

Contents

Preface	V
About the Authors	IX
1 Introduction	1
1.1 Historical Background	1
1.2 Fiber-Reinforced Composites	7
1.3 Lightweighting in Automotive Applications	12
1.4 Background and Challenges in Designing with Discontinuous Fibers ...	20
1.5 Structure and Objectives of this Book	23
References	26
2 Materials	29
2.1 Reinforcing Phase	29
2.1.1 Particle-Reinforced Composites	30
2.1.2 Continuous Fibers	31
2.1.2.1 Woven Fabrics	31
2.1.2.2 Braiding	33
2.1.3 Discontinuous Fibers	34
2.1.4 Sizing	36
2.2 Matrix	37
2.2.1 Thermoplastics	37
2.2.1.1 Amorphous Thermoplastics	43
2.2.1.2 Semi-crystalline Thermoplastics	45
2.2.2 Thermosets	47
2.2.2.1 Curing Reaction	50
References	57

3	Manufacturing Processes	59
3.1	Fiber-Reinforced Thermoset Molding Processes	59
3.1.1	Compression Molding of Sheet Molding Compound	60
3.1.2	Injection-Compression Molding of Bulk Molding Compound	64
3.2	Fiber-Reinforced Thermoplastics	65
3.2.1	Injection Molding	66
3.2.2	Extrusion Compression Molding	76
3.2.3	GMT Compression Molding	78
3.3	Additive Manufacturing	80
3.4	Vacuum Bagging Techniques	83
3.4.1	Fiber Spray-up Molding	83
3.4.2	Hand-Layup Molding	84
3.4.3	Vacuum-Assisted Resin Infusion	85
3.4.4	Resin Transfer Molding Techniques	88
3.5	Processes Involving Hybrid Structures	93
	References	94
4	Microstructure in Discontinuous Fiber-Reinforced Composites	95
4.1	Process-Induced Microstructure in Discontinuous Fiber-Reinforced Composites	95
4.1.1	Fiber Attrition	96
4.1.2	Fiber Alignment	101
4.1.3	Fiber-Matrix Separation	106
4.1.4	Fiber-Matrix Bonding	110
4.1.5	Microstructure-Property Relationship	111
4.2	Characterization Techniques for Fiber Microstructure Analysis	115
4.2.1	Measuring Fiber Orientation	116
4.2.2	Review of Fiber Length Measurement Methods	129
4.2.2.1	Comparative Study of Measurement Techniques	139
4.2.3	Measuring Fiber Concentration	145
4.2.4	Fiber Microstructure Characterization Conclusions	151
4.3	Case Study: LFT Injection Molding of a Simple Plaque Geometry	153
4.3.1	Analysis of the Process-Induced Fiber Alignment	156
4.3.2	Analysis of the Process-Induced Fiber Breakage	158
4.3.3	Analysis of the Process-Induced Fiber Concentration	160
4.3.3.1	Flow Front Analysis	163
4.3.4	Discussion and Conclusions	166
	References	172

5	Mechanics of Composites	177
	<i>Paul V. Osswald and Tim A. Osswald</i>	
5.1	Anisotropic Strain–Stress Relation	178
5.2	Laminated Composite	179
5.2.1	Equilibrium, Deformation, and Constitutive Equations	180
5.2.2	Transverse Properties—The Halpin-Tsai Equation	181
5.2.3	Transformation of Fiber-Reinforced Composite Laminate Properties	184
5.2.4	Sample Application of a Laminated Composite	187
5.3	Discontinuous Fiber-Reinforced Composites	190
5.3.1	Sample Application of Critical Length for Load Transfer	193
5.3.2	Reinforced Composite Laminates with a Fiber Orientation Distribution Function	197
5.4	Failure of Fiber-Reinforced Composites	198
5.4.1	Failure of an Axially Loaded Laminate	198
5.5	Failure Criteria for Composites with Complex Loads	200
5.5.1	Maximum Stress Failure Criterion	201
5.5.2	Tsai-Hill Failure Criterion	203
5.5.3	A New Strength Tensor Based Failure Criterion with Stress Interactions	205
	References	215
6	Modeling and Simulation of Discontinuous Fiber-Reinforced Composites	217
6.1	Introduction to Finite Element Methods (FEM)	217
6.1.1	Basic Concept of FEM	218
6.1.2	Status of FEM in the Industry	226
6.2	Key Challenges in Using FEM for Fiber-Reinforced Polymers	227
6.3	Modeling Discontinuous Fiber-Reinforced Materials for FEM Implementation	232
6.3.1	Macro Scale or Phenomenological Modeling	233
6.3.2	Micro Scale Modeling	234
6.3.2.1	Mean Field Homogenization	240
6.3.2.2	Representative Volume Element (RVE) Using a Finite Element Approach	242
6.3.2.3	Generalized Method of Cells	244
6.3.2.4	Repetitive Unit Cell (RUC)	246
6.3.3	Multiscale Modeling	248

