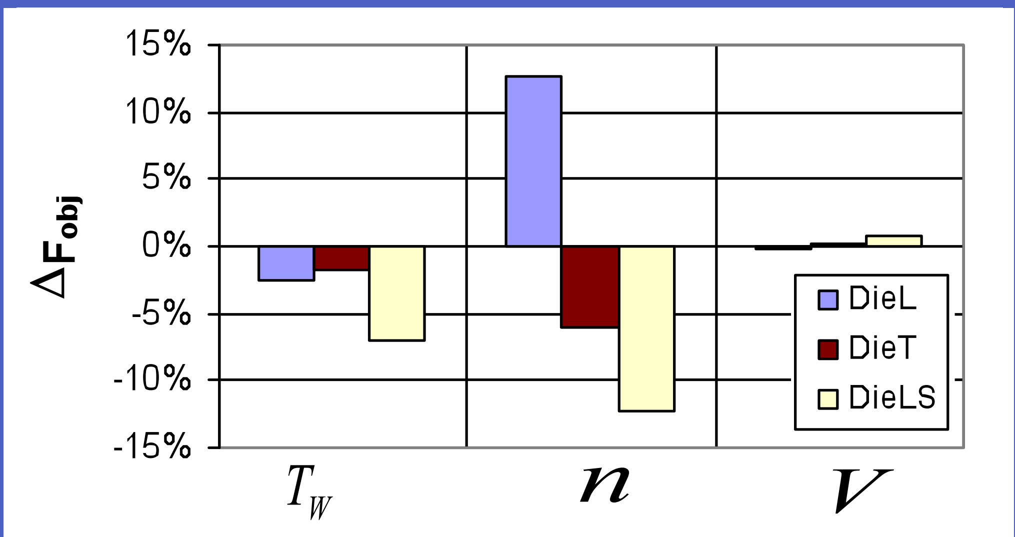
		Optimized die		
		DieL (length)	**DieT** (thickness)	**DieLS** (length)
Length/ Thickness	ES1	3.75	12.40	10.75
	ES2/3	4.60	14.20	13.80
	ES4	5.83	15.57	12.67
	ES5	3.50	12.40	12.25
	ES6	15.00	18.81	15.00

The factors considered can be divided in two different groups:

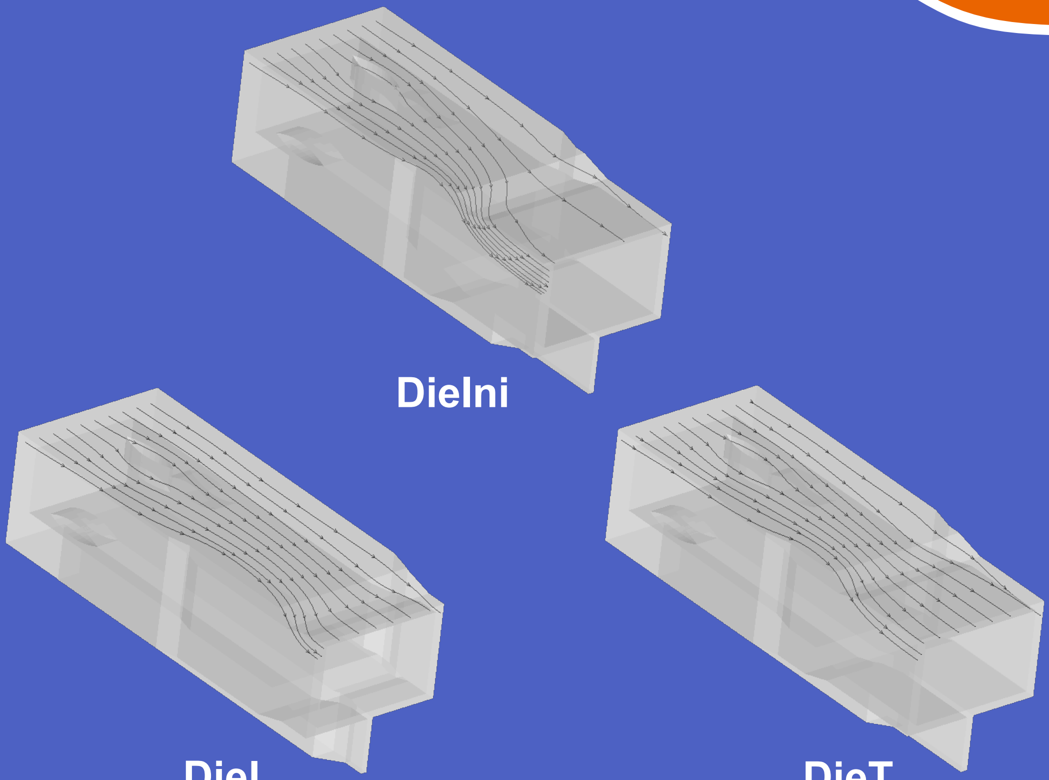
i) **processing conditions: V, T_w**
ii) **melt rheological properties: n**

The experiments (simulations) performed were defined by a statistics Taguchi technique, considering three levels for each factor

Extrusion Dies - *Length vs Thickness Optimisation*



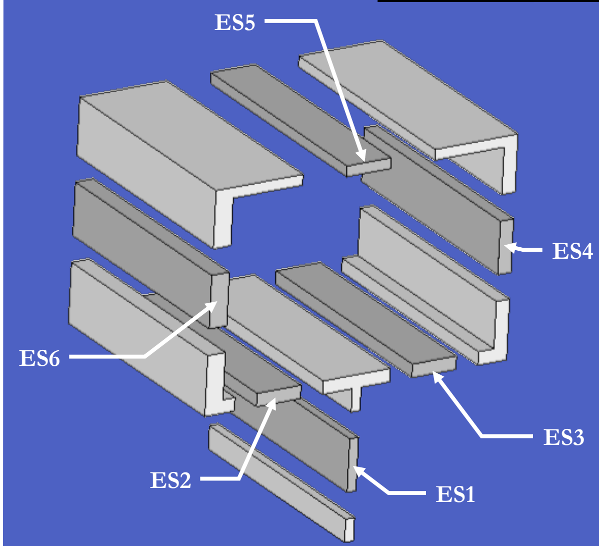
Extrusion Dies - *Length vs Thickness Optimisation*

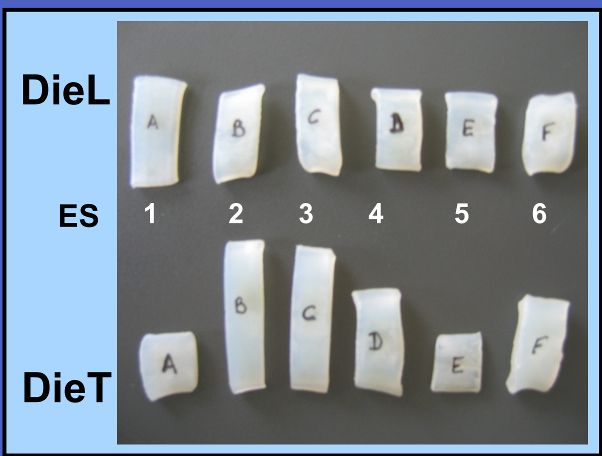


Extrusion Dies - *Length vs Thickness Optimisation*

Ratio $\overline{V}_{max}/\overline{V}$

Extrusion Die	ES1	ES2	ES3	ES4	ES5	ES6
DieINI	6.20	3.72	3.39	2.18	7.46	1.00
DieL	1.08	1.15	1.03	1.12	1.15	1.00
DieT	1.68	1.38	1.33	1.24	1.56	1.00

