

Table of Contents

Dedication	V
Acknowledgement	VII
Preface	XVII
1 Background	1
1.1 Plastics Industry Review	1
1.1.1 Manufacturing Productivity	1
1.1.2 Manufacturing Cost Breakdown.....	4
1.1.3 Characteristics of Productive Plastics Manufacturers.....	6
1.2 Manufacturing and Strategic Planning.....	8
1.2.1 Manufacturing Planning.....	8
1.2.2 Manufacturing System Design	11
1.2.3 Strategic Planning.....	13
1.3 Engineering Economics	16
1.3.1 Payback Period	18
1.3.2 Net Present Value	18
1.3.3 Internal Rate of Return	20
1.4 Summary	22
2 Plastics Manufacturing Systems	25
2.1 Overview of Plastics Processing.....	25
2.1.1 Extrusion	26
2.1.2 Blow Molding	27
2.1.3 Injection Molding.....	28
2.1.4 Thermoforming	29
2.2 Characteristics	30
2.2.1 Closed Loop Control	30
2.2.2 Open Loop Control	32
2.2.3 Dynamic Control	34
2.2.4 Control Modes	35
2.2.5 Control Architectures	37
2.2.6 Automatic Control	39
2.3 Performance Measurement	40
2.3.1 Dynamic Response.....	41
2.3.2 Repeatability	42
2.3.3 Productivity	44
2.4 Summary	46

3 Heating and Cooling	47
3.1 Specifications	47
3.1.1 Power Output	48
3.1.2 Actuator Efficiency	49
3.1.3 Linearity	50
3.1.4 Consistency	51
3.1.5 Failure Rate and Mode	52
3.1.6 Cost	53
3.1.7 Operating Requirements	54
3.2 Heating	56
3.2.1 Conduction Heaters	57
3.2.2 Radiant Heaters	61
3.2.3 Heater Controls	64
3.3 Cooling	68
3.3.1 Coolants	68
3.3.2 Coolant Temperature Controllers	70
3.4 Transient Analysis	73
3.4.1 Lumped Thermal Capacitance	73
3.4.2 Finite Thickness Model	78
3.5 Summary	82
4 Hydraulics and Pneumatics	85
4.1 Specifications	86
4.2 Pumps and Compressors	88
4.2.1 Gear Pump	90
4.2.2 Vane Pump	91
4.2.3 Piston Pump	92
4.3 Fluid Conditioning	94
4.3.1 Filters	94
4.3.2 Heat Exchangers	96
4.3.3 Accumulators	97
4.3.4 Relief Valves	99
4.3.5 Pressure Regulators	100
4.4 Actuators	102
4.4.1 Cylinders	102
4.4.2 Motors	106
4.5 Control Valves	108
4.5.1 Directional Valves	111
4.5.2 Metering Valves	112
4.6 Dynamic Analysis	116
4.6.1 Valve Dynamics	116
4.6.2 Fluid Dynamics	118
4.6.3 Machine Dynamics	121
4.7 Summary	123

5 Electric Drives	125
5.1 Introduction	125
5.1.1 Electromagnetism	125
5.1.2 Electromotive Forces	127
5.1.3 Common Motor Types	128
5.1.4 Typical Specifications	129
5.2 Linear Solenoids	130
5.3 DC Motors	133
5.3.1 DC Brushed Motors	133
5.3.2 DC Brushless Motor	134
5.3.3 Analysis	135
5.3.4 DC Motor Controls	138
5.4 AC Induction Motors	140
5.4.1 Design	141
5.4.2 Analysis	142
5.4.3 Behavior	145
5.4.4 AC Motor Controls	147
5.5 Other Motors	149
5.5.1 Stepper Motors	149
5.5.2 Linear Motors	152
5.6 Motor Specification Guidelines	153
5.7 Summary	155
6 Process Sensors	157
6.1 Specifications	157
6.1.1 Sensitivity, Responsivity, and Resolution	157
6.1.2 Response Time	159
6.1.3 Precision and Accuracy	161
6.1.4 Linearity and Hysteresis	162
6.1.5 Range	165
6.1.6 Life Expectancy	166
6.1.7 Size	167
6.1.8 Calibration	168
6.2 Temperature Sensors	169
6.2.1 Thermocouples	169
6.2.2 Resistance Temperature Detectors	172
6.2.3 Infrared Pyrometers	173
6.3 Force and Pressure Sensors	175
6.3.1 Strain Gages	175
6.3.2 Load Cells	177
6.3.3 Pressure Transducers	179
6.4 Displacement Sensors	182
6.4.1 Resistive Sensors	183
6.4.2 Inductance Sensors	184
6.4.3 Magnetostrictive Sensors	185

