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Computer simulation of flow balance in the die of slot coater: Part 2: Manifold geometry (Conference Paper)

 Park, Y.^a, Kim, H.^a, Lyu, M.-Y.^a, Namkung, K.^b, Jeoung, J.^b
^a Seoul National Univ. of Science and Technology, Seoul, South Korea^b Narae Nanotech Co., Kyunggido, South Korea

Abstract

Coating operations such as spin coating, curtain coating, role coating, slide coating, slot coating, and etc. are dated from long time ago and still considered very important processing. Slot coating is considered

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ABSTRACT

Coating operations such as spin coating, curtain coating, role coating, slide coating, **slot** coating, and etc. are dated from long time ago and still considered very important processing. **Slot** coating is considered very important specially for the manufacturing of liquid crystal display **parts**. Photo resistant is coated on the glass and is sent to next process to make TFT board. Coating quality such as uniformity of coating thickness can be divided into two categories, which are machine direction quality and transverse direction quality. Machine direction quality is related to **die** lip design and operation conditions whereas the transverse direction quality is related to **flow** uniformity inside of the **die**. The **flow** uniformity is governed by **flow balance** in the **die**. The most important design factors for the inside **die geometry** are **manifold** and land. Through this study the **flow balance** according to the **manifold** design has been examined by **computer simulation**. The design variables of **manifold** were **manifold** volume and **manifold** shape. Well designed **manifold** gives good **flow balance** in the **die** land and consequently gives good coating uniformity. Good **manifold** design has been investigated by **computer simulation**.

Indexed keywords

Coating quality; Coating thickness; Coating uniformity; Curtain coating; Design and operations; Design factors; Design variables; **Die geometry**; **Flow balance**; **Flow** uniformity; Machine directions; Transverse directions

Engineering controlled terms: Computational methods; **Computer simulation**; Design; Dies; Liquid crystal displays; Plastic products; Thickness measurement

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Computer Simulation of Flow Balance in the Die of Slot Coater:

Part 2: Manifold Geometry

Yohan Park¹, Hyun Kim¹, M.-Y. Lyu^{1}, Ki Namkung², and Joajin Jeoung²*

¹ *Seoul National Univ. of Science and Technology, Seoul, S. Korea*

² *Narae Nanotech Co., Kyunggido, S. Korea*

Abstract

Coating operations such as spin coating, curtain coating, role coating, slide coating, slot coating, and etc. are dated from long time ago and still considered very important processing. Slot coating is considered very important specially for the manufacturing of liquid crystal display parts. Photo resistant is coated on the glass and is sent to next process to make TFT board. Coating quality such as uniformity of coating thickness can be divided into two categories, which are machine direction quality and transverse direction quality. Machine direction quality is related to die lip design and operation conditions whereas the transverse direction quality is related to flow uniformity inside of the die. The flow uniformity is governed by flow balance in the die. The most important design factors for the inside die geometry are manifold and land. Through this study the flow balance according to the manifold design has been examined by computer simulation. The design variables of manifold were manifold volume and manifold shape. Well designed manifold gives good flow balance in the die land and consequently gives good coating uniformity. Good manifold design has been investigated by computer simulation.

Introduction

Demand of photo-resist (PR) coating has been increased as liquid crystal displays for monitor, TV, and other display screen increase. There are many kinds of coating operations such as curtain coating, roll coating, slide coating, spin coating, slot coating, and so on in coating industry (1-9). There are two kinds of coating uniformity in slot coating. One is a uniformity along the machine direction which is a coating direction. This uniformity depends upon not only die geometry but operational condition. The other is a uniformity in the transverse direction of coater moving. This uniformity is governed by flow balance inside the die and depends upon flow uniformity at the exit of the die. The shape and volume of manifold, and geometry of die land strongly affect the flow uniformity at the exit of the die.

The role of manifold in the die is distributing the fluid from the small area of inlet to the wide area of die land. Through this study the flow balance according to the manifold design has been examined by computer simulation. The parameters for manifold design are manifold volume, angle of manifold shoulder, and stepped manifold. Well designed manifold gives good flow balance in the die land, and consequently uniform coating can be achieved. Manifold design has been investigated by computer simulation to give guidelines for the manifold design in the slot coater.

