

13th CIRP Conference on Computer Aided Tolerancing

The coherent point drift algorithm adapted for fixtureless metrology of non-rigid parts

Ali Aidibe*, Antoine Tahan

Products, Processes, and Systems Engineering Laboratory (P²SEL), Ecole de Technologie Supérieure, 1100 Notre-Dame West, Montreal H3C 1K3, Quebec Canada

Abstract

Unlike the metrology of rigid parts, no viable and industrial solutions in the case of non-rigid parts are available. Due to gravity load and residual stress, non-rigid parts (flexible, compliant) may have in a Free State condition a significant different shape than their corresponding nominal geometry (CAD model). As a result, very expensive and specialized fixtures mounting are needed by the industry to constrain the component during the inspection. Dealing with this real industrial problem, this paper proposes a new method to inspect non-rigid parts without these specialized fixtures. In this method, the CAD model is smoothly modified to fit the scanned part respecting two criteria that belong to non-rigid parts. The first criterion is the isometric transformation (or the condition that stretch should be very small) between the original CAD model and the modified one. The second criterion is the Euclidian distance between the modified CAD model and its corresponding scanned part. Our approach consists of adapting the Coherent Point Drift powerful non rigid registration method to meet the specifications of non-rigid parts. In other words, by minimizing the two above criteria, the paper proposes a 'flexible' registration to align the scanned manufactured compliant part to its nominal model in order to compare them and to deliver an inspection report. Satisfying results were obtained when validating our proposed method on a case study taken from the aerospace industry. The low percentage of error between the estimated value of defect and the reference one reflect the effectiveness of our method.

© 2014 The Authors. Published by Elsevier B.V. Selection and/or peer-review under responsibility of Professor Tan Jianrong .

Keywords: geometric inspection; dimensionnal inspection; registration; GD&T; fixtureless; flexible part; tolerancing

1. Introduction

Geometric and dimensional tolerance standards, such as ASME Y14.5 or ISO GPS assume inspections of manufactured mechanical parts are carried out in a Free State condition [1, 2]. This is an inappropriate assumption when dealing with non-rigid parts such as thin wall parts used in automotive and aerospace industries. Due to gravity effect and residual strain, these parts may have, in a Free State condition, a significantly different form comparable to their nominal model.

Specialized fixtures are then needed to constrain these non-rigid parts during the inspection process. Fig.1 shows a typical aircraft skin panel mounted and conformed on a representative jig causing substantial costs for industry. For instance, the preparation time to inspect this panel is around 60 man-hours. That is why fixtureless quality control of non-rigid parts has become a challenging task in the transport industry.

This subject has been studied by many researchers and an exhaustive review has been provided in [3]. The state of the art in machine vision inspection research and technology has been presented by Malamas *et al.* [4]. Ravishankar *et al.* [5] proposed a rigid registration method for non contact inspection of freeform surfaces by matching shapes based on the modified Iterative

* Corresponding author. Tel.: +1-514-979-1286; E-mail address: ali.aidibe.1@etsmtl.net.

Closest Point (ICP) method to define a criterion for the acceptance or rejection of a part. Weckenmann *et al.* [6] as well as Jaramillo *et al.* [7] proposed an approach based on a finite element method to obtain a physical deformation of the original CAD model, and radial basis functions to approximate this deformation faster and in real time, opening the door to on-line inspection of deformable parts. In 2010, Abenhaim *et al.* [8] proposed the Iterative Displacement Inspection (IDI) algorithm by iteratively deforming smoothly the CAD mesh until it matches the scanned part without profile deviation or measurement noise. An improvement of this method has been presented in [9]. By taking advantage of the geodesic distance metric properties, Radvar-Esfahlan *et al.* [10] proposed the Generalized Numerical Inspection Fixture (GNIF) algorithm. An improvement of their method has been presented in [11]. In 2013, Wen *et al.* [12] presented an evaluation of freeform surface profile error based on Quasi Particle Swarm Optimization algorithm (QPSO) to implement the localization between the Measurement Coordinate System (MCS) and the Design Coordinate System (DCS), and on a surface subdivision method to search the closest points on the design model corresponding to the measured points. Furthermore, Aidibe and Tahan [13] developed in 2013 a new fixtureless inspection method for compliant parts by combining the curvature estimation with the Thompson-Biweight test as identification module. In their work, they proposed a new method to quantify the flexibility/rigidity of a given industrial compliant part. The proposed quantification method will allow industries to properly classify their mechanical components and will be strongly useful during tolerancing operations. They categorized non-rigid parts into three different categories.



