



**FACULTY OF MECHANICAL AND CIVIL ENGINEERING KRALJEVO  
UNIVERSITY OF KRAGUJEVAC  
KRALJEVO – SERBIA**

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## PREFACE

Ladies and gentlemen, dear colleagues,

Welcome to Zlatibor, to the International Scientific Conference Heavy Machinery 2017.

This year the International Conference Heavy Machinery is held by the University of Kragujevac, Faculty of Mechanical and Civil Engineering in Kraljevo from 28 of June to 1 of July 2017.

It has gained a unique recognizable form for exchange of information, ideas and new scientific researches. The Conference is held in the year when the Faculty of Mechanical and Civil Engineering in Kraljevo celebrates the 58<sup>th</sup> year of university teaching in mechanical engineering and sixth year of university teaching in civil engineering.

For 24 years of its existence it has acquired specific and recognizable form in domestic and foreign scientific circles thanks to its scientific and research results.

The goal of the Conference is to make the research from the fields covered at the Faculty of Mechanical and Civil Engineering in Kraljevo available and applicable both within domestic and foreign frames. Also, our scientific workers will have the opportunity to learn about results of research done by their colleagues from abroad in the fields of transport design in industry, energy control, production technologies, and civil engineering through the following thematic sessions:

- Earth moving and transportation machinery,
- Production technologies,
- Automatic control, robotics and fluid technique,
- Machine design and mechanics,
- Railway engineering,
- Thermal technique and environment protection,
- Civil engineering and materials.

High scientific rating of domestic and foreign participants as well as the number of papers provide guarantees that the Conference is going to be very successful.

I wish to emphasize that this year we have a large number of papers, especially from abroad. The program also contains 104 invited papers in the plenary session. The invited lectures reflect the wide spectrum of important topics of current interest in heavy machinery. The sponsorship by the Ministry of Education and Science of the Republic of Serbia is supportive of efforts to promote science and technology in the area of mechanical and civil engineering in Serbia. We would like to express our sincere thanks to all members of scientific and organizing committee, reviewers, as well as to all participants including invited speakers for coming to Zlatibor to present their papers.

Thank you and see you at the next conference.

Kraljevo – Zlatibor, June 2017

Conference Chairman,

  
Prof. Dr. Milomir Gašić, mech eng.

## PLENARY SESSION

<b>COMPUTER MODELLING OF A DIGGING ZONE OF A SINGLE-BUCKET EXCAVATOR</b> Evgeniy M. Kudryavtsev	1
<b>AN EXPERIMENTAL STUDY ON THE FATIGUE RESPONSE OF 15-5 PH STAINLESS STEEL BUILT BY DMLS</b> Dario Croccolo, Massimiliano De Agostinis, Stefano Fini, Giorgio Olmi, Aleksandar Vranic, Snezana Ciric-Kostic	9
<b>TRIBOLOGICAL PROPERTIES OF DETERGENTS AS ADDITIVES FOR MOTOR OILS</b> Anatoly Dotsenko, Vladimir Samusenko	17
<b>A SURVEY OF RESEARCHES IN THE FIELD OF ECODESIGN RELATED TO INTRALOGISTICS AT THE UNIVERSITY OF BELGRADE - FACULTY OF MECHANICAL ENGINEERING (2010-2017)</b> Nenad Zrnić	23
<b>DAMPING CHARACTERISTICS OF THE SEISMIC ISOLATION BEARINGS GROUP, IN MODULAR DESIGN, FOR BRIDGES AND VIADUCTS</b> Marian Dima, Catalin Francu	41

## SESSION A: EARTH-MOVING AND TRANSPORTATION MACHINERY

<b>DYNAMIC ANALYSIS OF TOWER CRANE MOVEMENT MECHANISM</b> Evgeniy Kudryavtsev	1
<b>THE DEFINITION OF BASIC PARAMETERS OF THE SET OF SMALL-SIZED EQUIPMENT FOR PREPARATION OF DRY MORTAR FOR VARIOUS APPLICATIONS</b> Inga Emelyanova, Vladimir Blazhko, S.I Karpenko	7
<b>SHAPELESS MANUFACTURE OF REINFORCED CONCRETE CYLINDRICAL AND SPHERICAL SHELLS WITH THE HELP OF NEW GENERATION HYDRAULIC EQUIPMENT OF NEW GENERATIONS</b> Inga Emelyanova, Ana Anishchenko, Sergey Guzenko, Denis Chayka	11
<b>RESEARCH OF STRESS-STRAIN STATE OF METAL CONSTRUCTIONS FOR STATIC AND DYNAMIC LOADS MACHINERY</b> Ivan Nazarenko, Oleg Dedov, Igor Zalisko	17
<b>RESEARCH OF ENERGY-SAVING VIBRATION MACHINES WITH ACCOUNT OF THE STRESS-STRAIN STATE OF TECHNOLOGICAL ENVIRONMENT</b> Ivan Nazarenko, Oleg Dedov, Anatoly Svidersky, Nicolay Ruchinsky	21
<b>APPLICATION OF NUMERICAL METHODS FOR ANALYSIS OF VERTICAL TRANSPORT SYSTEMS</b> Jovan Vladić, Radomir Đokić, Anto Gajić	25
<b>GEOMETRICAL IDENTIFICATION OF CYLINDRICAL CARRIER OF AXIAL BEARINGS WITH BIG DIAMETERS</b> Milomir Gašić, Mile Savković, Goran Marković, Nebojša Zdravković, Srđan Ribar	33

