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Towards turbine blade production with zero waste

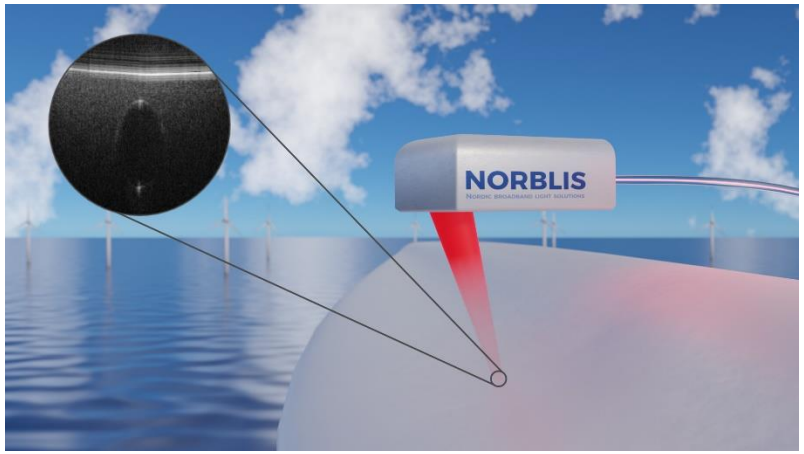
Horizon Europe 101058054

TURBO public presentation

https://turboproject.eu

Presentation outline

- **Overview**
  - Consortium
  - Key objectives
  - Partner contributions
- **Supporting technologies**
  - Simulation
  - In-line monitoring
  - NDT of blade coatings
- **Manufacturing technologies**
  - Digital twin
  - Improved composite manufacturing
  - Sustainability assessment
  - TURBO demo



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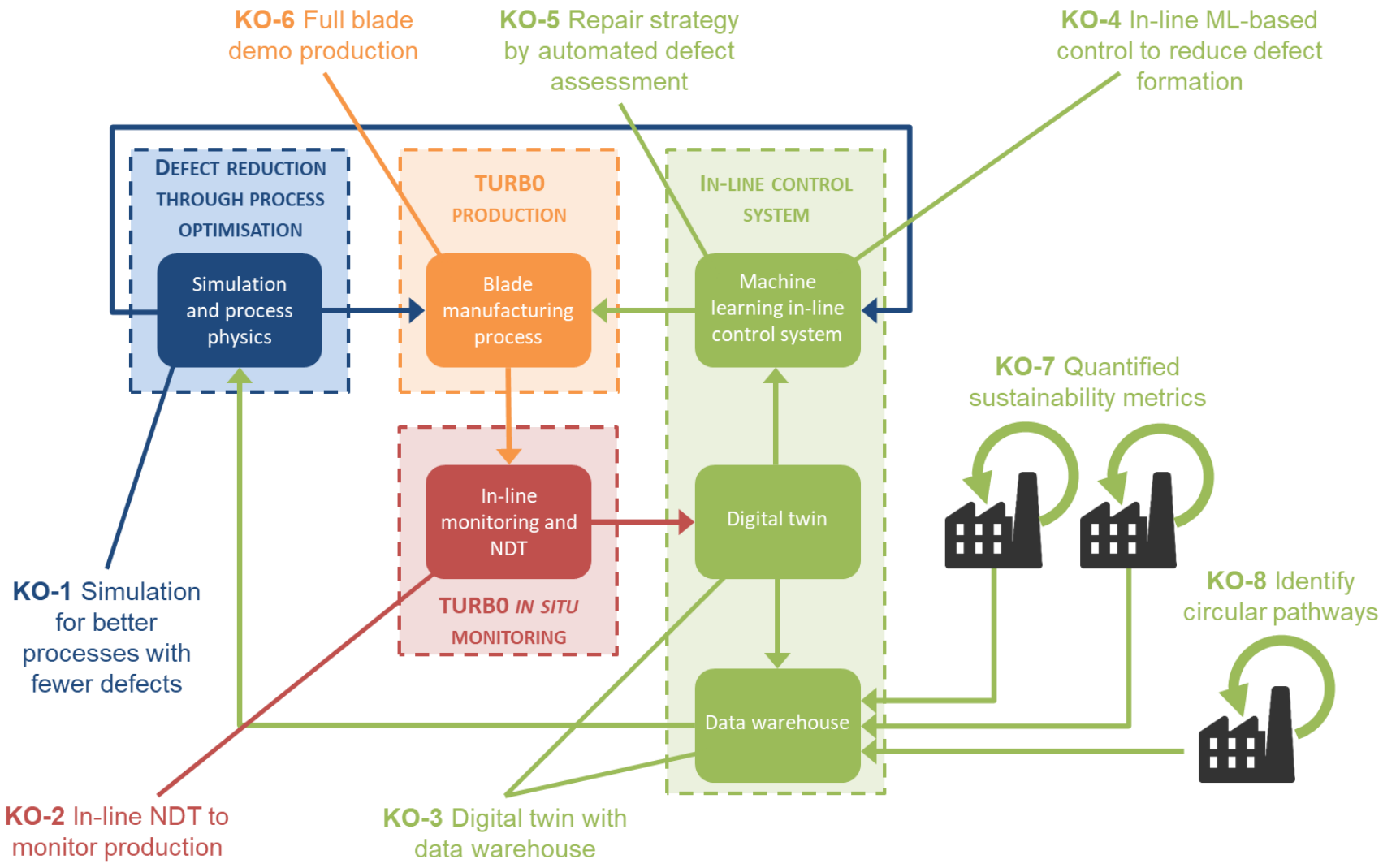
Consortium

