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13 Abstract

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15 A web-based conceptual design prototype system is presented. The system consists of four parts which interpret on-line 16 sketches as 2D and 3D geometry, extract 3D hierarchical configurations, allow editing of component behaviours, and produce 17 VRML-based behavioural simulations for design verification and web-based application. In the first part, on-line freehand sketched input is interpreted as 2D and 3D geometry, which geometrically represents conceptual design. The system then infers 18 19 3D configuration by analysing 3D modelling history. The configuration is described by a parent-child hierarchical relationship and relative positions between two geometric components. The positioning information is computed with respect to the 20 21 VRML97 specification. In order to verify the conceptual design of a product, the behaviours can be specified interactively on 22 different components. Finally, the system creates VRML97 formatted files for behavioural simulation and collaborative design application over the Internet. The paper gives examples of web-based applications. This work forms a part of a research project 23 24 into the design and establishing of modular machines for automation manufacture. A consortium of leading automotive 25 companies is collaborating on the research project.

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28 *Keywords:* Sketch; Conceptual design; Behavioural simulation; Web application

30 1. Introduction

Economic globalisation is creating competitive pressures on industry to minimise the time to bring products to market. Project timing through the whole production process: conceptual design, detailed design, analysis and test, installation, to maintenance must be compressed wherever possible. Today, information technol-

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ogies and the web are challenging, and changing the way 37 industry works. It is believed that web-based conceptual 38 design techniques can be applied to improve efficiency 39 by first building conceptual design models to represent 40 products' geometry, structures, and behaviours, and 41 then distributing the models over the web for remote 42 evaluation and verification of the design correctness. 43 The web is seen as the ideal method to achieve this. 44 because a web-based system has a universal interface, 45 uses open standards, and is globally supported [1,2]. 46

Conceptual design is an early stage of the product 47 development process having characteristics of fuzzy 48

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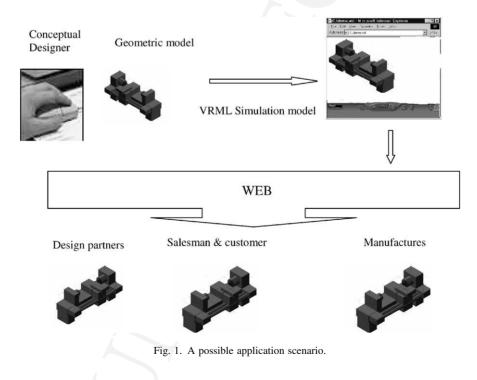
² PII: S0166-3615(02)00117-3

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problems, tolerating a high degree of uncertainty. 49 During the conceptual stage of design, designers 50 generate ideas, turn them into quick sketches with 51 basically two-dimensional (2D) tools like pencil and 52 53 paper, while at the same time these activities are guided by function design. Designers not only need 54 to determine the physical structure of the design, but 55 also need to verify design functions. Conventional 56 CAD systems do not readily support this conceptual 57 design process, since they usually require complete, 58 concrete and precise definitions of the geometry, 59 which are only available at the end of the design 60 process. To provide computational support for com-61 puter aided conceptual design (CACD), studies [3–5] 62 indicated that a CACD system must allow sketched 63 input. On the other hand, during conceptual design, 64 collaborating designers or partners (e.g. customer, 65 manufactures), may work in different sites all over 66 the world. To some extent, there is a lack of consistent 67 visualising tools to view, share, and evaluate concep-68 tual design models or results. 69

Our research investigates sketch and simulation
based design tools to allow users to quickly model
their design ideas and test their design by performing
products' behavioural simulation on the Internet. A

possible application scenario is shown in Fig. 1. 74 Designers first sketch out their conceptual design 75 and transform the design into a simulation model, 76 then send or broadcast the animated simulation model 77 of the conceptual design over the Internet to enable 78 collaborative working with designers, manufactures, 79 and potential customers who wish to evaluate and 80 verify the initial design ideas. The designers can thus 81 quickly get feedback from their partners. Simulating 82 and testing various design ideas in a rough model at 83 the early stages of design facilitates the integration of 84 the geometric design with the product's behavioural 85 description. Our research focuses on geometric mod-86 elling and simulation, rather than discrete event simu-87 lation [6]. Many geometric simulators [7] have been 88 explicitly developed for simulation of robots, e.g. 89 CimStation and RobCAD. The last can be used for 90 professional robot simulation and production cell 91 animation, but for a number of reasons the required 92 functions of a conceptual simulation model cannot be 93 created with these software systems [8]. For example, 94 the processing of sketched input is generally unavail-95 able. For the viewing of sketch-based modelling, some 96 efforts [9–11] in recognising 3D objects from a set of 97 sketched 2D input have been made. These efforts 98



