Contents

Preface VII

1 Introduction 1

1.1 Discontinuous Fiber Composites 1
1.2 Processing, Microstructure and Properties 2
1.3 Computer-Aided Engineering Workflow 5
1.4 Scope and Organization of the Book 8
1.5 Accompanying Software 9

2 Describing Fiber Orientation and Fiber Length 11

2.1 Single Fiber Orientation 11
2.2 Distributions of Fiber Orientation 12
2.2.1 Planar Orientation 12
2.2.1.1 Matching ψ_ϕ to Data 13
2.2.2 Three-Dimensional Orientation 14
2.3 Orientation Tensors 16
2.3.1 Introduction 16
2.3.2 Relationship to the Distribution Function 20
2.3.3 Properties of the Orientation Tensor 22
2.3.4 Principal Directions and Principal Values 23
2.3.4.1 Properties of Eigenvalues and Eigenvectors 24
2.3.4.2 Relationship to Coordinate Transformation 25
2.3.4.3 Indeterminate Eigenvectors 27
2.3.4.4 Numerical Details 28
2.3.5 The Fourth-Order Orientation Tensor 29
2.3.5.1 Contracted Notation 30
2.3.5.2 Examples 32
2.4 Reconstructing Distribution Functions 34
2.4.1 Planar Orientation 35
2.4.1.1 Fourier Series 35
2.4.1.2 Jeffery Distribution, Planar Orientation 36
2.4.1.3 Comparison of Planar Orientation Reconstructions 37

2.4.2 3-D Orientation 39
2.5 Fiber Length 40
2.6 Number-Average and Weight-Average Orientation 42
2.7 Chapter Summary 43

3 Measuring Fiber Orientation and Length 45
3.1 Planar Section Measurements of Orientation 45
3.1.1 Mathematical Principles 45
3.1.1.1 Correcting for Sample Bias 47
3.1.1.2 Ambiguous Angles and Ambiguous Tensor Components 51
3.1.1.3 Systematic Errors in θ 52
3.1.2 Practical Aspects of Measurement 53
3.1.2.1 Sample Preparation and Imaging 53
3.1.2.2 Image Analysis 54
3.1.2.3 Sample Size and Orientation 56
3.1.3 Example: Core/Shell Structures in Injection Molded Composites 57
3.1.4 Measurement Accuracy 58
3.2 Micro-CT Measurements of Orientation 62
3.2.1 Image Acquisition and Sample Size 62
3.2.2 Image Analysis 65
3.2.2.1 Voxel Orientations 65
3.2.2.2 Fiber Reconstruction 67
3.2.2.3 Example Data 68
3.2.2.4 Comparison of Image Analysis Schemes 69
3.2.2.5 Samples with Fiber Bundles or Platelets 69
3.3 Length Measurement 70
3.3.1 Destructive Sampling 70
3.3.2 Micro-CT Data for Length 73
3.4 Chapter Summary 75

4 Flow Orientation of Single Fibers 77
4.1 Flow Kinematics 77
4.1.1 Deformation Rate and Vorticity 77
4.1.1.1 Invariants and the Scalar Strain Rate 79
4.1.1.2 Basic Flows 79
4.1.2 Finite Deformation Measures 85
4.1.2.1 Displacement Functions 85
4.1.2.2 Deformation Gradient Tensors 86

4.1.2.3 Stretching of a Material Line 88
4.1.2.4 Basic Deformations 89
4.2 Jeffery's Equation 91
4.2.1 Rate Form 91
4.2.2 Example Solutions and the Two Rules of Fiber Orientation 93
4.2.2.1 Planar Orientation in Simple Shear 93
4.2.2.2 Planar Orientation in Planar Extensional Flow 95
4.2.3 Numerical Solutions 96
4.2.4 Particle Shape Factors 97
4.2.5 Jeffery Orbits 99
4.2.6 Strain-Time Scaling and Reversibility 101
4.2.7 Deformation Form 101
4.3 Orientation Patterns in Injection and Compression Molding 103
4.3.1 Two Rules that Explain Everything 103
4.3.2 Shell Layers in Injection Molding 104
4.3.3 Core Orientation in Injection Molding 105
4.3.4 Skin Layers and the Fountain Flow 108
4.3.5 The Mystery of Thick Plaques 110
4.3.6 Compression Molding 112
4.3.6.1 Lubricated Squeeze Flow 112
4.3.6.2 Non-Lubricated Squeeze Flow 114
4.4 Chapter Summary 116

