



9th INTERNATIONAL CONFERENCE
"RESEARCH AND DEVELOPMENT
IN MECHANICAL INDUSTRY"

RaDMI 2009

PROCEEDINGS

Volume 1

Editor:
Predrag V. Dašić

16-19. September 2009.
Vrnjačka Banja, Serbia

1



Vrnjačka Banja, Serbia

**9th INTERNATIONAL CONFERENCE
"RESEARCH AND DEVELOPMENT IN
MECHANICAL INDUSTRY"**

RaDMI 2009

PROCEEDINGS

Vol. 1

Editor:

Predrag V. Dašić

**Vrnjačka Banja, Serbia
16 - 19. September 2009.**

Publisher: SaTCIP (Scientific and Technical Center for Intellectual Property) Ltd.,
36210 Vrnjačka Banja, Serbia

For publisher: Jovan Dašić, Director of the firm SaTCIP Ltd.

Reviewers: Prof. dr. Branislav Dragović, vice-dean, Maritime Faculty, University of
Montenegro, Kotor (Montenegro)
Prof. dr Volodymir Fedorinov, rector, Donbass State Machinery Academy
(DSMA), Kramatorsk (Ukraine)
Prof. dr Georgios Petropoulos, University of Thessaly, Faculty of Mechanical
& Industrial Engineering, Volos (Greece)

Technical processing and design: Predrag Dašić
Jovan Dašić

Approved by:
Decision no. 006/2009 from 01-09-2009 from SaTCIP Ltd., Vrnjačka Banja (Serbia)

Circulation: 80 exemplars

Printed by: SaTCIP (Scientific and Technical Center for Intellectual Property) Ltd.
36210 Vrnjačka Banja, Serbia

ORGANIZER



Vrnjačka Banja, Serbia

<http://www.satcip.com/>

ORGANIZING COMMITTEE

1. Predrag Dašić, SaTCIP Ltd. Vrnjčka Banja, Chairman
2. Milan Marinković, INTERHEM Research Center, Belgrade (Serbia), Vice-chairman
3. Dr Stjepan Panić, director, High Business Technical School of Užice (Serbia)
4. Dr Milutin Milosavljević, Economic Institute, Belgrade (Serbia)
5. Dr Dragan Milenković, IHTeM Institute, Belgrade (Serbia)
6. Slobodan Radosavljević, Mining Basin “Kolubara”, Lazarevac (Serbia)
7. Veis Šerifi, Technical Faculty, Čačak (Serbia)
8. Jovan Dašić, SaTCIP Ltd., Vrnjčka Banja (Serbia)