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focused only on geometric descriptions in a global 99 co-ordinate system. However, a simulation model 100 should be described in a hierarchical way and be 101 associated with behavioural descriptions embedded 102 103 within the design. Our research integrates sketch-104 based 3D recognition techniques with simulation modelling techniques to support web-based concep-105 106 tual design activities. In Section 2, our initial sketchbased modelling system is briefly described. The 107 process of obtaining hierarchy information is pre-108 109 sented in Section 3. In Section 4, our approach to specify behaviours is discussed. Finally, examples are 110 given and conclusions made. 111

112 2. Sketch-based modelling

113 2.1. Initial sketch interpretation system

Our initial sketch interpretation system [12] has 114 115 been developed in three phases: segmentation and 116 curve fitting, constraint solver and 2D geometry, and 3D interpretation. Here, a brief introduction to 117 the system is given to describe its functions and 118 discuss our newly developed work. In the first phase, 119 a conventional mouse is used as the input device. 120 While sketching, the system gets a sequence of input 121 data from mouse button presses, mouse motion and 122 mouse button release events. This sequence of data 123 represents a freehand curve that may consist of several 124 sub-curves. The investigated segmentation approach 125 accepts the input of on-line free-hand sketch, and 126 segments it into meaningful parts, by using fuzzy 127 knowledge in terms of sketching position, changes 128 of drawing direction, drawing speed and acceleration. 129 After segmentation, each sub-curve represents one 2D 130 131 primitive. The sub-curve is then classified into one of 132 the following 2D primitives: straight lines, circular arcs and elliptical arcs, or free-form curves, it is then 133 fitted with corresponding parameters. As a result of 134 the segmentation and curve fitting, a set of 2D primi-135 tives or free-form curves are obtained. These 2D 136 entities are roughly placed at their proper positions 137 138 and directions. In general, however, they are not connected together correctly to reflect users' intent. 139 A geometric constraint inference engine and a con-140 straint solver are utilised to capture the designers' 141 142 intention, and to generate a possible solution. At the

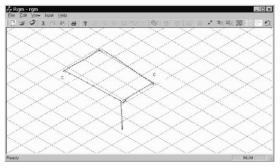
end of this phase, 2D entities have their correct 143 positions and 2D constrained connections. In the last 144 phase, rule-based feature interpretation and manipula-145 tion techniques are investigated. While drawing, the 146 2D geometry is accumulated until it can be interpreted 147 as a 3D feature. The feature is then placed in a 3D 148 space and a new feature can be built incrementally 149 upon previous versions. Therefore, this 3D recogni-150 tion process automatically assembles features in 3D 151 space. Once a feature is created, a user can examine it 152 in a wire-frame model or in a shaded solid model from 153 different views. In addition to the sketched input, users 154 can input 2D primitives interactively. This gives more 155 freedom in inputting 2D information. The system 156 currently supports only extruded objects. Fig. 2 shows 157 the sketch-based modelling process. The background 158 diagonal lines parallel to the axes of the isometric 159 projection are auxiliary lines for assisting sketch. 160