Fig. 1. Aircraft skin panel conformed on a specialized jig

Zone A for the rigid parts where the displacement induced by a reasonable force during inspection is less than 10% of the parts' assigned profile tolerance. **Zone B** for the compliant parts. Parts classified in this zone are

the most problematic to manage with regards to the specification, tolerance, and inspection of their geometric and dimensional requirements. By applying a certain amount of force, these parts get closer to the third zone. Finally, **Zone C** for the very flexible parts. In this zone very large deformations are produced just by the effect of the gravity (such as textile, human tissue, vessels, etc.).

There are many registration algorithms that offer robust and fast solutions they are adapted to parts located in Zone A and Zone C cases. For example, the Iterative Closest Point (ICP) algorithm developed in 1992 by Besl and Mackay represents one of the most important 3D rigid matching registration techniques [14]. It works very well with rigid parts located in Zone A. On the other side, the Coherent Point Drift (CPD) algorithm developed by Myronenko and Song [15] and widely used in the medical registration domain, works well with the very flexible parts located in Zone C. But these algorithms do not match with the alignment problems of relatively compliant parts located in Zone B.

Section 2 of this paper proposes our approach to fixtureless inspect flexible parts located in the Zone B. The approach aims to develop a 'flexible registration' that retains the preservation of curvilinear distances (geodesic) while taking into account the presence of manufacturing profile [\triangle , \cap] defect areas on the inspected part.

2. Methodology

Originally, the CPD algorithm includes two hyper parameters λ and β which are set manually [15]. Both parameters reflect the amount of smoothness regularization. Parameter β controls the rigidity and the locality of spatial smoothness while parameter λ reflects its strengths. The proposed approach consists of an optimization of the regularization parameters in order to adapt the CPD algorithm to the problem of relatively flexible parts as mentioned in the introduction.

In other words, this paper proposes to automatically estimate parameters λ and β by an iterative process that decides how much smoothing is necessary and how wide the range of interaction should be with respect to certain specific distance criteria. These criteria belong to relatively compliant parts (Zone B) and they are described in Fig. 3. The proposed method main steps are presented in Fig. 2.

The approach is started by initializing λ and β . Typically $\lambda_0 \in [1 \ 50]$ and $\beta_0 \in [1 \ 20]$.

Let $S = \{s_1, s_2, s_3, \dots, s_n | s_j \in \mathbb{R}^3\}$ be the set of n nodes representing the meshed CAD model and $P = \{p_1, p_2, p_3, \dots, p_m | p_j \in \mathbb{R}^3\}$ be the set of m | $m \gg n$

nodes representing the scanned part. The ICP algorithm is used in order to prealign the two given point sets in a common coordinate system (step 1 – Fig.2).

The CAD model is smoothly modified by the CPD to fit the scanned part respecting two criteria that belong to non-rigid parts (steps 2, 4 and 5 – Fig.2).

The first criterion Δ_{str} is the condition that stretch difference should be very small between the original CAD model and the modified one (Fig 3a).

The second criterion Δ_D is the Euclidian distance between the modified CAD model and its corresponding scanned part (Fig. 3b).

$S' = \{s'_1, s'_2, s'_3, \dots, s'_n | s'_j \in \mathbb{R}^3\}$ is the set of n nodes resulting from this alignment. A $dsearchn$ function in Matlab® based on Quickhull [16] is used to find C which is the set of n nodes representing the closest point in P to S' (step 3 – Fig. 2).