<b>DESIGN OPTIMIZATION OF THE RECTANGULAR BOX SECTION OF THE DOUBLE BEAM BRIDGE CRANE USING MATLAB OPTIMIZATION TOOLBOX</b>	<b>37</b>
Goran Pavlović, Mile Savković, Nebojša Zdravković, Vladimir Kvrđić, Stefan Mitrović	
<b>INTEGRITY OF BEAM BRACES AND THREADED SPINDLE FOR CONJOINT OPERATION OF TWO 5 MN BRIDGE CRANES</b>	<b>45</b>
Miodrag Arsić, Mladen Mladenović, Bojan Međo, Zoranka Malešević, Zoran Savić	
<b>ORGANIZATIONAL-TECHNOLOGICAL MODELS FOR THE FORMATION OF EFFECTIVE SETS OF MACHINES AND TECHNOLOGIES IN THE PERFORMANCE OF CONSTRUCTION WORKS</b>	<b>53</b>
Maxim Nazarenko, Ivan Pereginets, Viktor Leschinsky	
<b>RISK MANAGEMENT IN MECHANICAL ENGINEERING</b>	<b>57</b>
Vladimir Zorin	
<b>LABORATORY TEST RIG FOR NONDESTRUCTIVE INSPECTION OF STEEL CORD BELTS</b>	<b>61</b>
Miloš Đorđević, Nenad Zrnić, Srđan Bošnjak	
<b>ANALYSIS OF THE INFLUENCE OF BASIC PARAMETERS OF THE MAGNETIC SEPARATOR ECMS-500 FOR NON-FERROUS METALS ON THE SEPARATION FORCE INTENSITY</b>	<b>69</b>
Mile Savković, Milomir Gašić, Nebojša Zdravković, Goran Marković, Goran Pavlović	
<b>APPLICATION OF RELIABILITY CENTERED MAINTENANCE METHODOLOGY FOR MAINTENANCE OF AN SPECIAL MILITARY VEHICLE ENGINE</b>	<b>75</b>
Slavko Rakić, Uglješa Bugarić	
<b>THE APPLICATION OF VOITH HYDRODYNAMIC COUPLERS WHILE STARTING THE BELT CONVEYORS OF MINING</b>	<b>83</b>
Dragoljub Veličković, Svetislav Marković, Dragana Andjelić	
<b>SOME MODERN SOLUTIONS FOR DELIVERY OPERATION IN POSTAL TRAFFIC</b>	<b>87</b>
Aleksandar Čupić, Mladenka Blagojević, Goran Marković	
<b>MATERIAL HANDLING EQUIPMENT SELECTION USING AN INTEGRATED APPROACH F-MODIPROM: AN ADVANTAGE GAINED FROM USING FUZZY NUMBERS</b>	<b>95</b>
Goran Marković, Mile Savković, Nebojša Zdravković, Aleksandar Čupić, Marko Popović	
<b>DIGGING RESISTANCE MODEL SHOVEL MANIPULATOR OF HYDRAULIC EXCAVATOR</b>	<b>101</b>
Vesna Jovanović, Dragoslav Janošević, Jovan Pavlović, Goran Petrović	
<b>ANALYSIS OF THE INFLUENCE OF PARAMETERS OF HYDROSTATIC SYSTEM ON THE MANIPULATOR DRIVE OF THE MOBILE MACHINE</b>	<b>105</b>
Jovan Pavlović, Dragoslav Janošević, Vesna Jovanović, Nikola Petrović	
<b>RESEARCH AND CALCULATION OF RATIONAL MODES AND PARAMETERS OF AN ULTRASONIC CAVITATOR</b>	<b>109</b>
Irina Bernyk, Oleksandr Lugovskoy	

## **SESSION B: PRODUCTION TECHNOLOGIES**

<b>DETERMINATION OF EXPULSION COSTS IN RESISTANCE SPOT WELDING</b>	<b>1</b>
Miomir Vukićević, Mišo Bjelić, Marina Pljakić, Milan Tešević	

