

Investigation and development of textile lightweight bodies for urban logistic vehicles

Fabian Edel¹, Corinna Pulkus², Sarah Kim², Jürgen Erhardt³, Sven Kuijpers²

¹*Fraunhofer-Institute for Industrial Engineering IAO, Nobelstr. 12, 70569 Stuttgart, Germany,
Fabian.Edel@iao.fraunhofer.de*

²*German Institutes of Textile and Fiber Research Denkendorf (DITF), Denkendorf, Germany*

³*Erhardt GmbH, Stuttgart, Germany*

Summary

The urban logistic sector is struggling with the following two problems: A particularly high level of traffic and air pollution. For those reasons, small electric vehicles are the perfect technical solution to cope sustainably with the increasing parcel volume in urban areas. To compensate the weight disadvantage of electric drive, a textile lightweight solution for the body of logistics vehicles is examined in this study. Therefor various textiles and mounting solutions are examined and developed as well as tested by multiple testing procedures. The result of this work is an ideal combination of a textile and suitable mounting method for a textile lightweight body for last-mile logistic vehicles.

Keywords: freight transport, materials, truck, research, special vehicles

1. Introduction

Nowadays, inner-city logistics is struggling with two significant problems: First, an increasing volume of parcel has been recorded for the last few years. Second, urban areas are facing air pollution due to the constant increase in traffic. [1–4] Therefore, one effective solution are small electric-driven logistic vehicles for the last-mile in urban areas. From a technical point of view these vehicles represent an ideal application field as they have plannable routes and pre-defined depots. [5]

Additionally, electric-driven logistic vehicles are smaller and lighter compared to conventional logistic vehicles. Therefore, they contribute to reduce clogging in urban areas and drive locally emission-free. However, the electrification and reduction of the logistic vehicle size as well as the high weight of the battery lead to a reduction in payload which is already smaller for small logistic vehicles. But the payload is the most important variable in the logistic business.

The main target of this work is to replace conventional parts of small electric logistic vehicles by lightweight components, to compensate the losses. In terms of the components, it is to improve the weight and additionally to optimize them with technologies from other industries. This work specifically focuses on the use of technical

textiles in vehicle exteriors, which are investigated. Previous studies have already presented the general feasibility of textiles in the exterior of the vehicles (passenger vehicles). Within this work, textiles for exterior are transferred into the logistics area. [6] In the case of logistic vehicles, the vehicle body of the cargo space offers a great potential to reduce the weight.

2. State of the Art in Science and Technology

Textiles are already being used in the exterior of logistic vehicles in the form of truck tarpaulins. Truck tarpaulins, which are polyester carrier fabrics with PVC (polyvinyl chloride) coating on both sides are commercially available in weights of 670 to 900 g/m² [7–9]. They are considered to be highly tear-resistant and serve as mobile advertising space. In the roof area, translucent PVC tarpaulins are preferred. Horizontal surfaces often suffer, in addition to their own weight, from the weight of snow mass, which can lead to damage. Tarpaulins are attached to the frame of truck bodies using piping, straps, eyelets or similar. However, additional fastenings lead to additional weight. For logistic vehicles with a body made of truck tarpaulins, there is a risk of theft due to cutting into the tarpaulin. Currently, segments made of PVC with attached wires that trigger an alarm when cut represent the solution to this problem [10]. This can also be used to upgrade existing tarpaulins. In the calculation of the permitted total mass of a truck and smaller sized logistic vehicles, saved weight means lower energy consumption and thus the possibility of a higher payload.

Mainly sandwich structures are used for logistic vehicle bodies. Sandwich structures are made up of two face layers and a core material. The core materials usually consist of lightweight foam, or a honeycomb structure enclosed by two solid, force-absorbing surfaces. While the top surface absorbs compressive stress the core provides cohesion and dissipates shear forces. Often further layers for heat-insulating or sound-insulating effect are added. The lightweight construction of sandwich structures combines high stiffness and compressive strength at low weight.

The materials used are subject to constant change, driven by increasing requirements in terms of lightweight design, safety, rigidity, reliability, environmental compatibility, and economy. The general target from the point of view of lightweight construction is to meet all the requirements of a vehicle components with minimum mass demand. Automotive developers are already presenting approaches in lightweight concept vehicles in which the vehicle exterior is completely covered with a textile. At the beginning of 2019 the simulation of the "Futurelight Camper" - a trailer with a frame made of carbon fibre was presented by the outdoor company The North Face in collaboration with the BMW Group subsidiary [11]. A waterproof and breathable membrane made of a nanofiber structure covers the frame. It is possible to adjust weight, stretchability, air permeability and robustness in the existing "Futurelight" textile during manufacturing [12]. Details on the realization have not been provided yet.