Parameters λ and β are then optimized by minimizing the proposed objective function that combines the normalized root mean square of the two described

criteria as shown in equations 1, 2 and 3. The detailed explanation with equations are provided in Fig. 3.

$$NRMS_{Str} = \frac{\sqrt{\frac{\sum \|\Delta_{str}\|^2}{n-1}}}{\overline{Str}_{S'}} \tag{1}$$

$$NRMS_D = \frac{\sqrt{\frac{\sum \|\Delta_D\|^2}{n-1}}}{\overline{D}_{C,S'}} \tag{2}$$

Where $\overline{Str}_{S'}$ is the mean value of the stretch criteria of S' and $\overline{D}_{C,S'}$ is the mean value of the Euclidian distance between C and S' .

$$[\beta, \lambda] = \operatorname{argmin} F(\beta, \lambda | C, S, S') \tag{3}$$

Where

$$F(\beta, \lambda | C, S, S') = 20 \times NRMS_{Str} + NRMS_D \tag{4}$$

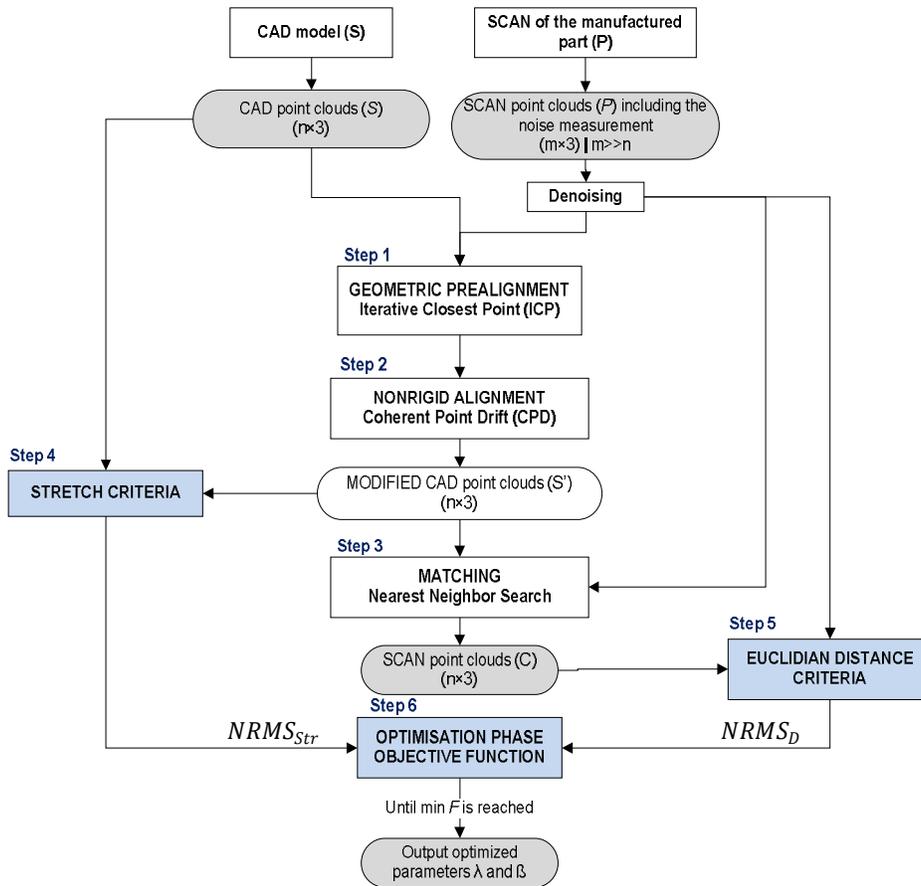


Fig. 2. Main steps of the proposed method

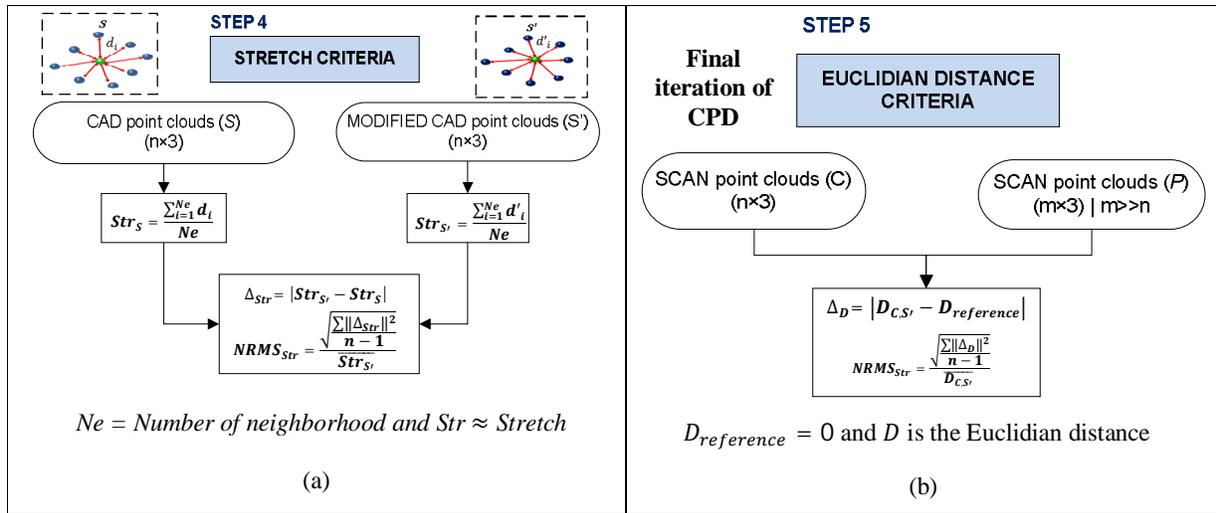


Fig.3 Developed criteria belonging to non-rigid part: (a) Stretch criteria (b) Euclidian distance criteria

3. Case studies

3.1. Description

In this section, an industrial case study is performed to validate the proposed methodology.

The test panel represented in Fig. 4a is made with an aluminum gauge 14 (1.63 mm). The shape varies significantly from its corresponding nominal at Free State. Consequently, the part is mounted on a very complicated and specialized jig designed by the First Article Inspection (FAI) department at an industrial plant as shown in Fig. 4b. Fig. 5 and Table 1 describes the different positions of the imposed profile defects. V0 test is performed to ensure that the method does not induce a

bias. In other words, no defects should be detected if there aren't any imposed defects in the simulation part. In addition, five additional tests (V1 to V5) are performed to validate the methodology.

The scanned parts are compared with their corresponding nominal models using the proposed method. All case studies are performed on an Intel Core i7, 1.73 GHz, 4.0 GByte using a 64 bit operating system. The optimization phase is performed using the constrained nonlinear minimization (fmincon) on a Matlab R2012b platform.

