KT Journal of Mechanical Engineering

ISSN: 3048-9563 (Online)

Key Tech Services Publication, India

http://www.ktjme.com
https://doi.org/10.64188/3048956325020
Vol.: 1, No. 2, 2024, Pages: 35-44

BUILDING AN AUTOMATION-BASED PROCESS CONTROL SYSTEM WITH IOT INTEGRATION

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Abstract

In the research, an advanced measuring gauge has been designed, featuring ultrasonic sensors for highly precise non-contact measurements spanning from 0.2 mm to 10 mm, with an exceptional level of accuracy at ±0.05 mm. The gauge comes equipped with an intuitive user interface for real-time measurement display and the ability to store data. Its potential applications are wide-ranging, offering substantial benefits to the manufacturing sector by enhancing quality control and aiding research in industries related to washers.

1. Introduction

The precise measurement of thickness constitutes a critical facet of quality control and manufacturing procedures within industries relying on gauges. Conventional methods necessitate physical contact with the gauge, thereby introducing the potential for damage and measurement inaccuracies. Additionally, manual measurement techniques are labor-intensive and susceptible to operator fatigue, which can lead to errors. To overcome these challenges, we have conceived a cutting- edge measurement device that harnesses ultrasonic sensing technology for accurate and efficient thickness measurement, all without the need for physical contact. Ultrasonic sensing technology has demonstrated its reliability and precision over decades of use across diverse industries.

2. Literature Review

Received:04.09.2024 Revised: 22.10.2024 Accepted: 23.11.2024 Published Online: 31.12.2024

Keywords: Quality Management, Internet of Things, Automation, Gauging System

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How to cite this article: Sandip Langade, Rohan Channe, Om Langade, Building an automation-based process control system with IOT integration, KT Journal of Mechanical Engineering, 1(2), 2024, 35-44. https://doi.org/10.64188/3048956325020

Saadia Binte Alam et al. [1] presents a novel approach to measuring muscle thickness utilizing ultrasonic waves. The method employs continuous wavelet analysis to accurately identify boundaries between fat and muscle tissues, resulting in a mean absolute error of only 0.03237 mm. While primarily focused on biological applications, the underlying concept of ultrasonic wave measurement holds relevance for industrial applications, including washer thickness assessment. Wu Ang et al. [2] address the need for precise and efficient wall thick- ness measurement in underground oil and gas pipelines. They introduce a dynamic testing facility incorporating high-energy multi-channel ultrasonic probes and advanced computer test- ing software. This system enables continuous measurement, boasting high accuracy (0.1 mm) and the capability to visualize thickness curves. Moreover, it aligns with industry standards, making it a valuable reference for washer thickness measurement in industrial settings. Haibo Liu et al. [3] emphasize the significance of precise wall thickness measurement for large aerospace thin-walled components. They propose an innovative approach employing ultrasonic scanning to extract thickness and coordinate data from measuring points. The study also introduces an impedance control strategy to ensure measurement stability. With promising results, this method offers potential efficiency and accuracy benefits for industrial applications, including washer thickness measurement. Nava-Balanzar et al. [4] provide detailed insights into the pulse- receiver circuit, acquisition circuit, and data-processing com- ponents of the system. Emphasizing low power consumption, high accuracy, and alignment with industry norms, this prototype offers valuable inspiration for designing an efficient and accurate washer thickness measurement system. M.B. Marshall et al. [5] introduce the concept of using ultrasound to investigate real engineering component contacts. The non-intrusive nature of ultrasound and its reflection properties for contact assessment may yield valuable insights applicable to washer thickness measurement in industrial contexts. Wen- Bin Tang et al. [6] present a laser-based system for precise measurement. With its high accuracy (within 0.6 mm) and precision, this system may offer insights into advanced measurement techniques relevant to washer thickness measurement methods. Xiwei Yang et al. [7] introduce a gauge design emphasizing low power consumption, high accuracy, and data communication capabilities. These principles may provide valuable inspiration for the development of an efficient and precise washer thickness measurement system. Jin-sheng Yang et al. [8] introduce a wheeled ultrasonic thickness measurement system designed for gas pipelines. The system utilizes a specialized elastic material for acoustic coupling, enabling continuous measurement. While its primary focus is on pipelines, the concept of the wheeled probe and acoustic coupling may hold relevance for the development of a washer thickness measurement method. Yongqiang Liu et al [9] present a laser ultrasonic thickness measurement method for metal plates, founded on spectral analysis. The method achieves accurate thickness measurements, with relative errors below 0.66. While its primary focus is on metal plates, the underlying principles of laser ultrasonic measurement and data processing may inform the development of an innovative washer thickness measurement system for industrial applications. Bahrami et al. [10] proposed a method for measuring the thickness of metallic plates using an ultrasonic sensor. The proposed method utilized a signal processing technique to improve the accuracy of the measurements, and the results showed that the method was effective in measuring the thickness of metallic plates with high accuracy. Anand et al. [11] presented a non-destructive testing technique for measuring the thickness of composite laminates using an ultrasonic sensor. The proposed technique utilized a pulse- echo method and signal processing techniques to measure the thickness of the composite laminates with high accuracy. In terms of microcontroller-based systems, several studies have explored the use of microcontrollers for data processing and control in various applications. Beltr´an et al. [12] proposed a microcontroller-based system for monitoring and controlling the temperature and humidity of a greenhouse. The proposed system utilized wireless communication and cloud- based storage for data analysis and visualization. Hua et al. [13] proposed a method for measuring the thickness of thin films using an ultrasonic sensor. The proposed method utilized a pulse-echo technique and signal processing techniques to improve the accuracy of the measurements. The results showed that the proposed method was effective in measuring the thickness of thin films with high accuracy. Zhang et al. [14] presented a smart sensor system for measuring the thickness of coatings on metal substrates. The proposed system utilized an ultrasonic sensor and a microcontroller-based system for data processing and control. The system also included a wireless communication module for remote monitoring and control. The results showed that the proposed system was effective in measuring the thickness of coatings on metal substrates with high accuracy and providing real-time monitoring and control. Arif et al. presented a user-friendly interface for a smart irrigation system using a microcontroller. The proposed interface utilized a mobile application for remote monitoring and control of the system, and the results showed that the interface was effective in providing user feedback and control