In Fig. 2a, three strokes were drawn. Two of them 161 contain two straight lines with corner points marked 162 with letter "C". Another stroke is a vertical line. The 163 system first found the corner points by segmentation 164 processing, then sketches were classified as straight 165 lines, and fitted with lines. These sketched lines initially 166 were not connected properly and were not parallel 167 to the axes of the isometric projection to reflect a 168 user's intention. However, the system examined those 169 sketched input to the extract 2D constraints: connection 170 relations between those entities, and unitary relations 171 such as vertical direction. Consequently, the system 172 produced a 2D solution (geometry) for extracted con-173 straints shown in Fig. 2b. The lines became parallel to 174 the axes of the isometric projection with proper con-175 nections. This reflects the user's intention. Based upon 176 the 2D geometry, the system interpreted the input as a 3D 177 box feature illustrated in Fig. 2c. Afterwards, the user 178 continued sketching a cylinder on the left face of the box 179 (Fig. 2d). After receiving the cylinder, a truncated 180 cylinder was entered by interactive input of an ellipse 181 and a line on the top face of the box (Fig. 2e). The user 182 can choose to input 2D entities by either sketched input 183 or interactive input. As a result of the 3D interpretation, 184 combined 3D objects were received (Fig. 2f). 185

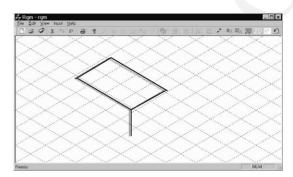
2.2. Improved prototype system 186

In order to construct simulation models, hierarchy 187 information and relative positioning information are 188

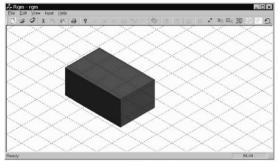
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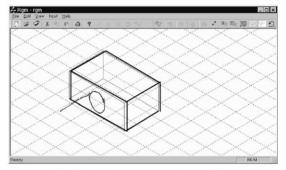
(a) Sketched input: curve segmentation and fittings



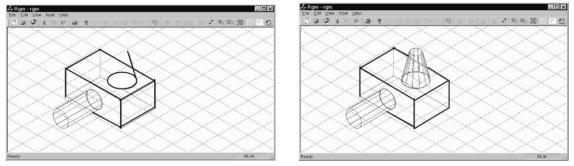
(b) Results of solving 2D constraint



(c) Interpretation of 3D objects



(d) Sketching on a previous object



(e) Input of 2D primitives interactively



Fig. 2. Modelling process.

needed. We have improved our initial sketch interpretation system to support the simulation modelling
processes. From the geometric modelling processes,
the hierarchy information is extracted and is described
as a tree structure shown in Fig. 3.

The root node in Fig. 3 is a null object. It just defines a
global co-ordinate system, in which the positive *X*direction points to the right, the positive *Y*-direction

points up, and the Z-direction points out from the 197 screen. It also provides three co-ordinate planes as 198 reference planes. A parent-object is linked with its 199 child-objects. This means that the parent-object is used 200 as a reference to further build its child-objects. Thus, 201 one parent-object can be classified as a child-object 202 when referencing to its parent-object, and it can also be 203 identified as a parent when looking at its children. 204

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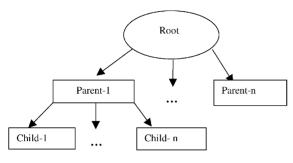


Fig. 3. Tree structure.

205 2.2.1. Hierarchy information

During sketching, after finding closed profiles, 206 extrusion edges and directions, e.g. an ellipse and a 207 line drawn from the ellipse in Fig. 2d, the system can 208 recognise the sketched input as an extrusion feature. 209 Then it has to find a reference plane from previous 3D 210 objects in order to obtain information about features' 211 sizes and their positions (transformation information). 212 213 If the reference plane exists, the 3D transformation information can be extracted. The referenced 3D 214 object will become a parent-object, and the new object 215 (feature) will become a child-object linked to the 216 parent. If the reference plane comes from one of 217 218 the three global co-ordinate planes, the new object will be linked to the root. Brother or sister relation-219 ships can be formed when two or more objects come 220 from the same parent. 221

To determine a reference plane, the system first computes the centroid of a closed profile. If the inferring feature is a cylindrical object, its centroid is the centre of the ellipse (closed profile). If the feature is a non-cylindrical object, the centroid can be received by

$$x_{\rm cd} = \frac{\sum_{i=1}^{n} x_i}{n, y_{\rm cd}} = \frac{\sum_{i=1}^{n} y_i}{n}$$

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where *n* is the number of elements involved in the closed profile, x_i and y_i the pair of co-ordinates of the end points for each element.