No.	Short name	Name	Country
Beneficiaries			
1	DTU	DANMARKS TEKNISKE UNIVERSITET	DK
2	SGRE	SIEMENS GAMESA RENEWABLE ENERGY AS	DK
3	ESI	ESI GROUP	FR
4	UPV	UNIVERSITAT POLITECNICA DE VALENCIA	ES
5	SYN	SYNTHESITES	BE
6	NORBLIS	NORBLIS APS	DK
7	VIV	VIVID COMPONENTS GERMANY UG	DE
8	ARDITEC	ARDITEC	FR
Associated partners			
9	NCC	NCC OPERATIONS LIMITED	UK
10	CPI	CENTRE FOR PROCESS INNOVATION LIMITED	UK

TURBO key objectives



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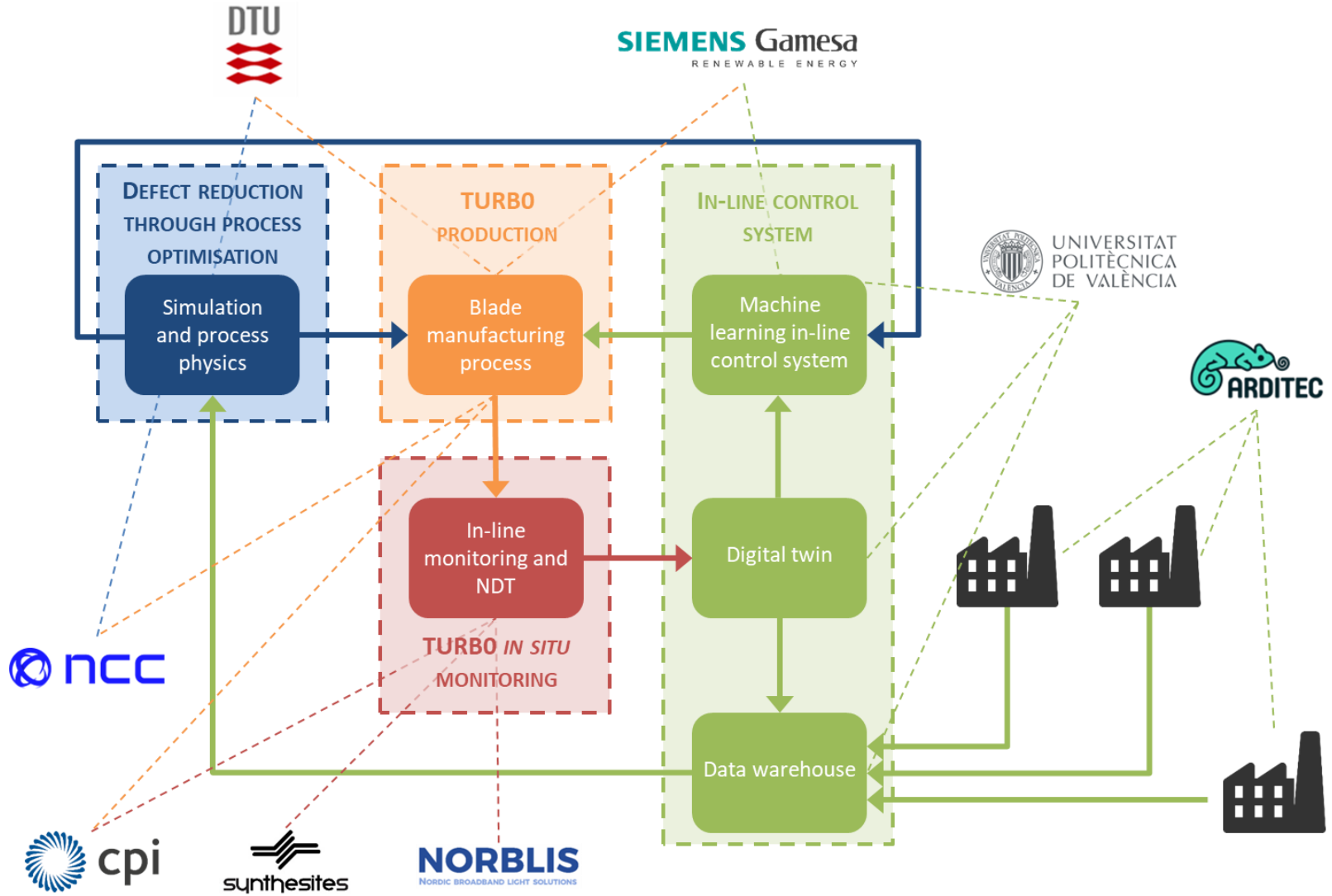
TURBO partner key contributions