3. Materials and Methods

The proposed methodology outlines a systematic approach to developing an ultrasonic-based thickness measurement system. It commences with thorough research into key components such as the ultrasonic sensor, microcontroller, display, and necessary software elements. The research forms the foundation for a comprehensive design that incorporates important features like non-contact measurement, real-time data display, and data storage capabilities Following the design phase, the hardware components are procured and assembled according to the specified de-sign parameters. The microcontroller is then programmed to facilitate precise thickness measurement using the ultrasonic sensor. Calibration of the sensor is carried out to ensure the highest level of accuracy. To enhance user-friendliness, an intuitive interface is developed, offering real-time measurement updates and the possibility of issuing alarms for thickness measurements falling outside acceptable ranges. To validate the system's accuracy and reliability, rigorous testing procedures are executed, including comparisons with established measurement methods. Based on the testing results, necessary adjustments and refinements are implemented, resulting in a well-honed design ready for practical deployment

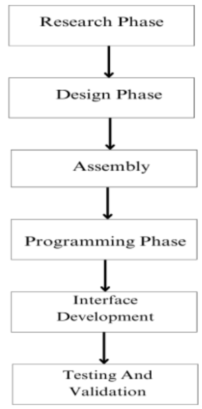

Figure 1: Methodology Flow Chart

4. Design and Manufacturing Process

The creation and production of the measurement device that utilizes ultrasonic sensing technology encompassed various phases. These phases included the choice of components, The establishment of the microcontroller-based system, and the incorporation of ultrasonic sensors.

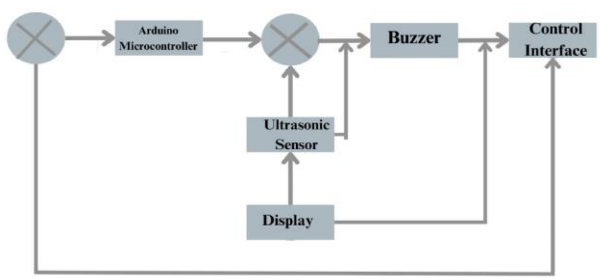

Figure 2: Control Loop Process

5. Experimental Work

Due System implementation is the pivotal phase where the Smart Measuring Gauge is put into action within real-world settings. This process encompasses the installation of the device in a suitable location and the configuration of its settings to ensure optimal functionality. The implementation typically follows these crucial steps:

A. Installation: The device is securely mounted in a strategic location, often within a production line, where it can precisely gauge the thickness.

B. Thickness Measurement: The ongoing measurement is presented on the LED screen in real time. Should the thickness pass a predetermined thresh- old value, the device activates a buzzer to promptly alert the user. This notification allows the user to take immediate action, such as replacing the spacer.

