

Mechanisms and Machine Science


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Machine and Industrial Design in Mechanical Engineering

Proceedings of KOD 2024



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Preface

Dear Ladies and Gentlemen, respectable Colleagues and Friends of KOD,

The 12th International Conference of Machine and Industrial Design in Mechanical Engineering—KOD 2024 is being organized by the Faculty of Technical Sciences, the University of Novi Sad from the 23rd till the 26th of May 2024 in Hotel Marina at Balatonfüred, Hungary.

The Conference Chair would like to extend special gratitude to the Editor of the Springer book series Mechanisms and Machine Science, Prof. Marco Ceccarelli, for supporting the Conference and giving the chance to all authors to publish a paper in an edition titled Machine and Industrial Design in Mechanical Engineering—Proceedings of KOD 2024.

The basic goal of this conference is to assemble experienced researchers and practitioners from universities, scientific institutes and different enterprises and organizations from within this field. Also, it should instigate more intensive cooperation and exchange of practical professional experiences in the field of shaping, forming and design in mechanical and graphical engineering, industrial design and shaping, product development and management. As there is a pressing need, under the cover of Industry 4.0, for more effective, simpler, smaller, cheaper, noiseless and more esthetically pleasing products that can easily be recycled and are not harmful to the environment, the cooperation between specialists in these fields should certainly be well developed and intricate.

Finally, we would like to thank all the people who have supported the Conference and have helped and encouraged us in all the activities.

We are very grateful to our reviewers whose enormous work of assessing the papers is gratefully appreciated.

We would also like to express our appreciation to our keynote speakers for their invaluable contribution.

We would like to thank the authors themselves for contributing research papers, without whose expert input there would have been no conference.

We are thankful to our sponsor Termometal d.o.o. Ada for helping and supporting the conference.

And, last but not least, we are pleased to acknowledge the assistance provided by the members of the International Scientific Committee and Technical Program Committee of the KOD 2024 Conference.

We wish You to have an interesting and stimulating conference that will bring about numerous fruitful discussions and lay the foundations for future collaboration.

Have an unforgettable stay in Balatonfüred, catch up with old friends and make some new ones.

We wish You good health and success in Your further research and great fortune and happiness in Your personal life.

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Balatonfüred
May 2024

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Contents

Invited Keynote Lecture

Evolution and Tendencies in Design and Exploitation of Cutting Tools and Processes	3
<i>Mircea-Viorel Dragoi</i>	

Design, Manufacturing and Management of Machine Elements, Equipment and Systems

Design of a Drive Unit for Technical Equipment Working in the Amusement Industry	17
<i>Denis Molnár, Miroslav Blatnický, Vadym Ishchuk, and Dávid Čierňava</i>	

Buckling Analysis of Symmetric Laminated Composite Plate Subjected to Biaxial Compressive Loading Using Finite Element Software	29
<i>Dejan Jeremic, Nebojsa Radic, Nikola Vucetic, and Ranko Antunovic</i>	

Calculation of the Technological Forces Transmitted to the Extraction Tower Through Means of the Extraction Pulley	37
<i>Răzvan-Bogdan Itu, Toderas Mihaela, Ioan-Bogdan Marc, and Vlad Alexandru Florea</i>	

Air-Dynamic Measurements on “S” Shape Hydrofoils	47
<i>Adriana-Sida Manea, Daniel-Catalin Stroita, Ilare Bordeasu, Cristian Ghera, and Alexandru-Nicolae Luca</i>	

ContributionsContributions on Mathematical Determination of Surfaces in Unconventional Worm Gear	57
<i>Ninacs Roland and Haragas Simion</i>	

Dimensional Calculation of the Main Beam of a Technical Equipment Intended for the Amusement Industry	68
<i>Vadym Ishchuk, Miroslav Blatnický, Denis Molnár, Ján Dižo, and Dávid Čierňava</i>	

Spiroid Gears vs. Bevel and Hypoid. Design Preconditions and Practice of Implementation	81
<i>Evgeniy Trubachev</i>	

Using Experimental Results to Determine Calculation Parameters for Press Fitting Ball Bearings into 3D Printed Parts	92
<i>Srecko Palic, Nenad Petrovic, Nikola Palic, Strahinja Milenkovic, and Zivana Jovanovic Pesic</i>	
Determination of 3D Printed Parts Various Geometric Tolerances	102
<i>Anja Velemir, Andjela Perovic, Nenad Petrovic, Nenad Kostic, and Nenad Marjanovic</i>	
Damage to Bearing Assemblies on Cardan Joints of Agricultural PTO Shafts ...	110
<i>Eleonora Desnica, Alexander Pastukhov, Evgeny Timashov, Do Duc Trung, and Aleksandar Ašonja</i>	
Geometric Tolerances Influence on Socket Set Screw Connection Dimensioning	120
<i>Andjela Perovic, Anja Velemir, and Milos Matejic</i>	
Design and Analysis of Different Materials in Gear Pairs	131
<i>Sandra Gajević, Rodoljub Vujanac, Miloš Matejić, Ivan Miletić, Miladinović Slavica, and Blaža Stojanović</i>	
Reconstruction of the Belt Conveyor Drive of the Rotary Excavator Using the ∇ (Nabla) Model of Engineering Design	139
<i>Ivica M. Jovanović, Aleksandar B. Marinković, and Dragan S. Živković</i>	
The Influence of Deaxiality of an IC Engine Slider-Crank Mechanism on the Mechanical Load of the Engine Cylinder	149
<i>Nebojša Nikolić, Danilo Brdar, Dragan Ružić, and Dalibor Feher</i>	
Improving Self-Lubricating Sliding Bearing Performances	160
<i>Aleksandar B. Marinković and Ivan M. Simonović</i>	
Investigation of Pellet Machine with Fixed Roller Axle and Flat Rotating Die	170
<i>Milos Matejic, Lozica Ivanovic, Marija Matejic, Jovana Zivic, and Snezana Joksic</i>	
Exploring the Viability of a Unique Piston Mechanism Through Load and Kinematic Analysis	180
<i>Dalibor Feher, Jovan Dorić, Dijana Čavić, Maja Čavić, Nebojša Nikolić, and Stjepan Galamboš</i>	
Study of H-Darrieus Wind Turbine with Hollow Blades	191
<i>Krasimir Tuzharov and Simeon Iliev</i>	