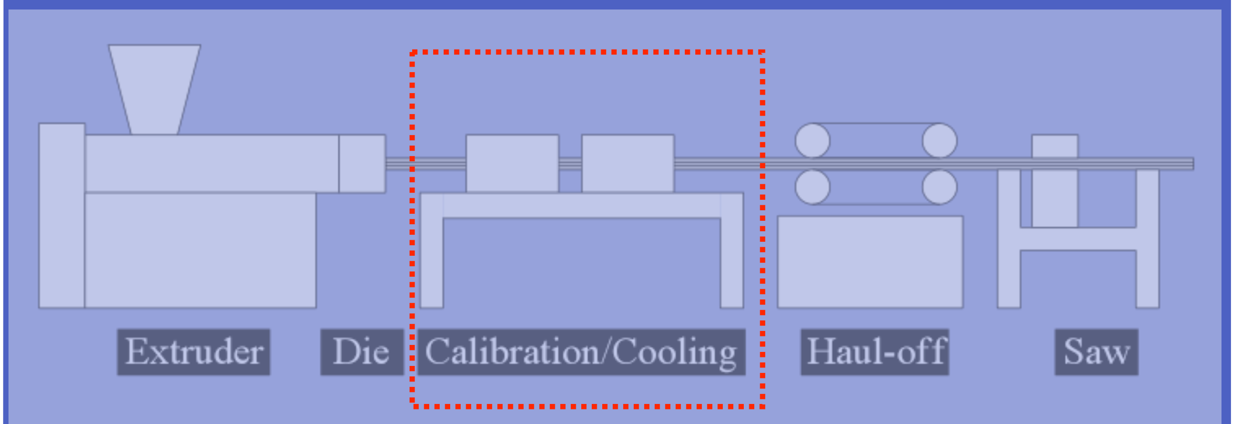




Extrusion Dies - *Conclusion*

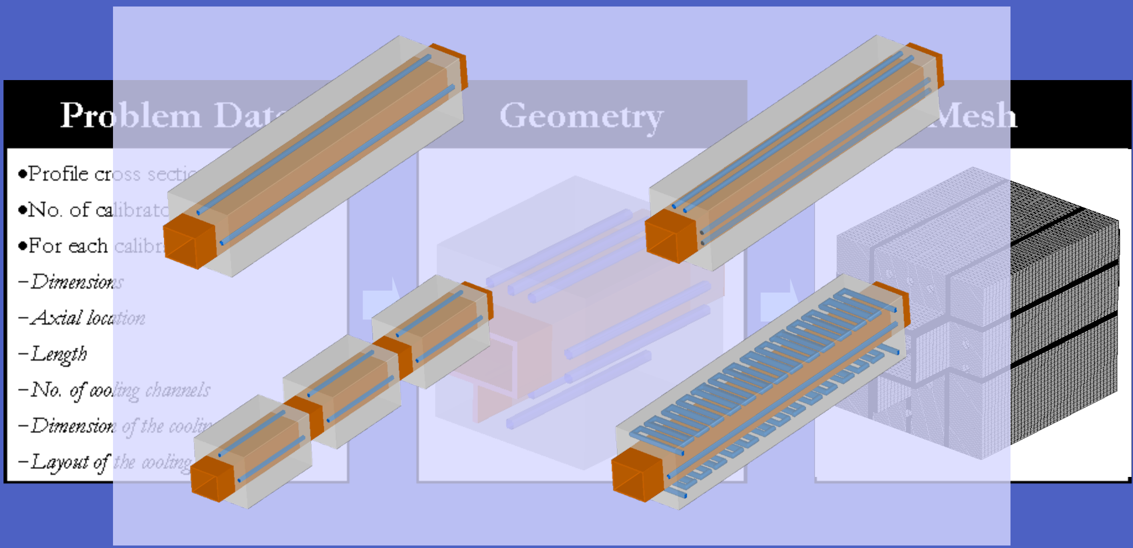
- *Length control* is difficult to apply in geometries with different flow restrictions and leads to dies with higher sensitivity to processing conditions than thickness control;
- *Flow separators* had a positive effect in the flow distribution but affect negatively in the die sensitivity;
- *Thickness optimised dies* produce extrudates that have higher propensity to distort.

Calibrators – *Problem Statement*

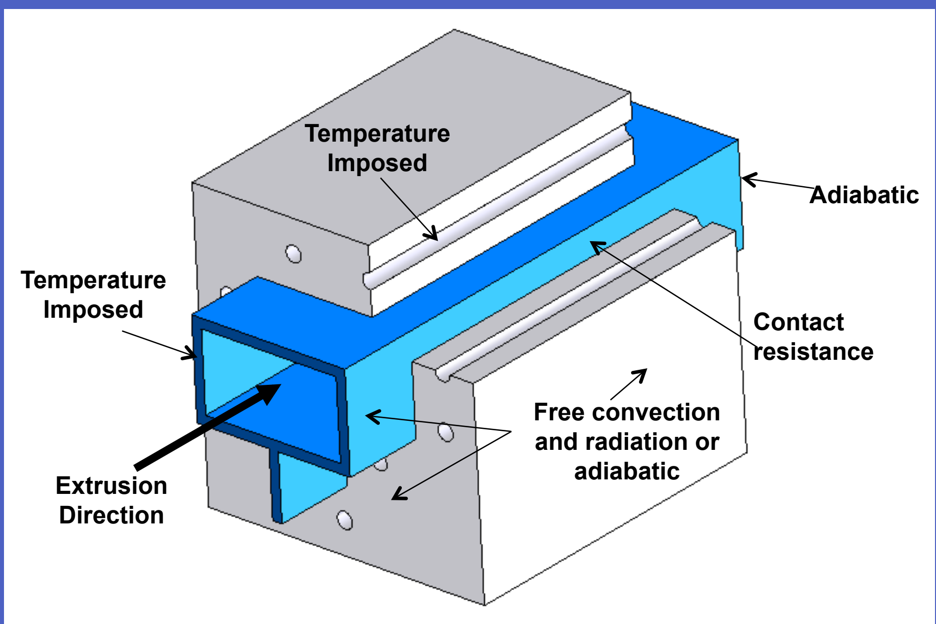


$$\bar{T} < T_s \quad \downarrow \sigma_T$$

Calibrators - *Pre-processor*



Calibrators – *Numerical boundary conditions*



Calibrators - *Equations to solve*

Polymer

$$\frac{\partial}{\partial x}\left(k_p \frac{\partial T_p}{\partial x}\right)+\frac{\partial}{\partial y}\left(k_p \frac{\partial T_p}{\partial y}\right)+\frac{\partial}{\partial z}\left(k_p \frac{\partial T_p}{\partial z}\right)-\rho_p c_p \frac{\partial}{\partial z}\left(wT_p\right)=0$$

