



UNIVERSITI PUTRA MALAYSIA

**ISOTHERMAL AND THERMAL ANALYSES OF
ELASTOHYDRODYNAMIC LUBRICATION
OF HARD ROLLING CONTACT**

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By

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TABLE OF CONTENTS

		Page
ACKNOWLEDGMENTS	11
LIST OF TABLES	v1
LIST OF FIGURES	v11
LIST OF PLATES	x1
LIST OF ABBREVIATIONS	x11
ABSTRACT	xv
ABSTRAK	xv111
CHAPTER		
I	INTRODUCTION	1
	Background Overview	1
	Aims of Current Research	4
	Thesis Layout	4
II	LITERATURE REVIEW	6
	Introduction	6
	Elastohydrodynamic Phenomena	7
	Theoretical and Experimental Investigations	9
	Elastohydrodynamic Lubrication System	12
	Problem of Elastohydrodynamic System Contact	14
	Line Contact	15
	Point Contact	19
	Dry Contact	20
	Lubricant Contact	24
	Isothermal EHL	26
	Thermal EHL	28
	Closure	31
III	THEORY.....	32
	Introduction.....	32
	Characteristics of Lubricant	33
	Reynolds Theory.....	37
	Thermal Theory	38
	Dimensionless Parameters	40
	Influence of Load	43



	Influence of Speed	45
	Influence of Material Properties	46
	Theoretical Framework.....	49
	Theory of Models	53
	Model-A	54
	Model-B	56
	Model-C	58
	Model-D	60
	Closure	61
IV	ISOTHERMAL STUDIES	62
	Introduction	62
	Isothermal Rolling Contact	63
	Isothermal Model Verification	64
	Verification of Model A	65
	Verification of Model B	65
	Pressure Distribution	66
	Model-A	67
	Model-B	68
	Film Thickness	70
	Closure	71
V	THERMAL STUDIES	87
	Introduction	87
	Thermal-1 Model	88
	Thermal-2 Model	91
	A Comparison of Isothermal and Thermal Results	92
	Closure	94
VI	CONCLUSIONS AND RECOMMENDATIONS ..	112
	Conclusions	112
	Recommendations	114
	REFERENCES	116
	APPENDICES	123
	BIOGRAPHICAL SKETCH	133



LIST OF TABLES

Table		Page
1	Properties of Some Synthetic Lubricants and Mineral Oil	36
2	Variation of Film Thickness with Load Dimensionless Variables	45
3	Variation of Film Thickness with speed Dimensionless Parameter	46
4	The Variation of Minimum Film Thickness with the Material Dimensionless Parameter .	47
5	Classification of Models	53
6	Properties of Lubricants used in the Models Calculations, Mineral Naphthenic (TN22) and Synthetic Cycloaliphatic (ST40)	73



LIST OF FIGURES

Figure		Page
1	A Wide General Applications of EHL for Line Contact in Machine Elements	17
2	EHL Line Contact Geometry	19
3	EHL Point Contact Geometry	21
4	A Front View of a Simple Rolling Model ...	25
5	Classification of Various Liquid Lubricant	35
6	Heat Balance at the Oil Film Conjunction ..	39
7	Variation of the Dimensionless Pressure and Film Thickness as a Function of the X- Coordinate for $U=1.0 \times 10^{-11}$ $W=1.638 \times 10^{-5}$ and $G=5000$	42
8	Typical Film Shape and Pressure Distribution Results in EHL Hard Rolling ..	44
9	Variation of Film Thickness with Load at $U=3.0 \times 10^{-11}$ AND $G=4.6618 \times 10^3$	48
10	Variation of Film Thickness with Speed at $W=8.6 \times 10^{-7}$ and $G=4.6678 \times 10^3$	48
11	Rolling Contact Geometry of Hard Rolling ..	50
12	Geometrical Shape of Film Thickness in Hard Rolling Contact	51
13	Sketch to Illustrate Calculations of Pressure Distributions Acting in Interval..	55
14	Schematic Representation of Pressure Distributions Profile	55
15	Isothermal Conditions for EHL of Hard Rolling Process	72
16	Isothermal Model of Hard Rolling Contact ..	73