5 Flow Orientation of Groups of Fibers 117

5.1 Jeffery's Equation for the Orientation Tensor 117
5.1.1 Derivation 118
5.1.2 Numerical Solution for a Material Point 119
5.1.3 Spatial Fields of Orientation 121
5.2 Solving for the Distribution Function 122
5.2.1 Planar Orientation 122
5.2.2 3-D Orientation 124
5.3 Isotropic Rotary Diffusion: The Folgar–Tucker Model 126
5.3.1 Planar Orientation Distribution Function 127
5.3.2 3-D Orientation Distribution Function 129
5.3.3 Tensor Equation 130
5.4 Closure Approximations 131
5.4.1 Quadratic, Linear and Hybrid Closures 131
5.4.2 Fitted Closures 132

5.4.2.1 Eigenvalue-Based Orthotropic Fitting 133
5.4.2.2 Invariant-Based Orthotropic Fitting 136
5.4.2.3 The Jeffery Distribution and the Natural Closure 137
5.4.2.4 Closures Using Numerical Distribution Function Solutions..... 140
5.4.3 Comparison of Closure Approximations 141
5.4.3.1 Equal Interaction Coefficients 142
5.4.3.2 Tuned Interaction Coefficients..... 143
5.4.3.3 Particle Shape Factor 144
5.5 Choosing the Value of the Interaction Coefficient 147
5.6 Anisotropic Rotary Diffusion..... 149
5.6.1 Motivation and Concept 149
5.6.2 General Equations 150
5.6.2.1 Tensor Equation..... 150
5.6.2.2 Distribution Function Equation 151
5.6.3 Choices for the Rotary Diffusion Tensor 152
5.6.3.1 Five-Constant Model 152
5.6.3.2 Folgar–Tucker Model 153
5.6.3.3 iARD Model 153
5.6.3.4 MRD and pARD Models..... 153
5.6.3.5 Wang or Two-Constant Model 154
5.6.4 Choosing ARD Model Parameters..... 155
5.7 Transient Orientation and Slow Kinetics Models 159
5.7.1 Motivation..... 159
5.7.2 SRF/Slip Model 161
5.7.3 Objective Models: RSC and RPR 163
5.7.4 Choosing the RSC or RPR Parameter 165
5.7.5 Combining Slow Kinetics with Anisotropic Rotary Diffusion 166
5.7.6 Flow-Type Dependence 167
5.7.6.1 Rationale 167
5.7.6.2 Models..... 168
5.7.6.3 Example 170
5.8 Chapter Summary 171

6 Suspension Rheology and Flow-Orientation Coupling 173

6.1 Basics of Constitutive Equations 173
6.1.1 Total Stress and Extra Stress 174
6.1.2 Newtonian fluid 174
6.1.3 Generalized Newtonian Fluid 175

6.1.4 Shear vs. Extensional Viscosity 175
6.2 Steady Shear Viscosity of Fiber Suspensions 176
6.2.1 Measurements and Typical Data 176
6.2.2 Relationship to Fiber Orientation 178
6.3 An Anisotropic Constitutive Equation for Fiber Suspensions 178
6.3.1 Fluid Motion Relative to the Fibers 178
6.3.2 Stress with Fully Aligned Fibers 180
6.3.3 Stress with Distributed Orientation 182
6.3.4 Theoretical Predictions for N_p 185
6.4 Solving Flow Problems 187
6.4.1 Governing Equations 187
6.4.2 Boundary and Initial Conditions 188
6.4.3 Solution Schemes: Coupled and Decoupled 189
6.4.4 Temperature Effects 189
6.5 Example Solutions 190
6.5.1 Axisymmetric Contraction 190
6.5.2 Anisotropic Squeeze Flow 192
6.6 Decoupled Flow as a Special Case 193
6.6.1 Center-Gated Disk 193
6.6.2 General Criteria for Decoupling 196
6.7 Orientation Dependent Isotropic Viscosity Model 198
6.8 Transient Rheological Experiments 200
6.8.1 Flow Geometries 200
6.8.2 Initial Fiber Orientation State 201
6.8.3 Comparing Models to Data 202
6.8.4 Insights from Transient Rheology Experiments 203
6.9 Chapter Summary 203