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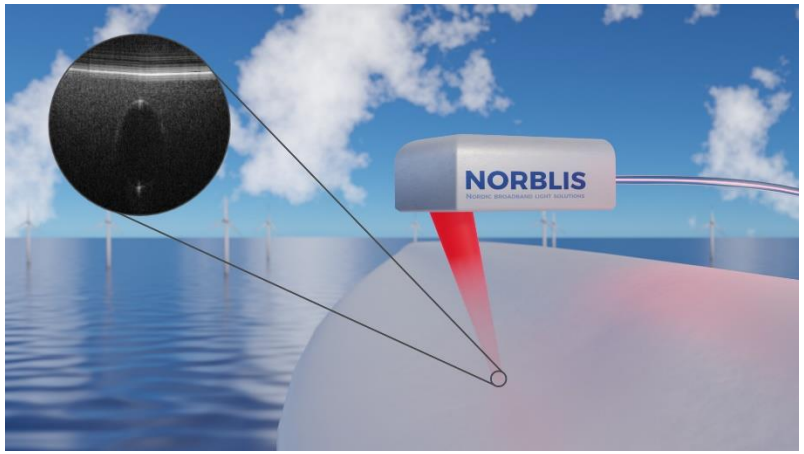

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Simulation

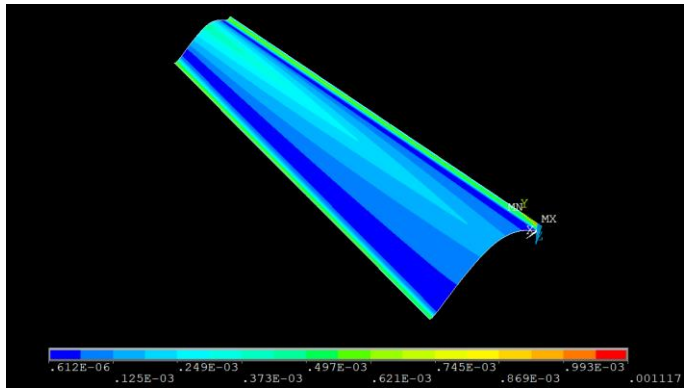
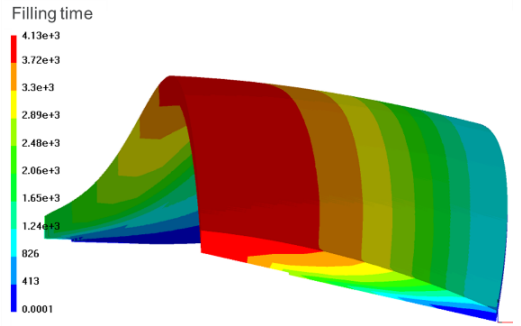


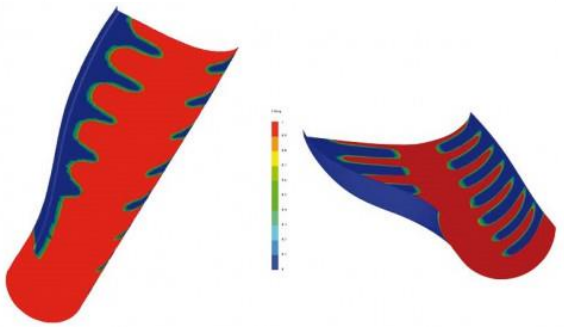
Image courtesy of DTU Construct

- What ?
  - Numerical simulation combined with sensor data
  - Used to minimise defect formation by:
    - Defining the manufacturing processes
    - Understanding how the process should be modified in real-time in response to *in situ* monitoring data