17	Pressure Distributions Results of Model-A Compared with a published Results of Okamura (1982).....	75
18	A comparison Between the Pressure Distribution Results of Model-A and Model-B	76
19	Pressure Distributions Results of Model-B Compared with a Published Results of Jacobson (1991)	77
20	Effect of Dimensionless Load Parameter on Pressure Distributions for Isothermal EHL of Model-A	78
21	Pressure Distribution Results for Isothermal EHL of Hard Rolling (Model-B) Using Mineral Lubricant	79
22	Pressure Distribution Results for Isothermal EHL of Hard Rolling (Model-B) Using Synthetic Lubricant	80
23	Pressure Distribution Results for Isothermal EHL of Hard Rolling Compared for Synthetic and Mineral Lubricant	81
24	Film Thickness Results for Isothermal EHL of Hard Rolling Using Mineral Lubricant ..	82
25	Film Thickness Results for Isothermal EHL of Hard Rolling (Model-B) Using synthetic Lubricant	83
26	Film Thickness Results for Isothermal EHL of Hard Rolling (Model-B) Compared for Mineral and Synthetic Lubricant	84
27	Pressure Distribution and Film Thickness Results for Isothermal EHL of Hard Rolling (Model-B) Using Mineral Lubricant	85
28	Pressure Distribution and Film Thickness Results for Isothermal EHL of Hard Rolling (Model-B) Using Synthetic Lubricant	86
29	Pressure Distribution Results for Thermal-1 EHL of Hard Rolling Using Mineral Lubricant	95



30	Pressure Distribution Results for Thermal-1 EHL of Hard Rolling Using Synthetic Lubricant	96
31	Comparison of Pressure Distribution Results for Mineral and Synthetic Lubricant of Thermal-1 EHL of Hard Rolling	97
32	Film Thickness Results for Thermal-1 EHL of Hard Rolling Using Mineral Lubricant	98
33	Film Thickness Results for Thermal-1 EHL of Hard Rolling Using Synthetic Lubricant ...	99
34	Comparison of Film Thickness Results for Mineral and Synthetic Lubricant of Thermal-1 EHL of Hard Rolling	100
35	Pressure Distribution and Film Thickness Results for Thermal-1 EHL of Hard Rolling Using Mineral Lubricant	101
36	Pressure Distribution and Film Thickness Results for Thermal-1 EHL of Hard Rolling Using Synthetic Lubricant	102
37	Pressure Distribution Results for Thermal-2 EHL of Hard Rolling Using Mineral Lubricant	103
38	Film Thickness Results for Thermal-2 EHL of Hard Rolling Using Mineral Lubricant	104
39	Comparison of Film Thickness Results for Thermal-1 and Thermal-2 EHL of Hard Rolling Using Mineral Lubricant	105
40	Pressure Distribution and Film Thickness Results for Thermal-2 EHL of Hard Rolling Using Mineral Lubricant	106
41	Comparison of Pressure Distribution Results for Isothermal, Thermal-1 and Thermal-2 EHL of Hard Rolling Using Mineral Lubricant ..	107
42	Comparison of Pressure Distribution Results for Isothermal and Thermal-1 EHL of Hard Rolling Using Synthetic Lubricant	108



43	Comparison of Film Thickness Results for Isothermal, Thermal-1 and Thermal-2 EHL of Hard Rolling Using Mineral Lubricant	109
44	Comparison of Film Thickness Results for Isothermal and Thermal-1 EHL of Hard Rolling Using Synthetic Lubricant	110
45	Comparison of Pressure Distributions with a Published Results (Wolff et al., 1992) for Thermal-1 Model, Using Mineral Lubricant.....	111
46	Equilibrium on an Element of Lubricant ...	125
47	Flow through a Column Fixed in Space	129



LIST OF PLATES

Plate		Page
1	A Typical Application of Extreme Lubricant in Rolling Mill Operation	18
2	Rolling Stands of Perawja Steel Complex ...	18
3	Railways a Rigid Straight Surface of Dry Contact	23
4	Railwheel Rolling over a Rail with Dry Contact	23
5	A Flow of liquid Lubricant in Hard Rolling Process	26



LIST OF ABBREVIATIONS

D_{ij}	Influence Coefficients to Calculate Elastic Deformation of Node I due to p_j
E	Elasticity Modulus
E'	Effective Elastic Modulus
E_0	Initial Elastic Modulus of Material in Contact
F_x	Force in x Direction
F_y	Force in y Direction
G	Shear Modulus
g	Acceleration of Gravity
h	Lubricant Film Thickness
h_c	Film Thickness at Maximum Pressure
h_s	Inlet Film Profile
H	Dimensionless Film Thickness, h/R
h_m	Film Thickness at Point of Maximum Pressure
H_{min}	Minimum Film Thickness
h_0	Film Thickness on Line of Centres
K	Lubricant Conductivity, $W/(m^{\circ}C)$
m_x, m_y	Mass Flow per unit Width, x and y Direction
p	Pressure
Q_{gen}	Rate of Generation of Heat per unit Volume
Q_{out}	Amount of Heat Flow out Oil Film
Q_{in}	Amount of Heat Flow into Oil Film
Q_{R1}	Amount of Heat loss via Roller1