Degradation of 3D Printed Parts in Simulated Environmental Conditions	202
<i>Kenan Muhamedagic, Cekic Ahmet, Ira Bjelak, Maida Cohodar Husic, and Derzija Begic-Hajdarevic</i>	
Numerical Investigation on the Modal Analysis of Truss Type Highway Sign Support Structures	212
<i>Daniela Delia Alic, Imre Zolt Miklos, and Cristina Carmen Miklos</i>	
Loaded FEM Analysis of the Tooth of Driven Gears in Case of Bevel Gears Having the Modification of the Sum of Pitch Angles	222
<i>Sándor Bodzás and Gyöngyi Szanyi</i>	
Influence of the Teeth Flexibility on the Load Sharing and Tooth Strength of Spur Gears	235
<i>José I. Pedrero, Miguel Pleguezuelos, and Miryam B. Sánchez</i>	
Fracture Behavior Analysis of Weld Metal Generated Through Diverse Welding Technologies Under Both Primary and Secondary Stress Conditions	245
<i>Amna Bajtarević-Jeleč, Nedeljko Vukojević, Mersida Manjgo, and Fuad Hadžikadunić</i>	
Resistance Spot Welding Technology of DC03 Cold-Rolled Steel Sheets	256
<i>Sándor Pálinkás</i>	
Investigation of Cavitation Resistance of Biocompatible Zinc-Based Alloys for Biomedical Applications	272
<i>Ilare Bordeasu, Cristian Ghera, Alexandru-Nicolae Luca, Adriana-Sida Manea, Daniel-Catalin Stroita, Cornelia Laura Salcianu, Brandusa Ghiban, and Lavinia Madalina Micu</i>	
A Case Study of Decreasing Dust Pollution in Steel Melt Shop by Virtual Prototyping Developed Approach	282
<i>Konstantin Kamberov, Georgi Todorov, and Tsvetozar Ivanov</i>	
Aspects Regarding the Design of a Low-Head Hydraulic Turbine Test Stand . . .	292
<i>Teodor Costinel Popescu, Alexandru-Polifron Chiriță, Sergiu Nicolaie, and Rareș-Andrei Chihaia</i>	
Assessment of the Quality of Regeneration of Splineways Using Polymer Masses	301
<i>Arkadiusz Gola, Anna Rudawska, Jakub Szabelski, Dana Stančeková, Radovan Madleňák, Ivan Kuric, and Miloš Poliak</i>	

The Influence of Regeneration with Epoxies on the Strength of Adhesive Joints	312
<i>Jakub Szabelski, Anna Rudawska, Arkadiusz Gola, Antoni Świć, Dana Stančėková, and Tetiana Vitenko</i>	
The Influence of the Type of Wood and Construction on the Strength of Wood Adhesive Joints	318
<i>Anna Rudawska, Izabela Miturska-Barańska, Elżbieta Doluk, Jakub Szabelski, Daniel Gaska, Dana Stančėková, and Nataša Náprstková</i>	
Redesigning and Optimizing Above-Knee Prosthetic Leg for Additive Manufacturing	327
<i>Zlata Jelačić</i>	
Validation of Design and Ergonomics of a Protective Mask by Creating a Silicone Replication in a 3D Printed Mold Tool	335
<i>Todor Todorov, Krasimira Bineva, and Borislav Romanov</i>	
Design of Continuous Vertical Conveyors – Vertiveyors	345
<i>Saša Marković, Danijel Marković, Nikola Petrović, and Dragan Marinković</i>	
Optimization of a Rack & Pinion Pneumatic Actuator by Applying Design-to-Value Integrated with Multiple Simulation Techniques	354
<i>Giovanni Maiocchi, Giuseppe Carucci, Gianni Nicoletto, and Luca Collini</i>	
Recycled Titanium Alloy TiAl6Nb7 and 3D Print Technology	365
<i>Aida Imamović, Amra Talić-Čikmiš, Mirsada Oruč, Šaban Žuna, and Zijad Alibašić</i>	
Kinetostatic and Stress Analysis of Scissor Lift	374
<i>Nedeljko Vukojević, Amra Talić-Čikmiš, and Kenan Šabanović</i>	
Sensor Oriented Dynamics Model of Rotor as Basis of Machines Diagnostic ...	383
<i>Ranko Antunovic, Nikola Vucetic, and Dejan Jeremic</i>	
Analysis of the Possibility of Joining DP Steel and CFRP with Epoxy Adhesive and Hybrid Joining Technology	393
<i>Aleskija Đurić, Damjan Klobčar, Dragan Milčić, Biljana Marković, Srđan Samardžić, Nataša Zdravković, and Miodrag Milčić</i>	
Improvement of Agricultural Equipment Durability Through Laser Remelting Technology	403
<i>István Domokos and Sándor Pálinkás</i>	

Biomimicry in Machine Design: Symmetry, Harmony, and Perfection (SHP) Method of Self-Assembly of Nano-Micro-Macro Machines	413
<i>Lidija Matija, Ivana Stanković, Branislava Jeftić, Aleksandra Dinić, Mijat Lalić, and Đuro Koruga</i>	
Virtual Commissioning Integration in Logistics Operations: An Innovating Approach for Enhanced Efficiency and Sustainability	425
<i>Daynier Rolando Delgado Sobrino and Martin Kotian</i>	
Proposal for a Design of an Abrasive Disc Machine for Grinding Metal Specimens and Samples	436
<i>Juan T. Cruz-Aragón, Manuel Vite-Torres, and Ezequiel A. Gallardo-Hernández</i>	
Impact Sliding Wear Behavior of Pearlitic/Ferritic and Pearlitic Ductile Cast Iron	445
<i>Harun Mindivan, Emre Aydın, and Zafer Ay</i>	
Fuzzy System for Determining the Parameters for Laser Cutting with Compressed Air	452
<i>Florin Blaga, Pop Alin, Andrei Cristea, George Nastor, Voichița Hule, and Traian Buidos</i>	
Numerical Simulation of Self-Excited Vibrations in Milling	461
<i>Cvijetin Mladjenovic, Aleksandar Kosarac, Aleksandar Živković, Miloš Knežev, Dejan Marinković, Vojin Ilić, and Luka Mejić</i>	
Influence of Geometry Parameters on Shaft's Load-Carrying Capacity	472
<i>Pavle Ljubojević, Tatjana Lazović, and Ivana Atanasovska</i>	
Preliminary Investigation of Assisting Electrode EDM of Zirconium Ceramic	482
<i>Dragan Rodić, Marin Gostimirović, Milenko Sekulić, Borislav Savković, and Anđelko Aleksić</i>	
Dynamic Analysis of a Radial Bearing Using the FEM Model	491
<i>Mirjana Bojanić Šejat, Miloš Knežev, Aleksandar Živković, Milan Rackov, Ivan Knežević, and Danka Labus Zlatanović</i>	
The Test Bench for Determining Impact of Polymer Housing Material on the Bearing's Internal Friction	504
<i>Marko M. Tasić, Radivoje M. Mitrović, and Žarko Z. Mišković</i>	