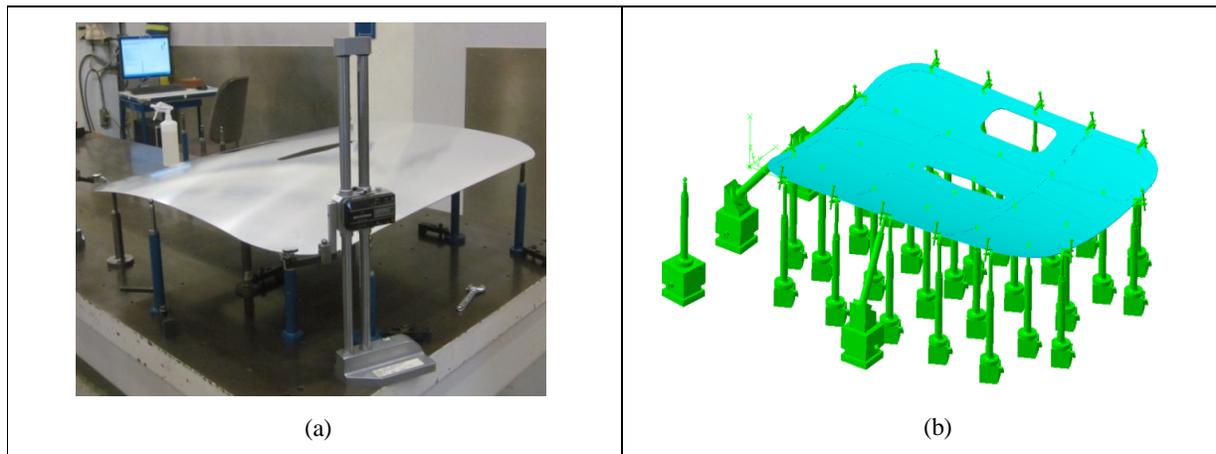


Fig. 4. Non rigid part case study: (a) at free state (b) at conformed state

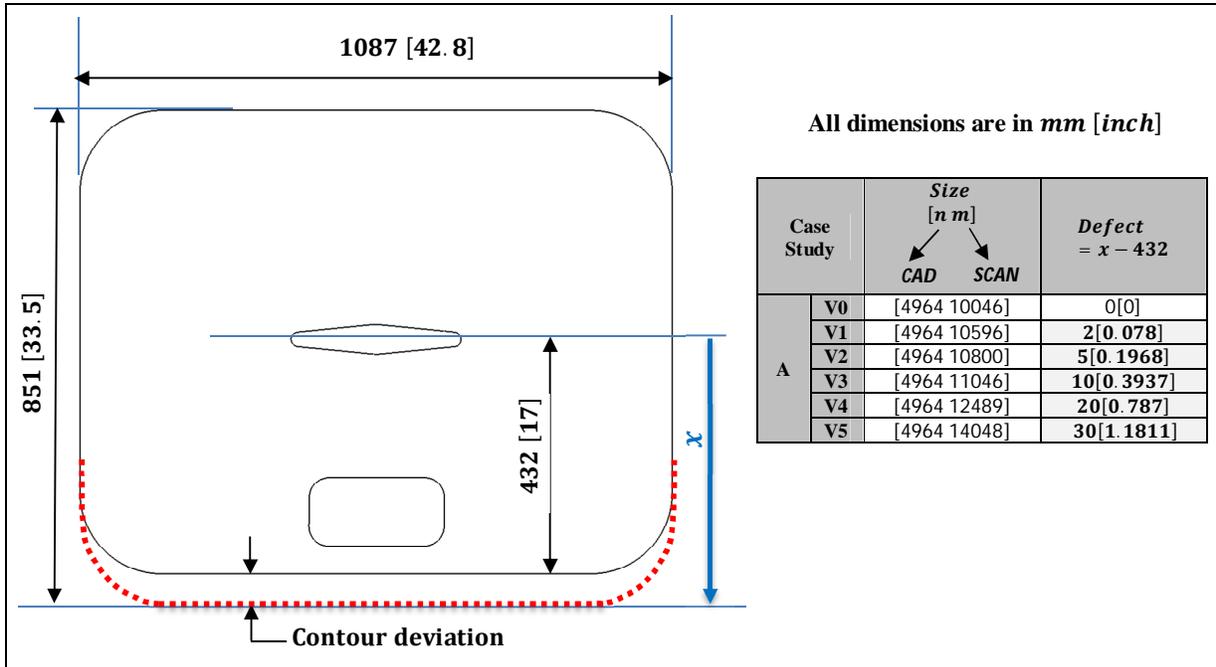


Fig. 5. Non rigid part case studies description

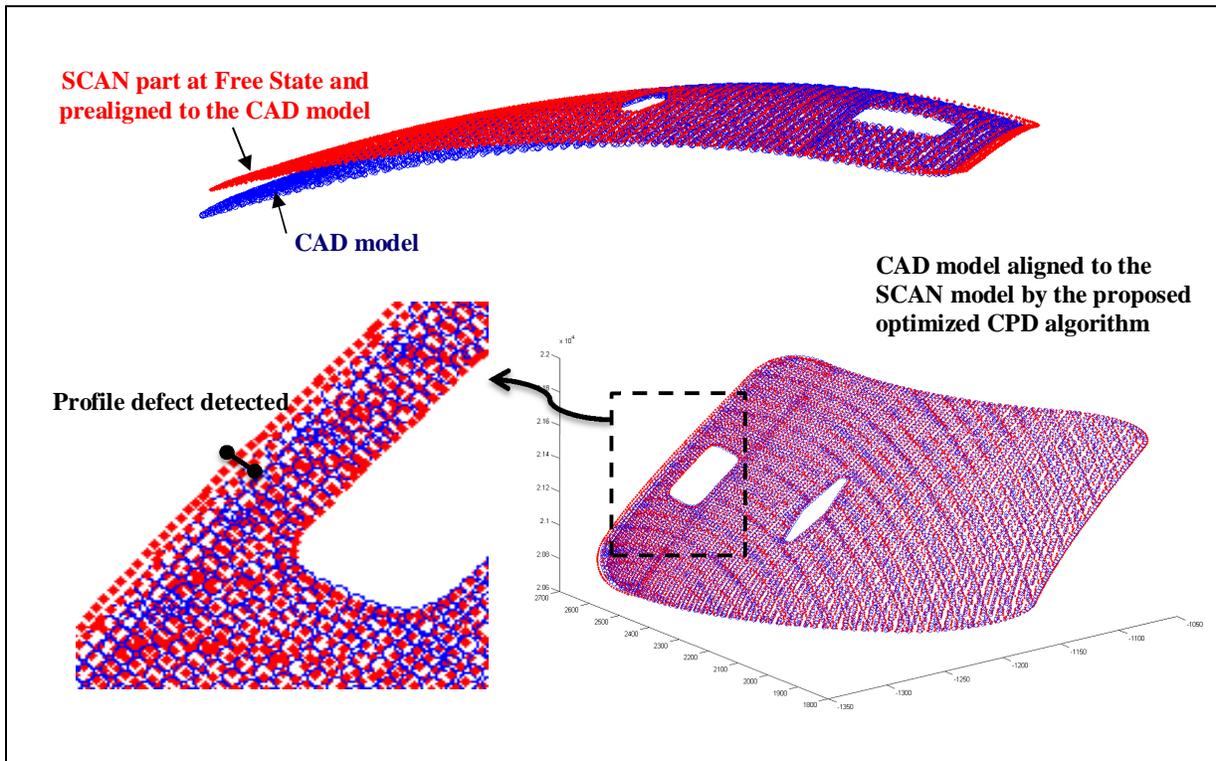


Fig. 6. Results of the proposed method

3.2. Results and discussion:

Analyzing Fig. 6 and Table 1, we can notice that:

- No defects are detected in the V0 case and this ensures that the proposed method does not create a bias.
- Using the proposed optimized coherent point drift algorithm, the nominal model is well-aligned to its corresponding scan in all cases.
- Table 1 shows that the estimated values of the profile defects are much closer to the reference ones in all cases.

Table 1. Results of the proposed method

Case	β λ	Nominal value	Estimated value
		Defect	Defect
A	3.9 8.2	V0	0[0]
		V1	2[0.078]
		V2	5[0.1968]
		V3	10[0.3937]
		V4	20[0.787]
		V5	30[1.1811]

These results prove that the proposed method achieves acceptable results in the detection of the value and the position of the manufacturing profile defects.

4. Conclusion

Fixtureless metrology of non-rigid parts which is still a real problem for transport industry, specifically the aerospace one, is presented in this paper. Dealing with this problematic, a new method is developed to inspect non rigid parts without specialized fixtures. Two criteria that belong to the specifications of non-rigid parts and an optimization of the CPD' regularization parameters to satisfy these criteria are developed and described in this paper. The results shows that the proposed method is useful in the detection of the positions and the values of the defects. The profile defects estimated results in five different industrial case studies present closer values to the reference ones, thus reflecting the effectiveness of the proposed approach. Future research is underway to improve the performance of the proposed methodology and to validate it on other experimental case studies with different type of defects (for example, dimensional defects).