SCIENTIFIC COMMITTEE

1. Prof. dr Grigoryev Sergey Nikolaevich, rector, Moscow State Technological University "STANKIN", Moscow (Russia), Chairman
2. Prof. dr Valentin Nedeff, rector, University of Bacău, Faculty of Engineering, Bacău (Romania), Vice-chairman
3. Prof. dr Friedrich Franek, University of Vienna and president of Austrian Tribology Association, Vienna (Austria), Vice-chairman
4. Prof. dr Raycho Ilarionov, vice-rector, Technical University of Gabrovo (Bulgaria), Vice-chairman
5. Dr Syed Ahmed, CSEM S. A., Surface Engineering Division, Neuchâtel (Switzerland)
6. Prof. dr Emilia Assenova, Technical University of Sofia, Sofia (Bulgaria)
7. Prof. dr Anatoly P. Avdeenko, Donbass State Machinery Academy, Kramatorsk (Ukraine)
8. Prof. dr Milun Babić, University of Kragujevac, Faculty of Mechanical Engineering, Kragujevac (Serbia)
9. Prof. dr Rade Biočanin, University of Novi Pazar, Technical Faculty, Novi Pazar (Serbia)
10. Prof. dr Pavao Bojanić, University of Belgrade, Faculty of Mechanical Engineering, Belgrade (Serbia)
11. Prof. dr Leonid Borisenko, Technical University of Mogilev, Mogilev (Belarus)
12. Prof. dr Konstantin D. Bouzakis, Aristoteles University of Thessaloniki, Faculty of Mechanical Engineering, Thessaloniki (Greece)
13. Prof. dr Miodrag Bulatović, University of Podgorica, Faculty of Mechanical Engineering, Podgorica (Montenegro)
14. Prof. dr Mikhail V. Burmistr, academician, rector, Ukrainian State Chemical Technology University of Dnipropetrovsk, Dnipropetrovsk (Ukraine)
15. Prof. dr Alexander I. Burya, academician, Dnipropetrovsk State Agrarian University, Dnipropetrovsk (Ukraine)
16. Prof. dr Ilija Ćosić, dean, University of Novi Sad, Faculty of Technical Scientific, Novi Sad (Serbia)
17. Prof. dr Predrag Ćosić, University of Zagreb, Faculty of Mechanical Engineering Naval Architecture, Zagreb (Croatia)
18. Prof. dr George Dobre, University Politehnica, Bucharest (Romania)
19. Prof. dr Alexandre Dolgui, Ecole Nationale Supérieure des Mines de Saint-Etienne, Saint-Etienne (France)
20. Prof. dr Ćemal Dolićanin, rector, University of Novi Pazar, Technical Faculty, Novi Pazar (Serbia)
21. Prof. dr. Branislav Dragović, vice-dean, Maritime Faculty, University of Montenegro, Kotor (Montenegro)
22. Prof. dr Ljuben Dudesku, vice-dean, University of Skopje, Faculty of Mechanical Engineering, Skopje (Macedonia)
23. Prof. dr Petru Dusa, Technical University "Gh. Asachi", Faculty of Mechanics, Iași (Romania)
24. Prof. dr Ljubodrag Đorđević, University of Union, Faculty of Industrial Management, Kruševac (Serbia)
25. Prof. dr Vladan Đorđević, academician, University of Belgrade, Faculty of Mechanical Engineering, Belgrade (Serbia)
26. Prof. dr Sabahudin Ekinović, rector, University of Zenica, Faculty of Mechanical Engineering, Zenica (Bosnia and Herzegovina)
27. Prof. dr Volodymir Fedorinov, rector, Donbass State Machinery Academy, Kramatorsk (Ukraine)
28. Prof. dr Milomir Gašić, University of Kragujevac, Faculty of Mechanical Engineering, Kraljevo (Serbia)
29. Prof. dr Manfred Geiger, University Erlangen-Nuremberg, Erlangen (Germany)
30. Prof. dr Anatoly Ivanovich Grabchenko, National Technical University, Kharkov Polytechnical Institute, Kharkov (Ukraine)
31. Prof. dr Nicolae Valentin Ivan, University Transilvania of Brasov, Faculty of Mechanical Engineering, Brasov (Romania)
32. Prof. dr Ratimir Ječmenica, University of Kragujevac, Technical Faculty, Čačak (Serbia)
33. Prof. dr Milan Jurković, University of Bihać, Technical Faculty, Bihać (Bosnia and Herzegovina)
34. Prof. dr Isak Karabegović, dean, University of Bihać, Technical Faculty, Bihać (Bosnia and Herzegovina)
35. Prof. dr Baki Karamiş, Erciyes University, Faculty of Mechanical Engineering, Kayseri (Turkey)
36. Prof. dr Branko Katalinić, University of Vienna, Vienna (Austria)
37. Prof. dr Veijo Kauppinen, Helsinki University of Technology, Espoo (Finland)
38. Prof. dr Marianna Kazimierska - Grebosz, Technical University of Lodz, Faculty of General Mechanics, Lodz (Poland)
39. Dr Sergei A. Klimenko, Director of Association of Machine – Building Technologists of the Ukraine - ATMU, Kiev (Ukraine)