Calibrator

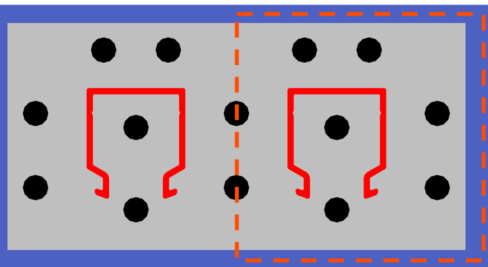
$$\frac{\partial}{\partial x}\left(k_c \frac{\partial Tc}{\partial x}\right)+\frac{\partial}{\partial y}\left(k_c \frac{\partial T_c}{\partial y}\right)+\frac{\partial}{\partial z}\left(k_c \frac{\partial Tc}{\partial z}\right)=0$$

Polymer-calibrator interface

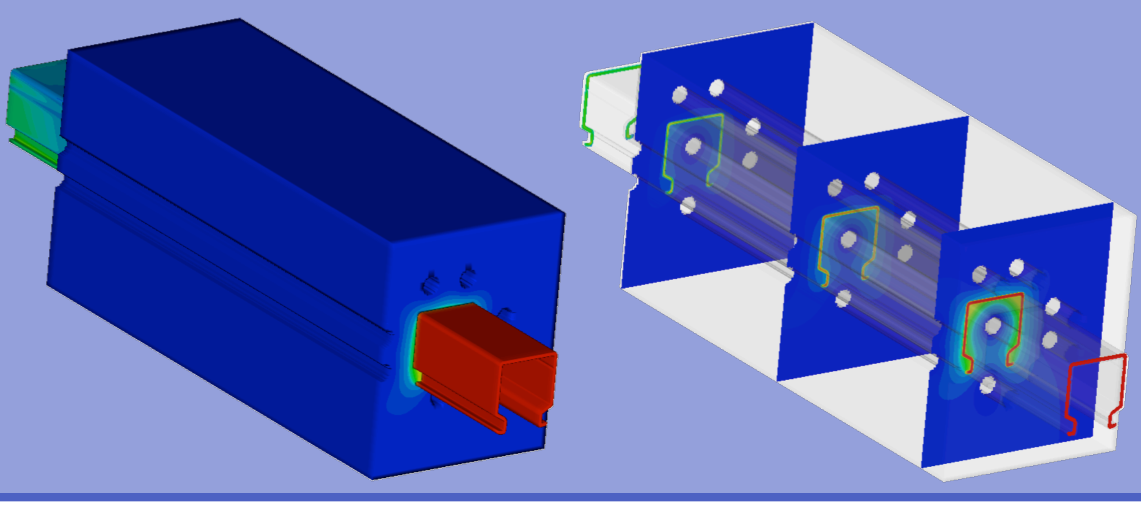
Contact Resistance

$$k_c\left(\frac{\partial T_c}{\partial n}\right)_{\text{interface}}=-k_p\left(\frac{\partial T_p}{\partial n}\right)_{\text{interface}}=h_i\left(T_p-T_c\right)_{\text{interface}}$$

Calibrators - *Typical result*



3D Temperature field calculation (FVM)



Calibrators - *System Behaviour*

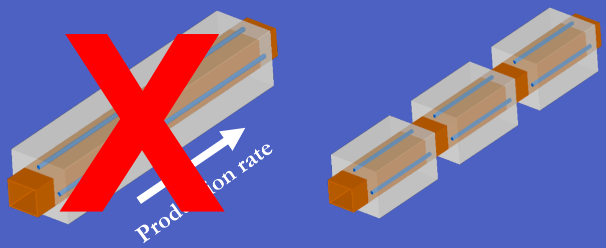
Influence of boundary conditions, process and geometrical parameters on the system performance (in terms of average temperature and temperature uniformity)

Conclusion:

In general

$$\downarrow \bar{T} \Rightarrow \uparrow \sigma_T$$

Exceptions



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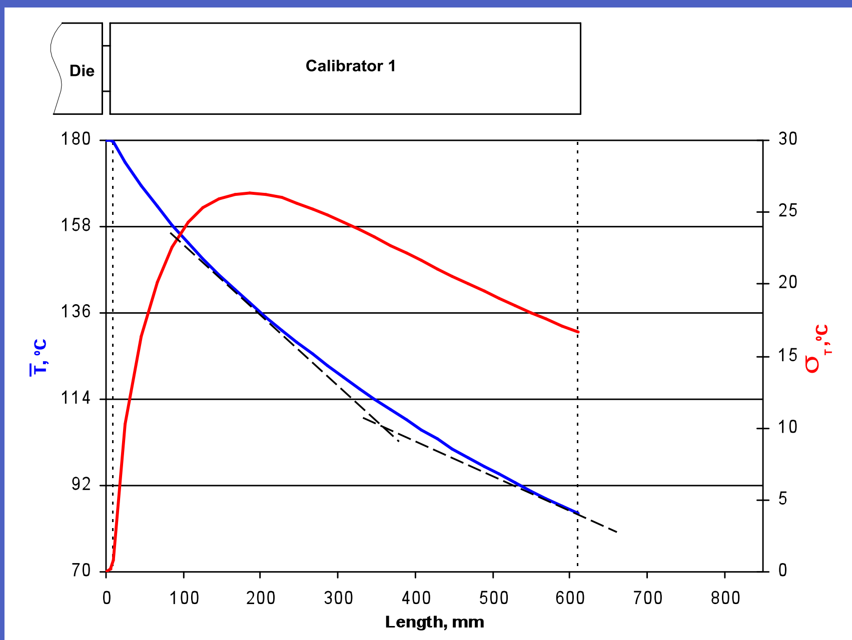
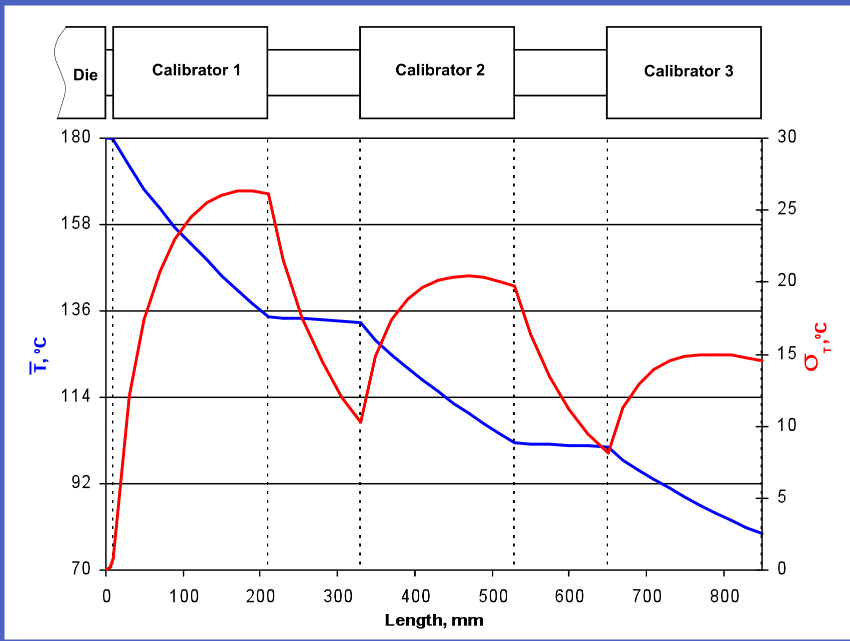
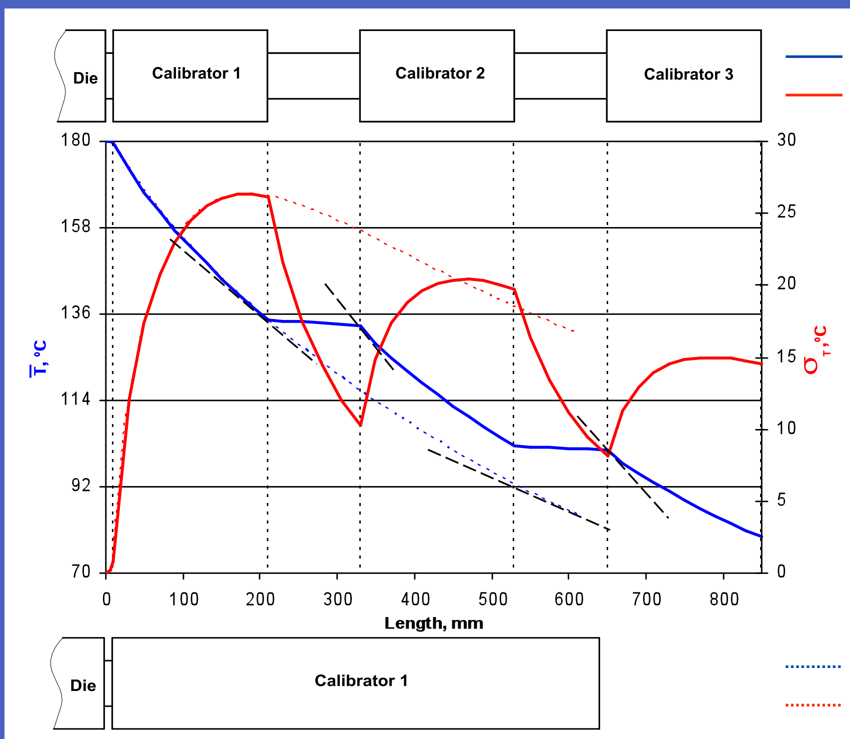
Calibrators - *System Behaviour*



