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SIMULATION OF FUNCTIONING PROCESS OF EQUIPMENT FOR TECHNOLOGY OF UAV ELEMENTS MANUFACTURING FROM USED PACKAGING WASTES

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Introductions. Unmanned aerial vehicles (UAVs) can solve a variety of tasks, be used to strike land and sea targets, intercept air targets, carry out radio interference, control fire, indicate targets, relay messages and data, as well as deliver cargo. Their main advantage is significantly lower cost of creation and operation. An important factor is that a UAV pilot does not risk his life, unlike an airplane pilot [1].

Today, there are already UAVs samples, the elements of which are made of cardboard [2]. Cardboard and corrugated cardboard are distinguished from other materials by their light weight, relatively low cost, and optimal physical parameters allowing their wide use in various areas of industry and business. But the main quality of corrugated cardboard is the possibility to use the waste of used packaging, i.e. waste paper in its manufacturing. This fact is very valuable for ensuring environmental safety.

UAVs elements made of corrugated cardboard need to ensure special properties, namely: strength, rigidity, the ability to withstand shock loads, plane and end pressure, as well as resistance to moisture penetration. To ensure these properties,

it is necessary to create an appropriate technology for the processing of used packaging waste, which will meet the following requirements:

- sharply organized collection, sorting and transportation of raw materials
 (used packaging waste, waste paper) to processing enterprises;
- processing of collected raw materials (used packaging waste, waste paper)
 for further production of corrugated cardboard;
- manufacturing of cardboard and paper for flat layers and fluting with special properties (water resistance);
 - manufacturing of high-strength corrugated cardboard with special properties;
 - established production of elements for UAVs.

For most operations of the manufacturing process of corrugated board, they use steam. Maintaining the temperature regime of the steam is one of the main factors allowing to withstand the requirements for the strength of the material to be used in UAVs elements. The equipment to ensure the supply of steam of the required temperature and pressure to the corrugated unit is a steam boiler.

Aim. The aim of the study was to develop the model of functioning of the steam boiler in the steam pipeline system for technology of UAV elements manufacturing from used packaging wastes.

Materials and methods. The scheme of the steam boiler used for the manufacturing of corrugated cardboard from the waste of used packaging is presented in fig. 1 [3].

The principle of operation of a steam boiler is that when fuel is burned in the furnace of the boiler, flue gases of high temperature are formed. These gases pass through the gas ducts of the boiler, washing the bundles of pipes through which water circulates. As a result, the gases give some of their heat to the water and cool down. The water is heated and turns into steam, collected in the upper drum of the boiler. Rarefaction in the furnace is formed by smoke.

Cooled flue gases are removed into the air with the help of a flue cleaner through chimneys and a chimney. Prepared water is supplied by a pump through the pipeline to the upper drum of the boiler.

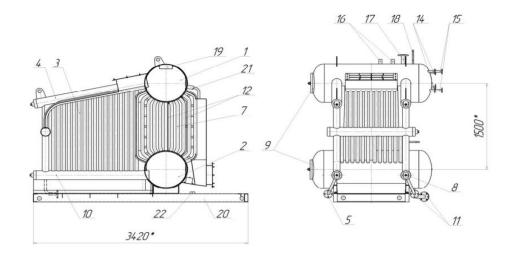


Fig. 1. Scheme of the steam boiler [3]:

1 – upper drum; 2 – lower drum; 3 – furnace screen; 4 – upper collector; 5-blow-out fitting; 6 – shield; 7 – pipe connection; 8 – inspection hatch; 9 – drum hatches; 10 – lower collector; 11 – blow-out fitting; 12 – heat-resistant partition; 13-transverse front collector; 14 – water indicating fittings; 15 – uniform column; 16– safety valve; 17 – steam outlet fitting; 18 – pressure gauge mounting tube; 19-separation device; 20 – frame; 21 – water supply pipe; 22 – mounting bracket

To determine the technological parameters of the pressure loss in the section of the steam pipeline [4] an improved numerical model of the steam boiler operation process in the steam pipeline system of the corrugated unit was developed. The model includes the system of four dependencies (1)–(4).

Assuming that the pressure losses occur uniformly over the entire area, the average linear loss is determined by the formula:

$$R_{local} = \frac{P_1 - P_2}{\sum l_i (1 + \alpha_{local})}, \tag{1}$$

where P_1 and P_2 – pressure value at the beginning and at the end of the steam pipeline; $L = \sum l_i$ – length of the steam pipeline; α_{local} – the coefficient of local losses, which for steam pipelines consisting of several sections, is determined by the formula.

$$\alpha_{local} = \frac{\sum \alpha_i l_i}{\sum l_i},$$
(2)

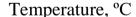
where α_i – coefficient of local losses of the *i*-th section of the steam pipeline, which is determined by the Shifrenson formula.

$$\alpha_i = z\sqrt{G} \,. \tag{3}$$

The estimated pressure drop in the section of the steam pipeline is determined by the formula:

$$\Delta P_i = R_{local} l_i = \frac{\Delta P l_i}{\sum l_i (1 + \alpha_{local})}.(4)$$

Results and discussion. Based on the results of simulation using the developed model (1)–(4), the dependence of the temperature at the outlet of the steam pipeline on the pressure in the steam boiler under different conditions of the manufacturing process was determined (Fig. 2). As it may be seen, the higher the steam pressure value produced by the steam boiler, the higher the steam temperature at the outlet from the boiler to the unit is. It was established that if the required level of pressure in the steam boiler is not maintained, the temperature regime for the manufacturing of corrugated cardboard will not ensure the required strength of the material for the manufacturing of UAVs elements.



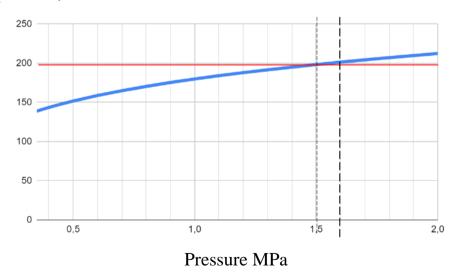


Fig. 2. Dependence of the temperature at the outlet of the steam pipeline on the pressure in the steam boiler

Accordingly, in the technological process of manufacturing corrugated cardboard, at a specific enterprise, it is possible to obtain the required temperature of about 200°C by changing such a parameter as the pressure of the steam generated by the steam boiler. Established temperature regime will make it possible to withstand the given parameters of the manufacturing technology and produce durable corrugated cardboard that can be used for the manufacturing of durable UAV structural elements.

That is, at a specific production, by changing only one such parameter as the pressure of saturated water vapor, we get:

- cardboard of the strength needed to make UAV elements;
- raise of the productivity of the corrugated unit by 40...50 %;
- significant reduction of the amount of waste in the form of scrap.

Conclusions.

- 1. An improved numerical model of the functioning of a steam boiler in a steam pipeline system in the manufacturing process of corrugated cardboard from packaging waste is proposed. In particular, a set of parameters of the numerical model has been defined, which includes technological parameters affecting the strength of the obtained material, namely: the temperature of the steam at the outlet of the steam pipe of the corrugated unit and the pressure of the steam created by the steam boiler. According to the simulation results, the dependence of the steam temperature at the outlet of the steam pipeline on the steam pressure created by the steam boiler was determined.
- 2. According to the results of simulation, it was determined that the most effective method allowing to ensure proper temperature regime, is to change such a technological parameter of a steam boiler as the steam pressure at the outlet of the boiler.

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