C. Portability and User-friendliness: The device is engineered to be portable and user-friendly, comfortably fitting in one hand for swift and precise thickness measurements. The LED display is bright and legible, ensuring usability in various lighting conditions. Overall, the user interface of the Smart Washer Thickness Measuring Gauge is crafted to be intuitive, enabling users of all experience levels to operate it effectively, even without prior exposure to similar devices.

6. Testing and Maintenance Procedures

Rigorous testing is conducted to confirm that the system performs as expected. This involves a series of measurements to validate the accuracy of the device and to ensure that the buzzer functions correctly when the washer thickness exceeds the predetermined threshold.

Functional Testing: Verify that all components of the system work together as intended.

Accuracy Testing: Conduct measurements to validate the accuracy of the device.

Threshold Testing: Ensure the buzzer functions correctly when the washer thickness exceeds the predetermined threshold.

Endurance Testing: Subject the device to prolonged usage under simulated real-world conditions.

7. User Interface

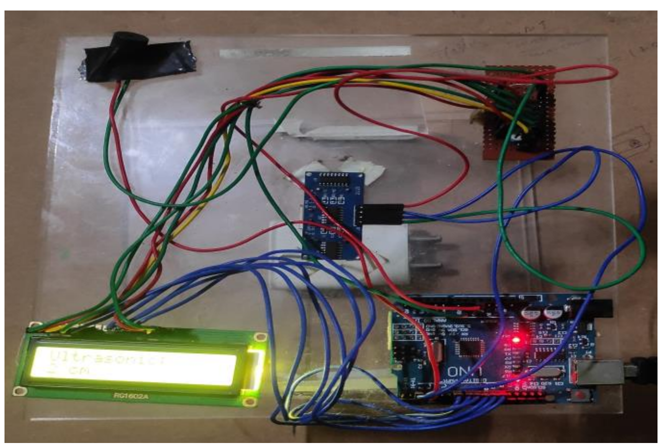

Figure 3: Caption for your picture

A. The user interface of the Smart Washer Thickness Mea- suring Gauge has been meticulously designed to prioritize simplicity and ease of use.

• The device boasts a compact LED display that pro- vides real-time thickness measurements of the spacer. Additionally, it features a single button that serves the functions of powering the device on or off and resetting measurements.

• Upon powering on the device, it immediately commences measuring the thickness of the components. The ongoing measurement is presented on the LED screen in real time. Should the thickness surpass a predetermined threshold value, the device activates a buzzer to promptly alert the user. This notification allows the user to take immediate action, such as replacing the components.

• The device is engineered to be portable and user-friendly, comfortably fitting in one hand for swift and precise thickness measurements. The LED display is bright and legible, ensuring usability in various lighting conditions. Overall, the user interface of the Smart Washer Thickness Measuring Gauge is crafted to be intuitive, enabling users of all experience levels to operate it effectively, even without prior exposure to similar devices.

A. System Architecture

- Microcontroller: Functioning as the central processing unit of our system, the microcontroller is responsible for orchestrating the activities of the various components
- Ultrasonic sensor: The core component of our system is the ultrasonic sensor, which plays a pivotal role in accurately measuring the thickness of washers
- LED Screen: For real-time display of washer thickness measurements, we employ an LED screen connected to the microcontroller
- Buzzer: An optional component, the buzzer, can be integrated to deliver an audible alert when the measured thickness deviates from the desired range

7.1 Data Description

The data generated by the Smart Washer Thickness Mea- suring Gauge encompasses a range of critical information, including

Thickness Measurements: The device records real-time spacer thickness measurements, which can be conveniently stored within the device or transferred to a computer for in-depth analysis.

Threshold Values: Users have the flexibility to adjust predetermined threshold values that trigger the buzzer alerts. These values can be tailored to specific application requirements or embedded within the device’s software.

Battery Status: The device provides essential battery information, such as remaining charge or expected battery life, aiding in maintenance planning and ensuring uninterrupted operation.