Calibrators - *System Behaviour*

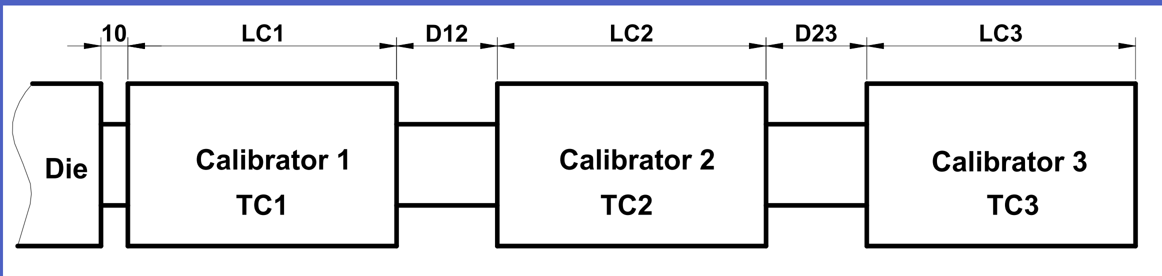


Calibrators - *System Behaviour*



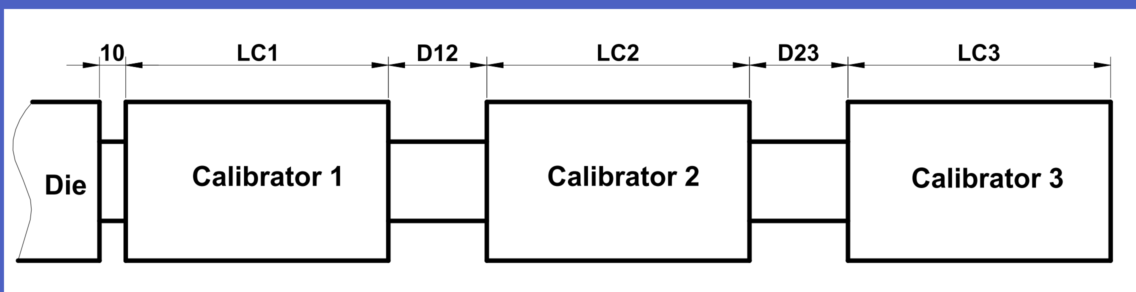
Calibrators - *System Behaviour*

Influence of the cooling units and annealing zones lengths and cooling fluid temperature on the system performance

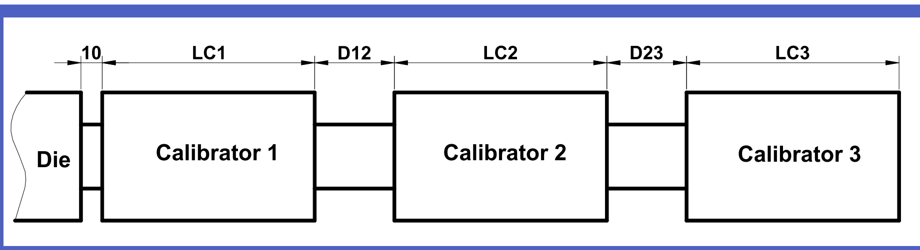


Calibrators - *System Behaviour*

Influence of Length Distribution
LCi and Dij



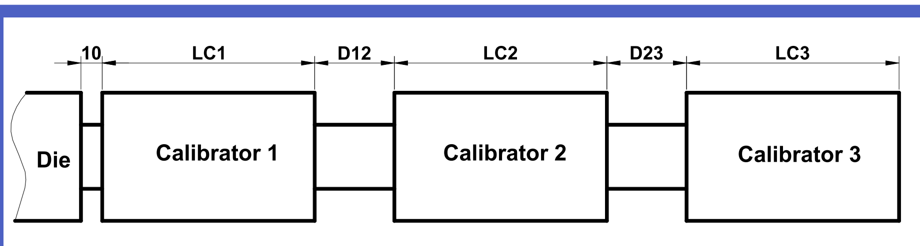
Calibrators - *System Behaviour*



LCi	LC1 [mm]	LC2 [mm]	LC3 [mm]	Dij	D12 [mm]	D23 [mm]
→	600	-	-		-	-
→	300	300	-	→	240	-
→	200	200	200	→	120	120
→	200	200	200	↗	60	180
→	200	200	200	↘	180	60
↘	300	200	100	→	120	120
↗	100	200	300	→	120	120
↘	300	200	100	↘	180	60
↘	300	200	100	↗	60	180
↗	100	200	300	↘	180	60
↗	100	200	300	↗	60	180