- How ?
  - Multi-scale modelling of the manufacturing process
    - From virtual characterisation of the local material properties to high fidelity analysis of the manufacturing of the blade
  - Exploring the field of possibilities in real time
    - By the combination of advanced AI techniques (model order reduction, machine learning *etc*.)
  - Generating physical-based prediction in a decision support system for the production hybrid sensor



30 meters wind spar cap infusion



Images courtesy of ESI Group

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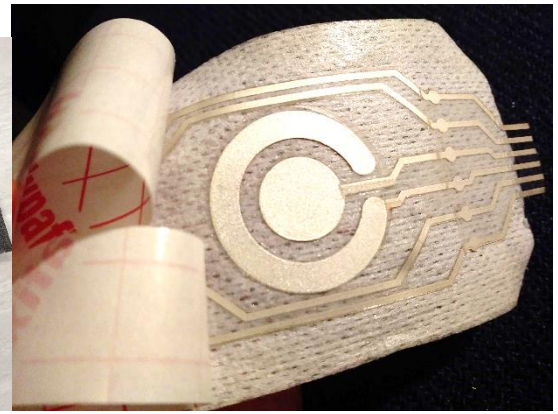
In-line process monitoring

- Synthesites TURBO system will
  - Measure resin arrival during infusion and temperature measurement (≤ 56 points)
  - Calculate online resin viscosity and gelation time
  - Track the evolution of glass transition temperature (T_g) at several locations
  - Broadcast all data in real-time to help define system control signals

Images courtesy of Synthesites

- CPI will develop a TURBO embedded wireless sensor system
  - Measures resin arrival and temperature
  - Fabricated on flexible substrate
  - Wireless communications will send data from inside the mould (*i.e.* LoRaWAN)



Images courtesy of CPI

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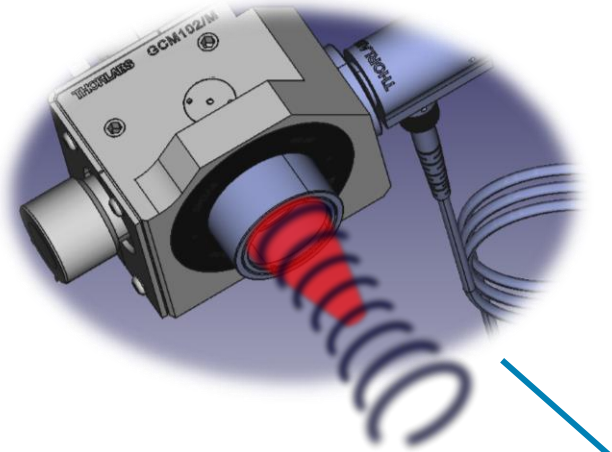
NDT of blade coatings

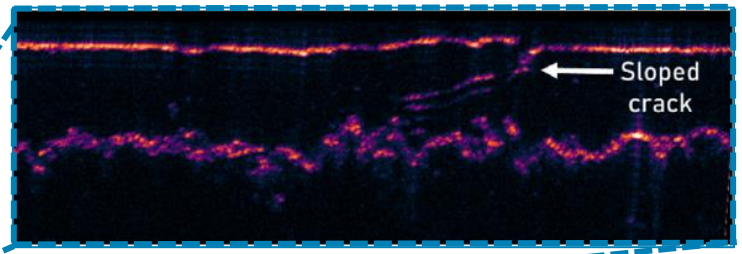
- First industrial-scale combined thermography and mid-IR optical coherence tomography (OCT) scanner



- Deep penetration of thermography combined with new technology of mid-IR OCT

- For *sub-surface* defect detection

- High resolution images of the critical upper layers



- Demonstrated on ship hulls

Petersen, Christian R., *et al.* "Non-destructive subsurface inspection of marine and protective coatings using near-and mid-infrared optical coherence tomography." Coatings **11**: 877 (2021).