40. Prof. dr Karel Kocman, Technical University of Brno, Brno (Szech Republic)
41. Prof. dr Janez Kopac, University of Ljubljana, Faculty of Mechanical Engineering, Ljubljana (Slovenia)
42. Prof. dr Marian Kralik, vice-dean, Slovak University of Technology, Faculty of Mechanical Engineering, Bratislava (Slovakia)
43. Prof. dr Zdravko Krivokapić, vice-dean, University of Podgorica, Faculty of Mechanical Engineering, Podgorica (Montenegro)
44. Prof. dr Janos Kundrak, University of Miskolc, Faculty of Production Engineering, Miskolc, (Hungary)
45. Prof. dr Evgeniy A. Kundrashov, academician, State Technical University, Chita (Russia)
46. Prof. dr Cristian N. Madu, Pace University, Lubin School of Bussiness, New York (USA)
47. Prof. dr Velibor Marinković, University of Niš, Faculty of Mechanical Engineering, Niš (Serbia)
48. Prof. dr Vlatko Marušić, University of Osijek, Mechanical Engineering Faculty, Slavonski Brod (Croatia)
49. Prof. dr Ostoja Miletić, vice-rector, University of Banja Luka, Faculty of Mechanical Engineering, Banja Luka (Bosnia and Herzegovina)
50. Prof. dr Onisifor Olaru, dean, University "Constantin Brancusi" of Tg-Jiu, Faculty of Engineering, Tg-Jiu (Romania)
51. Prof dr Constantin Oprean, rector, "Lucian Blaga" University of Sibiu, Sibiu (Romania)
52. Prof. dr Liviu Palaghian, vice-dean, University of Galati, Galati (Romania)
53. Prof. dr. Nam Kyu Park, Tongmyong University, Busan (Korea)
54. Prof. dr Jozef Peterka, vice-dean, Slovak University of Technology, Faculty of Material Sciences and Technology of Trnava, Trnava (Slovakia)
55. Prof. dr Georgios Petropoulos, University of Thessaly, Faculty of Mechanical & Industrial Engineering, Volos (Greece)
56. Prof. dr Narcisa Popescu, University "Politehnica", Bucharest (Romania)
57. Prof. dr Stanislaw Pytko, Technical University of Krakow, Krakow (Poland)
58. Prof. dr. Zoran Radmilović, Faculty of Transport and Traffic Engineering, University of Belgrade Belgrade (Serbia)
59. Prof. dr Snežana Radonjić, vice-dean, University of Kragujevac, Technical Faculty, Čačak (Serbia)
60. Prof. dr Miroslav Radovanović, University of Niš, Faculty of Mechanical Engineering, Niš (Serbia)
61. Prof. dr Georgi Rashev, dean, Technical University of Gabrovo, Faculty of Mechanical Engineering, Gabrovo (Bulgaria)
62. Prof. dr. Milorad Rašković, dean, Maritime Faculty, University of Montenegro, Kotor (Montenegro)
63. Prof. dr. Dong-Keun Ryoo, College of International Studies, Korea Maritime University, Busan (Korea)
64. Prof. dr Igor Sergeevich Sazonov, rector, Technical University of Mogilev, Mogilev (Belarus)
65. Prof. dr Adolfo Senatore, University of Salerno, Faculty of Mechanical Engineering, Fisciano (Italy)
66. Prof. dr Dimitri Yu. Skubov, State Technical University of Sankt Petersburg, Sankt Petersburg (Russia)
67. Prof. dr Georgy Slynko, academician, Zaporozhye National Engineering University, Zaporozhye (Ukraine)
68. Prof. dr Mirko Soković, University of Ljubljana, Faculty of Mechanical Engineering, Ljubljana (Slovenia)
69. Prof. dr Drago Soldat, High Technical School, Zrenjanin (Serbia)
70. Prof. dr Viktor Starkov, Moscow State Technological University, Moscow (Russia)
71. Prof. dr Ljubodrag Tanović, University of Belgrade, Faculty of Mechanical Engineering, Belgrade (Serbia)
72. Prof. dr Oleg Vasilevich Taratynov, academician, Moscow State Industrial University, Moscow (Russia)
73. Prof. dr Mirela Toth-Tascau, Politehnica University of Timișoara, Faculty of Mechanical Engineering, Timișoara (Romania)
74. Prof. dr Nikolaos Vaxevanidis, Institute of Pedagogical & Technological Education, N. Heraklion Attikis (Greece)
75. Prof. dr Karol Velisek, Slovak University of Technology, Faculty of Material Sciences and Technology of Trnava, Trnava (Slovakia)
76. Prof. dr Edward Walicki, University of Zielona Gora, Faculty of Mechanics, Zielona Gora (Poland)
77. Prof. dr Ton van der Wiele, Erasmus University, Rotterdam School of Management, Rotterdam (Netherlands)
78. Prof. dr Carol Zoller, University of Petrosani, Faculty for Mechanical and Electrical Engineers, Petrosani (Romania)
79. Prof. dr Jeroslav Živanić, dean, University of Kragujevac, Technical Faculty, Čačak (Serbia)
80. Prof. dr Dragan Živković, High Technical School, Zrenjanin (Serbia)