<b>NUMERICAL SIMULATION OF HARDNESS DISTRIBUTION AT THE HAZ OF P355GH STEEL</b>	<b>7</b>
Mišo Bjelić, Karel Kovanda, Ladislav Kolařík, Marie Kolaříková, Miomir Vukićević, Branko Radičević	
<b>APPLICATION OF MULTICRITERIA DECISION MAKING IN SELECTION OF OPTIMAL TOOLPATH</b>	<b>13</b>
Aleksandra Petrović, Slobodan Ivanović, Goran Miodragović, Vladan Grković	
<b>ELECTRODE INVESTIGATION AT PLASMA CUTTING</b>	<b>19</b>
Bogdan Nedić, Marko Jankovic, Peko Ivan	
<b>ANALYTICAL ANALYSIS OF DRILLING-ASSOCIATED DAMAGE IN COMPOSITES</b>	<b>23</b>
Navid Zarif Karimi, Giangiacomo Minak	
<b>THE SIMULATION PROCESS IN SMALL AND MEDIUM ENTERPRISES: DECISION-MAKING SUPPORT</b>	<b>29</b>
Miroslav Dragić, Miloš Sorak	
<b>THE INFLUENCE OF WORKING EXPERIENCE AND LEVEL OF EDUCATION ON THE MARKET ORIENTATION OF SMES IN TRANSITION</b>	<b>37</b>
Ljiljana Pecić, Milan Kolarević, Vladan Grković, Natasa Obradović	
<b>ESSENTIAL REQUIREMENTS FOR SUSTAINABILITY COMPLIANCE IN THE PROCESS OF EXPLOITATION MACHINES</b>	<b>45</b>
Miljan Cvetković, Žarko Janković, Dragan Cvetković	
<b>PARTNERSHIP FOR ENTREPRENEURIAL ENGINEERING EDUCATION</b>	<b>51</b>
Milica Gerasimović, Ugljesa Bugarić	
<b>ORAL PRESENTATIONS OF COMPANIES IN ESP CLASSES AS A MULTI-PURPOSE TASK</b>	<b>55</b>
Nataša Pavlović	
<b>MACHINING SIMULATION AND VERIFICATION OF TOOL PATH FOR CNC MACHINE TOOLS WITH SERIAL AND HYBRID KINEMATICS</b>	<b>63</b>
Saša Živanović, Slobodan Tabaković, Milan Zeljković, Cvijetin Mladenović, Aleksandar Košarac	
<b>3D ANIMATION OF WORKPIECE TRANSFORMATION DURING MILLING OPERATION</b>	<b>69</b>
Slobodan Ivanović, Aleksandra Petrović, Ljubomir Lukić, Marina Pljakić	
<b>OPTIMIZATION MODEL FOR MACHINING PROCESSES DESIGN IN FLEXIBLE MANUFACTURING SYSTEMS</b>	<b>75</b>
Ljubomir Lukic, Slobodan Ivanovic, Aleksandra Petrovic, Mirko Djapic	
<b>APPLICATION OF AXIOMATIC DESIGN THEORY AND BELIEF FUNCTION THEORU IN THE ASSEMBLY SYSTEM IMPROVEMENT</b>	<b>83</b>
Zvonko Petrović, Mirko Đapić, Ljubomir Lukić	
<b>THE APPLICATION OF DEMPSTER-SHAFER THEORY ON FAILURE ANALYSIS OF HYDRAULIC HAND PUMPS</b>	<b>89</b>
Violeta Đorđević, Mirko Đapić, Zvonko Petrović	



<b>REMOTE MONITORING AND CONTROL OF ASYNCHRONOUS DRIVES PERFORMANCE – LABORATORY STAND</b> Vasil Dimitrov, Petko Kostadinov	<b>97</b>
<b>SYNERGISTIC MODEL OF TRAFFIC FLOWS</b> Galina Cherneva, Emiliya Dimitrova	<b>103</b>
<b>DYNAMIC FAULT TREE. COMPUTATION OF PARAMETERS – PART I</b> Emiliya Dimitrova, Plamen Atanasov	<b>109</b>
<b>DYNAMIC FAULT TREE. COMPUTATION OF PARAMETERS – PART II</b> Emiliya Dimitrova, Plamen Atanasov	<b>115</b>
<b>SESSION C: AUTOMATIC CONTROL, ROBOTICS AND FLUID TECHNIQUE</b>	
<b>ADAPTIVE INPUT DESIGN FOR ROBUST IDENTIFICATION OF OUTPUT-CONSTRAINED OE MODELS</b> Vladimir Stojanović, Novak Nedić, Dragan Pršić	<b>1</b>
<b>CONDITIONAL OPTIMIZATION OF COMPUTER AUTOMATIC CONTROL SYSTEM OF AN SELECTED PLANT AT ARBITRARY INITIAL CONDITIONS</b> Vladimir R. Zarić, Zoran M. Bučevac, Radiša Ž. Jovanović	<b>7</b>
<b>CONDITIONAL OPTIMIZATION OF TRANSIENT BEHAVIOUR OF PLANT CONTROLLED WITH PI CONTROLLER CONSIDERING INITIAL CONDITIONS</b> Goran Petrović, Zoran Ribar , Radiša Jovanović	<b>13</b>
<b>IDENTIFICATION OF MIMO HAMMERSTEIN MODELS IN THE PRESENCE OF PIECEWISE POLYNOMIAL DISTURBANCES USING KACZMARZ ALGORITHM</b> Vojislav Filipović, Vladimir Djordjević	<b>19</b>
<b>PHILOSOPHICAL INTERPRETATION OF CONNECTION OF ROBUST STATISTICS AND FUZZY LOGIC: THE ROBUST FUZZY CLUSTERING</b> Vladimir Djordjević, Vojislav Filipović	<b>25</b>
<b>SELF-TUNING PID CONTROLLER BASED ON TIME RESPONSE CHARACTERISTICS</b> Novak N. Nedić, Saša Lj. Prodanović	<b>31</b>
<b>DESIGN OF FIXED ORDER <math>H_{\infty}</math> CONTROLLERS WITH SPECIFIED SETTLING TIME USING D-DECOMPOSITION</b> Ljubiša Dubonjić, Vojislav Filipović, Novak Nedić, Vladimir Đorđević	<b>37</b>
<b>DATA CLASSIFICATION USING A SET OF NEURAL NETWORKS</b> Srdjan Ribar	<b>43</b>
<b>KINEMATIC AND DYNAMIC ANALYSIS OF THE PATH OF MOVEMENT OF THE ROBOT</b> Ljiljana Pecić, Zvonko Petrović, Nikola Kostić	<b>49</b>
<b>WATER DRAIN EMERGENCY SYSTEM</b> Nikola Terzić, Dragan Pršić	<b>55</b>