Σ LCi (600 mm), Σ D (240 mm) (system length = 850 mm)

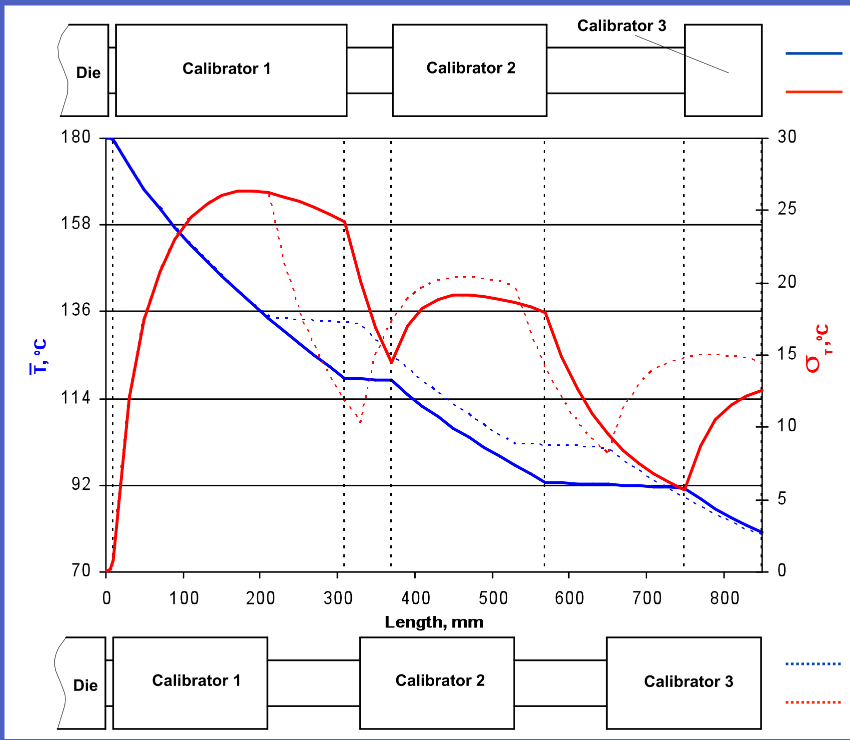
Calibrators - *System Behaviour*



LCi	LC1 [mm]	LC2 [mm]	LC3 [mm]	Dij	D12 [mm]	D23 [mm]	$\overline{T}$ [ºC]	$\overline{T}$ [%]	σ_T [ºC]	σ_T [%]
→	600	-	-		-	-	84.9	0.0%	16.6	0.0%
→	300	300	-	→	240	-	80.3	-5.5%	15.2	-8.6%
→	200	200	200	→	120	120	79.2	-6.7%	14.5	-12.6%
→	200	200	200	↗	60	180	79.5	-6.4%	14.5	-13.1%
→	200	200	200	↘	180	60	79.4	-6.5%	14.8	-10.8%
↘	300	200	100	→	120	120	79.5	-6.4%	13.0	-22.1%
↗	100	200	300	→	120	120	79.4	-6.5%	15.1	-9.3%
↘	300	200	100	↘	180	60	79.6	-6.3%	13.8	-17.3%
↘	300	200	100	↗	60	180	79.9	-5.9%	12.6	-24.3%
↗	100	200	300	↘	180	60	79.7	-6.1%	15.2	-8.4%
↗	100	200	300	↗	60	180	79.5	-6.3%	15.1	-9.4%

Σ LCi (600 mm), Σ D (240 mm) (system length = 850 mm)

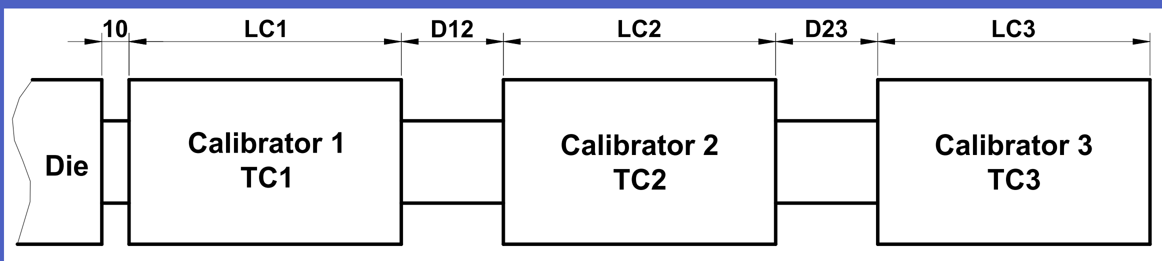
Calibrators - *System Behaviour*



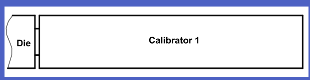
Calibrators - *System Behaviour*

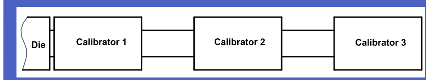
Influence of cooling fluid temperature

TCi

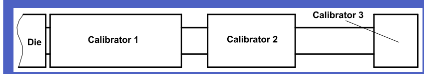


Calibrators - *System Behaviour*





→ LCi + → Dij

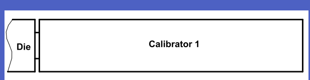


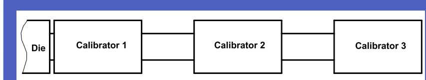
↘ LCi + ↗ Dij

TCi	TC1 [ºC]	TC2 [ºC]	TC3 [ºC]
→	18	-	-
→	18	18	18
→	10	10	10
→	26	26	26
↘	26	18	10
↗	10	18	26
→	18	18	18
→	10	10	10
→	26	26	26
↘	26	18	10
↗	10	18	26