CONTENTS

Volume 1

PLENARY SESSION (INVITATION PAPERS)

P-1.	Petropoulos G. (Volos – Greece), Kechagias J. (Larissa – Greece), Dašić P. (Vrnjačka Banja – Serbia) & Iakovakis V. (Larissa – Greece)	1
	EXPERIMENTAL ANALYSIS AND A NEURAL NETWORK SOLUTION FOR SURFACE FINISH IN TURNING OF ERTALON 66 GF-30 COMPOSITE	
P-2.	Bošnjak M. S., Petković D. Z., Zrnić Đ.N. (Belgrade – Serbia), Dragović M. B. (Kotor - Montenegro) & Gnjatović B.N. (Belgrade – Serbia)	15
	COMPARATIVE STRESS ANALYSIS – THE BASIS OF EFFICIENT REDESIGN OF THE BUCKET WHEEL EXCAVATORS SUBSTRUCTURES	
P-3.	Popović P. (Niš – Serbia)	26
	THE GLOBAL PROBLEM OF SURVIVAL, SCIENCE ELITE AND THE STATUS IN MECHANICAL ENGINEERING	
P-4.	Dragović B. (Kotor - Montenegro), Park N.K. (Busan – Korea), Meštrović (Kotor - Montenegro), Kim J.Y. (Tongmyong – Korea), Rašković M. & Mihaljević N. (Kotor - Montenegro)	28
	MODELING AND OPTIMIZATION OF CONTAINER TERMINALS OPERATIONS	
P-5.	Marušić V., Milinović A. & Ivandić Ž. (Slavonski Brod – Croatia)	42
	INFLUENCE OF COMPOSITION AND PRODUCTION PROCEDURE ON PROPERTIES OF POLYESTER LAMINATES	
P-6.	Kegl B., Pehan S. & Kegl M. (Maribor – Slovenia)	52
	OPTIMIZATION OF A FUEL INJECTION SYSTEM BY USAGE OF BIODIESEL	
P-7.	Park N.K. (Busan – Korea), Dragović B. (Kotor - Montenegro) & Kim J.Y. (Tongmyong – Korea)	64
	YARD TRUCK DYNAMIC PLANNING SYSTEM AT A CONTAINER TERMINAL	
P-8.	Grabchenko I.A., Dobroskok L.V. & Tchernyshov I.S. (Kharkiv – Ukraine)	74
	FORECASTING OF OUTPUT PARAMETERS OF WORKING PROCESSES OF RAPID PROTOTYPING BY MONTE CARLO METHOD AT USE OF FUZZY PARAMETERS	
P-9.	Ilarionov R. (Gabrovo – Bulgaria)	85
	MODEL APPROACH IN THE DESIGN OF DEVICES FOR INPUT OF 2D GRAPHICAL INFORMATION IN COMPUTING ENVIRONMENT	
P-10.	Barac N., Milovanović G. & Andelković A. (Niš – Serbia)	94
	IMPACT OF RFID TECHNOLOGY ON SUPPLY CHAIN MANAGEMENT	
P-11.	Andelković-Pešić M. & Stanojević M. (Niš – Serbia)	109
	THEORETICAL AND PRACTICAL IMPLICATIONS OF SIX SIGMA CONCEPT IMPLEMENTATION	
P-12.	Milenković D. (Kruševac – Serbia), Dašić P. (Vrnjačka Banja – Serbia) & Milosavljević M. (Belgrade – Serbia)	120
	CARBON NANOTUBES (CNT) - MATERIL IN TWENTY FIRST CENTURY	
P-13.	Radosavljević S. & Radosavljević M. (Lazarevac – Serbia)	131
	REDESIGN OF TECHNOLOGICAL LINES IN MINING AND RISK	