## SESSION D: MECHANICAL DESIGN AND MECHANICS

<b>DAMPING AND SEISMIC ISOLATION BEARINGS GROUP, IN MODULAR DESIGN, FOR BRIDGES AND VIADUCTS. CONSTRUCTION AND WORKING PRINCIPLE</b> Marian Dima, Catalin Francu	1
<b>DYNAMICS OF THE ROTATING CANTILEVER BEAM</b> Aleksandar Nikolić, Slaviša Šalinić	7
<b>EXPERIMENTAL INVESTIGATION OF TRIBOLOGICAL BEHAVIOR OF JOURNAL BEARING COATED BY BABBITT ALLOYS TEGOTENAX V840</b> Amir Alsammarraie, Dragan Milčić, Milan Banić, Goran Radenković, Miodrag Milčić	13
<b>SURFACE QUALITY OF MARAGING STEEL PARTS PRODUCED BY DMLS</b> Nebojša Bogojević, Aleksandar Vranić, Nusret Muharemović, Nenad Drvar	21
<b>MACHINING AND HEAT TREATMENT EFFECTS ON THE FATIGUE PROPERTIES OF MARAGING STEEL PRODUCED BY DMLS</b> Snežana Čuč-Kostić, Nebojša Bogojević, Aleksandar Vranić, Dario Croccolo, Massimiliano De Agostinis, Stefano Fini, Giorgio Olmi	27
<b>A HEURISTIC APPROACH TO THE ESTIMATION OF MASS OF THE WASTE POWDER DURING SELECTIVE LASER SINTERING OF POLYAMIDE PA2200</b> Zlatan Šoškić, Simona Montanari, Gian Luca Monti, Michele Monti	37
<b>PRACTICAL EXAMPLES OF REGENERATION OF THE DAMAGED HEAVY MACHINERY PARTS</b> Svetislav Marković, Vladimir Stepanović, Lazar Jovičić, Milijan Čuč, Ivan Stanišić, Miroslav Čučin, Nemanja Petrović	45
<b>ANALYSIS OF FREE OSCILLATION OF SPATIAL FRAMES APPLYING THE METHOD OF CONSISTENT MASSES</b> Rade Vasiljevic	51
<b>NUMERICAL ANALYSIS OF TRIBOMECHANICAL SYSTEM BRAKE DISC-PAD FOR HEAVY DUTY VEHICLES</b> Nadica Stojanović, Jasna Glišović, Blaža Stojanović, Ivan Grujić	57
<b>ANALYTICAL, EXPERIMENTAL AND NUMERICAL STUDY OF SEMI-RIGID BEAM-TO-COLUMN CONNECTIONS IN THE STEEL STRUCTURE OF PALLET RACKS</b> Rodoljub Vujanac, Snezana Vulovic, Nenad Miloradovic, Aleksandar Disic	65

## SESSION E: RAILWAY ENGINEERING

<b>THE PURPOSE OF DIAGNOSTICS OF PANTOGRAPHS USED IN THE SERBIAN RAILWAYS</b> Branislav Gavrilović, Zoran Bundalo	1
<b>PROCESSES AND DEPENDENCIES RELATED TO NADAL'S FORMULA</b> Dobrinka Atmadzhova	7
<b>OSCILLATION OF RESERVOIR OF TANK-WAGON IN DYNAMIC LONGITUDINAL LOAD</b> Dragan Petrović, Milan Bižić	17