A very light variant of a sandwich panel structure can be made of polyester resin panels with a glass fibre reinforcement and a PET foam core. With a thickness of about 14 mm, such panel has a price of about 45 €/m² and weights 4.35 kg/m² [13]. The weight of a commercial truck tarpaulin without a frame starts at about 670 g/m².

The potential of outdoor textiles to resist UV radiation and intense climatic fluctuations has been proven for quite some time in many fields. They are used in the field of architectural textiles, boat construction, air sports, clothing, tents, garden furniture and sunshades.

3. Methodical Approach

To investigate the usage of textile in urban logistic vehicles, a methodological approach has been developed consisting of four individual steps. The first step is the identification of basic requirements. Based on the defined requirements textiles are researched that are already used in various areas and industries in the exterior, followed by the selection of the most prospective. Basic tests of the textiles help to verify the compliance with the requirements. Mounting possibilities for textiles at the construction of the vehicle body have also been researched, selected, and tested. The results were merged and transferred into early-prototypes. Using these early-prototypes, further tests such as weathering, air flow (wind tunnel) as well as cargo securing, and the load resistance of the

lateral surface are executed. After all tests have been completed, one textile and one mounting mechanism was assembled in a prototype. Figure 1 shows the approach.

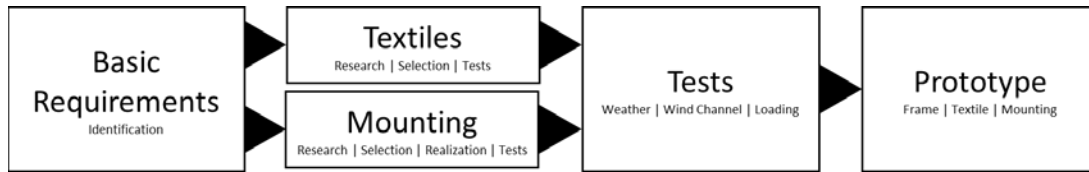


Figure 1: Methodical approach for examining textile bodies for urban logistic vehicles

Basic Requirements: The identification of the basic requirements consist of the definition of the application area, the components, and legal requirements. The first step is the definition of the application area, in this case the vehicle category like passenger transportation, logistic transportation, etc. If the application area is defined, the components, which should be replaced by textiles, have to be defined. If the components are defined, research about the valid legal requirements is necessary, to get information about the legal framework and vehicle registration. In addition, further technical, emotional, and aesthetic requirements are included which is important for the product development later.

Textiles: To find suitable Textiles for the use case, eligible materials are researched for the application. This involves searching the use case industries but also in externally industries. Based on the technical specification researched textiles are shortlisted. These textiles are subject to comprehensive laboratory testing like artificial weathering, soiling, and cleaning behaviour, determination of water and oil mark or burst properties. The three most convinced textiles, which meet the requirements for use in logistic bodies are selected to execute further tests. [14]

Mounting: Mounting techniques must be researched and reviewed to find the most suitable joining technique for the special use case. Afterwards, they are systematically evaluated whether they can be transferred to the application. The individual mounting techniques must be tested under laboratory conditions.

Tests: Once the textiles and mounting mechanism are selected and tested under laboratory conditions, pre-prototypes of the construction are created and tested as a system. In this use case three different tests with early-prototype are performed:

Wind-Tunnel-Test: In a wind-tunnel-test, the effect of the flow around the pre-prototype is tested. With the airflow the tensile and compressive force on the textile and the deformation of the textiles (fluttering) is measured.

Load-Test: A drop test is conducted to check the mechanical resilience of the lateral surface (textile) and mountings. The test simulates an impact of the package on the lateral surface of the body when driving along curves by “falling” onto the textile surface with the same force. Accordingly, a calculation of the impact force is performed to generate consistent values of a curve run.

Weathering-Test: The textile is tested in an endurance test by being exposed to all climatic conditions for 12 months. This shall examine the weather compatibility of the textiles and mounting systems.

Figure 2 shows the several principles of testing.

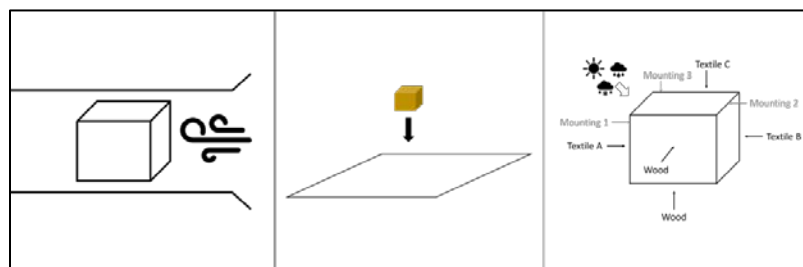


Figure 2: Test procedures of the wind-tunnel-test (left), load-test (middle) and weathering-test (right)

Prototype: After implementing and evaluating the tests, a prototype of the logistics body has been built. The prototype contains both, the most appropriate textile as well as the most appropriate mounting mechanism, selected by taking the basic requirements in account.