A-21.	Magda A., Popescu M., Locovei C., Codrean C., Mocuta G.E. & Hluscu M. (Timișoara – Romania) GALVANIZED STEEL WELDING USING THE COLD METAL TRANSFER PROCESS (CMT)	263
A-22.	Marković Lj. S. (Čačak – Serbia) THE INFLUENCE OF HEREDITARY CHARACTERISTICS ON TRIBOLOGICAL PROPERTIES BY HARD FACING OF THE REGENERATED GEAR TEETH	269
A-23.	Milčić D. (Niš – Serbia) & Miladinović S. (Zvečan – Serbia) DETERMINATION OF THE OF BUCKET WHEEL EXCAVATOR SRs 1300 LOAD SPECTRUM IN THE COAL STRIP MINE DRMNO	277
A-24.	Militaru C. & Georgescu D. (Bucharest – Romania) PRODUCTIVITY IMPROVEMENT OBJECTIVE OF LEAN TPM	287
A-25.	Milovančević M. (Niš - Serbia) & Veg A. (Belgrade - Serbia) APPLICATION OF AXIOMATIC DESIGN ON VIBRO-DIAGNOSTIC SYSTEMS	295
A-26.	Mironenko E.V. & Kovalyov D.G. (Kramatorsk – Ukraine) RESEARCH OF DURABILITY OF THE TOOL FOR HEAVY LATHES	301
A-27.	Polakovič M. & Peterka J. (Trnava – Slovakia) SIMULATION ALGORITHM OF MILLING BASED ON MODELS OF CUTTING FORCE, TOOL DEFLECTION AND SURFACE ROUGHNESS	306
A-28.	Polakovič M. & Peterka J. (Trnava – Slovakia) SURFACE ROUGHNESS SIMULATION BASED ON VOXELS	312
A-29.	Popescu M., Marta C., Rădescu D. & Danciu I.M. (Timișoara – Romania) WELDING AND ERGONOMICS. CASE STUDIES	318
A-30.	Popescu M., Nica-Belu R., Mocuta G.E., Marta C. & Căneparu A. (Timișoara – Romania) RESISTANCE SPOT WELDING OF METALLIC COMPOSITE MATERIALS	326
A-31.	Račić M.M. & Jovanović D.J. (Podgorica - Montenegro) COMPARATIVE ANALYSIS OF MECHANICAL AND MECHATRONIC DESIGN	332
A-32.	Rădescu D., Ardelean F. & Danciu I.-M. (Timișoara – Romania) MECHANIZED THERMAL CUTTING MACHINE WITH TWO SINCRON OXIGAS TORCHES AND A PLASMA ONE	340
A-33.	Rashev G., Angelov I., Petrov M. & Todorov V. (Gabrovo – Bulgaria) METHODOLOGY FOR DETERMINING THE EFFECT OF SCALE FACTOR ON THE FATIGUE STRENGTH OF DUCTILE CAST IRON	346
A-34.	Rashev G., Angelov I., Todorov V. & Petrov M. (Gabrovo – Bulgaria) METHODOLOGY FOR PREDICTING THE WORKING STRENGTH OF STRUCTURAL ELEMENTS IN THE PRESENCE OF A CRACK	350
A-35.	Ristivojević M. (Belgrade – Serbia), Radović D. (Kruševac – Serbia) & Radović B. (Belgrade – Serbia) REPARATION AS STRATEGIC CHOICE FOR EFFICIENT RESOURCE EXPLOITATION	356
A-36.	Ristović I. (Belgrade -Serbia), Fedorko G. (Košice - Slovakia) & Vulić M. (Ljubljana - Slovenia) MODELLING AND MONITORING THE PROCESS OF THE MAINTENANCE OF AUXILIARY MECHANIZATION IN LIGNITE OPEN PITS	363
A-37.	Sekulić S. (Novi Sad – Serbia) ONE METHODOLOGY FOR DETERMINATION WEIBULL'S DISTRIBUTION FUNCTIONS BY MEDIAL RANKS FOR WHICHEVER SIZE SAMPLE	369
A-38.	Simeonov S. & Tsvetanov G. (Gabrovo – Bulgaria) DEFORMATION STATE OF INVOLUTE CYLINDTICAL GEARS WITH ASYMMETRICAL PROFILE	378
A-39.	Slavković R., Miličević I., Jugović Z. & Golubović D. (Čačak – Serbia) MANUFACTURING TECHNOLOGY APPLIED TO IMPROVEMENT OF CUTTING CHARACTERISTICS OF REFINER PLATE AND CONSUMPTION OF ELECTRIC ENERGY	383
A-40.	Stoychev B. (Gabrovo – Bulgaria) & Stefanov S. (Sofia – Bulgaria) AN ADDITIONAL MECHANISM FOR TORSION TO THE NEW DEVICE FOR FATIGUE TESTING UNDER ROTATED BENDING COMBINED WITH TORSION	390
A-41.	Todorović M. (Trstenik – Serbia), Dedić M. (Kraljevo – Serbia), Čajetinac S. & Jevremović V. (Trstenik – Serbia) INFLUENCE OF CROSS-SECTION AREAS OF BARS TO DEFORMATIONS OF A TRUSS BEAM	395