6.4	Survey of Existing Options in Multiscale Modeling of Fiber-Reinforced Material	252
6.5	Comments and Guidance	253
	References	255
	Appendix	256
7	Process Simulation for Discontinuous Fibers	261
	<i>Huan-Chang Tseng, Jim Hsu, Anthony Yang, Sebastian Goris, Yu-Yang Song, Umesh N. Gandhi, and Tim A. Osswald</i>	
7.1	Modeling Fiber Motion During Processing	261
7.2	Process Simulation	261
7.2.1	Injection Molding	262
7.2.1.1	Mathematical Models and Assumptions	262
7.2.1.2	Numerical Method	264
7.2.2	Compression Molding	266
7.2.3	Discussion on Key Challenges in Simulation of Compression Molding	268
7.2.3.1	Key Challenges in Compression Molding Simulation Using a Bulk Charge	273
7.2.3.2	Key Challenges in Compression Molding Simulation Using Sheet Charge	274
7.3	Fiber Modeling	277
7.3.1	Fiber Orientation	277
7.3.1.1	Folgar-Tucker Model	277
7.3.1.2	RSC Model and ARD-RSC Model	278
7.3.1.3	iARD-RPR Model	280
7.3.2	Fiber Breakage	281
7.3.3	Fiber Concentration	283
7.4	Fiber Configuration Prediction	286
7.4.1	Fiber Orientation and Fiber Breakage	286
7.4.2	Fiber Concentration	294
7.5	Direct Fiber Simulation	297
7.5.1	Application Example: Fiber Orientation Evolution during Compression Molding	302
7.6	Conclusions	305
7.7	Future Challenges	305
	References	307

8	Case Studies to Demonstrate Application of Multiscale Modeling for Fiber-Reinforced Polymers	311
8.1	Study of Effect of Manufacturing Process on Flat Plaques	312
8.1.1	Plaque Manufacturing Details	312
8.1.2	Effect of Manufacturing Process on Plaque Properties	314
8.2	Multiscale Finite Element Simulation for the Fiber-Reinforced Flat Plaques	326
8.2.1	Details of the Finite Element Model	331
8.2.1.1	Process Simulation Model	331
8.2.1.2	Structure Simulation Model	334
8.2.1.3	Discussion on How to Choose the Modeling Details	335
8.2.2	Simulation Results for the Plaques	338
8.2.3	Discussion on Applying the Multiscale Simulation	341
8.2.4	Comments on Limitations of the Approach	349
8.3	Warpage Study for a Flat Plaque	350
8.3.1	Discussion on Mechanism of Warpage	351
8.3.2	Detail of the Plaques	353
8.3.3	Prediction Method Approach	355
8.3.4	Mechanical Material Properties Calculations Using Reverse Engineering	359
8.3.5	Finite Element Analysis to Calculate Warpage	365
8.3.6	Comments and Limitations	367
	References	368
9	Special Topic: Compression Molding of Discontinuous Fiber Material	371
9.1	Compression Molding of Bulk Materials	374
9.1.1	Example 1: Single-Cavity Glass Fiber-Reinforced Polymer (GFRP) Part	375
9.1.1.1	Actual Part Manufacture	375
9.1.1.2	Fiber Orientation Mapping Approach	377
9.1.1.3	Mapping Algorithm	379
9.1.1.4	Demonstration of Effect of Initial Charge Orientation in the CAE Model	381
9.1.1.5	Comments and Conclusions	385
9.1.2	Example 2: Three-Cavity Carbon Fiber-Reinforced Plastic (CFRP) Sample	385
9.1.2.1	Actual Part Manufacture	386
9.1.2.2	Material Properties Measurements	387
9.1.2.3	Development of Model for CAE	388
9.1.2.4	Comparison between Simulation and Experiments	390
9.1.2.5	Comments and Conclusions	396

9.2	Compression Molding of Sheet Materials	396
9.2.1	Actual Part Manufacturing	397
9.2.2	Measurement of Material Properties of the Sheet Material	401
9.2.2.1	Material Structural Properties	401
9.2.2.2	Sheet/Mat Properties for the Mold Filling Analysis	402
9.2.3	CAE Simulation for the Compression Molding of Mats	403
9.2.3.1	Draping Analysis Using LS-DYNA	403
9.2.3.2	Compression Molding Analysis with Moldex3D	405
9.2.3.3	Comparison between Simulation and Experiments	406
9.2.4	Comments and Conclusions	410
9.3	Compression Molding of GMT Material	411
9.3.1	Discussion on GMT and Approach	412
9.3.2	Actual Part Manufacturing	413
9.3.3	Finished Parts Properties Measurements	414
9.3.4	FEA Analysis	417
9.3.4.1	Compression Molding Process Simulation	417
9.3.4.2	Non-linear Structural FEA Simulation for the Tensile and Bending Test	422
9.3.5	Comments and Conclusions	429
	References	429
10	Special Topics in CAE Modeling of Composites	433
10.1	Mixed or Hybrid Fiber-Reinforced Material Modeling	433
10.1.1	Study Detail	434
10.1.2	Tensile and Bending Test Comparison	435
10.1.3	Finite Element Modeling for the Hybrid Material	437
10.1.4	Comparison of Simulation Result with the Measurement	439
10.1.5	Conclusion for Hybrid Material Modeling	441
10.2	Adhesive Joining Modeling	442
10.2.1	Background of Adhesive Modeling in Finite Element Models	444
10.2.2	Sample Preparation and Testing	445
10.2.3	Lap Shear Test	446
10.2.4	Peel Test	447
10.2.5	Complex Shaped Part Test	448
10.2.6	Modeling and Simulation	449
10.2.7	Lap Shear FE Model	451
10.2.8	Peel Test FEM Modeling	452
10.2.9	Complex Shaped Part FEA Modeling	455
10.2.10	Conclusions for Adhesive Joining	457
	References	458
	Index	461