<b>RELIABILITY INDICATORS OF THE BRAKE DISTRIBUTORS KE 1 FOR ROLLING STOCK IN OPERATION</b> Vasko Nikolov	23
<b>THE IMPORTANCE OF THE RAILWAY INFRASTRUCTURE IN THE OPERATIONAL PROGRAM "TRANSPORT AND TRANSPORT INFRASTRUCTURE."</b> Mira Zafirova	27
<b>STUDY OF THE INTERACTION "WHEELSET-TRACK" OF THE ATTACKING WHEELSET OF TRAM BOGIE TYPE T81 IN EXPLOITATION IN SOFIA</b> Dobrinka Atmadzhova, Emil Mihaylov, Emil Iontchev	33
<b>OVERVIEW OF WHEEL-RAIL ROLLING CONTACT THEORIES</b> Milan Bižić, Dragan Petrović	41
<b>STUDY OF THE MOVEMENT OF THE ATTACKING TRAM WHEELSET ON TRACK WITH GAUGE 1009 MM</b> Emil Mihaylov, Emil Iontchev, Vladimir Zhekov, Zornitsa Evlogieva, Metodi Atanasov	49
<b>THE IMPACT OF THE CHARACTERISTICS OF TRAIN ON THE TRAIN BRAKING DISTANCE AT CRITICAL SECTIONS OF THE BELGRADE – BAR RAILWAY LINE</b> Dusan Vujović	57
<b>METHODS FOR CARRYING OUT TRACK MAINTENANCE AND OPTIMIZATION POSSIBILITIES</b> Metodi Atanasov	65
<b>MEASUREMENTS OF NOISE LEVELS OF FREIGHT TRAIN ON SERBIAN RAILWAYS</b> Jelena Tomić, Nebojša Bogojević	71

## **SESSION F: THERMAL TECHNIQUE AND ENVIRONMENT PROTECTION**

<b>MODELING OF TECHNOLOGICAL EQUIPMENT AND TECHNOLOGICAL TRANSPORTATION FLOWS OF THE INDUSTRIES BINDER USING MATHEMATICAL METHODS</b> Cristina Sescu-Gal	1
<b>ENSURING PHONIC COMFORT IN URBAN ENVIRONMENT</b> Vasile Bacria, Nicolae Herisanu	9
<b>OPTIMIZATION OF FLOW SCHEMES IN RADIANT RECUPERATORS</b> Rade Karamarković, Vladan Karamarković, Miloš Nikolić, Nenad Stojčić, Miljan Marašević	15
<b>ACOUSTIC PROPERTIES OF RECYCLED RUBBER AT NORMAL INCIDENCE</b> Milan Kolarević, Branko Radičević, Nicolae Herisanu, Miloje Rajović, Vladan Grković	23
<b>DESIGNING RECUPERATOR ON A ROTARY KILN SUPPLIED WITH ENRICHED AIR DURING THE CALCINATION OF DOLOMITE</b> Miljan Marasevic, Vladan Karamarković, Nenad Stojic, Milos Nikolic, Djordje Novčić	29
<b>ANALYSIS OF DYNAMIC PINCH</b> Aleksandar Vičovac, Rade Karamarković, Dragan Pršić	37

**SELECTION OF THE OPTIMAL ROUTE OF TRANSPORTATION – A CASE STUDY OF TRANSPORT OF MUNICIPAL WASTE IN THE MUNICIPALITY OF TRSTENIK** 45  
Nikola Kostic, Milomir Mijatovic, Sasa Babic, Branimir Milosavljevic, Zvonko Petrovic

**DESIGN IMPROVEMENT OF A SIDE WATER INTAKE ON A SMALL HYDROPOWER PLANT** Miloš 51  
Nikolić, Vladan Karamarković, Rade Karamarković, Miljan Marašević

**MEASUREMENT AND ANALYSIS OF CHANGES IN TOTAL QUANTITY OF INJECTION DEPENDING ON THE CHANGES IN VALUE OF PRESSURE IN COMMON RAIL SYSTEM** 57  
Nikola Kostic, Božidar Krstic, Milomir Mijatovic, Sasa Babic, Branimir Milosavljevic

**DETERMINATION OF TRANSFER FUNCTION OF PHOTOACOUSTIC SYSTEM BY ACQUISITION CARDS WITH UNSYNCHRONIZED SIGNAL INPUT AND OUTPUT** 69  
Slobodan Todosijević, Nenad Drvar, Zlatan Šoškić

**PROTOTYPE SYSTEM FOR GAS TANKS CLEANING** 74  
Zoran Petrović, Mirosljub Babić, Uglješa Bugarić, Dušan Petrović

## **SESSION G: CIVIL ENGINEERING AND MATERIALS**

**MACHINE FOR IMPACT TESTING OF PLASTIC PIPES - IMPACT 2000 DESIGN, DEVELOPMENT AND PROTOTYPING** 1  
Ivan Milićević, Miloš Božić, Vojislav Vujičić, Radomir Slavković