A-42. Tsonev T.V. & Nikolov D.N. (Sofia – Bulgaria)	401
EXPERIMENTAL STUDY ON HEATING DEVICE FOR TESTING MATERIALS, INTENDED FOR A LONG WORK AT INCREASED TEMPERATURES	
A-43. Vodolazskaya N. (Donetsk - Ukraine), Iskritzskiy V. & Vodolazskaya E. (Kramatorsk - Ukraine)	407
CALCULATION FEATURES OF THE FRICTIONAL LIMITER'S PARAMETERS OF THE TORQUE SHOCK TIGHTENING OF THREADED CONNECTIONS	
A-44. Vrekić S. (Kragujevac – Serbia)	415
CRITERIA FOR THE DESIGN OF ALUMINUM IN VEHICLE APPLICATIONS	
A-45. Zhelezarova I.D. & Angelov A.I. (Gabrovo – Bulgaria)	420
STRESSED STATE OF NOTCHED AND SMOOTH LABORATORY SPECIMENS MADE OF 23Mn2SiVN STEEL	
A-46. Zheng W. (Lanzhou - China), Petrović R., Gašić M. & Todić N (Kraljevo - Serbia)	426
THE INFLUENCE OF FLUID COMPRESSIBILITY ON DISCHARGE FLOW IN HIGH PRESSURE VANE WITHIN VANE TYPE PUMP	