Q_{R2}	Amount of Heat loss via Roller2
q	Reduced Pressure, $q = (1-e^{-\alpha P})/\alpha$
R	Equivalent Radius of Roller, $1/R = 1/R_1 + 1/R_2$
R_1	Radius of upper Roller
R_2	Radius of Lower Roller
R'	Radius of Curvature
T	Dimensionless Temperature, t/t_0
t	Time
U	Dimensionless Speed Parameter, $\eta_0 u/E'R$
u	Mean Surface Velocity in x direction, $1/2(u_1+u_2)$
u_1, u_2	Surface Velocities of Solids in x-direction
v_1, v_2	Surface Velocities, y direction
w_z	Load per unit Length of Roller
W	Dimensionless Load Parameter, $w_z/E'R$
x_E	Any value at the Inlet Region
x_1	Unknown Value in the Inlet Line Contact
x_0	Unknown Value in the Outlet Line Contact
x, y, z	Coordinates Axes

Greek Symbols

α	Pressure Exponent of Viscosity
τ	Shear Stress
γ	Shear Strain Rate



τ_{zx}	Lubricant Shear Stress in x direction in Plan whose Normal is z
τ_{zy}	Lubricant Shear Stress in y direction in plan whose Normal is z
η	Dynamic Viscosity Coefficient
η_0	Viscosity at Atmospheric Pressure
ρ	Lubricant Density
ν	Kinematic Viscosity
ζ	Combined Displacement of Two Solids

Subscript

E	Related to Value in the Outlet Line Contact
EHD	Elastohydrodynamic
EHL	Elastohydrodynamic Lubrication
i	Related to Value in the Inlet Line Contact
inlet	Related to Lubricant Inlet Position
out	Related to Lubricant Outlet Position



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In the field of industrial tribology, elastohydrodynamic lubrication (EHL) is a comparatively recent area of research. It only became properly established in the early 1960s. EHL of rolling contact is mainly divided to two phases (soft and hard), depending on the elasticity modulus of the material in contact. Hard rolling which relates to materials of high modulus of elasticity e.g. metal, is the part of interest in the present study.



The first objective of the research is to study the elastohydrodynamic lubrication problem of hard rolling line contact. Second is to investigate the isothermal and thermal conditions for EHL in hard rolling system. The contact geometry of the rolling process was specified as a line contact. An incompressible fluid flows in to the system. Under both isothermal and thermal conditions, a Newtonian lubricant was described. Two different widely used lubricants were tested. First, is a mineral Naphthenic (TN22) and the second is a synthetic Cycloaliphatic (ST40).

It is assumed that two rollers of equal radius are moving relatively with same speed on a plane of different velocity. Two coordinate axes were considered (x and y). The parameters and conditions of controlling the system of contact are theoretically selected to match the practical field situations. Newton-Raphson and the finite difference methods were represented in the mathematical technique used for computations.

Two isothermal models and another two of thermal conditions were developed. The analysis for the isothermal and thermal models did not show any obvious



difference between the mineral and synthetic oil film used. The results of pressure distribution and film thickness for the two thermal models under isoviscous and viscous conditions did not show any change in pattern. The comparison between isothermal and thermal behaviour has shown that the thermal effects have a strong influence on the pressure spike amplitude. The present results were compared and discussed with other earlier published results.



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**ANALISIS ISOTERMA DAN TERMA PELINCIRAN
ELASTOHIDRODINAMIK SENTUHAN GULINGAN KERAS**

oleh

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Didalam bidang tribologi industri, pelinciran elastohydrodynamic (EHL) adalah merupakan suatu yang agak baru kepada dunia penyelidikan. Ianya hanya menjadi satu kenyataan yang berasas pada sekitar awal tahun enampuluan. EHL yang berhubung dengan penggulingan bersentuh (rolling contact) telah terbahagi kepada dua fasa (lembut dan keras) yang bergantung kepada modulus keanjalan sesuatu bahan yang bersentuh. Penggulingan keras merupakan sesuatu yang berkait rapat dengan bahan yang mempunyai modulus keanjalan yang tinggi bahan logam, yang mana didalam penulisan ini ianya menjadi sebahagian dari kajian.