**MULTI-CRITERIA SELECTION OF OPTIMAL MECHANIZATION FOR ROAD CONSTRUCTION** 7  
Vladimir Mandić, Saša Marinković, Jovana Bojković

**PREDICTION OF ACOUSTICAL PROPERTIES OF POROUS BUILDING MATERIALS** 13  
Jovana Bojković, Branko radičević, Nedeljko Manojlović, Mišo Bjelić, Vladimir Mandić, Saša Marinković,

**FLOTATION TAILINGS FROM COPPER MINING AND SMELTING PLANT AS MINERAL ADDITIVES FOR SCC** 19  
Saša Marinković, Vladimir Mandić, Jovana Bojković, Stefan Mihajlović

**RESEARCH OF SHEAR STRENGTH AND COMPATIBILITY BY HEAT CONDITIONING OF SHEETS FOR WATERPROOFING USED IN CONCRETE BRIDGE DECKS** 27  
Nikolina Porozhanova

**WELDING OF THE RESERVOIRS FOR OIL DERIVATIVES STORAGE WITH SELF-SHIELDED CORED WIRE** 33  
Radomir Jovičić, Olivera Erić Cekić, Aleksandar Sedmak, Sanja Petronić, Vukić Lazić

**DETAILED GEOTECHNICAL INVESTIGATIONS OF THE LANDSLIDE BOCKE** 41  
Mitar Đogo, Milinko Vasić

# Research and Calculation of Rational Modes and Parameters of an Ultrasonic Cavitator

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*In the executed researches it is accepted that the highest efficiency of transformation of electric energy into energy of acoustic vibrations and radiation in the work environment is subject to the approval of the resistance of the medium and the use of force apparatus. Implementation of the proposed approach is implemented reflect the changes in the rheological properties of the technological environment, by choosing the physical model and its mathematical description. Presented in the mathematical form of the stages of the cavitation process. The key parameters of cavitation bubbles in an acoustic field. The estimation of the cavitation process on the coefficient of the cavitation index and absorption coefficient in cavitating medium. The absorption coefficient is a measure of the efficiency of cavitation effect, the connection of this parameter with power density of shock waves.*

**Keywords:** disperse medium, ultrasound, cavitation, rheology, intensity, impedance, absorption coefficient.

## 1. FORMULATION THE PROBLEM

Ultrasonic cavitation technology allows to intensify the technological processes, to increase the utilization of raw materials, to modify the original properties of the material, to create new substances and the environment to ensure environmental cleanliness and safety of production [1–11]. The process of turning electric energy into acoustic waves and its radiation in the working environment shall be carried out with the greatest efficiency, subject to the approval of the resistance of the medium and the use of force apparatus. Therefore, research aimed at improving the efficiency of cavitation technologies for the realization of different kinds of technological processes is the task urgent.

## 2. FORMULATION OF THE TASK

The aim of this work is to study the process of cavitation treatment of technological environments, the setting of parameters of influence and assess its effectiveness.

## 3. STATEMENT OF THE MATERIAL

Implementation of the proposed approach requires determining the change in rheological properties of the technological environment, which is the viscosity, plasticity and elasticity [2]. The procedure for accounting of these properties lies in the choice of the physical model with further mathematical description and assessment of the impact in the calculation of dependencies. From a physical point of view, the choice of model predefined the main characteristics of the deformation and stresses that occur during the technological influence and form the so-called stress-strain state.

The main properties of the processed media are the basis of any material. There are three idealized models of materials: the ideal elastic body (Hooke); ideally viscous liquid (Newtonian); a perfectly plastic body (Saint-Venant) [3]. In real-world environments, which have a complex structure, can occur for all three rheological properties. To build the model they are interconnected in series or in parallel (tab. 1). Such models belong to the basic elastic-plastic body Saint-Venant, the viscoelastic body of the Kelvin-Voigt and Maxwell visco-plastic body Shvedov-Bingham and others, the use of which is determined by other properties.

The next step envisaged in the mathematical form of the stages of the process of cavitation: the formation of bubbles, their oscillation, the development and collapse. This process is accompanied by complex mass and heat transfer in the formed cavitation region.

The key parameter in the evolution of the gas and air bubbles in the acoustic field is the energy, the components of which are the pressure, time and speed of flow of the process of cavitation [5, 6]. Under the action of ultrasonic harmonic oscillation on environments, the amplitude of the sound pressure is determined in accordance with dependencies:

$$P_m = \rho_k c_k \omega A, \quad (1)$$

where:  $\rho_k$  and  $c_k$  – the density and speed of sound in cavitating medium;  $\omega$  – the circular frequency of the sound wave;  $k = \frac{\omega}{c}$  – wave number;  $A$  – the vibration amplitude of the radiator;  $\rho_k c_k$  – the impedance of the medium, which determines the speed of oscillations for a given acoustic pressure.