This methodical approach was applied in this work to generate knowledge about the usage of textiles for vehicle bodies for urban logistic vehicles.

4. Results

According to the methodical approach developed in this project, the research work was conducted, and the results presented in this chapter were obtained.

4.1 Basic Requirements

The application areas in this project were predefined through the project partner. The usage of textiles in the vehicle exterior should be analysed in logistic transportation and in passenger transportation. This paper shows only the results of logistic transportation, the methodical approach is the same for both application areas. The results of passenger transportation may follow in another scientific paperwork. For the logistic transportation, the focus was set on an urban logistic vehicle (<3.5t).

To define the component, which should be replaced by textiles, a workshop with relevant project partners was conducted. In this meeting a lot of “textile” ideas came up. At urban logistic vehicles, the most prospective assembly group for a “textilization” was the vehicle body. The experts in the project have seen the highest potential to reduce weight in that assembly group. The whole sides of the body can be designed by textiles. Also, mechanical elements like roller blinds and sliding doors should be analysed in that work. For a higher resistance of the textiles, the inside of the textiles should be protected by a textile net. This could be necessary if the textiles get impact by moving packages inside of the cargo hold. Summarized, the following components should be implemented:

- Vehicle body with textile sides
- Inner textile net for a higher resistance
- Roller blinds and sliding doors

After defining the components, the legal requirements for the construction of urban logistic vehicle bodies must be researched. Before this step, the daily use-case of an urban logistic vehicle was elaborated for a same understanding of the research object. There exist a few legal (technical) requirements (for the defined user region Germany) for the construction of a logistic vehicle body. The most relevant for this project were

- no sharp, pointed or protruding edges [15]
- closable, also while driving [16]
- width of 2.55m and height of 4m must not be exceeded [17]
- lashing possibilities must be installed [18]

In addition to the legal technical requirements, further technical, emotional, and aesthetical requirements also were considered (Table 1).

Table 1: Technical, emotional, and aesthetical requirements

Technical Requirements	Emotional Requirements	Aesthetical Requirements
<ul style="list-style-type: none"> • Weather-Resistance • Theft-Resistant • No acoustic disturbances • Wear and Tear-Resistant • Dirt-Resistant 	<ul style="list-style-type: none"> • Roller blind and sliding door with high usability • Textile visually and haptically high-quality and appealing • Individuality for recognition value 	<ul style="list-style-type: none"> • Valence • Modern Design • Corporate Design

A catalogue of requirements for further research and development of the textiles and mounting techniques was drawn up based on the basic requirements identified.

4.2 Textiles

Based on the basic requirements identified in chapter 4.1, specific technical requirements for the textile were derived and defined. These technical requirements include f. e. a water tightness of 1500mm water column, an air impermeability of $>5 \text{ l/m}^2/\text{s}$, an UV resistance of 5 years, climate resistance at temperatures from -10°C to $+70^\circ\text{C}$, no wetting of oil and water, dirt repellence and a weight that is well below 520 g/m^2 (equivalent to the weight of conventional PVC truck tarpaulin) [7–9]. In a first step, textiles already available on the market from various outdoor sectors such as construction textiles, tents, boat building, air sports, sun protection and outdoor clothing with potential suitability for this project were researched and compared with the defined technical requirements.

In addition, suitable test methods were identified to model the behaviour of the textiles in an actual application, so that an assessment could be made for their suitability for the usage of textile in vehicle exterior. These are water and oil repellency – Determination of oil and water marks, scratch resistance – Determination of the tendency to thread pulling and snagging, colour fastness – Determination of colour fastness after artificial weathering with UV irradiation, bursting properties before and after artificial weathering with UV irradiation and soiling and cleaning behaviour. Figure 3 shows an overview of the test methods.