Acknowledgements

The authors would like to thank the National Sciences and Engineering Research Council (NSERC), Bombardier Aerospace Inc. and the École de Technologie Supérieure (ÉTS) for their support and financial contribution.

References

- [1] ASME Y14.5-2009, "Dimensioning and tolerancing. The American Society of Mechanical Engineers National Standard" The American Society of Mechanical Engineers, New York.
- [2] ISO1101, 2012, "Geometrical product specifications (GPS) — geometrical tolerancing," International Organization for Standardization (ISO), Geneva.
- [3] G. Abenhaim, A. Desrochers, and A. Tahan, 2012. "Nonrigid parts' specification and inspection methods: notions, challenges, and recent advancements," *The International Journal of Advanced Manufacturing Technology*, 63, p. 1-12.
- [4] Malamas, E. N., Petrakisa, E. G. M., Zervakisa, M., Petitb, L., and Legatb, J.-D., 2003. "A Survey on Industrial Vision Systems, Applications and Tools," *Image and Vision Computing*, 21(2), p. 171-188.
- [5] Ravishankar, S., Dutt, H.N.V., Gurumoorthy, B., 2010. "Automated inspection of aircraft parts using a modified ICP algorithm," *Int J Adv Manuf Technol* 46(1-4), p. 227-236.
- [6] Weckenmann, A., 2006. "Optical inspection of formed sheet metal parts applying fringe projection systems and virtual fixation," *Metrology and Measurement Systems*, (4), p. 321-334.
- [7] Jaramillo, A. E., Boulanger, P., and Prieto, F., 2009. "On-line 3-D inspection of deformable parts using FEM trained radial basis functions," *Int J Adv Manuf Technol*, 57, pp. 1053-1063.
- [8] Abenhaim, G. N., Tahan, A. S., Desrochers, A., and Maranzana, R., 2011. "A novel approach for the inspection of flexible parts without the use of special fixtures," *J Manuf Sci Eng*, 133(1), pp. 011009-1-011009-11.
- [9] Aidibe, A., Tahan, A. S., Abenhaim, G. N., 2012. "Distinguishing profile deviations from a part's deformation using the maximum normed residual test" *WSEAS Transactions on Applied and Theoretical Mechanics*, 7, p. 18-28.
- [10] Radvar-Esfahlan, H., and Tahan, S.-A., 2012, "Nonrigid geometric metrology using generalized numerical inspection fixtures," *Precision Eng.*, 36(1), pp. 1-9.
- [11] Radvar-Esfahlan, H., and Tahan, S.-A., 2013, "Robust generalized numerical inspection fixture for the metrology of compliant mechanical parts," *Int J Adv Manuf Technol*, p. 1-12.
- [12] Wen, X., Zhao, Y., Wang, D., Zhu, X., Xue, X., 2013. "Accurate evaluation of free-form surface profile error based on quasi particle swarm optimization algorithm and surface subdivision," *Chinese Journal of Mechanical Engineering*, 26(2), p. 406-413.
- [13] A. Aidibe, A. S. Tahan, 2014. "The inspection of deformable bodies using curvature estimation and Thompson-Biweight test" *Int J Adv Manuf Technol*. (Accepted for publication)
- [14] Besl, P. J., McKay, H. D., 1992. "A method for registration of 3-D shapes" *IEEE Transactions on Pattern Analysis and Machine Intelligence*, 14, p. 239-256.
- [15] Myronenko, A., Song, X., 2010. "Point set registration: Coherent Point drift" *IEEE Transactions on Pattern Analysis and Machine Intelligence*, 32, p. 2262-2275.
- [16] Barber, B. C., Dobkin, D. P., Huhdanpaa, H., 1996. "The quickhull algorithm for convex hulls," *ACM Trans. Math. Softw.*, 22, p. 469-483.