Computer Simulation

1 Material and Model

Viscosity and density of photo resistant used in this study were 0.038 poise and 1.003 g/cm³ respectively. Fig.1 shows a die for slot coater. The region of inside of die divided into manifold and land as shown in Fig. 2. The manifold geometry is a variable in this study. The shapes of manifold for study are summarized in Table 1.

2 Modeling for FEA and Boundary Conditions

Fig. 3 shows a modeling for finite element analysis. It contains four boundaries. Boundary 1 is an inlet of PR and pressure was imposed in this inlet. Boundary 2 is a symmetric plane. Boundary 3 is a wall and no slip condition was imposed on this boundary. Boundary 4 is an exit and outlet condition was imposed on this boundary. The hexahedron mesh was used for numerical computation. Commercial code, Fluent, was used for computer simulation.

Results and Discussions

1 Manifold Volume

Velocity Distributions

Fig. 4 shows velocity distributions at the cross sections along the flow direction in the die. The maximum velocity occurred at the center of manifold and velocity profiles became uniform as PR flowed through die land as shown in Fig. 4(a). Fig. 4(b) and 4(c) show the exit velocities. Edge velocity was bigger than center velocity on both

manifold volumes. However large manifold volume showed large edge velocity.

Velocity Vector in the Manifold

Fig. 5 shows velocity vectors in the manifold at the edge region. Downward flow to the die land from manifold became bigger and bigger as manifold volume increased. Consequently edge velocity at the die exit became higher for larger manifold volume. Larger the manifold volume showed higher the standard deviation of exit velocity as shown in Fig. 6.

2 Manifold Shoulder Angle

Velocity Distributions

Velocity at the exit of die for manifold shoulder angle is shown in Fig.7. Manifold having big shoulder angle showed small velocity difference at die exit. Larger shoulder angle of manifold gave more uniform velocity distribution.

Velocity Vector in the Manifold

Fig. 8 shows velocity vector at the manifold for manifold shoulder angle. Small shoulder angle manifold gave large downward flow. Consequently it made big exit velocity at the edge of die compared with velocity at the center of die.

3 Stepped Manifold

Velocity Distributions

Velocities at the die exit for two types of stepped manifolds are shown in Fig. 9. Edge velocity at the die exit was much higher than center velocity when the lower shoulder angel was located in lower part of manifold. When the lower shoulder angle was located in upper part of manifold, the center velocity increased and became higher than edge velocity.

Velocity Vector in the Manifold

Fig. 10 and Fig. 11 show the velocity vector at the entrance (center of manifold) and edge of the manifold. Downward velocities at the center of manifold and at the edge of manifold were high when the lower shoulder angle was located in upper part of manifold. Downward velocity at the center region of manifold (at the entrance region) made high center velocity at the die exit.

Conclusions

Flow balance in the coater die has been investigated through computer simulation. Several manifold designs in the die of coater have been analyzed to study the exit velocity of die. Manifold designs were manifold volume, lower shoulder angle, and stepped manifold. As manifold volume increased standard deviation of exit velocity of the die increased. Therefore the manifold volume should be decided according to required coating quality. As lower shoulder angle decreased flow toward the edge increased and this made edge velocity high. When design the stepped manifold in the die the lower shoulder angle should be

located upper part of manifold to get uniform exit velocity.

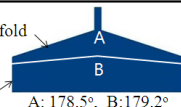
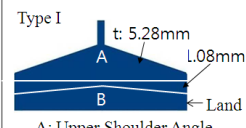
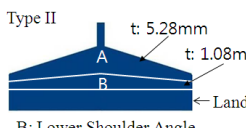
Acknowledgements

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Table 1 Manifold geometry for flow balance simulation

Manifold Geometry		
Manifold Volume	60.72cc	
	90.55cc	
	150.00cc	
Lower Shoulder Angle of Manifold (B)	B: 178.7°	A: 178.5°
	B: 179.7°	
Stepped Manifold and Location of Lower Shoulder	Type I 	Type II 
	A: Upper Shoulder Angle	B: Lower Shoulder Angle