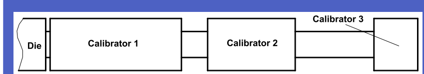
10ºC <= TCi <= 26ºC

Calibrators - *System Behaviour*





→ LCi + → Dij

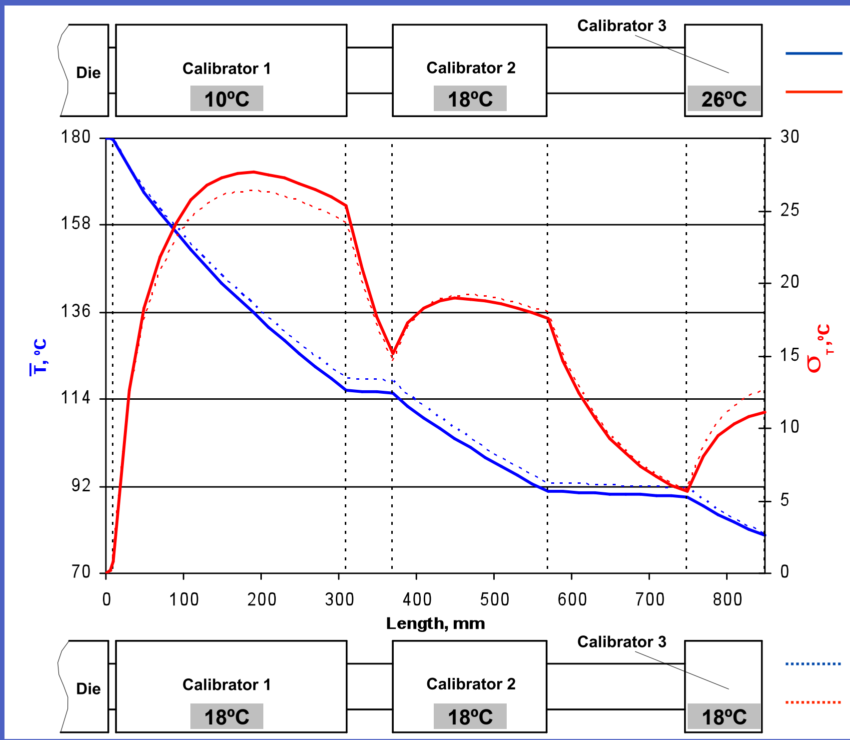


↘ LCi + ↗ Dij

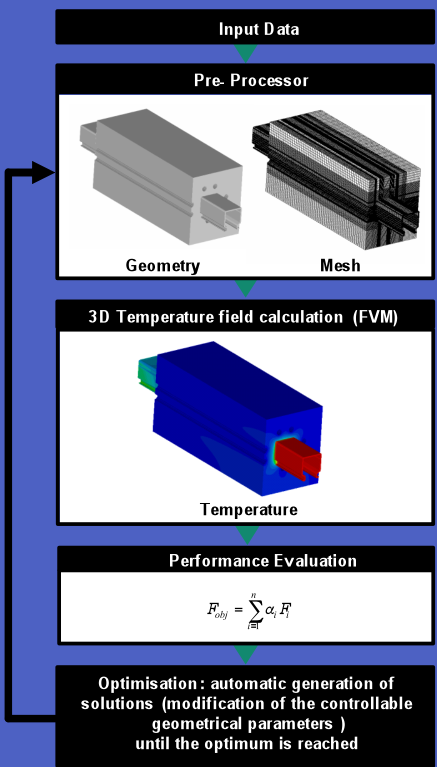
TCi	TC1 [ºC]	TC2 [ºC]	TC3 [ºC]	$\overline{T}$ [ºC]	$\overline{T}$ [%]	σ_T [ºC]	σ_T [%]
→	18	-	-	84.9	-	16.6	-
→	18	18	18	79.2	-6.7%	14.5	-12.6%
→	10	10	10	74.4	-12.3%	15.3	-8.2%
→	26	26	26	83.9	-1.1%	13.8	-17.0%
↘	26	18	10	78.0	-8.1%	16.0	-3.6%
↗	10	18	26	80.3	-5.4%	13.0	-21.7%
→	18	18	18	79.9	-5.9%	12.6	-24.3%
→	10	10	10	75.2	-11.4%	13.2	-20.7%
→	26	26	26	84.6	-0.4%	12.0	-28.0%
↘	26	18	10	80.2	-5.5%	14.1	-15.5%
↗	10	18	26	79.5	-6.3%	11.1	-33.1%

10ºC <= TCi <= 26ºC

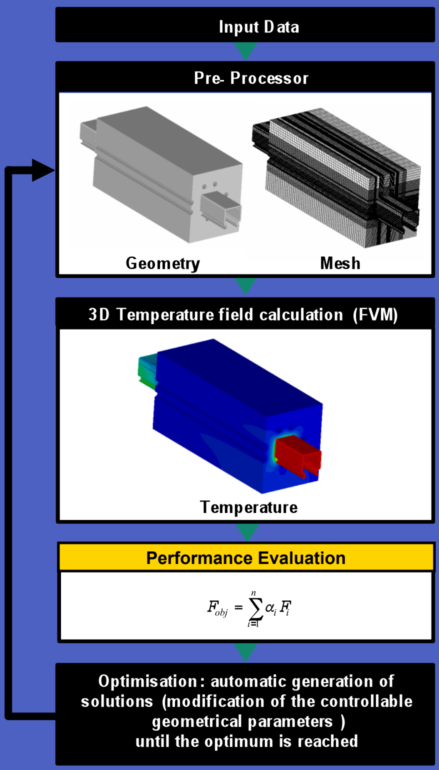
Calibrators - *System Behaviour*



Calibrators - *Optimisation Methodology*



Calibrators - *Optimisation Methodology*



Temperature uniformity

$$\sigma_T = \sqrt{\frac{\sum_{i=1}^{n_f} \left(T_i - \overline{T}\right)^2 A_i}{A_T}}$$

Cooling efficiency

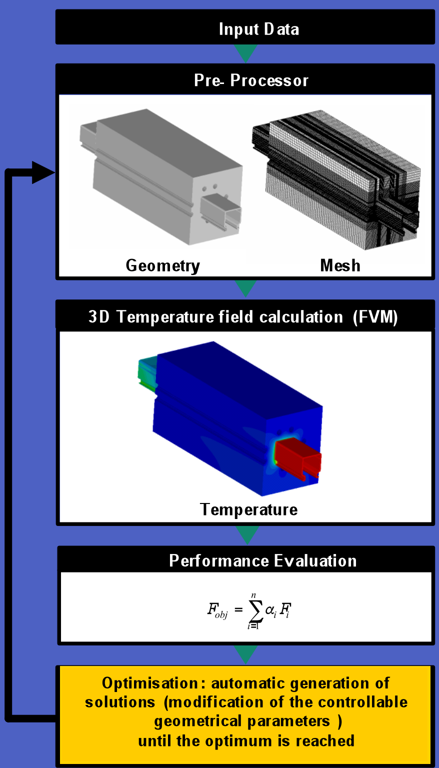
$$\overline{T} = \frac{\sum_{i=1}^{n_f} T_i A_i}{A_T}$$

$$F_{obj} = K\left|\overline{T} - T_S\right| + \sigma_T$$

where:

$$\begin{cases} \overline{T} \leq T_S \Rightarrow K = 0 \\ \overline{T} > T_S \Rightarrow K = 1000 \end{cases}$$

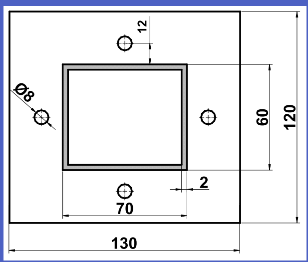
Calibrators - *Optimisation Methodology*

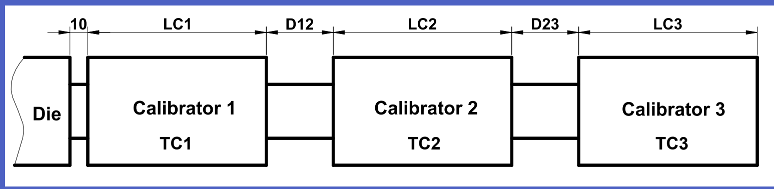


Optimisation algorithm

Non-linear SIMPLEX method

Calibrators - *Case Study*





Restrictions:

- Number of calibration/cooling units <= 3
- Total calibration length (ΣLCi) <= 600 mm
- Total system length (ΣLCi + Σ Dij + 10) <= 850 mm
- Cooling Fluid Temperature TCi ∈ [10ºC,26ºC]