Thick Steel Plates Stamping After Welding Process	513
<i>Waldemar Matysiak, Jakub Hajkowski, Dorota Czarnecka-Komorowska, and Miroslav Duspara</i>	
Analysis of Dynamic Phenomena in the Hydraulic Circuit of the Engine Lubrication System	521
<i>Václav Rychtář, Miroslav Malý, and Tomáš Zvolský</i>	
Management and Monitoring of Manufacturing Processes	
Enhancing Synthetic Leather Airbag Components Through Laser Microperforation Process Optimization: A Noise (Energy) Analysis	535
<i>Alexandru-Nicolae Rusu and Adela-Eliza Dumitrascu</i>	
Employee Competencies Required for MIS Implementation in the Context of Industry 4.0	542
<i>Filip Praj, Peter Košťál, Martina Horváthová, and Viera Bestvinová</i>	
Process Improvement Tools and Methods	551
<i>Škúrková Lestyánszka Katarína and Vanessa Prajová</i>	
Sources of Noise and Vibration on Car Gearboxes	562
<i>Elias Tomeh and Samnang Sann</i>	
Business Model for SMEs in Crisis Conditions: Lessons for the Development of the 4.0 Maritime Industry	576
<i>Dragana Milošević, Senka Šekularac-Ivošević, and Ivona Milić Beran</i>	
Optimizing of the WEDM Technologies Used in Progressive Dies Manufacturing	587
<i>Andrei Horia Brănescu, Adrian Marius Pascu, Nicolae Florin Cofaru, and Olivia-Laura Petraşcu</i>	
Techno-Economic Comparative Analysis of the Cutting Processes of Steel Sheets C45	598
<i>Dejan Lukic, Mijodrag Milosevic, Dragan Rodic, Stevo Borojevic, Dejan Bozic, and Savo Bojic</i>	
China Is the Leading Country in the World in the Implementation of Robotic Technology as the Basic Technology of Industry 4.0	612
<i>Isak Karabegović, Ermin Husak, Edina Karabegović, and Mehmed Mahmić</i>	

Applied Modelling, Industrial Design and Virtual Engineering

Investigation of the Freight Wagon Dynamics Under Specific Operational Conditions	625
<i>Alyona Lovska, Sebastián Solčanský, Vadym Ishchuk, and Ján Dižo</i>	
An Engineering Design of a Scooter	635
<i>Ján Dižo, Miroslav Blatnický, Alyona Lovska, Denis Molnár, and Radovan Šuvada</i>	
Dynamic Vehicle Dashboard Design for Reduced Driver Distraction	645
<i>Viktor Nagy and Ágoston Pál Sándor</i>	
Comparative Study of Different Software for Design Optimization	655
<i>Ivan Palinkas, Eleonora Desnica, Jasmina Pekez, Gergely Dezsó, and Ljiljana Radovanovic</i>	
Learning Geometric Dimensioning and Tolerancing in the Model-Based Definition Environment	665
<i>Tatjana Kandikjan and Ile Mircheski</i>	
Finite Element Analysis of 3D Printed TPU Part	675
<i>Juan Giler, Rami Alawar, Nazim Baghirzade, Dániel Nemes, Dávid Huri, and Tamás Mankovits</i>	
An Approach to Decrease Dust Pollution in Steel Melt Shop by Virtual Prototyping	685
<i>Georgi Todorov, Konstantin Kamberov, and Tsvetozar Ivanov</i>	
Numerical Analysis of the Modified 3D Arc-Star-Shaped Auxetic Structure	695
<i>Vladimir Sinđelić, Snežana Ćirić-Kostić, Nebojša Bogojević, and Aleksandar Nikolić</i>	
Instability of Vibrations in Complex Moving Objects with New Couplings	706
<i>Dunja Milić, Jian Deng, Vladimir Stojanović, and Marko D. Petković</i>	
Theoretical Research on Transient Process in Hydraulic Cylinder with Conical Cushioning Devices	717
<i>Sasko Dimitrov, Sara Srebrenkoska, Dejan Krstev, Mishko Dzidrov, Marija Cekerovska, and Todor Cekerovski</i>	

Research on the Optimal Granulation of Biomass in a Vibrating-Fluidized Bed Dryer	727
<i>Ioan Pavel, Alexandru Polifron Chirita, Gabriela Matache, Gheorghe Sovaiala, Alina Iolanda Popescu, Stefan-Mihai Sefu, and Kati Pavel</i>	
Mechanical Design and Simulation of Electric Vehicles for Sustainable Mobility	737
<i>Dániel Nemes and Sándor Hajdu</i>	
Machine Learning Model for Detection of Extraneous Vibrations in 3D Printing Process	747
<i>Paweł Tomiło, Dariusz Majerek, Dariusz Mazurkiewicz, and Jarosław Pytka</i>	
Design and Compressive Strength Analysis of a Bio-Inspired Cell-Based Lattice	757
<i>Elena Angeleska, Blagoja Nestorovski, Nikola Avramov, and Jelena Djokikj</i>	
Probabilistic Modelling of Corrosive Wear in Bulkhead Panels for Bulk Carriers	767
<i>Nataša Kovač and Špiro Ivošević</i>	
Measurement Results Comparison Between CMM Measuring and Geometry Scanning on the 3D Printing Product	777
<i>Almira Softić, Hazim Bašić, Kenan Baljić, Sabina Serdarević-Kadić, and Kenan Varda</i>	
Material Analysis for Reduced-Order Model of Rubber Mount Dynamic Properties	787
<i>Jan Danko, Martin Bernáth, Luboš Magdolen, Tomáš Milesich, and Igor Krjak</i>	
Mechatronics and Robotics: Design, Kinematics and Dynamics	
Kinematic Analysis of a 3-PRPS Type Parallel Manipulator	801
<i>Zhumadil Baigunchekov, Med Amine Laribi, Giuseppe Carbone, Rustem Kaiyrov, Wang Xuelin, Li Qian, and Abzal Kassinov</i>	
Design and Fabrication of Cycloidal Drive Using FDM 3D Printer	809
<i>Malik Čabaravdić, Kenan Varda, Amer Sarajlić, and Haris Lulić</i>	