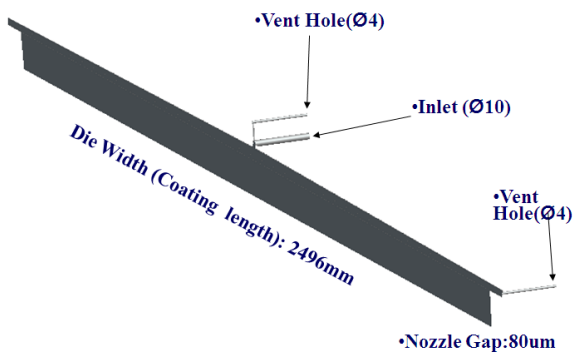


Fig. 1 Schematic drawings of slot coater

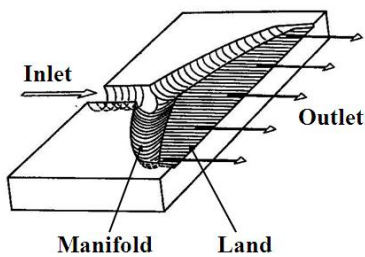


Fig. 2 Schematic drawing of inside die geometry in the slot coater

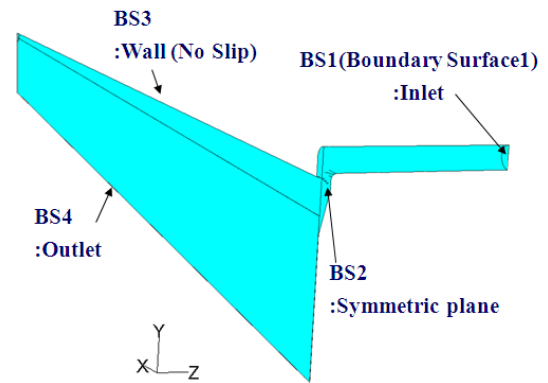
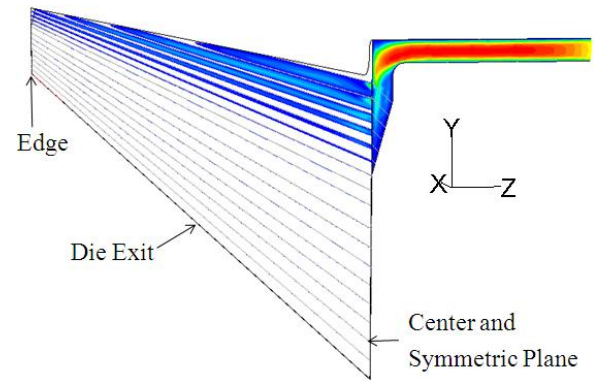
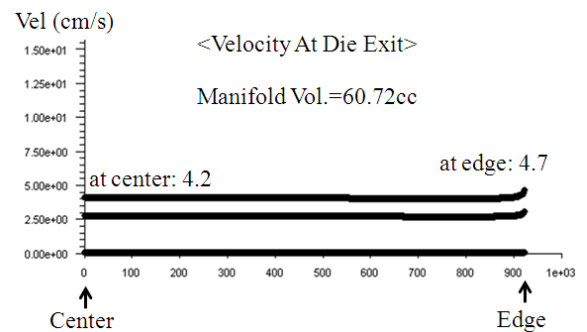