After obtaining the centroid position, the system continues to conduct a containment test [13] between the centroid point and the closed profile (a polygon or ellipse), which is a projection of a face of a previous 3D object. If the centroid is within two or more closed profiles (or projection areas of faces), the system will further determine which face is a reference plane by finding an minimum angle between the extrusion 241 direction vector and projected normal vectors of can-242 didate faces. For example in Fig. 2d, the centre of the 243 ellipse is within the projection areas of the left face 244 and the bottom face of the box object. The extrusion 245 direction is parallel to the normal vector of the left 246 face. It is obvious that the angle between the extrusion 247 direction vector and the projected vector of the normal 248 of the bottom face is bigger than the angle between the 249 extrusion direction vector and the projected vector of 250 the normal of the left face. Thus, the left face of the 251 box object is determined as a reference plane. Con-252 sequently, the box object becomes a parent-compo-253 nent of the new component (cylinder). In turn, the 254 cylinder is a child of the box object. 255

2.2.2. Relative positioning

Each object is described in three co-ordinate systems 257 in terms of the object (or primitive), relative and global 258 co-ordinate systems. The object co-ordinate system is 259 related to a graphics rendering program, e.g. OpenGL 260 and VRML97 [14]. In order to easily transfer models 261 into VRML97 format for the web-based application, the 262 object co-ordinate system is consistent with shape and 263 geometry definition in VRML97. For example, a cylin-264 der can be defined in its object co-ordinate system by a 265 radius and a height as shown in Fig. 4. In the relative co-266 ordinate system, an object coupled with its object 267 coordinate system is defined in its parent's object co-268 ordinate system. The definition includes transformation 269 of a child's co-ordinate system to its parent's co-ordi-270

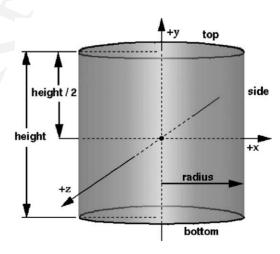


Fig. 4. An object co-ordinate system.

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271 nate system and geometric descriptions in its own object co-ordinate system. In order to display objects 272 and produce projection of faces of objects, descriptions 273 of objects are finally transformed to the global co-274 275 ordinate system.

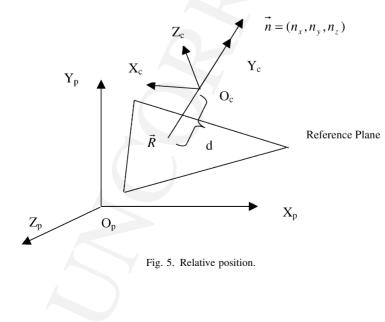
276 Each object is internally represented by an objectoriented class, which encapsulates modelling data: 277 278 dimensional and positional parameters, derived data from the model such as B-rep (boundary representa-279 tion) information about faces, edges, and vertices, and 280 281 its member functions (methods) for building the model, producing B-rep information, accessing the 282 data and so on. Each object model is an instance of its 283 284 corresponding class. This representation can take full advantages of the features and properties of object-285 oriented design, e.g. data encapsulation and code 286 reuse through the inheritance mechanism. Taking a 287 box part as an example, its corresponding class can be 288 defined as follows: 289

- 290
- 291 class Box::Object
- 292
- ł 293 protected:
- 294 double length, width, height; //dimensional para-295 meters
- double relative_tx, relative_ty, relative_tz; //rela 296 tive translation parameters 297
- double relative_ax, relative_ay, relative_az; 298 //relative rotation axis 299
- double relative angle; //rotation angle about the 300 301 relative rotation axis

double globle_x, globle_y, globle_z; //globe trans	302
lation parameters	303
	304
public:	305
Box(Object referentObject, double Length, double	306
Width, double Height);	307
void Draw2D();	308
void Draw_frame3D();	309
void DrawShade3D();	310
void generating_faces();	311
<pre>void get_data_of_faces();</pre>	312
	313
};	314 315

This class named *Box* is derived from an existing 316 public class named Object. In the data field, we 317 declare modelling data and derived data as protected 318 type. The construction function takes a reference 319 object and dimensions of the box as input and gen-320 erates relative positions to its parent (the reference 321 object) and globe positioning information. 322