Quality Engineering and Management

The Use of Artificial Intelligence in Industrial Management	819
<i>Goga Alexandru Silviu</i>	

International Cooperation of Bosnia and Herzegovina Within the Framework of the Agreements on the Recognition of Metrology Services	829
<i>Haris Memić, Šejla Ališić, and Almira Softić</i>	

The Improvement of Industrial Products Quality Through Six Sigma Method Implementation	841
<i>Dorin-Ion Dumitrascu, Alexandru-Nicolae Rusu, and Adela-Eliza Dumitrascu</i>	

Ecology, Ergonomics, Energy Efficiency, Environment Protection, Safety and Health at Work

Medical Disinfection Robots. A Review on Disinfection Methods	853
<i>Elida-Gabriela Tulcan, Carmen Sticlaru, Narcis-Grațian Crăciun, Florina Pop, and Erwin-Christian Lovasz</i>	

Investigation of the Gasoline Engine Performance and Emissions Working on N-Butanol-Gasoline Blends	861
<i>Simeon Iliev and Ivailo Ivanov</i>	

Alternative Fuel Options for Internal Combustion Engines	872
<i>Sorin Aurel Rațiu, Diana Monica Stoica, Ana Josan, and Camelia Pinca-Bretotean</i>	

Potential Solutions for Improvement of the Thermal Conditions in a Bus Passenger Compartment	882
<i>Dragan Ružić, Nebojša Nikolić, and Dalibor Feher</i>	

Lubricants for Internal Combustion Engines and Transmission Oils for Hybrid Vehicles: An Overview	890
<i>Diana Miruna Armioni, Ioana Ionel, Sorin Aurel Rațiu, and Adrian Gidali</i>	

Applying Ergonomics to Increase Job Sustainability in the Face of Labour Market Changes	900
<i>Petra Marková, Vanessa Prajová, and Peter Košťál</i>	

Multi-purpose Utilization of Rainwater in a Hilly Settlement Near Lake Velence	910
<i>Attila Kálmán and Katalin Bene</i>	

Energy Efficiency of the Electric Drive System of a Passenger Car Under Normal Operation Conditions	921
<i>Jarosław Mamala, Mariusz Graba, and Patryk Stasiak</i>	
Total Cost of Ownership and Future Challenges with Different Powertrain Types	933
<i>Milja Simeunović, Pavle Pitka, Milan Simeunović, Tatjana Kovačević, and Dejan Kolečka</i>	
Developmental Research in the End-Of-Life Vehicle Materials Recycling System	939
<i>Dorota Czarnecka-Komorowska, Wiktoria Kanciak, Jakub Hajkowski, Waldemar Matysiak, and Lucia Knapčíková</i>	
 Academic and Mechanism Education and History of MMS	
E-learning Platform for Information Technology in Business Management	949
<i>Vanessa Prajová, Filip Praj, Peter Košťál, and Mária Homokyová</i>	
Generic Core and Soft Skills for Maritime Industry 4.0: A Conceptual Framework	959
<i>Senka Šekularac-Ivošević</i>	
Problems and Dilemmas with Mechanism Preservation: Petrovaradin Clocktower Mechanism Case Study	968
<i>Dijana Čavić, Radoslav Tomović, and Maja Čavić</i>	
Author Index	979



Theoretical Research on Transient Process in Hydraulic Cylinder with Conical Cushioning Devices

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Abstract. Hydraulic cylinders are devices that very often move large masses with high potential energy at high speeds. Abrupt stopping at its end positions, the hydraulic cylinders may damage or destroy itself or the whole system. To prevent the hydraulic system from damaging, the incorporation of the cushioning devices is introduced in the design of the hydraulic cylinder to help smoothly stop at the end position. In this work a mathematical model of a conical cushioning device in vertically mounted hydraulic cylinder is developed and simulated the transient process at the end of its stroke.

Keywords: Hydraulic Cylinder · Cushioning · Transient Process

1 Introduction - Theoretical Background

High speed of hydraulic cylinders in combination with large moving masses can release large amounts of energy when the rod reaches the end position, which might destroy the hydraulic cylinder. In such cases, hydraulic cylinders with cushioning might be required which reduces the speed to the desire value. Ideally, a constant reduction of the velocity is desired. The cushioning design used should accomplish this objective with effectiveness in all of the operating ranges of the cylinder at the minimum pressure.

Many authors have researched the transient process in hydraulic cylinders at the end of its stroke. In [1] dynamic models are developed for describing the cylinder cushioning systems that when solved numerically predicts the pressure and velocity responses of the cylinder with time. The study includes modeling of cushion profiles and performing analytical analysis for achieving a constant deceleration during the cushioning phase. It has been observed that the performance of the cushion is highly sensitive to variations in the spear shape profile. A cushioning device with more intricate and complicated structure with 9 steps using CFD analysis method is presented in [2]. The CFD model can be helpful for analyzing the flow field in cushion chamber. In [3] a mathematical model for horizontally mounted cylinder with cushioning from the piston side has been developed and numerically solved. Few proposals have been given for improvement of the transient process. The work [4] describes the theoretical-experimental study of an

auto-adjustable stroke end cushioning device utilized in hydraulic cylinders, focusing the characterization of the bush geometry effect on the cushioning achieved. A nonlinear model is presented which includes the physical phenomena that exert a significant influence on the performance of this hydraulic component such as: friction, fluid compressibility and pressure energy loss in the cushioning section. The model is validated through the comparison between theoretical and experimental results, under different conditions of load, supply pressure and piston speed.