6.4.4	Optical Encoders	186
6.4.5	Laser Interferometers.....	187
6.5	Summary	187
7	Signal Conditioning	189
7.1	Conversion	189
7.1.1	Resistance to Voltage.....	189
7.1.2	Bridge Circuits	190
7.1.3	Current to Voltage	195
7.2	Amplification	196
7.2.1	Operational Amplifiers.....	198
7.2.2	Unity Amplifier.....	200
7.2.3	Gain Adjustment.....	201
7.2.4	Bias Adjustment	204
7.3	Filtering	206
7.3.1	Passive Filters.....	209
7.3.2	Active Filters	214
7.4	Signal Conditioning in Software	218
7.4.1	Calibration	219
7.4.2	Software Filters	222
7.4.3	Linearization	227
7.5	Summary	230
8	Data Acquisition Systems	233
8.1	Overview	233
8.2	Analog to Digital Conversion.....	236
8.2.1	Resolution.....	237
8.2.2	Range.....	243
8.2.3	Sampling Frequency.....	245
8.2.4	Bandwidth	249
8.2.5	Buffer Size.....	250
8.2.6	Single-Ended and Differential Signaling	251
8.2.7	Input Impedance.....	253
8.2.8	Slew Rate.....	254
8.2.9	Thermocouple Input Modules	255
8.3	Analog Output Modules	256
8.4	Digital Input/Output Modules	258
8.5	Summary	260
9	Machine Controllers	263
9.1	System Architectures.....	264
9.1.1	PLC/PAC Controllers	264
9.1.2	PC/PLC Controllers.....	271
9.1.3	Virtual Controllers.....	274
9.1.4	Distributed/Embedded Microcontrollers.....	276
9.1.5	Summary	278

9.2	Implementation	279
9.2.1	Control Architecture	279
9.2.2	Control Cabinet	280
9.2.3	Auxiliary Modules	282
9.2.4	System Operation	285
9.3	Summary	288
10	Process Control.....	289
10.1	Open Loop Control.....	290
10.2	Thermostat Control	293
10.3	PID Control.....	296
10.3.1	Proportional Control.....	296
10.3.2	Integral Control	298
10.3.3	Proportional-Integral (PI) Control	300
10.3.4	Proportional-Integral-Derivative (PID) Control	300
10.4	Common Issues	303
10.4.1	Saturation	303
10.4.2	Electrical Noise	305
10.4.3	Filters.....	306
10.4.4	Delays	308
10.5	Additional Topics.....	310
10.5.1	Tuning Methodology	311
10.5.2	Analog Implementation	315
10.6	Summary	318
11	Process Characterization.....	321
11.1	Statistical Characterization	322
11.1.1	Mean and Range	323
11.1.2	Standard Deviation	324
11.1.3	Coefficient of Variation.....	325
11.2	Design of Experiments.....	326
11.2.1	Full and Fractional Factorial Designs	327
11.2.2	Advanced Designs	332
11.3	Best Practices in Experimentation.....	335
11.3.1	Center-Points.....	335
11.3.2	Population Size	337
11.3.3	Characterization Range.....	341
11.3.4	Grouping and Randomization.....	342
11.3.5	Stabilization	343
11.4	Regression	345
11.4.1	Linear Least Squares	345
11.4.2	Outlier Analysis	347
11.4.3	Correlation Coefficient	348
11.4.4	Confidence Intervals	349
11.5	Summary	351

12 Process Optimization	353
12.1 Process Capability Assessment.....	354
12.1.1 Yield Estimates	354
12.1.2 Process Capability Indices, C_P and C_{PK}	355
12.1.3 Six Sigma.....	357
12.2 Process Feasibility Analysis.....	359
12.2.1 Monte Carlo Analysis	361
12.2.2 Constraint Based Reasoning	364
12.3 Process Optimization	369
12.3.1 Robustness and Yield.....	371
12.3.2 Cost Minimization.....	376
12.3.3 Pareto Optimality.....	379
12.4 Uncertainty	382
12.5 Summary	384
13 Quality Control	387
13.1 Gage Repeatability & Reproducibility.....	388
13.2 Acceptance Sampling	392
13.3 On-Line Metrology	395
13.3.1 Rheometry	396
13.3.2 Dimensional Metrology	398
13.3.3 Machine Vision	400
13.3.4 Weight	403
13.4 Statistical Process Control.....	405
13.4.1 Implementation.....	405
13.4.2 SPC Heuristics.....	408
13.4.3 Multivariate Statistical Process Control	410
13.5 Summary	416
14 Automation	419
14.1 Introduction to Automation	419
14.1.1 Advantages and Disadvantages.....	419
14.1.2 Plastics Factory Automation Systems	420
14.2 Raw Materials Handling.....	422
14.2.1 Loading.....	424
14.2.2 Drying.....	425
14.2.3 Gravimetric Blending	426
14.2.4 Granulation	428
14.3 Robotics	430
14.3.1 Sprue Pickers	430
14.3.2 Traversing Robots.....	432
14.3.3 SCARA Robot	433
14.3.4 Fully Articulated Robots.....	434
14.3.5 End of Arm Tooling.....	435

14.4	Finished Goods Handling	438
14.4.1	Conveyors.....	438
14.4.2	Part Sorters.....	439
14.4.3	Pallet Loader	441
14.4.4	Automated Guided Vehicle	442
14.5	Integrated Systems.....	443
14.5.1	Strategy	443
14.5.2	Examples.....	445
14.6	Summary	450
Appendix A: Statistical Labor Data.....		453
A.1	United States Labor Rates	453
A.2	International Labor Rates	454
A.3	Trends in International Manufacturing Costs	455
Appendix B: Material Properties		456
Appendix C: Unit Conversions.....		457
C.1	Length Conversions	457
C.2	Mass/Force Conversions	458
C.3	Pressure Conversions	458
C.4	Flow Rate Conversions.....	458
C.5	Viscosity Conversions.....	459
C.6	Power Conversions	459
C.7	Energy Conversions	459
Appendix D: Matlab Primer		460
D.1	Usage.....	460
D.2	Sample Program.....	461
D.3	Other Functions/Operators.....	463
Bibliography.....		467
Index.....		485