Calibrators - *Case Study*

General conditions for the simulations

Processing conditions

v_p = 2 m/min

T_m = 180 ºC

T_f = 18 ºC

T_s= 80 ºC

Materials Properties

K_p = 0.18 W/mK

K_c = 14 W/mK

ρ_p = 1400 kg/m^3

c_p = 1000 J/kgK

Boundary conditions

Annealing zones: free convection and radiation

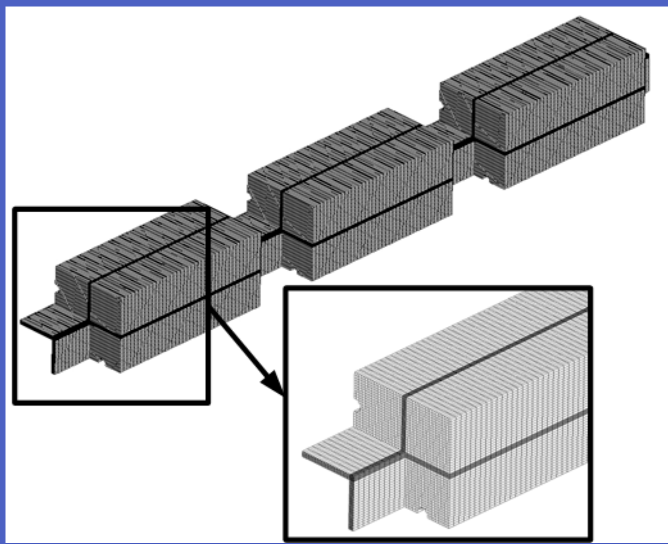
Polymer-calibrator interface: contact resistance

(h_i = 425 W/m^{2}K)