The work [5] performed a study of mechanical cushioning systems at the end of stroke of hydraulic linear actuators, analyzing various geometries (cylindrical, conical, double conical, etc.) with the objective of establishing a simulation mathematical model, being validated through experimental results. In [6] a relatively simple cushioning is presented. Its operation principle is the modulation of geometry of the discharge orifice (ports of the cylinder) using the piston body. Thus, once the piston reaches the ports, the outlet section is restricted, providing high impedance to flow around the interspace between the piston and the internal cylinder wall. Consequently, an increase of the pressure and a deceleration force are generated. Using Bond graph method, the solution of the theoretical mathematical model is presented and also CFD simulation of the flowing process has been done. Experimental records approved the obtained results by dynamic simulation.

The principal of operation of the cushioning theoretically researched in this paper has been shown on Fig. 1. Smooth stopping at the end of the cylinder stroke is performed by cushioning devices built into its covers [7]. Upon reaching the distance L_d before the end of the stroke, a specially shaped protrusion to the piston closes a certain space from the return area of the cylinder, forcing the oil from this chamber to pass through a throttle with section area A_{ds} . The pressure in the enclosure chamber increases to p_d , creating a braking force. The deceleration is determined by the size of the throttle section area A_{ds} during the braking distance L_d .

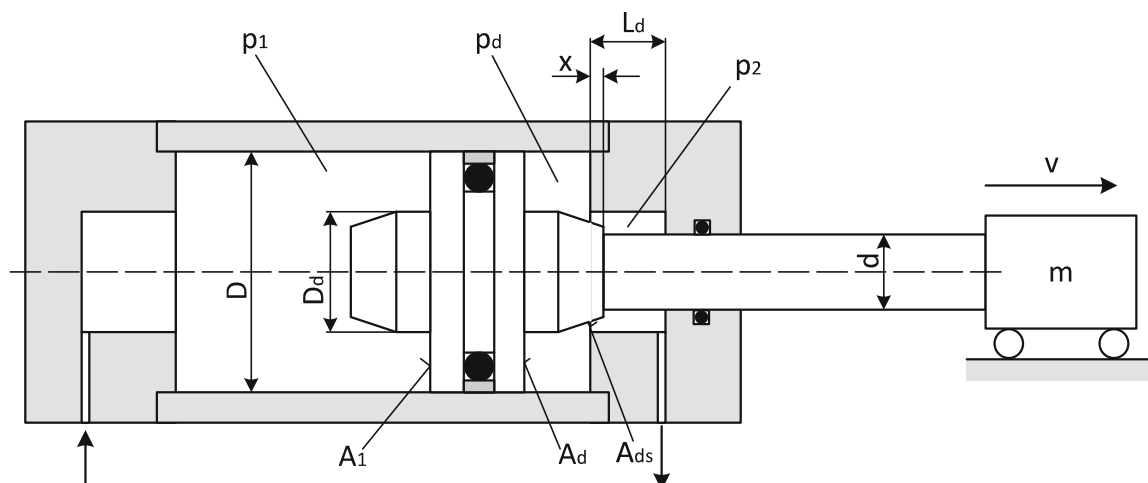


Fig. 1. Cushioning device in hydraulic cylinders.

2 Mathematical Modeling of a Cone Cushioning Device for Vertically Mounted Hydraulic Cylinder

The subject of this research is mathematical modeling and simulation of the transient processes when a vertically placed hydraulic cylinder stops at the end of its stroke. The hydraulic cylinder with piston diameter D_b and rod diameter d is vertically mounted (Fig. 2). At the end of its rod a mass m is hanged which tends to move vertically under the influence of gravitational force. At the rod side chamber of the cylinder there is a restrictor r_0 to control the mass velocity v , i.e. to exert a counter – pressure p_d ($p_2 = p_d$ in stationary motion) to prevent the mass m from falling uncontrollably. When the piston rod comes to a distance L_d (Fig. 1) to the end stroke, a special shape of the rod, so-called cushioning device begins to enter into the sleeve made in the cylinder head. At that moment the cushioning process begins.

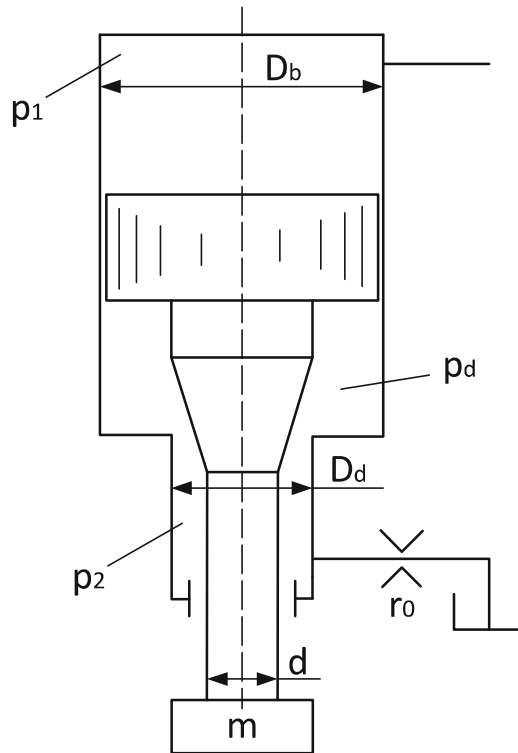


Fig. 2. Vertical hydraulic cylinder with cushioning device.

On Fig. 3 a conical, concentric gap formed between a conical cushioning device of length L_d and a cylindrical sleeve with diameter D_d is presented. The height of the gap at the beginning of the cone is h_1 , and at the end the cushioning device ends with a cylindrical shape of length L_z and constant height of the gap h_k .