To compute relative positions of a child-object to its 323 parent-object, the object co-ordinate system $O_{\rm p}X_{\rm p}Y_{\rm p}Z_{\rm p}$ 324 of the parent is assumed as in Fig. 5. The object co-325 ordinate system $O_c X_c Y_c Z_c$ of the child is transferred to 326 a new position from its initial position that is coin-327 cident with $O_{\rm p}X_{\rm p}Y_{\rm p}Z_{\rm p}$. The transformation processes 328 can be identified as a rotation about an axis vector to 329 make the Y_c consistent with (pointing to) the normal 330 direction of the reference plane, and a translation to let 331 the origin $O_{\rm c}$ has a distance of d from the reference 332



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plane to enable a right size of the child-object. Let \vec{R} 333 be a vector from the origin O_p pointing to the inter-334 section point of the axis Y_c and the reference plane. 335 The relative positions are computed in terms of a 336 337 rotation axis vector, a rotation angle and a translation. 338

(1) Computing the rotation axis vector: The rotation 339 axis vector can be represented as 340

$$\vec{A} = \vec{y}\vec{n}$$

- where \vec{y} is a unit vector along Y-axis, \vec{n} is a unit 344 vector of the normal of the reference plane. In 345 case of \vec{v} parallel to \vec{n} , \vec{A} is assigned as a unit 346 vector along Z-axis. 347
- (2) Computing the rotation angle: The rotation angle 348 349 can be computed by

$$\theta = \arcsin(||\vec{A}||)$$

- When \vec{y} is equal to \vec{n} , θ is assigned a value of 0; 353 354 while \vec{v} is opposite to \vec{n} , θ is assigned a value of π .
- Obtaining the translation: The translation vector (3)355 \vec{T} can be given by 356

357

250

 $\vec{T} = \vec{R} + d\vec{n}$ 359

In order to obtain global positions of a child-360 object, the system will accumulate transforma-361 tions from the root to the child. 362

363 3. Behavioural description

From the sketch recognition, a hierarchical struc-364 ture of the design is received. Design structures can be 365 366 classified as static and dynamic structures. In a static structure, design components, their attributes, and 367 their relationships are fixed, and there is no active 368 component or process in the structure. They are 369 assumed not to change their structures with time, 370 e.g. civil engineering design. Whilst in a dynamic 371 structure, design components, their attributes and their 372 relationship to one another can be changed with time 373 374 by external effects or driving events. For instance, when a car is started, its engine will run. These driving 375 376 events (input to design) and their corresponding structural changes (output of the events) can be defined as 377 design components' behaviours in relation with func-378 tion design of a product. While designers sketch out 379 380 their design structures (geometry definition), the functional relationships are being considered. After struc-381 tural design, the designers can verify functional design 382 by specifying the behaviours of design components 383 and simulating them later. The behavioural simulation 384 is commonly used for functional design verification 385 [15]. The simulated and desired behaviours are com-386 pared in order to determine to the degree of function-387 ality achieved. 388

In our system, the designer can specify behaviours to 389 a selected object. The designer first selects a geometric 390 object representing a design component, and then 391 inputs the behaviour in a dialogue window shown in 392 Fig. 6. Behaviour can be triggered by a driving input (an 393 event). In order to produce a driving event at real-time 394 simulation, a touch sensor is attached to the selected 395 geometric object. In a simulation environment, if users 396 simply click the geometric object, the touch sensor will 397 be activated to drive the corresponding behaviours. 398 After receiving a driving event, the design component 399 will continuously change its initial state to a set of 400 different states. In the input window, designers specify 401 the name of the behaviour, and input time intervals 402 corresponding to serial states. If the states are related to 403 the position changes of the design component, the 404 designers can continue to enter key positions in relation 405 to state changes. If there is no position change of the 406 design component during the state transitions, the 407 designers can specify different colours of the geometric 408 object to represent different states. 409

Our approach is limited as the behaviours must be 410 known or specified by the designers. Design verifica-411 tion is achieved by ensuring that values of design 412 variables meet the functional requirement. 413

ОК	CANCEL
Colors	1.0 0.0 0.0
Z rotation	0
Y rotation	0
X rotation	0
Z position	0
Y position	0
X position	0
time interval	0
Behaviour name	
🛰 Specify A Beł	naviour 🛛 🗙

Fig. 6. Input window for behavioural descriptions.