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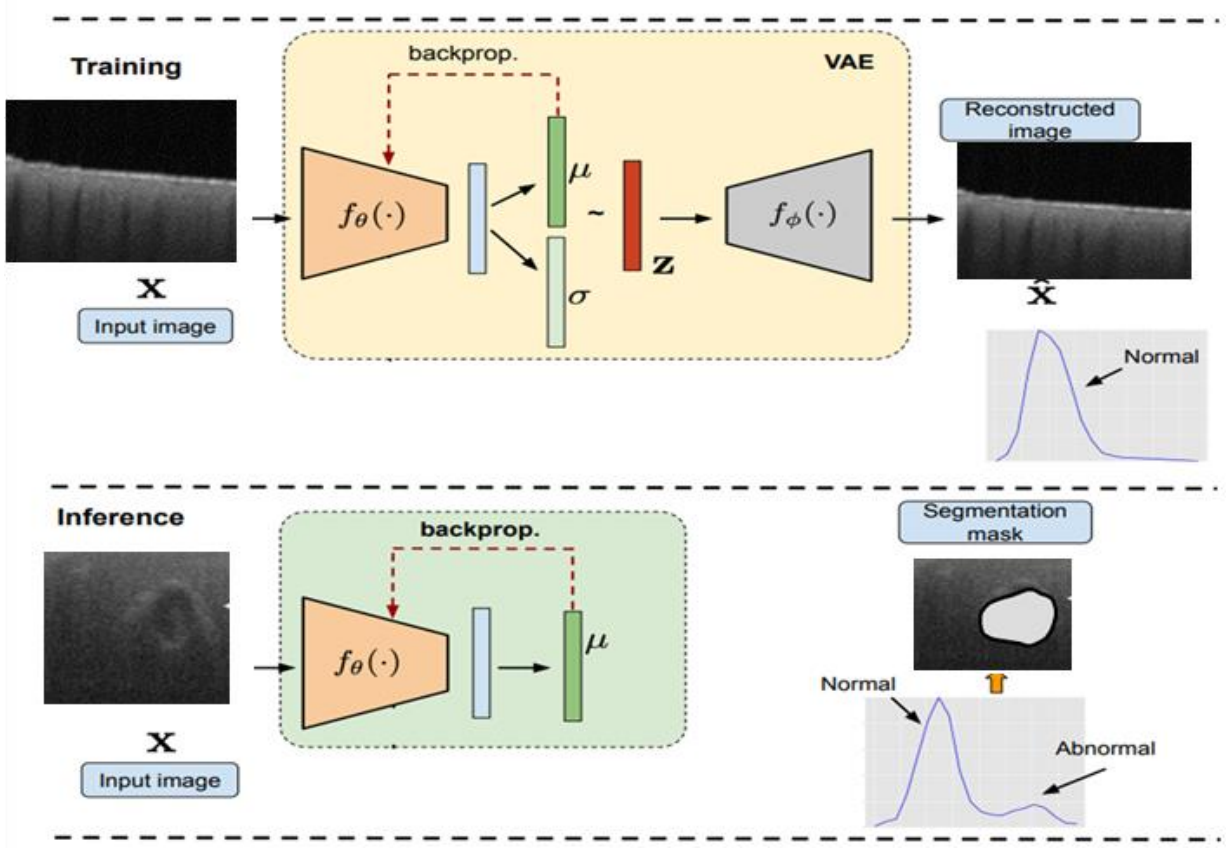
Machine learning analysis for NDT of blade coatings

- DTU will develop a supercontinuum extending to longer mid-IR wavelengths (*e.g.* 4 μm)
  - These wavelengths penetrate deeper than traditional near-IR OCT systems (typically 1.3 μm)
  - Source is based on a 2 μm laser to pump ZBLAN fibre

- UPV will develop machine learning based algorithms
  - Unsupervised anomaly detection techniques
  - Used to detect and segment different defects in OCT images without annotations