Fig. 3 Die modeling of slot coater for simulation



(a) Velocity distributions at the cross sections along the flow direction



(b) Velocity at the die exit for manifold volume: 60.72cc

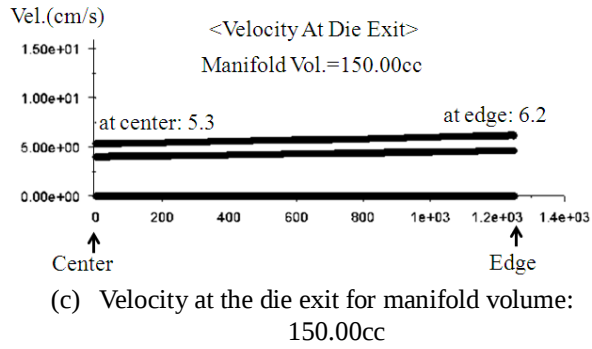


Fig. 4 Velocity distributions and exit velocity for manifold volume

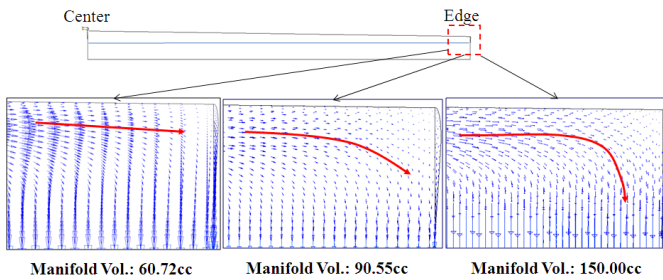


Fig. 5 Velocity vector in the manifold for manifold volume

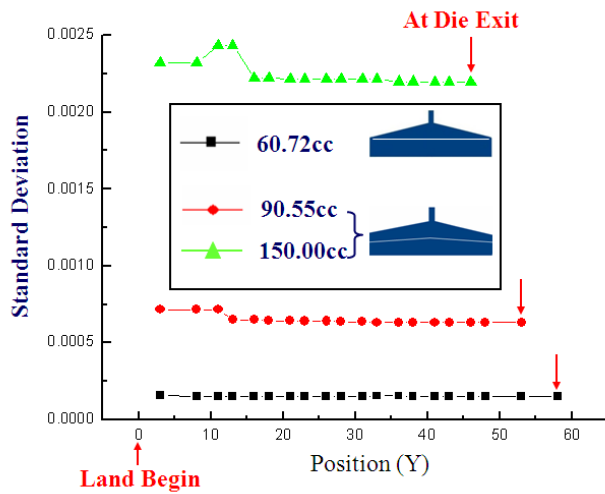
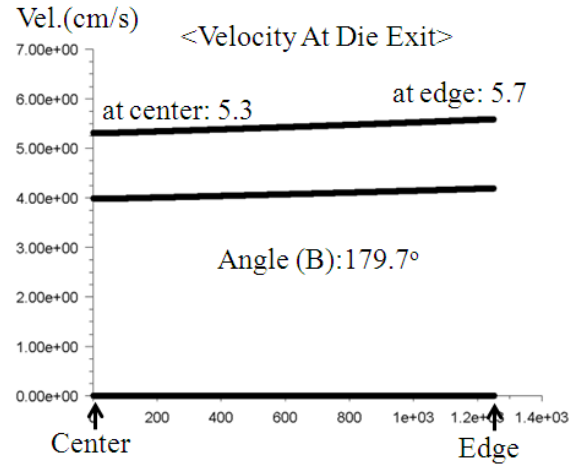
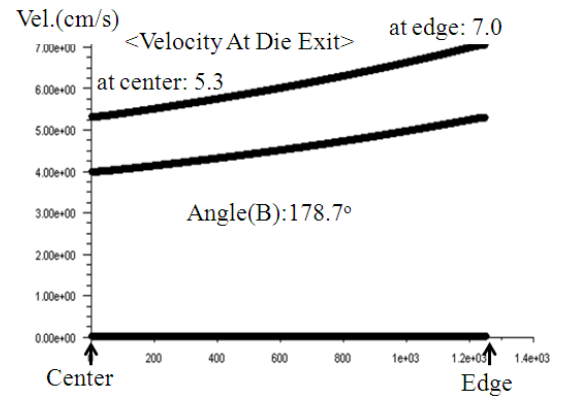