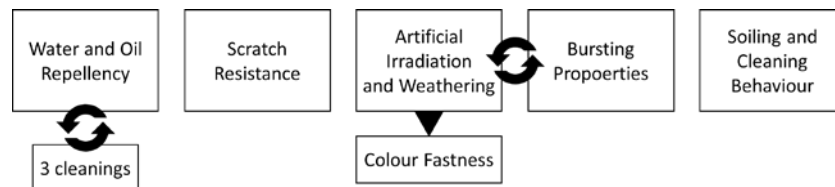


Figure 3: Overview of test methods for textile behavior

Water repellency and oil repellency: For use in vehicle exteriors, cleaning is considered a necessity. The repellency of oil- and water-containing liquids should therefore not lose its effect. The determination of the oil repellency (DIN EN ISO 14419) and water repellency (“3M-Water repellency”) were tested on the textiles before and after three cleanings with a cleaning agent typical for the automotive sector (car shampoo concentrate R527 from Förch) and a commercially available all-purpose cleaner (neutral cleaner from Frosch). In addition, the “colour stain test”, a test developed at the DITF, was performed, in which the wetting behaviour is evaluated with a dye solution. For the application in automotive exteriors, the test is intended to reveal no wetting of the textile.

Scratch resistance: The Orbitor Pilling and Snagging Tester 516 was selected for testing the pilling tendency and snagging. The corresponding standard is BS 8479. This test was selected to produce results similar to the stripping or snagging of a bush with thorns and spines when the vehicle is parked. The determination of the thread pulling tendency and the snagging proved the robustness of the textile under the influence of sharp objects, which can cause damage to the surface of coatings, holes, or thread pullers. As a comparison and confirmation, a test was performed with branches with spines of a rose plant, which were pulled over the textiles.

Artificial irradiation and weathering: Artificial irradiation and weathering was selected to mimic time-accelerated aging. The influence of weather and solar radiation varies greatly depending on the climatic zone. Artificial aging was performed according to the climatic zone “Central Europe” with treatment cycles set up at the DITF. The test includes temperature changes from -10 to $+70^\circ\text{C}$, humidity changes and irradiation with global radiation. For the artificial irradiation and weathering with UV fluorescent lamps a UV-global tester “Weiss UV200” was used. The procedure was carried out in accordance with the standard DIN EN ISO 4892-3. Artificial weathering can deviate from the behaviour under practical conditions during long-term outdoor weathering. The effect of photodegradation was then determined with colour fastness and the determination of the bursting strength.

Colour Fastness: The effect of weathering on the colour can cause the complete loss of it. The loss of the colour means at the same time the loss of the aesthetics expected by the customer. The colour before and after weathering and irradiation was measured on the spectrophotometer "X-rite colour i7" according to the CIELab system under daylight. The corresponding standard is DIN EN 20105-A02.

Bursting properties: The determination of bursting strength was chosen to gain an insight into the possible change in strength in combination with the artificial weathering and irradiation, as well as to gain knowledge of the deformation and recovery of the textiles as a basis for further tests in a wind tunnel. Due to the driving wind, outward pressure on the textiles is expected. The determination of the bursting properties is carried out according to DIN EN 13938-2 with the TruBurst Model 140 using a pneumatic method before and after artificial irradiation and weathering.

Soiling and cleaning behaviour: The aim was to replicate soiling in road traffic. Since the soil composition and the soil application of existing standards and test methods do not correspond to the actual application, an own soil was compiled, consisting of 9.59 g "Leverkusen Standard Soil 40" and 1.71 g brake dust dissolved in 4 l water. The outside of textiles was brought into direct contact with soil solution and the water was evaporated completely, depositing the soil on the textile. The textiles were visually assessed.

Subsequent cleaning was carried out with the same cleaning agent used for the oil and water mark. The cleaning tests examine whether the textiles can be cleaned without leaving residues. Figure 4 shows some impressions of the laboratory tests.



Figure 4: Impressions of the different textile laboratory tests

On basis of a utility value analysis, three most promising textiles were selected, which are described in more detail in the following:

Textile A: (Laminate)

Textile A is a three-layer laminate consisting of a polyamide fabric on the outside, a polyurethane membrane in the middle layer and an inner layer of a knitted polyester and elastane fabric. The textile is impregnated oil and water repellent with a fluorocarbon finish. Applications of this textile are e.g., motorcycle clothing or backpacks. [19]


























Textile B (Aircraft)

Textile B is a woven polyester fabric used for aircraft covering. The fabric, with a weight of 90 to 210 g/m², is applied and tensioned by gluing and shrinking by means of heat. Warp and weft density is identical; therefore, the woven textile has no preferred direction. The textile is non-combustible (DIN EN ISO 6941), UV-resistant and air-impermeable. Furthermore, the textile is re-shrinkable. A loss of tension caused by snow or rain load, can thus be easily retightened with hot air. The woven textile which is produced in Germany is available in different translucency. For the roof, a translucent material preferred to increase the brightness inside the vehicles body. [20]

Textile C (Kite)

This textile is very light with only 53g/m² and is used for kites. It is a double ripstop polyester woven fabric with very low stretch. Furthermore, the fabric is air-impermeable and water repellent. [21]

The three textiles were implemented in a pre-prototype with different textiles on each side of the body in order to be able to carry out further test (see chapter 4.4). Figure 5 shows an overview of the test-results of the selected textiles.