Constrained unsupervised anomaly classification and segmentation

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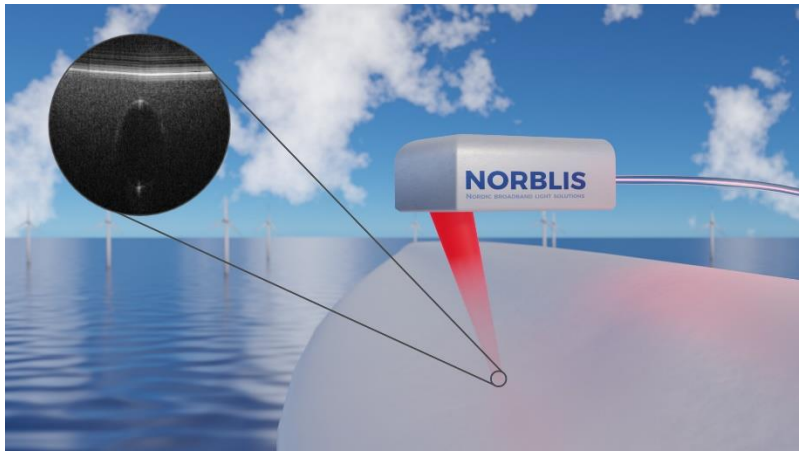
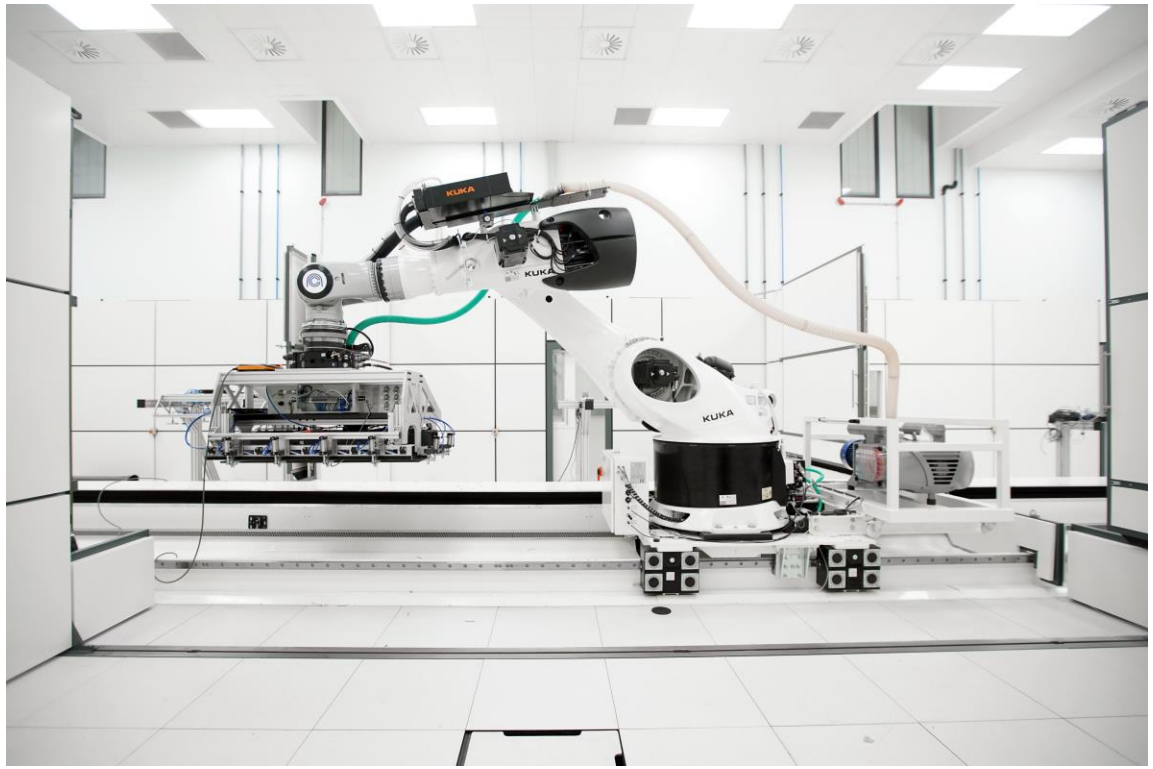