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414 4. Virtual reality mark-up language415 (VRML)-based simulation

A composite geometric and behavioural model is 416 417 constructed in our sketch-based modelling system. This model enables designers, during a conceptual 418 design stage, to effectively communicate their intent 419 420 by simulating and verifying dynamic behaviours. In order to effectively and easily conduct the simulation, 421 we output the model data into VRML formatted files. 422 423 VRML has an open structure and is easy to access over the Internet. The VRML files can be visualised gra-424 phically and animated interactively using a web brow-425 ser with a VRML plug-in, e.g. CosmoPlayer. This 426 simulation model can be shared with different partners 427 (co-designers, manufacturers, customers, etc.). The 428 simulation may be visualised and controlled remotely 429 over the Internet. Designers can use the models to 430 simulate the products' performance, to determine 431 part clearance, interference and collision detection, 432 433 and thus improve their designs. Moreover, utilising 434 VRML, designers can potentially further develop the simulation models into multimedia-based product 435 presentations for a advertising purposes by integrating 436 additional multimedia data. 437

438 It is easy to transfer the VRML-based model into
439 commercial CAD packages as an initial input for
440 detailed design. This allows design ideas to be con441 sistently transferred from the conceptual stage to the
442 detailed design stage.

443 **5. Examples and discussion**

We have, as an example, used our prototype system 444 to conceptually model a milling machine. Firstly, a 445 446 conceptual model of the milling machine was built on 447 sketched input. Its shaded model is given in Fig. 7. After obtaining the conceptual geometric model, the 448 system extracted the hierarchical information for the 449 design. For example, the vertical carriage is linked to its 450 parent component (the vertical base pillar). It has a child 451 (the table moving along X-axis) and a grandchild (the 452 453 workpiece holder moving back and forth). The vertical carriage can move up and down. These provide motion 454 in three directions. Based on the geometric model and 455 456 hierarchical structure, we interactively selected com-457 ponents to specify their behaviours. For example, we

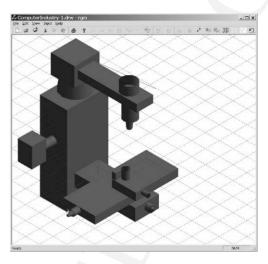


Fig. 7. A shaded model of the machine.

included a touch sensor to the workpiece (a cylinder on 458 the workpiece holder), specified a movement of the 459 vertical carriage from current position to 80 cm within a 460 time interval of 10 s, specified the table's motion of 461 moving 10 cm backwards and defined the workpiece 462 holder's motion of moving 40 cm to the right. We also 463 changed the colours of the components for appearance 464 modification. The geometric model and the behaviour 465 definitions formed a simulation model of the drilling 466 machine. 467

Finally, we outputted the simulation model into a 468 VRML97 formatted file and loaded this file in an 469 Internet browser. Fig. 8 shows the initial state of 470 the drilling machine. When the touch sensor was 471 activated, the defined behaviours were performed; 472 the final state was shown in Figs. 9 and 10. If the file 473 is linked to a web server, the simulation can be 474 executed remotely over the Internet for design ver-475 ifications. 476

After receiving conceptual design models in VRML477formatted files, we may use web technologies for478supporting the active feedback from the users (clients)479of the system and their collaborative work. The web480computing architecture [18,19] of the system could be481a three-tier client/server architecture: presentation tier,482application tier and share data tier as shown below.483

Shared data might be stored in a database server in a484collection of VRML files or a corresponding relational485database. A separate application server runs the col-486laborative design application logic (Java-application),487

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Fig. 8. Initial state of the machine.