Objektif pertama daripada kajian ini adalah untuk mendapatkan pemahaman yang mendalam terhadap permasalahan sistem pelinciran EHL keatas gulingan keras. Kedua, adalah untuk mengkaji syarat isothermal dan terma terhadap EHL didalam sistem penggulingan keras apabila dua bahan pelincir dari jenis berlainan digunakan.

Persentuhan jometri didalam proses gulingan ini telah dispesifikasikan sebagai garis sentuh. Bendalir yang tidak mampat dialirkan didalam sistem ini. Didalam dua keadaan, iaitu isoterma dan terma, pelincir Newtonian dapat diandaikan. Dua bahan pelincir yang luas penggunaannya dari jenis yang berlainan telah diuji. Bahan itu adalah Mineral Naphthenic (TN22) dan Synthetic Cycloaliphatics (ST40).

Diandaikan dua pengguling yang berjejari sama berpusing pada halaju yang sama diatas satah kelajuan berbeza pada dua paksi koordinat X dan Y. Parameter dan syarat pengawalan sistem sentuhan secara teorinya dipilih untuk menyamai keadaan sebenar. Pada peringkat awal Kaedah Newton-Raphson dan kaedah perbezaan terhingga telah digunakan didalam teknik matematik untuk tujuan pengiraan.

Analisis untuk model isoterma dan terma tidak menunjukkan sebarang perbezaan yang ketara diantara



bahan lapisan mineral dan sintatik yang digunakan. Dua model isoterma dan dua model terma telah terbentuk. Keputusan pengagihan tekanan dan ketebalan lapisan untuk kedua-dua model tidak menunjukkan sebarang perubahan dari segi corak. Perbandingan diantara perlakuan isoterma dan terma telah menunjukkan bahawa kesan terma mempunyai pengaruh yang kuat terhadap amplitud pepaku tekanan.

Keputusan yang telah didapati mempunyai persamaan amat memuaskan dengan keputusan ujikaji yang sebelumnya.

Chapter I

Introduction

Background Overview

Lubrication is an essential feature of most modern machinery and has wide applications in the operation of many industrial processes such as forming, forging, drawing, extrusion, and rolling. There is a great body of technological experience in the production and application of lubricants, but the scientific study of lubrication and associated problems of friction and wear is comparatively a recent development.

Nowadays the area of contact mechanics has become a very important topic for so many researchers in the field of industrial tribology. In many modern industrial applications, the contact action is unavoidable and without it the manufacturing of so many parts will be



relatively impossible, because usually deformation of product takes place due to the force of contact action exerted by another part. Friction is usually present at these contacts by which heat is generated and wear occurs, leading to a highly significant loss of energy. It is estimated that one third of the world's energy resources in present use is needed to overcome friction in one form or another. Analysis of machine break-downs also shows that majority of cases of failures and stoppages are associated with interacting moving parts such as gears, bearings, couplings, sealings, cams, clutches and other machine elements (Stachowiak and Batchelor, 1993).

Recently the elastohydrodynamic lubrication (EHL) has become an effective means of controlling wear and reducing friction. In this system, lubricant is introduced at the local contact and is designed to prevent direct contact between the surfaces in relative motion. The first notable breakthrough occurred by Grubin (1949) when he managed to incorporate both the elastic deformation of the solid and the viscosity-pressure characteristics of the lubricant in analyzing



the inlet region of lubricated non-conformal machine elements.

EHL of hard rolling or sliding systems can be briefly described as a form of hydrodynamic lubrication where elastic deformation of the lubricated surfaces becomes significant (Hamrock, 1994). It relates to materials of high modulus of elasticity and is usually associated with highly stressed machine elements, such as rolling element bearings and gears. The contact conditions and the controlling parameters of EHL systems for hard contact are now being investigated leading to the development of power transmission techniques which are expected to take the advantage of the system concept in a rolling configuration.

In a fully developed EHL, the elastic deformation of the solids is often significant relative to the thickness of the fluid film separating them and the contact pressure is high enough to significantly increase the lubricant viscosity within the junction. In this research the pressure distribution and film thickness in EHL for hard rolling contact will be



expressed in terms of isothermal and thermal analysis under various conditions. Since pressure and film thickness both are the most significant factors in EHL system.

Aims of Current Research

The main aims of this study are:

- 1) to study the elastohydrodynamic lubrication problem of hard rolling line contact,
- 2) to investigate the isothermal and thermal conditions for EHL in hard rolling system.

Thesis Layout

In this thesis, Chapter II includes a literature review in the field of elastohydrodynamic lubrication, theoretical and experimental investigations and explanations for the EHL system process covering the principles of line and point contact. Also given is a general description of dry and lubricant contact. Isothermal and thermal EHL are also included.