	Textile A (Laminate)	Textile B (Aircraft)	Textile C (Kite)
Material	3-layer laminate 1. PA fabric 2. PU membrane 3. PES/EL knitted fabric	PES fabric with PU coating	PES fabric with thin PU coating
Application	Clothing (motorcycle clothing), covers, ...	Aircraft covering	Kites, Sailing, ...
Weight [g/m ²]	 330	 150-210	 53
Repellence	 ++	 ++	 +
Soiling behavior	 +	 +	 +
Cleaning behavior	 +	 +	 +
Surface damage by tips [grade]	 4+	 1	 1
Color fastness [grade]	 3-4	 4	 2-3 bis 3
Bursting pressure [kPa]	 maximal	 maximal	 343,9
Strength loss by environmental simulation			 11,57%
Bursting curvature [mm]	 32,8	 22,6	 24,3

Legend:







-    : Feature poorly present
-    : Characteristic fully reached

Figure 5: Overview of the test-results of the textiles

4.3 Mounting

A conventional vehicle body consists of sandwich panels with aluminium profiling. Unlike textiles, the sandwich panels have a load-bearing and stabilizing function. Thus, the frame construction for a textile covering must be built differently. Several frame constructions were manufactured and tested for the project as individual elements from commercially available vehicle construction extruded profiles.

To find out whether it is possible to cover the large surfaces of the box structure or whether additional struts are required in the structure, test frames were manufactured, covered, and then tested in a load-test (see chapter 4.4.3). In addition, various joining techniques such as sewing, gluing, and riveting were examined.

It has been shown that a two-layer structure with an additional inner fabric net for load securing and protection of the outer textiles is most suitable. For the inner textile, a polyester net fabric coated with PVC with very high tear resistance was chosen. The fabric can be processed both by welding or sewing. Due to its very low price (about 3€/m² [22]), it is economically justifiable to replace it in case of damage. For long durability, reinforcements have been sewn on the location that are prone to a lot of stress due to friction. In addition, piping was applied to distribute forces over the entire surface in the event of an impact. The piping rails were attached to the frame interior with blind rivets, thus pulling in the textile and bringing it to tension.

As a result of the tests, the techniques selected as most appropriate were clamping by frame components, a solution of a piping system and gluing the textile onto the frame. Furthermore, textile B was selected as the outer skin with which good tension can be achieved due to its shrinkage behaviour of 15%. First, the textile was made up to the required size and then the PVC piping was glued on using dispersion hotmelt adhesive and a hot air blower. Since textiles might lose tension over time due to weathering, it is essential to be able to tension them again. The rail system used has several tensioning grooves to achieve this. The textile is pre-tensioned by means of the piping rails and then finally tensioned with a hot air dryer at a maximum of 180°C. The textile is then re-tensioned. To further improve the durability and stability of the frames and textiles additional struts were built in.

To keep the weight as low as possible, flexible PVC square profiles were installed, which are both light and stable. The mounting was done with blind rivets. Figure 6 shows the results of the mounting research.



Figure 6: Results of the mounting techniques research (left: outside, middle: inside) and the piping system (right)

4.4 Tests

After the research, selection and testing of promising textiles and mounting techniques, several early-prototypes were built to test the whole system with the assembled components. An early-prototype is defined as an easy- and fast-to-build but incomplete type of a prototype as it focusses on those aspects that are necessary for a defined test. Unlike a commonly known prototype, an early-prototype only includes properties which are necessary to realize a prototype at an explicit moment for the development of new technologies and to reach the defined testing goals. [23]

4.4.1 Wind-Tunnel-Test

For the wind-tunnel- and weathering-test an early-prototype named “the cube”, was built. All Sides of the cube have the maximum frame size, a final vehicle body would have (1500mm). The cube was equipped with the three identified textiles (Chapter 4.2) and three different mounting techniques (Chapter 4.3). The front and the bottom side are made of wood. The rear side is made of ordinary textile with two zippers for the entry of the inside of the cube. Figure 7 shows the textile and mounting distribution at the cube.