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Fig. 9. Final state of the machine.

which mediates between shared data and presentation
(web servers and web browses), and manipulates the
shared data. It takes inputs and requests through Java
remote method invocation (RMI) and common gateway interface (CGI) or the extendible mark-up language (XML) mechanisms from the presentation
(HTML or XML), decides what needs to be done,

495 decides what shared data should be accessed or must

be updated, manipulates that data appropriately, e.g. 496 creating a new design version, and responds to the 497 presentation. The shared data answers queries from 498 the application logic through JDBC or structured 499 query language (SQL) mechanisms, and the applica-500 tion logic determines what data is stored and what 501 queries are needed. In the presentation tier, web 502 servers interact with web browsers supporting the 503

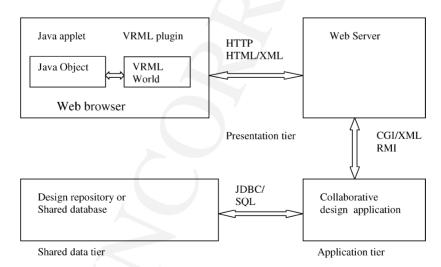


Fig. 10. The web computing architecture of the system.

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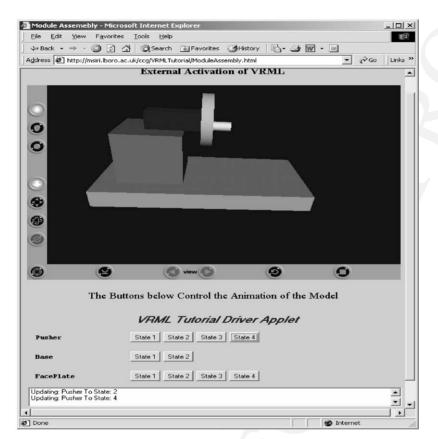


Fig. 11. External activation of a VRML model.

504 users. The users are able to navigate through the VRML worlds by using a VRML-browser. The external author-505 506 ing interface (EAI) makes it possible to control the VRML worlds dynamically via the Java applets or 507 Javascripts. For example, users can interactively verify 508 or evaluate a design model by interacting with a Java 509 applet that activates (http://msiri.lboro.ac.uk/ccg/ 510 vrmltutorial/moduleassembly.html) the VRML model 511 shown in Fig. 11. Users can click on different state 512 labels defined in the Java applet to activate design 513 simulations. In a similar way, users might dynamically 514 515 modify the design by changing design attributes, e.g. parameters of a cylinder, update their design to 516 collaborative participants' browsers (depending on 517 authorised rights) or request to store their design as 518 519 new versions in the database or send their evaluation feedback by e-mail. 520

6. Conclusion

From the examples, some features of the prototype 522 system can be identified as follows: 523 (1) Using an on-line sketch, users can rapidly and 525

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- easily create, and edit a 3D design geometric model for any purposes.
- (2) With behavioural definition attached to the 528 geometric model, designers can explore their 529 ideas not only in a static model form, but also in 530 a dynamic simulation form. This will provide an 531 effective evaluation mechanism for verifying 532 their conceptual designs. Instead of working 533 with confusing paper drawings, designers can 534 have a real-time shaded and animated view of 535 their design models, without the need for 536

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expensive CAD hardware or software, and with-out extensive training.

(3) This tool lets the designers publish their designs 539 on the Internet. Designers can share models and 540 541 data with their partners involved in the product 542 development process without the need for of expensive workstations and CAD software. This 543 VRML-based simulation is more accessible to 544 non-expert users. Non-CAD users such as 545 customers, suppliers, and managers may evaluate 546 547 the design and quickly give feedback. This communication mechanism may compress the 548 timing from the conceptual design to manufac-549 550 turing and marketing, and support distributed

551 engineering of manufacturing machines [20].

(4) With this tool, the designers could quickly
transfer their conceptual design ideas bounded
with approved modelling data into commercial
CAD packages to rapidly realise detailed design
and manufacturing processes. Comparing with
the current design process, time is saved by
directly importing VRML-based models into

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In summary, the authors believe that this tool has 561 the potential to save time and money by: (i) rapidly 562 developing a product model; (ii) improving under-563 standing design ideas for all parties involved; (iii) 564 facilitating communication so less time is spent in 565 face to face meetings; (iv) reducing the need to invest 566 567 more CAD workstations and software; (v) using simulation to reduce the number of costly physical 568 prototypes. 569

570 The next stage of this work will include an evalua-571 tion of the tool in design applications at our collabor-572 ating manufacturing companies.

573 Uncited references

CAD packages.

574 [16,17].

575 Acknowledgements

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- 578 Hueller Limited, Johann A. Krause GmbH and the

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