

## Contents

1	Introduction .....	1
1.1	Potential of continuous fiber thermoplastic composites .....	1
1.2	Motivation .....	2
1.3	Objective .....	2
1.4	Procedure .....	2
2	Theoretical background .....	5
2.1	Fiber composite materials .....	5
2.1.1	Fibers .....	6
2.1.2	Matrix .....	7
2.2	Energy absorption characteristics of fiber composites .....	8
2.2.1	Flat specimens .....	10
2.2.2	Self-supporting specimens .....	11
2.3	Size effect .....	12
2.4	Lamina stress-strain law .....	13
2.5	Failure of composite materials .....	16
2.5.1	Failure surface testing .....	17
2.5.2	Failure criteria .....	18
2.6	Explicit finite element method .....	19
2.7	User-defined material modeling (VUMAT) .....	21
2.8	Elasto-plasticity .....	22
3	Experimental material testing .....	27
3.1	Material .....	27
3.2	Tensile test .....	27
3.2.1	Test specimen .....	28
3.2.2	Test procedure .....	29
3.2.3	Results .....	30
3.3	Compression test .....	31
3.3.1	Test specimen .....	31
3.3.2	Test procedure .....	31
3.3.3	Results .....	33
3.4	Shear test .....	34
3.4.1	Test results .....	35
3.4.2	Cyclic shear test .....	36
3.5	Intra-laminar fracture energy .....	38

3.5.1	Tensile fracture energy.....	40
3.5.2	Compression fracture energy.....	44
3.6	Axial crushing behavior.....	45
4	Continuum damage mechanics.....	47
4.1	Basics of CDM.....	47
4.2	Ls-Dyna CDM model MAT_Laminated_Composite_Fabric.....	50
4.2.1	Fiber response.....	50
4.2.2	In-plane shear response.....	53
4.3	Abaqus CDM model ABQ_PLY_FABRIC.....	54
4.3.1	Fiber response.....	55
4.3.2	In-plane shear response.....	58
4.4	Validation.....	60
4.4.1	Three-point bending of rectangular specimen.....	60
4.4.2	U-profile.....	61
4.5	Conclusion.....	62
5	Shear modeling.....	63
5.1	Testing.....	64
5.1.1	Frame shear test.....	66
5.1.2	Rail shear test.....	68
5.1.3	Compression shear.....	69
5.1.4	Results and comparison.....	70
5.2	Improved shear modelling.....	73
5.2.1	Results.....	73
5.3	Validation.....	75
5.4	Conclusion.....	77
6	Strain-rate modelling.....	79
6.1	Test.....	79
6.1.1	Tensile strain-rate dependency.....	79
6.1.2	Shear strain-rate dependency.....	84
6.2	Strain rate-dependent modeling.....	91
6.2.1	Strain rate dependency in the fiber direction.....	91
6.2.2	Strain rate dependency along in-plane shear.....	92
6.2.3	Implementation as user-defined material subroutine.....	93
6.3	Validation.....	97
6.3.1	FEM model setup.....	98
6.3.2	Results.....	98

6.3.3	Discussion .....	99
6.4	Conclusion .....	100
7	Failure surface .....	103
7.1	Testing .....	103
7.2	Conclusion .....	108
8	Size effect .....	109
8.1	Size effect in tension .....	109
8.2	Size effect in bending .....	110
8.2.1	Pin-end buckling test .....	112
8.3	Proposed method for scaling strength in user-material subroutine .....	114
8.4	Conclusion .....	116
9	Axial crush simulation .....	117
9.1	Inter-laminar fracture energy measurement .....	117
9.1.1	DCB test .....	118
9.1.2	ENF test .....	122
9.2	Delamination modeling .....	124
9.2.1	Constitutive model of cohesive elements .....	124
9.2.2	Parameter calibration .....	126
9.2.3	Single-element simulation .....	128
9.2.4	Influence of cohesive modeling on composite response .....	130
9.3	Validation .....	132
9.3.1	DCB simulation .....	132
9.3.2	ENF simulation .....	134
9.4	Axial crush simulation .....	135
9.4.1	Conclusion .....	136
10	Summary and Outlook .....	137
10.1	Summary .....	137
10.2	Outlook .....	138
11	Bibliography .....	140
12	Annex .....	145
12.1	Test results data .....	145
12.1.1	Frame shear .....	145
12.1.2	Rail shear .....	145
12.1.3	Compression shear .....	146
12.1.4	High-speed tensile test .....	146
12.1.5	High-speed shear test .....	148

12.1.6	Off-axis tests .....	150
12.1.7	DCB test .....	152
12.1.8	ENF test .....	153
12.2	Specimen photos.....	154
12.2.1	Tensile test specimens.....	154
12.2.2	Compression tests specimens .....	154
12.2.3	Tensile-shear test specimens.....	155
12.2.4	Intralaminar fracture energy specimens .....	155
12.2.5	Axial crash of corrugated specimens .....	155
12.2.6	Rail shear tests specimens .....	156
12.2.7	Tensile shear specimens.....	156
12.2.8	Compression shear specimen.....	156
12.2.9	High speed tensile test specimens .....	156
12.2.10	High-speed shear specimen .....	158
12.2.11	Off-axis tensile test specimen .....	159
12.3	CAD drawings.....	160
12.3.1	CLC fixture .....	160
12.3.2	Clevis design for intra-laminar fracture energy.....	162
12.3.3	Frame shear fixture .....	163
12.3.4	Rail shear fixture .....	167
12.3.5	Pin-end buckling fixture .....	170