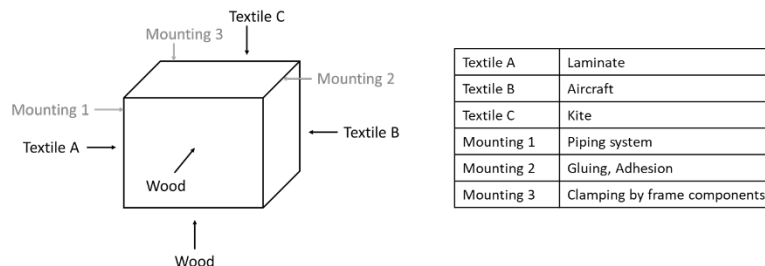


Figure 7: Textile- and mounting distribution at the system early-prototype the cube

At the wind-tunnel-test, the effect of the flow around the cube were tested. For a simulated and continuous air flow, a gust wind tunnel was used. By means of the air flow, the tensile and compressive force on the textile and the deformation of the textiles (fluttering) was measured. The tensile and compressive force is measured by a force gauge, the deformation of the textile by a camera with slow motion function. Seven different test runs have been completed to get all data for each textile in two flow-around positions of the cube. In position A the cube was flown around to simulate straight ahead driving (wood/textiles=90° to the flow). In position B the cube was flown around to simulate cornering (wood/textiles=45° to the flow). Figure 8 shows the different positions.

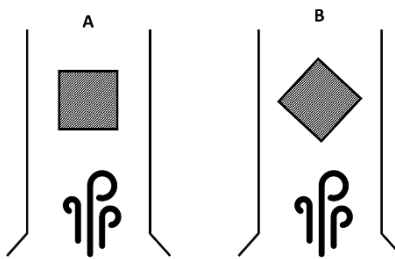


Figure 8: Flow around position of the cube at the wind tunnel

The measuring went from 0 m/s to 16.67 m/s. At the wind speed of 8.33 m/s (30 km/h), 13.89 m/s (50 km/h) and 16.67 m/s (60 km/h) the flow was constant for 30 seconds to get consistent conditions for predefined wind speeds.

The results of the wind-tunnel-test show, that textile B (Aircraft) has the best overall values. The fluttering (deformation) and the tensile force show the smallest amplitudes. The laminate (textile A), which has an elastic portion, already showed the first signs of material fatigue after stringing. It performed worst in the wind tunnel test due to strong fluttering, high tensile force, and high noise development. Figure 9 shows an example of the measured data at the wind-tunnel-test (Textile B, Aircraft).

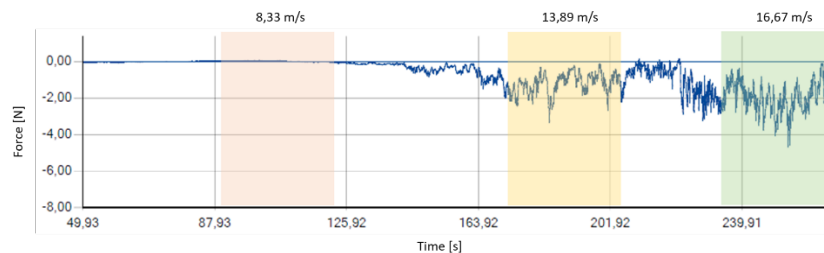


Figure 9: Example of the measured data at the wind-tunnel-test

4.4.2 Weathering-Test

For the weathering-test the cube was exposed for an endurance test to the weather. The test period went on for 12 months in all climatic conditions of central Europe like sun, wind/storm, rain, and snow (48.74047623855775, 9.096374837039678). This shall examine the weather compatibility of the textiles and mounting systems.

The following findings were made after 12 months:

- Textile C/Kite resists not the weather. Cracks appeared. It became porous.
- Textile A/3-layer-laminate lost some tension.
- Adhesive bonding of Textile B/Aircraft came off.

The results after 12 months showed, textile B/Aircraft and the piping system had the best withering properties for the use case as a vehicle body.

4.4.3 Load-Test

For the load-test an early-prototype was built to check the mechanical resilience of the textile and net at the lateral surface and also the mountings. The test simulates an impact of the package on the lateral surface of the vehicle body when driving along curves. To test this scenario with a vehicle while driving along a curve was too opulent, so a falling test was constructed to simulate a package is bumping into the lateral surface which consist of a net and a textile. Figure 10 shows the technical concept of the load-test.