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The propagation of ultrasonic waves associated with the transfer of energy. The energy density of sound waves, which falls per unit volume of the medium, can be expressed as:

$$E_s = p v^2 / 2 = 2\pi^2 p f^2 A^2 \quad (2)$$

The energy of ultrasonic waves that pass through unit area per unit time, it is customary to characterize the intensity of ultrasonic vibrations. When the plane wave is perpendicular to the surface, ultrasound intensity is associated with the amplitude of the sound pressure dependence:

$$I = 2\pi^2 p c f^2 A^2 = P_M^2 / (2 p c) \quad (3)$$

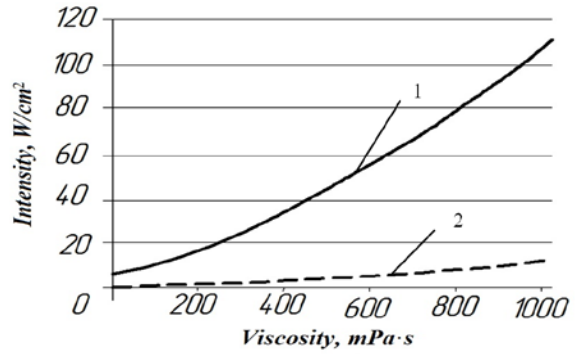


Figure 1: The change in the intensity of the cavitation processing of disperse media, depending on their viscosity: 1 – maximum intensity, 2 – min intensity

Table 1: Rheological models of simple and complex dispersed technological environments

In practice, an estimation of the cavitation process


using the ratio of the index of cavitation K, which equals the time average volumetric concentration of bubbles:

$$K = \frac{\sum_i V_i}{V_p + \sum_i V_i} \quad (4)$$

The change in the intensity of the viscosity (Figure 1) proves the necessity of taking into account dissipation in the determination of the parameters of the cavitation process.

where:  $V_p$  – the volume of fluid without bubbles,  $V_i$  – the average volume of cavitation bubble,  $i = 1, N$ ,  $N$  – the number of bubbles.

Then the wave resistance of cavitation medium can be represented as:

$$\rho_k c_k = \rho_0 c_0 \left[ \frac{1}{1 + \frac{K\beta_n}{\beta_0}} \right]^{1/2}, \quad (5)$$

where:  $\rho_0 c_0$  – the wave resistance of the medium;  $\frac{\beta_n}{\beta_0}$  – the ratio of compressibility of gas-vapor mixture in the bubbles to the compressibility of the fluid.

The dependence of the wave resistance of the medium from the cavitation index (Figure 2) shows that when the cavitation index of only 0.2% impedance and hence the amplitude of the current bubble sound pressure is reduced almost five times.

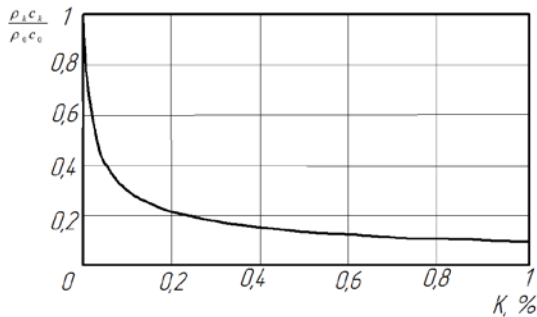


Figure 2: The dependence of the impedance changes of the medium from the cavitation index.

The bubbles, having a high compressibility, assume the external force in the sound wave, the same reducing the bulk modulus of elasticity of the medium of the  $E_c$  and the speed of sound:

$$c_k = \sqrt{\frac{E_c}{\rho_k}}. \quad (6)$$

An important parameter in the evaluation of process efficiency is the ratio of the velocities at the initial speed the process of cavitation  $c_c$ , which varies from the origin of cavitation bubbles, their collapse  $c_k$ :

$$k_c = c_c / c_k \quad (7)$$

The next process parameter is the absorption coefficient in cavitating medium  $K_\bullet$ . This parameter depends on the complex amplitude of acoustic pressure in the cavitation medium and the complex amplitude of the volumetric content of cavitation bubbles.

$$K_\bullet = -\frac{\omega}{c_0} \ln \frac{\rho_0 c_0 \bar{V}_1}{\bar{P}_1}, \quad (8)$$

where:  $\rho_0$  – the equilibrium density of the medium,  $\text{kg/m}^3$ ;  $p$  – the instantaneous pressure,  $\text{PA}$ ;  $c_0$  – the speed of sound in the liquid phase,  $\text{m/s}$ ,  $\bar{V}$  – instantaneous volume content of bubbles. Analysis of the dependence (8) shows that the absorption rate corresponds to the maximum efficiency of the cavitation process. In Fig. 3 shows the dependence of the absorption coefficient in cavitating liquids on the intensity effects for different viscosity ratios.