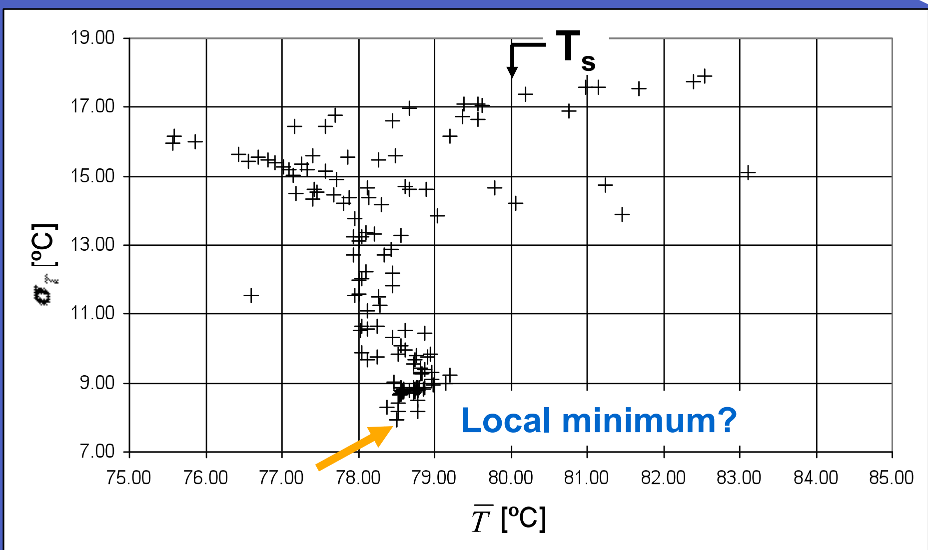
Calibrators - *Case Study*

Geometry

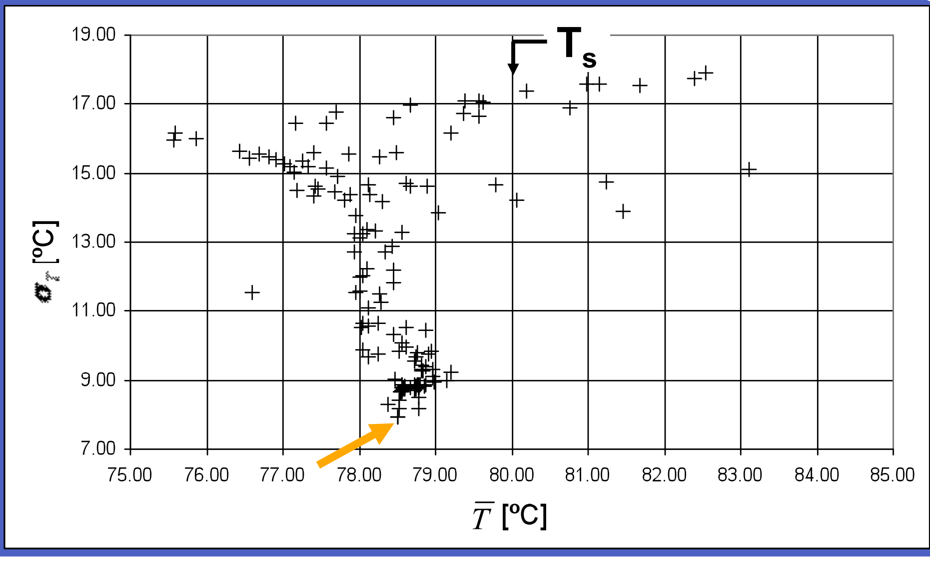
Mesh

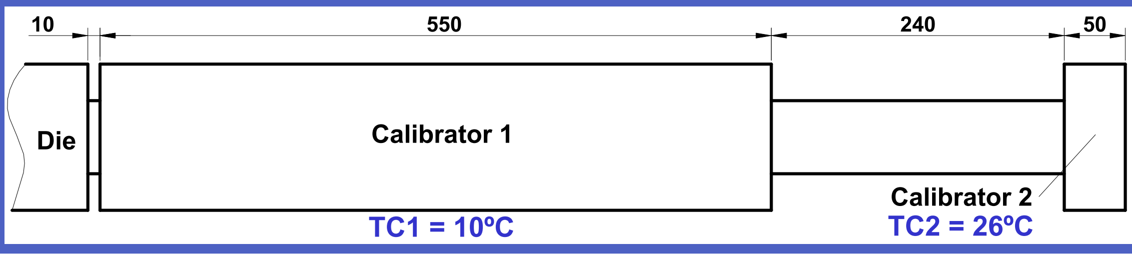


Calibrators - *Case Study*

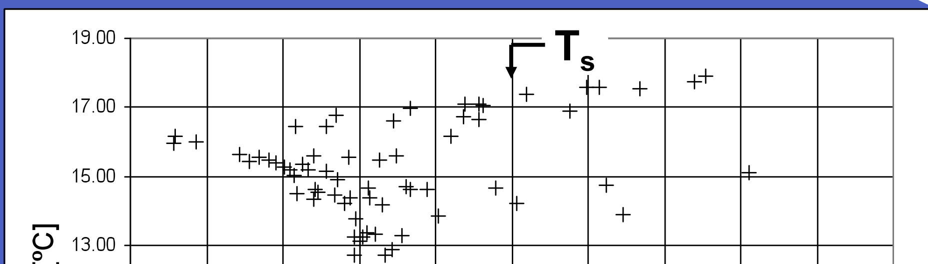


Calibrators - *Case Study*



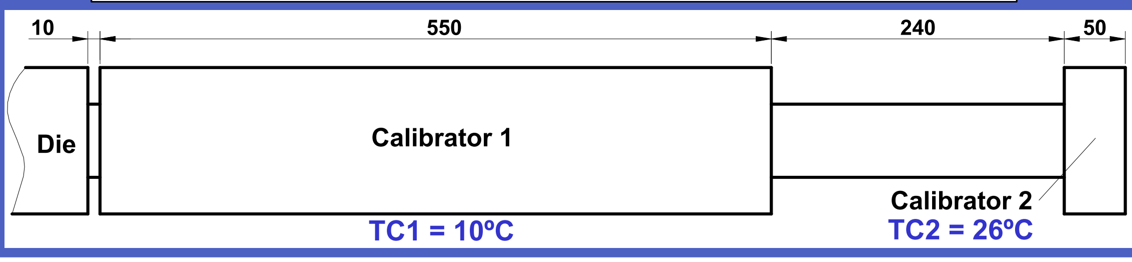


Calibrators - *Case Study*



Geometry	$\bar{T}$ [ºC]	σ_T [ºC]
One Calibrator (TC=18ºC)	84.9	16.6
Optimum Solution	78.5	7.9

- 52.4%



Calibrators - *Conclusion*

- Cooling systems with

  ascending cooling units lengths

  descending annealing zone lengths

  ascending cooling fluid temperatures

seem to have the best performance.

Conclusion

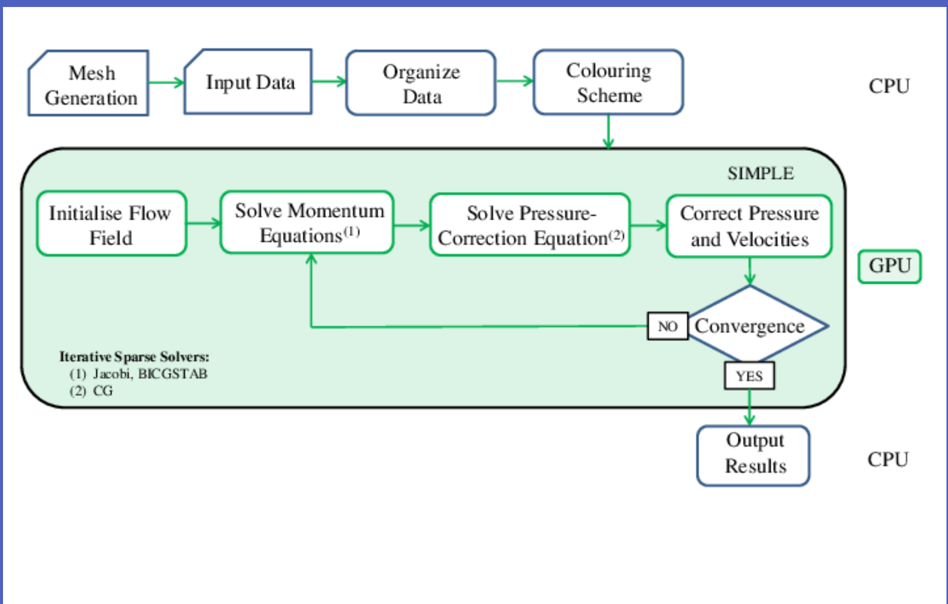
- The developed optimisation methodologies both for extrusion dies and calibrators were able to improve automatically the system performance;
- The optimisation methodologies are under development;
- The employment of numerical analysis allows a deeper insight of the process.

Ongoing work

- Implementation of the wall Slip and free-surface boundary conditions (L.L. Ferrás, PhD project);
- Development of unstructured numerical modelling code (N.D. Gonçalves, PhD project);
- Prediction of thermal induced stresses (A.M. Ribau, FCT Research project);
- Development of multiscale modelling approaches (S.T. Mould, PhD Project);
- Development of SPH numerical modelling code (D.F. Cordeiro, PhD/Cooperation Project);

Ongoing work

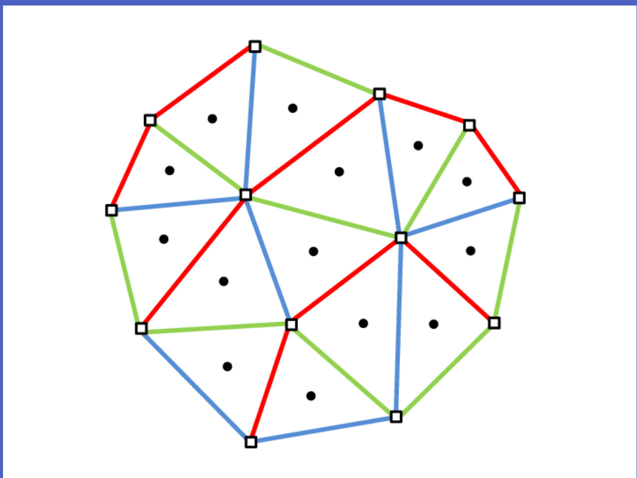
- Numerical code paralelization on GPU (S.P. Pereira, FCT Research Project);



Ongoing work

- Numerical code paralelization on GPU (S.P. Pereira, FCT Research Project);

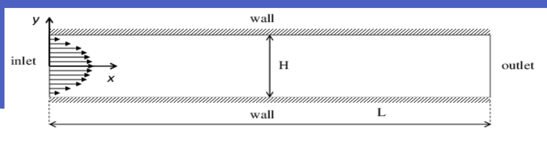
A colouring scheme was used to avoid race conditions

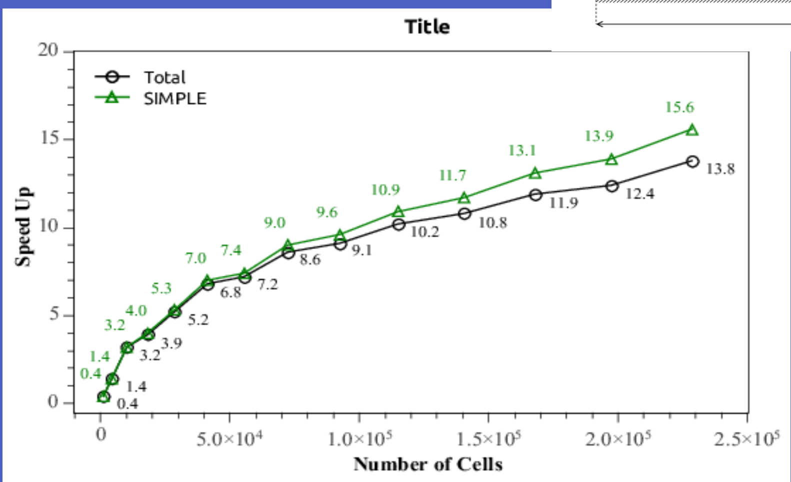


Ongoing work

- Numerical code paralelization on GPU (S.P. Pereira, FCT Research Project);

Poiseuille Flow – Speed Up





Ongoing work

- Numerical code paralelization on GPU (S.P. Pereira, FCT Research Project);

Lid Driven Cavity Flow – Speed Up