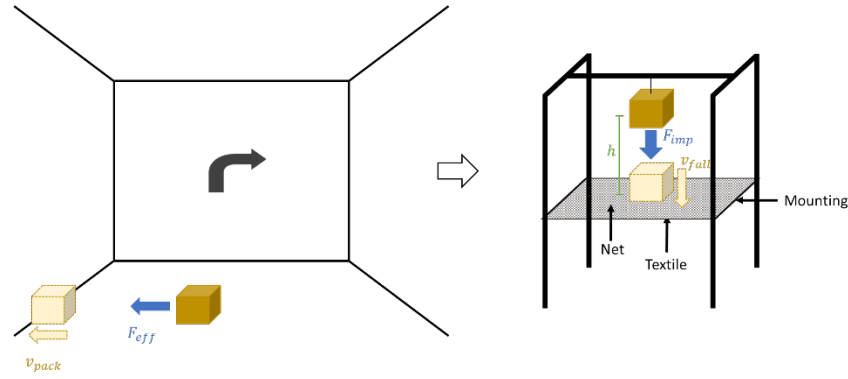


Figure 10: Technical concept of the load-test

To reach the same force acting in the lateral surface at the falling-test ($F_{eff} = F_{imp}$), the effective force and the impact force were calculated. The aim of the calculation is to find out the height h , the package has to fall down to reach the same velocity ($v_{pack} = v_{Fall}$) like a package can have at a bump into the side wall inside the vehicle body.

First, the effective force had to be calculated, which is determined from the difference between the centripetal force during cornering and the frictional force:

$$F_{eff} = F_a - F_{fric} = m_p * a_c - m_p * \mu_f * g = m_p * (a_c - \mu_f * g) \quad (1)$$

$$\text{with } F_a = m_p * a_c = m_p * \frac{(v_{truck})^2}{r} \quad (2)$$

$$\text{and } F_{fric} = m_p * \mu_f * g \quad (3)$$

$$m_{p, truck} = \text{mass of package [kg]}$$

$$\mu_f = \text{Coefficient of friction [-]}$$

$$v_{truck} = \text{maximum curve velocity } \left[\frac{m}{s}\right]$$

$$g = \text{acceleration of gravity } \left[\frac{m}{s^2}\right]$$

$$r = \text{curve radius [m]}$$

The height can be calculated by the acceleration due to gravity and the velocity of the parcel at the moment of impact, which takes the same value as in the sideways motion:

$$F_{imp} = m_{p, fall} * a_{fall} = m_{p, fall} * \frac{v_{pack}^2}{2 * h} \quad (4)$$

$$\text{with } v_{pack} = v_{fall} \text{ and } a_{fall} = g$$

$$h = \frac{v_{fall}^2}{2 * g} = \frac{(a_{ges} * t)^2}{2 * g} = \frac{\left(\frac{F_{eff}}{m_{p, fall}} * \sqrt{\frac{2 * b}{a_{ges}}}\right)^2}{2 * g} = \frac{\left(\frac{F_{eff}}{m_{p, fall}} * \sqrt{\frac{2 * b}{\frac{F_{eff}}{m_{p, fall}}}}\right)^2}{2 * g} \quad (5)$$

$$m_{p, fall} = \text{mass of package [kg]}$$

$$g = \text{acceleration of gravity } \left[\frac{m}{s^2}\right]$$

$$b = \text{maximum loading area width [m]}$$

$$h = \text{Fall height [m]}$$

The falling-test enables repetitive consistent conditions. For the special use-case in this work the following data were used to calculate the height h . All data based on a literature research or predefined vehicle data [24–26]. The mass of the package was reduced from 31.5 kg to 10 kg for a better handling during the tests.

Table 2: Data for the calculation of the fall-height

$m_{p,truck} = 31.5 \text{ kg}$	$m_{p,fall} = 10 \text{ kg}$	$v_{truck} = 5.6 \frac{m}{s}$	$r = 5 \text{ m}$
$\mu_f = 0.5$ (Cartridge – Wood / cartridge – cartridge)		$g = 9.81 \frac{m}{s^2}$	$b = 1.5$

By inserting the data above into the formula (1-5), a fall height $h = 0.45 \text{ m}$ is calculated. In addition to the calculated height, the maximum height $h_{max} = 1.45 \text{ m}$ given from the technical conditions and an absolute maximum test-force f_{edel} (person who throws the package) has also been tested. The point of impact (middle or at the edge) and the impact position (flat, edge or corner) of the package can be chosen variably. The testing of the fall-test was recorded by two cameras which were filming the drift punch of the textiles in front of a reference scale. One bar is about 2 cm. Figure 11 shows an example.



Figure 11: Example of recording the drift punch of a package in front of the reference scale

The results for the height $h = 0.45 \text{ m}$ are very low. For all textiles, there was no drift punch existing (0 cm). For the maximum technical height $h_{max} = 1.45 \text{ m}$ clear drift punches are existing in a range from 1.5 to 3 (0.03-0.06 m) without any damages of the net and textiles. For the maximum test-force f_{edel} the drift punches receive values from 5-7 (0.1-0.14 cm) without any damages. Table 3 shows the results.