TURBO digital twin framework

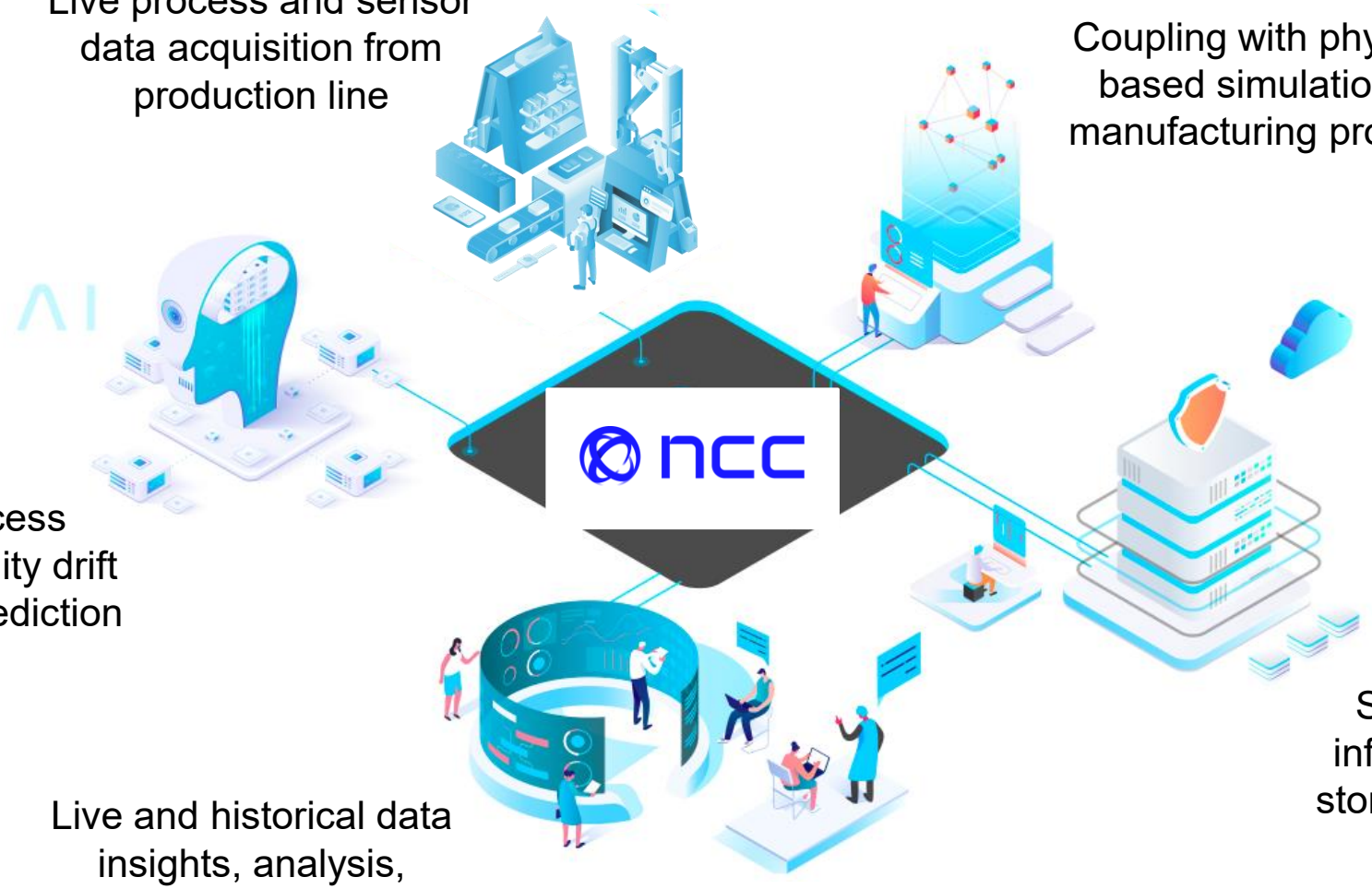
- NCC will develop a self-adaptive manufacturing process
  - Digital framework for zero waste wind turbine blade manufacturing
- Key steps:
  - Scale-up of manufacturing and simulation to a full scale blade demonstrator
  - Combine process and sensor data with machine learning and physics-based simulations
  - Provide live manufacturing quality insights and corrective feedback loop control
  - Development of a secure digital twin architecture scalable for industrial production environments



TURBO digital overview

Live process and sensor data acquisition from production line

Coupling with physics-based simulation of manufacturing process



ML-based process anomaly and quality drift evaluation and prediction

Secure hybrid data infrastructure for data storage and processing

Live and historical data insights, analysis, notifications and alarms

Improved composite manufacturing

- TURBO objective and tasks
  - SGRE will integrate the TURBO advances into infusion and control systems, particularly
    - Lessons from process simulation
    - Machine-learning based analysis of the digital twin based on in-line process monitoring and NDT
  - These objectives require a:
    - Manufacturing system interface to interpret and process the data from simulation and digital twin
    - Real-time infusion control system (hardware and software) based on data from the in-line sensors and NDT devices during infusion