The absorption coefficient can be a measure of the effectiveness of the cavitation effect. Evidence of this conclusion to serve the relationship of the absorption coefficient with the specific power of the shock waves on the basis of consideration of local area processing medium volume  $\Delta S \Delta x$ . So, using the law of conservation of energy, we find that the power density of the shock waves to be determined according to the expression:

$$P_{num} = \frac{\Delta S l}{\Delta x \Delta S} = \frac{\Delta S (I - I e^{-k \Delta x})}{\Delta x \Delta S} = \quad (9)$$

$$\frac{(I - I e^{-k \Delta x})}{\Delta x} = k \frac{I (1 - e^{-k \Delta x})}{k \Delta x} \approx k I,$$

where:  $\Delta I$  – the change in the intensity of this wave as a result of absorption,  $\text{W/m}^2$ .

The expression for the work of the cavitator in contact area has the form [6]:

$$A_k = \pi m_c A_0^2 \omega^2 \mu \quad (10)$$

where:  $m_c$  – mass technological environment;  $A_0$  – the amplitude of the contact zone;  $\mu$  – wave coefficient, which takes into account the influence of the environment on the movement of the cavitator.

Average power cavitator  $P_{cp}$ :

$$P_{cp} = 0,5 m_c A_0^2 \omega^3 \mu \quad (11)$$

Expressions (10) and (11) are the values of the unknown parameters of the work and power of the cavitator, which are implemented in the contact zone of the cavitator and technological environment. The difference of the dependence (11) from the existing ones lies in the fact that in the known dependence [4, 8, 9] used the concept of added mass, which is supposedly attached to the surface of the cavitator. In fact, the mass of the environment is variable [6] and depends on acoustic parameters in (11) takes into account the wave factor  $\mu$ . Under the conditions of pulsed energy transfer cavitator to the notion of vibration amplitude loses its definition, because the regime is not harmonic, but nonlinear.

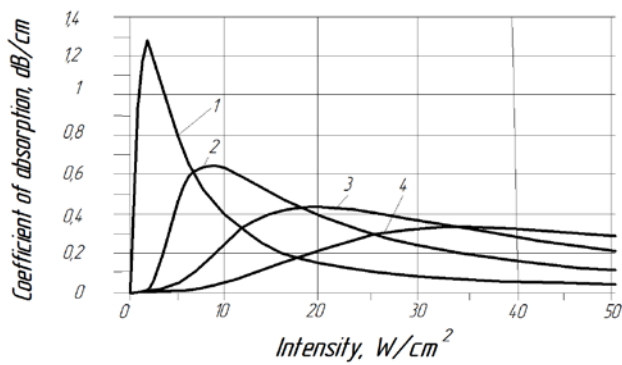


Figure 3: The dependence of the absorption coefficient in cavitating liquids on the intensity effects for different viscosity ratios: 1 - 1 MPa·s; 2 - 200 MPa·s; 3 - 400 MPa·s; 4 - 600 MPa·s

With this kind of movement is determined by the movement in the relevant time periods:  $t_{II} = t_1 + t_2$  where  $t_1$  – part of the period in a single move  $A_1$ , and  $t_2$  – in  $A_2$ . Denoting  $\alpha = t_1 / t_2$  и  $\omega_{cp} = 2\pi / t_{II}$  – the average frequency of;  $F_1, F_2$  – the amplitude of forces in the respective periods of oscillation of the contact zone.

Under these conditions, the expression of specific energy, per unit volume of the cavitation medium has the form:

$$\bar{E} = \frac{\Delta E}{V} = \frac{F \Delta x t_1}{\rho S \Delta x t_1} = \frac{F t_1 \omega_{cp}}{2\pi \rho S \alpha} \quad (12)$$

In the formula (12) contains all the components of parameters of the dynamic action of the cavitation device and the characteristics of the technological environment. Given formula (1 – 12) are initial information for development of algorithm of calculation of the cavitation device, which implements a harmonious and non-linear law of actions on the technological environment. And the absorption coefficient is a measure of the efficiency of ultrasonic cavitation, because of (9) follows: the specific energy of shock waves generated per unit time, is equal to the product of the absorption coefficient and the intensity of the primary ultrasound waves. Therefore, the absorption coefficient defines the ratio of useful energy created in the form of shock waves are necessary for the realization of cavitation process energy.

#### 4. CONCLUSIONS

1. An accurate description of cavitation processing technology of dispersed media depends on the choice of the model. The key parameter in the evolution of bubbles in an acoustic field is the energy, the components of which are the pressure coefficient of energy absorption, the time and speed of flow of the process.

2. We found that the characteristics of manufacturing environments, which can serve to define a rational model of technological process are: the load on the emitter, rheological properties and conditions influence the emitter.

3. The absorption coefficient is a measure of the efficiency of ultrasonic cavitation, i.e., determines the ratio of useful energy created in the form of shock waves are necessary for the realization of cavitation process energy.

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