Error Messages: In the event of sensor or microcontroller issues, the device generates error messages, often accompanied by explanatory details. These messages streamline

Table 1: Calibration Data

Reading (cm)	Proportion	UCL	LCL	Centerline
1.0045	0.02	0.232	-0.032	0.108
1.0146	0.04	0.232	-0.032	0.108
0.9512	0	0.232	-0.032	0.108
1.0197	0.06	0.232	-0.032	0.108
1.0287	0.08	0.232	-0.032	0.108
0.9591	0.02	0.232	-0.032	0.108
1.0204	0.06	0.232	-0.032	0.108
1.0407	0.1	0.232	-0.032	0.108
1.0473	0.12	0.232	-0.032	0.108
0.978	0.04	0.232	-0.032	0.108
0.994	0.06	0.232	-0.032	0.108
0.9533	0.02	0.232	-0.032	0.108
1.0105	0.04	0.232	-0.032	0.108
1.0037	0.02	0.232	-0.032	0.108
1.0192	0.06	0.232	-0.032	0.108
1.0221	0.06	0.232	-0.032	0.108
0.9821	0.04	0.232	-0.032	0.108
1.0062	0.02	0.232	-0.032	0.108
1.0043	0.02	0.232	-0.032	0.108
1.0201	0.06	0.232	-0.032	0.108
0.9501	0.02	0.232	-0.032	0.108
1.0084	0.04	0.232	-0.032	0.108
1.0101	0.04	0.232	-0.032	0.108
1.0221	0.06	0.232	-0.032	0.108
1.0153	0.06	0.232	-0.032	0.108
1.0236	0.08	0.232	-0.032	0.108

Calibration information is stored within the device to ensure measurement precision. This data can be retrieved during calibration procedures to guarantee accurate results.

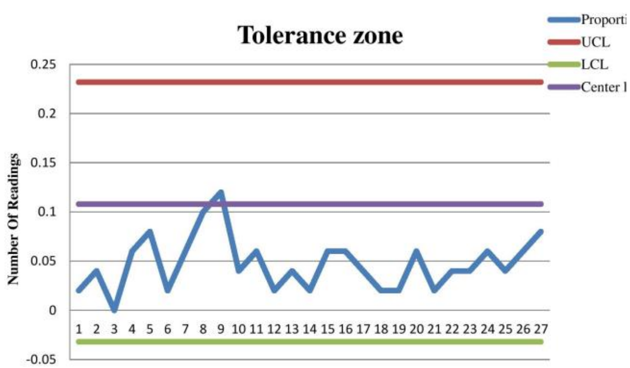

Figure 4: Process Chart

Upper Control Limit (UCL): The upper control limit (UCL) represents the threshold above which the proportion of nonconforming washers is considered unusually high. Lower Control Limit (LCL) Conversely, the lower control limit (LCL) sets the thresh- old below which the proportion of nonconforming washers is considered unusually low. In SPC, a control chart is used to monitor the stability of a process over time. The control limits (UCL and LCL) serve as reference lines on the control chart. If any data point falls outside these control limits, it indicates a statistically significant deviation from the expected variation. Such occurrences suggest that the process may be experiencing special causes of variation, which war- rant investigation and corrective action. Conversely, if all data points fall within the control limits, it suggests that the process is stable and operating within the expected variation. In summary, the upper and lower control limits in SPC provide a quantitative way to assess process stability and detect deviations from expected performance, helping organizations maintain consistent product quality and identify opportunities for improvement.

8. Experimental Results and Conclusion

Based on the methodology and experimental findings, our proposed smart washer thickness measuring gauge demonstrated a high level of accuracy, achieving precise measurements with an accuracy of 0.05 mm. The gauge leverages ultrasonic sensors to discern the distance between the sensor and the washer, employing this information to calculate the washer thickness through a well-defined mathematical formula.

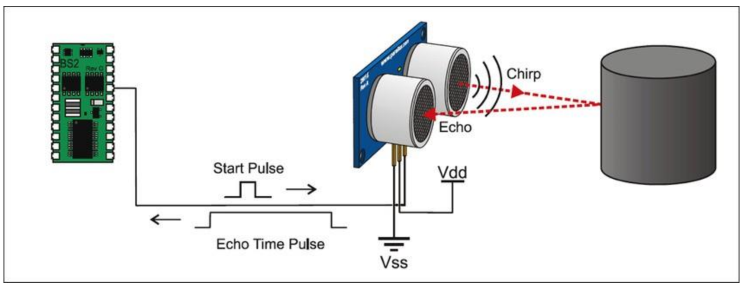

Figure 5: Ultrasonic Principle

To calculate the thickness of the washer, we need to consider the additional distance the ultrasonic waves travel through the washer. If washer represents the time taken for the ultrasonic waves to travel through the washer, then the thickness of the washer can be calculated using the formula: tthickness = vwasher × twasher. This formula provides the mathematical basis for calculating the thickness of the washer using the time-of-flight principle with ultrasonic sensors. It's crucial to accurately determine the velocity of sound in both the medium (air) and the washer material to achieve precise measurements.

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