7 Fiber Length Degradation during Processing 205

7.1 Model Development 205
7.1.1 Conservation of Fiber Length 205
7.1.2 Breakage Rate and Unbreakable Length 207
7.1.3 Child Generation Rates 210
7.2 Effects of Model Parameters 212
7.3 Implementation in Mold Filling Software 216
7.3.1 Fiber Length in an End-Gated Strip 217
7.3.2 Comparison with Experiments 219
7.4 Chapter Summary 222

8 Mechanical Properties and Orientation 223
8.1 Anisotropic Elasticity 223
8.1.1 Stress and Strain 223
8.1.2 Stiffness and Compliance Tensors 224
8.1.3 Contracted Notation 225
8.1.4 Material Symmetries 227
8.1.5 Engineering or Technical Constants 228
8.2 Homogenization 231
8.2.1 General Principles 231
8.2.2 Two-Step Homogenization 234
8.3 Stiffness Estimates for Unidirectional Discontinuous Fiber Composites 235
8.3.1 Eshelby/Mori–Tanaka Model 235
8.3.2 Lielens/Double-Inclusion Model 236
8.3.3 Halpin–Tsai Equations 237
8.3.4 Numerical Analysis of an RVE 238
8.3.5 Comparison and Recommendations 239
8.4 Averaging Stiffness for Orientation and Length 242
8.4.1 Definitions and Notation 242
8.4.2 Types of Stiffness Averages 243
8.4.3 Computing Orientation Averages 244
8.4.4 Averaging over Fiber Length 247
8.4.5 Modeling the Layered Structure of Injection Moldings 249
8.5 Comparison to Experiments 251
8.6 Thermal Expansion 252
8.6.1 Definitions 253
8.6.2 First Homogenization Step 253
8.6.3 Second Homogenization Step 255
8.7 Nonlinear Stress-Strain Behavior 256
8.8 Chapter Summary 258

9 Current and Future Trends 261
9.1 Fiber Migration 261
9.1.1 Volume Fraction Variations in Injection Molded Parts 261
9.1.2 Shear-Induced Migration Phenomena 262
9.1.3 Modeling Shear-Induced Migration 264
9.1.4 Application to Injection Molding 267
9.1.5 Fiber/Matrix Separation in SMC and GMT 269

9.2 Direct Fiber Simulations 270
9.2.1 Overview 270
9.2.2 Simulation Methods 271
9.2.2.1 Representing the Fibers 271
9.2.2.2 Initial Configuration 272
9.2.2.3 Hydrodynamic Forces 272
9.2.2.4 Interaction Forces 273
9.2.2.5 Solution and Time Stepping 274
9.2.3 Applications 274
9.2.3.1 Parameter Identification 274
9.2.3.2 Full-Part Simulations 276
9.2.3.3 New Orientation Models 278
9.3 Chapter Summary 278

A Vectors and Tensors 281

A.1 Definitions and Notation 281
A.1.1 Scalars and Vectors 281
A.1.2 Tensors 282
A.1.3 Index Notation 283
A.1.4 Identity Tensors and the Kronecker Delta 283
A.1.5 Transpose and Symmetries 284
A.1.6 The Trace of a Tensor 284
A.2 Algebraic Operations 284
A.2.1 Addition and Subtraction 284
A.2.2 Multiplication 285
A.2.3 Magnitude of a Vector 286
A.2.4 Tensor Inverse 286
A.3 Coordinate Transformation 287
A.4 Contracted Notation 288
A.4.1 Definitions 288
A.4.2 Identity Tensor 289
A.4.3 Operations 290
A.4.4 Fourth-Order Inverse 291
A.4.5 Coordinate Transformation 291
A.5 Calculations in MATLAB 292
A.5.1 Vectors and Second-Order Tensors 292
A.5.2 Fourth-Order Tensors 293
A.6 **D** and **W** in Cylindrical Coordinates 294

B Derivations **295**
B.1 Jeffery's Equation for Planar Orientation and Planar Flow 295
B.2 Tensor Form of the Folgar–Tucker Model 296
B.2.1 Preliminaries 296
B.2.2 Separating the Jeffery and Diffusive Contributions 297
B.2.3 Diffusive Contribution to $\dot{\mathbf{A}}$ 297
B.3 Steady-State Orientation of RSC and RPR Models 298
B.4 Mechanical Property Equations 299
B.4.1 Eshelby Strain Concentration Tensor 299
B.4.2 Eshelby Dilute Stiffness Model 300
B.4.3 General Stiffness Equation 301
B.4.4 General Equation for Thermal Stress 301

Symbols and Abbreviations **303**

References **309**

Index **325**