Fig. 6 Standard deviation of exit velocity according to the manifold volume



(a) Velocity at the die exit for manifold shoulder angle: 179.7°



(b) Velocity at the die exit for manifold shoulder angle: 178.7°

Fig. 7 Exit velocity distribution for manifold shoulder angle

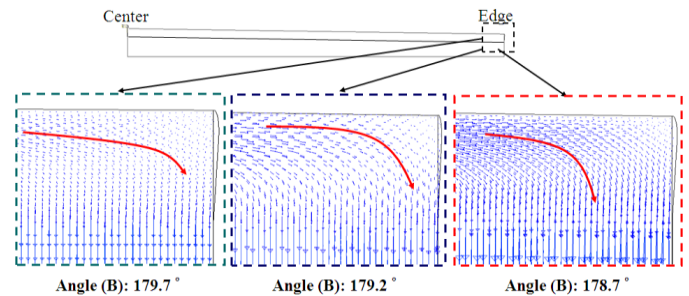
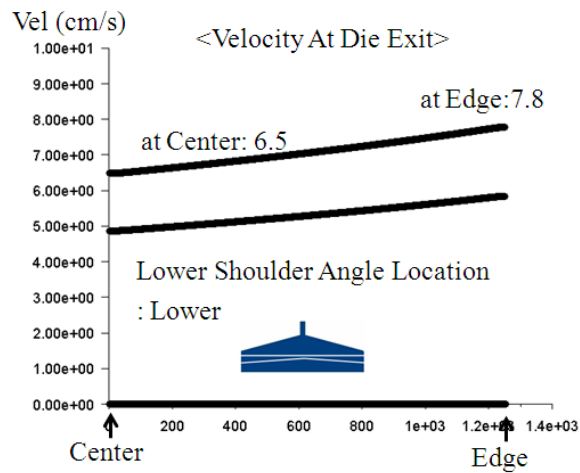
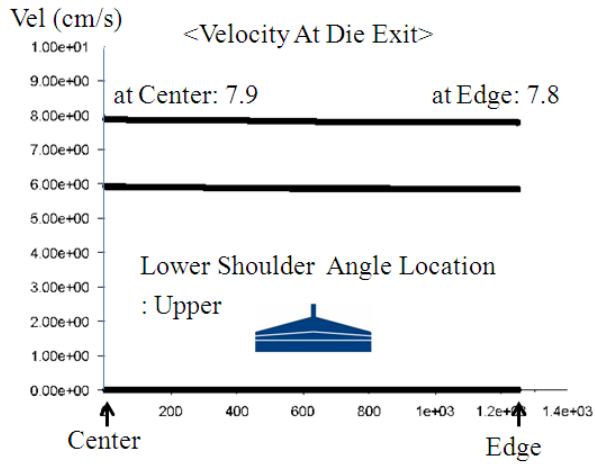


Fig. 8 Velocity vector in the manifold for manifold shoulder angle



(a) Velocity at the die exit for lower shoulder angle location of manifold: lower part



(b) Velocity at the die exit for lower shoulder angle location of manifold: upper part

Fig. 9 Exit velocity distribution for lower shoulder angle location of manifold

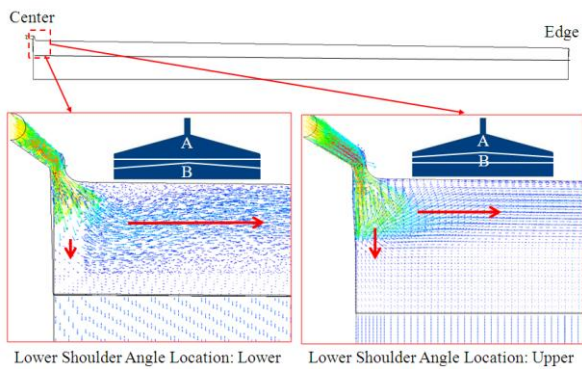


Fig. 10 Velocity vector at the entrance of manifold for lower shoulder angle location of manifold

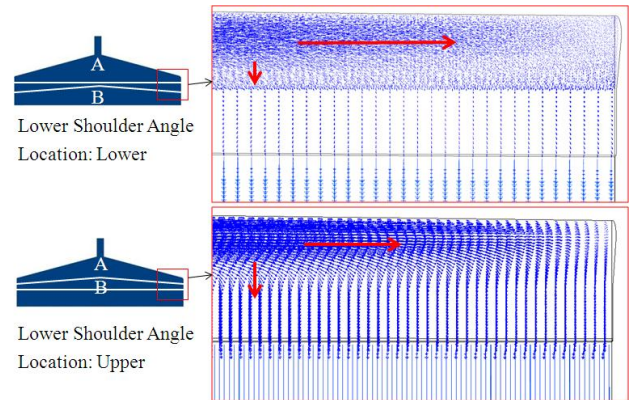


Fig. 11 Velocity vector at the edge of manifold for lower shoulder angle location of manifold