In vertical position of the cylinder with mass m at its rod end and initial speed v_0 , assuming laminar flow and neglecting the compressibility of the oil, the differential equation describing the motion of the mass has the form [7]:

$$m \frac{dv}{dt} = m \cdot g - p_d \cdot A_d - p_2 \cdot A_{ds} \quad (1)$$

and

$$p_2 \cdot A_2 = r_0 \cdot A_2^3 \cdot v^2 \quad (6)$$

Inserting Eq. 5 in Eq. 6 and then in Eq. 2, we deduce:

$$m \frac{dv}{dt} = m \cdot g \cdot \left(1 - \frac{v^2}{v_0^2}\right) - p_{d,2} \cdot A_d \quad (7)$$

2.1 Mathematical Modelling of the Flow in the Conical Gap

Assuming incompressible laminar flow in the gap, equilibrium of forces on a fluid particle, Fig. 4-a, gives [9–11]:

$$\frac{dp_{d,2}}{dx} = \eta \cdot \frac{d^2v}{dz^2}$$

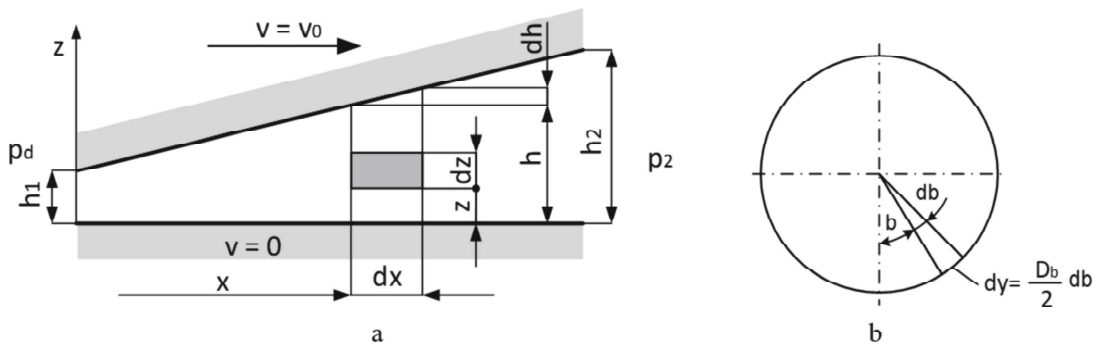


Fig. 4. Part of the conical gap.

Integrating twice, it gives

$$v = \frac{1}{2\eta} \cdot \frac{dp_{d,2}}{dx} \cdot z^2 + C_1 \cdot z + C_2 \quad (8)$$

Using the boundary conditions $v = v_0$ at $z = h$ and $v = 0$ at $z = 0$, the constants C_1 and C_2 can be solved:

$$C_1 = \frac{v_0}{h} - \frac{1}{2 \cdot \eta} \cdot \frac{dp_{d,2}}{dx} \cdot h$$

$$C_2 = 0$$

Substituting them in the Eq. (8), the velocity profile in the cone gap will be:

$$v = \frac{1}{2 \cdot \eta} \cdot \frac{dp_{d,2}}{dx} \cdot (z^2 - z \cdot h) + \frac{v_0 \cdot z}{h} \quad (9)$$

The flow through the conical gap will be:

$$\frac{dq}{dy} = \int_0^h v \cdot dz = -\frac{h^3}{12 \cdot \eta} \cdot \frac{dp_{d,2}}{dx} + \frac{v_0 \cdot h}{2} \quad (10)$$

Substituting $dy = \frac{D_d}{2} \cdot d\beta$ – Fig. 4-b, in (10) and integrating it around the circle from 0 to 2π , the pressure drop through the conical gap will be:

$$\frac{dp_{d,2}}{dx} = -\frac{12 \cdot \eta \cdot q}{\pi \cdot D_d \cdot h^3} + \frac{6 \cdot \eta \cdot v}{h^2} \quad (11)$$

The solution of the differential Eq. (11) for a laminar flow in a conical concentric gap with variable length x and $q = A_d \cdot v$ has the form:

$$p_{d,2} = \frac{6 \cdot \eta \cdot A_d \cdot v}{\pi \cdot D_d} \cdot \frac{x \cdot (h_1 + h_2)}{h_1^2 \cdot h_2^2} - \frac{6 \cdot \eta \cdot v \cdot x}{h_1 \cdot h_2} \quad (12)$$

where η – the dynamic viscosity.

The second component $\left(-\frac{6 \cdot \eta \cdot v \cdot x}{h_1 \cdot h_2}\right)$ in (14) is due to the entrained fluid from the surface of the cushioning device. It can be neglected compared to the first component, as it is about 100 times smaller. Thus the pressure drop $p_{d,2}$ depending on the speed v and the displacement x of the cushioning device, acquires the form

$$p_{d,2} = \frac{6 \cdot \eta \cdot A_d \cdot v}{\pi \cdot D_d} \cdot \frac{x \cdot (h_1 + h_2)}{h_1^2 \cdot h_2^2} \quad (13)$$

The pressure loss $p_{d,2}$ in the cylindrical concentric constant gap with height h_k in the second section of the cushioning will be

$$p_{d,2} = \frac{12 \cdot \eta \cdot A_d \cdot v \cdot [x - (L_d - L_z)]}{\pi \cdot D_d \cdot h_k^3} \quad (14)$$

The height of the gap h between the conical shape of the cushioning device and the cylindrical sleeve is not constant and depends on the displacement x of the cylinder and the slope of the cone $k = \frac{h_0}{L_d - L_z}$ and is determined by the expression

$$h = h_0 \cdot (1 - k \cdot x) \quad (15)$$

The heights in the conical gap of length x , in which the pressure drop $p_{d,2} = p_d - p_2$ is created, have the form

$$\begin{aligned} h_1 &= h_k + h_0 = h_0 \left(1 + \frac{h_k}{h_0}\right) = h_0 \cdot a_1 \\ h_2 &= h_k + h(x) = h_0 \left(1 + \frac{h_k}{h_0} - \frac{k}{h_0} \cdot x\right) = h_0 \cdot (a_1 - b \cdot x) \end{aligned} \quad (16)$$

where the constants are: $a_1 = 1 + \frac{h_k}{h_0}$; $b = \frac{k}{h_0} = \frac{1}{L_d - L_z}$.

Taking into account dependencies (16) and moving to the dimensionless coordinates: $V = \frac{v}{v_0}$ – the dimensionless velocity; $X = \frac{x}{L_d}$ – the dimensionless displacement; $\tau = \frac{t}{T}$ – the dimensionless time, where $T = \frac{L_d}{v_0}$ – the time constant; the cushion differential Eq. (7) takes the form

$$\frac{dV}{d\tau} = A \cdot (1 - V^2) - B \cdot V \cdot C(X) \quad (17)$$

where: $A = \frac{g \cdot T}{v_0} = \frac{g \cdot L_d}{v_0^2}$ and $B = \frac{6 \cdot \eta \cdot A_d^2 \cdot L_d^2}{\pi \cdot D_d \cdot h_0^3 \cdot v_0 \cdot m}$. $C(X)$ is a function of the displacement X and changes during the motion process, depending on the design of the cushioning device.