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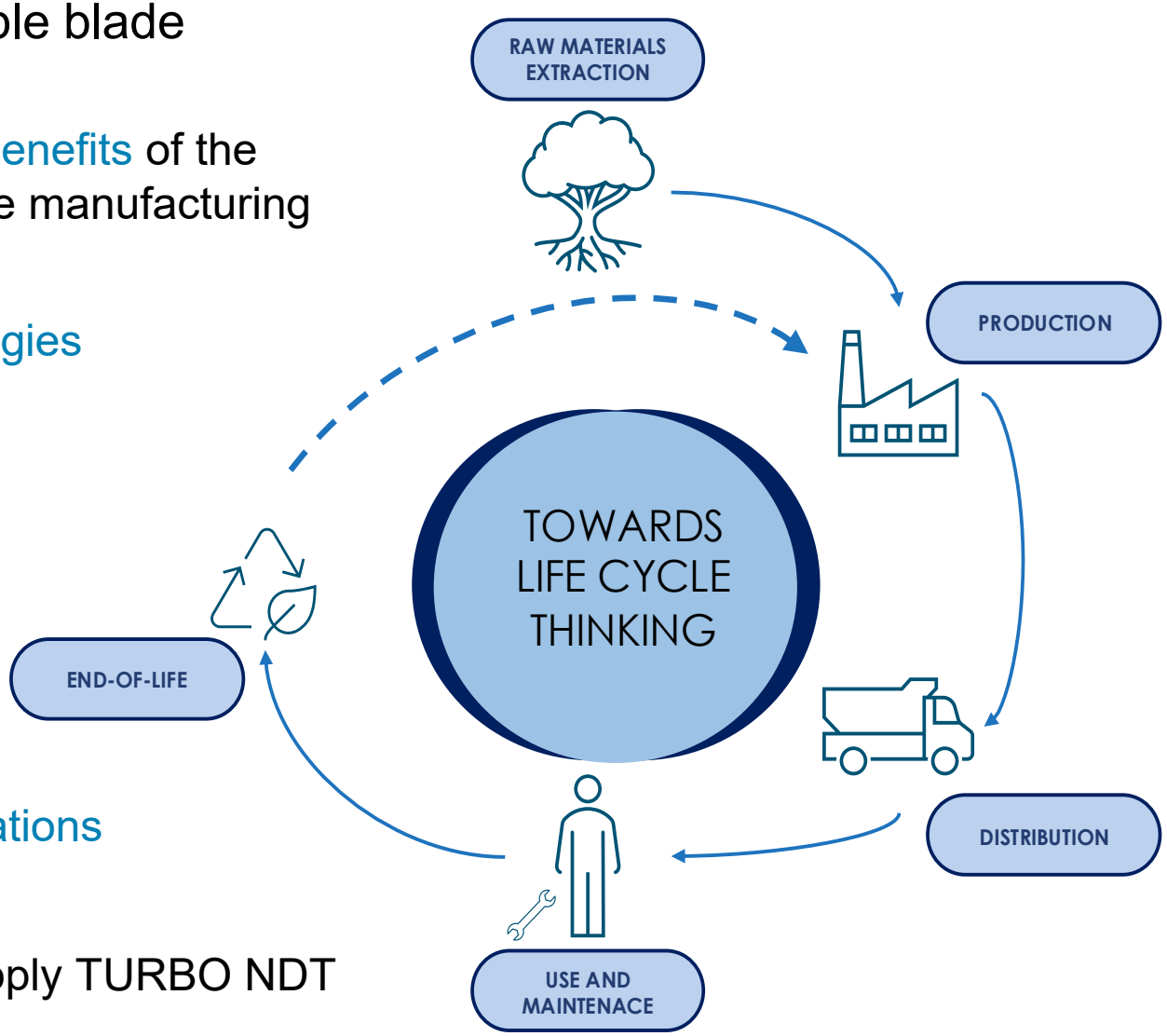
Sustainability assessments

- Arditec will help to develop circular and sustainable blade manufacturing by:
  - Assessing the environmental, economic and social benefits of the innovative value chain in comparison to current blade manufacturing processes
  - Using standardised life cycle assessment methodologies
    - LCA (ISO 14040/14044)
    - Life Cycle Costing (LCC, ISO, 2006)
    - Social LCA (UNEP/SETAC)
  - Developing circular pathways for production waste
    - Material Circularity Indicator (MCI) methodology developed by the Ellen MacArthur Foundation
  - Contributing to current relevant standards and regulations
    - IEC 61400-5/IEC 61400-28-2/REACH
  - Training SGRE personnel to operate the sensors, apply TURBO NDT methods and interpret the results



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TURBO demo

- SGRE will dedicate space in its Aalborg factory to preparations for the TURBO demo
- A large section of a >80 m blade will be used to demonstrate TURBO advances
  - Allows analysis of large blade aspects not possible on a smaller scale blade
  - Assess how TURBO technology can be integrated into a real production line
  - Quantify benefits in terms of improved quality and reduced scrap

Images courtesy of Siemens Gamesa Renewable Energy A/S.

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Thank you for your attention!

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This project has received funding from the European Union's Horizon Europe research and innovation programme under grant agreement No. 101058054 (TURBO).This includes funds from UK Research and Innovation (UKRI) under the UK government's Horizon Europe funding guarantee [grant numbers 10037822, 10042318 and 10044756] as part of the topic ID HORIZON-CL4-2021-TWIN-TRANSITION-01-02. Views and opinions expressed are however those of the authors only and do not necessarily reflect those of the European Union or UKRI. The European Union or UKRI cannot be held responsible for them.

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