Table 3: Results of the falling test

	Textile A + Piping System	Textile B + Piping System	Textile C + Piping System
$h = 0.45 \text{ m}$	0	0	0
$h_{max} = 1.45 \text{ m}$	2	3	1.5
f_{edel}	5	7.5	5

The fall test showed, the chosen textiles, safety net and mounting technique working excellent for the use as a vehicle body.

4.5 Prototype

At the end of the scientific work a prototype of the vehicle body has been built. For a customer approach because of the transportability, the prototype was built at a trailer to make the technologies presentable. The final prototype consists of one final selected textile B (Aircraft) as the outer skin for protection against water and dirt and as an

advertising medium and an inner textile for load securing and protection of the outer textiles from slipping cargo (polyester net coated with PVC). The textile is attached to the frame with a new type of rail and piping system. The opening systems are one flap at the back and two sliding doors at the sides. The whole textile system is about 15-20 percent lighter than conventional vehicle body (depends on the size of the vehicle body), which is a valuable contribution in the field of urban logistic. In comparison to a conventional vehicle body of this size, a payload increases about 80kg (conventional 3.5t truck: about 2t vehicle, 400kg vehicle body and 1t payload) is achieved. The focus at this work was the selection of lightweight textiles and mounting techniques according to demand. The lightweight construction potential was also considered, which can be further increased by suitable frame construction methods. Besides the reduction of weight, other important aspects are the possibility of a rapid replacement or repair of the textiles in the event of damage. Figure 12 shows the constructed prototype of the vehicle body.



Figure 12: Prototype of the textile vehicle body at a trailer

5. Conclusion

The work in this paper shows which textiles and mounting techniques can be used for vehicle bodies at urban logistic vehicles to reduce unladen weight for logistics. For the definition of the perfect textile setup, basic requirements were defined and textiles as well as mounting techniques were researched and tested. Three textiles and mounting techniques showed good results for the presented use case of a vehicle body. The selected textiles and mounting techniques were subjected to further tests like weathering, loading and durability in wind (wind-tunnel). At these tests one textile, a woven polyester fabric with Polyurethane (PU) coating used for light aircraft covering, with an Polyvinylchloride (PVC) coated polyester mesh fabrics on the inside for load security and a piping mounting system proved to be suitable. At the end, a prototype was built to get information about the market viability for urban logistic vehicles under 3.5t of total weight. The results showed a weight reduce potential about 15-20% in comparison to conventional materials like sandwich constructions (depends also on the size of the vehicle body). The project showed, the weight saving potential for vehicles <2.6t could be way higher, because the savings ratio for textiles is higher than by sandwich bodies for example. The smaller the vehicle the higher the potential weight saving. A second very big advantage of the textile vehicle body is the opportunity to distribute a construction kit decentralized. This is not possible with panels from conventional construction, as transport is more circumstantial. All the results and findings are an enormous added value and technical progress to promote electromobility in urban areas for the last-mile logistic industry. One disadvantage of the textile exterior is the lack of load-bearing capacity. A corresponding clamping frame must always be provided. Ideas for a frame made of material lighter than aluminium is being planned and gives further space for research questions. Further research work also consists of the implementation of a prototype of the body on a chassis and a practical application to gain further experience about the suitability of textiles in urban logistic vehicles.

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Presenter Biography



Fabian Edel started 2015 working at the Institute of Human Factors and Technology Management IAT of Stuttgart University. Since January 2017 Fabian Edel works at the Fraunhofer Institute of Industrial Engineering (IAO) as a researcher. Mr. Edel's main competences are micro-mobility and the fuzzy front end of the product innovation process including early prototypes.



Corinna Pulkus studied textile technology and textile management. Building on this, she completed the master's program in Interdisciplinary Product Development at Reutlingen University. She worked as a research assistant at the German Institutes of Textile and Fiber Research Denkendorf (DITF). Since March 2022, she started working as a trim engineer in the automotive industry at Lear Corporation Engineering GmbH.



Sarah Kim is a textile engineer and works as a researcher at the German Institutes of Textile and Fibre Research Denkendorf (DITF) since 2018, where her research interests include textile-based sensor technology and functional yarns. She represents DITF as an expert in the field of E-Textiles in national and international standardization bodies.



Jürgen Erhardt is managing director of Erhardt GmbH, which manufactures commercial vehicle bodies and provides services and vehicle conversions. Erhardt is active in many research projects to advance the logistics sector with new ideas and innovations.



Sven Kuijpers worked as a technical tailor in the industry from 2010-2018, where he manufactured e.g., textile structures, awnings, and truck tarpaulins. Since August 2018 he works at the German Institutes of Textile and Fibre Research Denkendorf (DITF), where he is specialized in the manufacture of technical textiles and their joining technology.