The scope of research in this work is a cushioning device with a conical shape with length $L_d - L_z$ and a cylindrical shape with length L_z , entering into sleeve with a length L_d equal to the sum of the lengths of the conical and cylindrical shapes.

a – First section when $x \leq L_d - L_z$.

When the conical part of the cushioning device $L_d - L_z$ enters the sleeve with length X , and the differential Eq. (17) will be

$$\frac{dV}{d\tau} = A \cdot (1 - V^2) - B \cdot V \cdot X \cdot \frac{(2 \cdot a_1 - b_1 \cdot X)}{a_1^2 \cdot (a_1 - b_1 \cdot X)^2} \quad (18)$$

where $a_1 = 1 + \frac{h_k}{h_0}$ and $b_1 = \frac{L_d}{L_d - L_z}$.

b – Second section when $L_d - L_z < x \leq L_d$.

When the cylindrical part of the cushioning device with the length L_z enters the sleeve and the differential Eq. (17) will be:

$$\frac{dV}{d\tau} = A \cdot (1 - V^2) - B \cdot V \cdot \frac{2}{(a_1 - 1)^2} \cdot \left[\frac{X - \frac{1}{b_1}}{a_1 - 1} + \frac{2 \cdot a_1 - 1}{2 \cdot a_1^2 \cdot b_1} \right] \quad (19)$$

3 Simulation of the Transient Process of the Cylinder

The solution of the differential Eqs. (18) and (19) represents the simulation of the transient process of the moving mass. The design parameters are the following: the moving mass $m = 30000\text{kg}$, the initial speed $v_0 = 0.0617\text{m/s} = 3.7\text{m/min}$, the oil kinematic viscosity $\nu = 46\text{cSt}$, the piston diameter $D_b = 0.25\text{m}$, the rod diameter $d = 0.11\text{m}$, the diameter of the cushioning device $D_d = 0.145\text{m}$, the length of the cushion $L_d = 0.35\text{m}$, the maximal height of the gap $h_0 = 0.001\text{m} = 1\text{mm}$, the length of the cylindrical section of the cushion $L_z = 0.12\text{m} = 120\text{mm}$, the height of the gap in the cylindrical section $h_k = 0.00012\text{m} = 0.12\text{mm}$.

For solving of the nonlinear differential equations, the adaptive Runge-Kutta method is used. This method based on the forth order Runge-Kutta method estimate the truncation error at each integration step and automatically adjust the time step size to keep the error within specified limits.

The solution of the differential Eqs. (18) and (19) and the transient process of the researched cylinder at the end of its stroke is presented at the diagrams on Figs. 5 and 6.

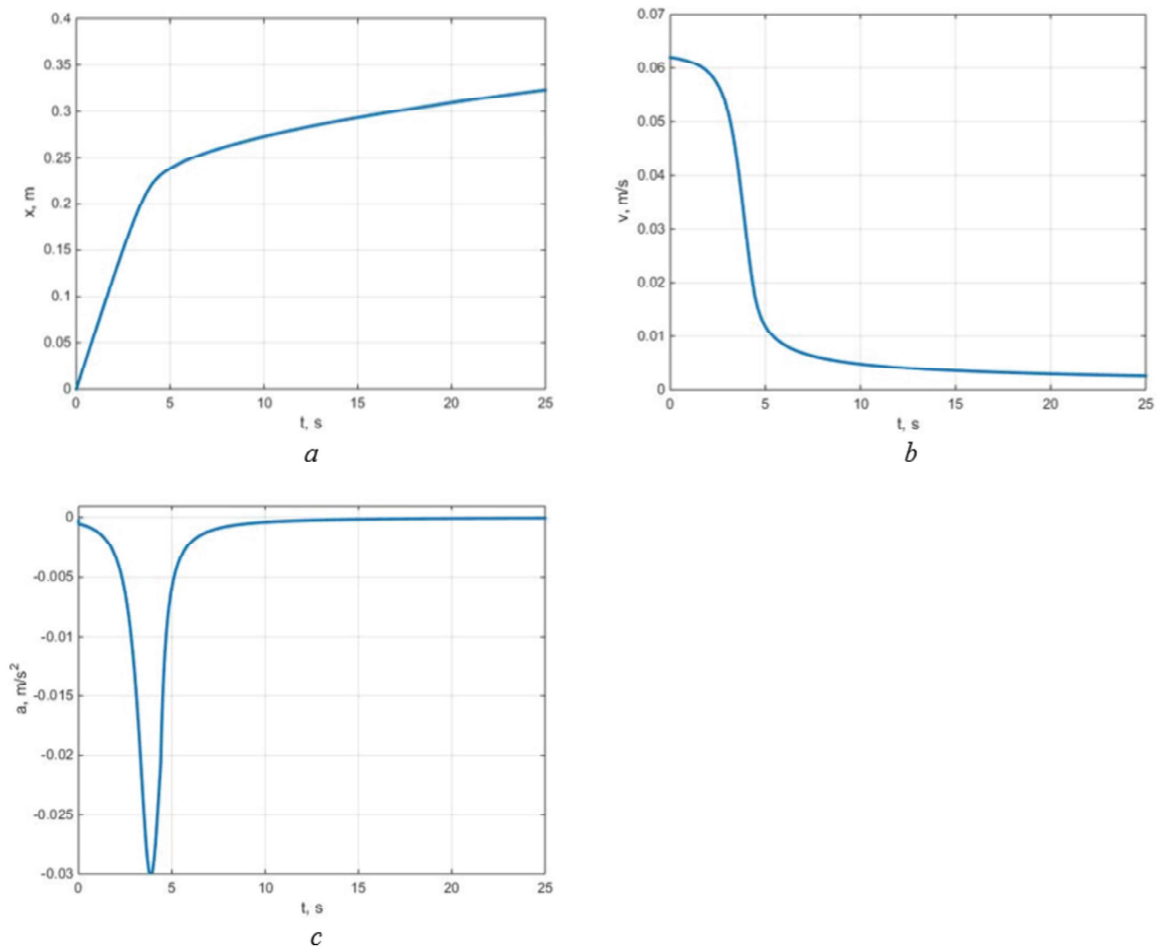


Fig. 5. Transient process in terms of time.

Maximum deceleration is $a_{max} = 0.03 m/s^2$ – Fig. 5 – c. So, the hydraulic cylinder is loaded with additional inertial force of $F_a = m \cdot a_{max} = 900 N$. This force can be neglected compared with the mass m . After 10 s of the beginning of the cushioning process, the speed is reduced to the value of $v = 0.005 m/s$ which is 12.5 times lower than state-state speed v_0 and at the end of the cushioning process the speed is $v = 0.002 m/s = 2 mm/s$ which meets the requirements of the process quite satisfactorily.

Maximum deceleration occurs at a stroke of $0.22 m$ – Fig. 6. At that moment the speed is $v = 0.032 m/s$, it is half of the steady-state value v_0 . At the distance of $0.23 m$ when the whole cone shape is inside the sleeve and the cylindrical shape begins to enter the sleeve, the actual speed of the cylinder rod is around $v = 0.015 m/s$ which is more than four times lower than the steady-state value of $v_0 = 0.0617 m/s$.

In stationary mode, before beginning the cushioning, the pressure $p_2 = p_d$ is around 74 bar – Fig. 7. It is a sufficient value to counterbalance the moving mass and to ensure it from falling uncontrollably. When the cushioning process begins, i.e. cone shape starts to enter into cylindrical sleeve, the pressure p_d is increasing to its final value of around 88 bar. The pressure p_2 is decreasing during the movement of the cushioning device into the sleeve and at the end of the stroke it is near zero.

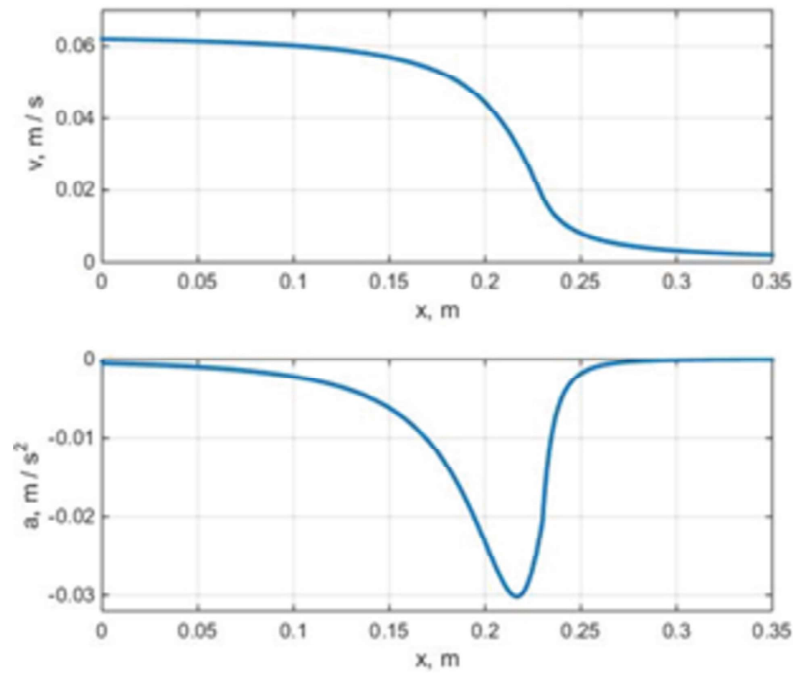


Fig. 6. Transient response in terms of cylinder stroke.

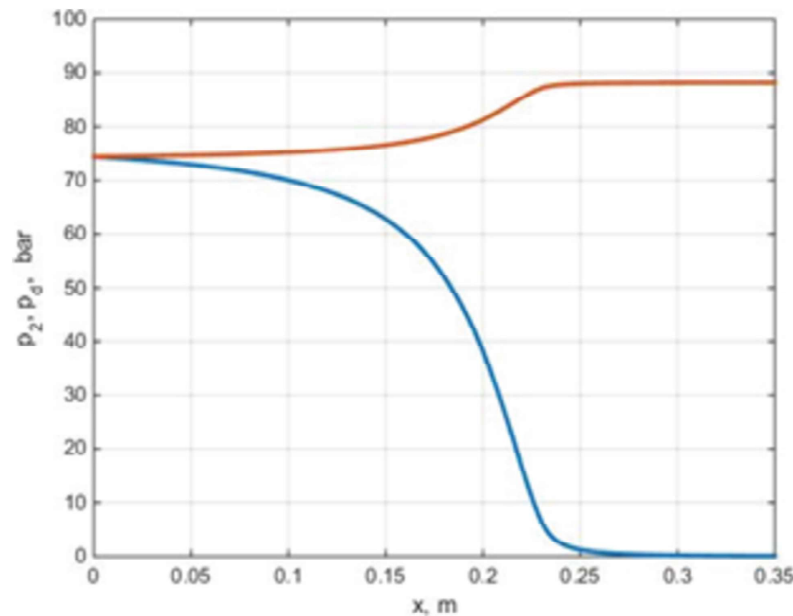


Fig. 7. Pressure distribution along the stroke.

4 Conclusion

Hydraulic cylinders are devices that very often move huge masses with high potential energy at high speeds. Abrupt stopping at its end positions, the hydraulic cylinders may damage or destroy itself or the whole system. To prevent the hydraulic system from damaging, the incorporation of the cushioning devices is introduced in the design of the hydraulic cylinder to help smoothly stop at the end position.

In this work a mathematical model of a conical cushioning device in hydraulic cylinders is developed and simulated the transient process at the end of its stroke. The proposed cushioning device ensures smooth deceleration at the beginning and at the end of the transient process with relatively low additional overload on the hydraulic cylinder as a result of the deceleration – Fig. 5. This type of cushioning provides good cylinder speed profile in time without pressure peaks in the cylinder chambers – Figs. 6 and 7.

As it was presented in the diagrams above, including cushioning devices in hydraulic cylinders is essential when they move large masses with high speeds to absorb the high potential energy when they stop.

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