SESSION B

TRANSPORT SYSTEMS AND LOGISTICS

B-1. Catalani M. (Naples - Italy) & Zamparelli S. (Campobasso – Italy)	433
TRANSPORT AS STRATEGIC ELEMENT OF LOGISTIC INDUSTRY MANAGEMENT	
B-2. Ćurčić S. & Milunović S. (Čačak – Serbia)	441
MODERN SYSTEM FOR INDUSTRIAL PRODUCTS STORAGE AND COMMISSIONING	
B-3. Dragović B., Jovović D., Škurić M. & Dragović-Radinović V. (Kotor – Montenegro)	449
CAPACITY AND PORT INVESTMENT MODEL	
B-4. Dragović B. (Kotor – Montenegro), Ryoo D.-K. (Busan – Korea), Dragović-Radinović V., Jovović D. & Krapović I. (Kotor – Montenegro)	456
CONTAINER PORTS CAPACITY STUDY: THROUGHPUT PERFORMANCE COMPARISON	
B-5. Gurning S. & Cahoon S. (Launceston – Australia)	464
MARITIME TRANSPORT SYSTEMS IN THE NORTH-SOUTH PACIFIC BOUND ROUTES THROUGH INDONESIA	
B-6. Ivoić J. (Leposavić – Serbia)	472
ACTIVITIES IN THE TRANSPOSITION OF MATERIAL PRODUCTS IN THE INTERNATIONAL GOODS TRADE MARKET	
B-7. Ivoić S. & Ivoić J. (Leposavić – Serbia)	479
STRUCTURE OF MERCHANDISE-TRANSPORT CENTER FUNCTIONS	
B-8. Jovičić M.N., Bošković B.G., Jovičić R.G. & Gordić R.G. (Kragujevac – Serbia)	484
IMPROVING EFFICIENCY OF MUNICIPAL WASTE COLLECTION USING GPS LOGISTICS	
B-9. Ng A.K.Y. (Kowloon – Hong Kong)	490
PORTS AND LOGISTICS FACILITATION: DEVELOPMENT AND CHALLENGES	
B-10. Radmilović Z. (Belgrade – Serbia) & Markolović T. (Kotor – Montenegro)	501
STRATEGIC DEVELOPMENT OF BOTH LEISURE NAVIGATION AND TOURISM WITHIN THE CANAL NETWORK DTD IN SERBIA	
B-11. Škurić M., Dragović B. & Markolović M. (Kotor – Montenegro)	508
A MONTENEGRIN NAUTICAL TOURISM STUDY AND PERSPECTIVE	
B-12. Zrnić Đ.N. (Belgrade – Serbia), Hoffmann K. (Vienna – Austria) & Bošnjak M.S. (Belgrade – Serbia)	515
50 YEARS OF STS CONTAINER CRANES IN SEA PORTS: 1959-2009	

IMPROVING EFFICIENCY OF MUNICIPAL WASTE COLLECTION USING GPS LOGISTICS

Nebojša M. Jovičić¹, Goran B. Bošković², Gordana R. Jovičić³, Dusan R. Gordić⁴

Faculty of Mechanical Engineering, Kragujevac, SERBIA,

¹ E-mail: njovicic@ept.kg.ac.rs, ² E-mail: gboskovic@ept.kg.ac.rs, ³ E-mail: gjovicic@ept.kg.ac.rs,

⁴ E-mail: gordic@kg.ac.rs

Summary: Typical municipal system for solid waste management consists of several sub-systems. Collection and waste transportation is one of the most important sub-system which includes almost half of the total expenses. In order to establish more efficient and economic sustainable public service it is necessary to make improvements of this sub-system. Some of the precautions for improvements are establishing the system for monitoring of waste collection (GPS satellite tracking system) and its implementation in the municipal environmental information database, which are presented in this paper. General methodology of route optimization for solid waste collection is also presented. Case study for typical communal vehicle in the city of Kragujevac within one route is made, and the result indicates possible saving of 800 km per year. According to published studies in this research field it is possible to make savings up to 40% of total costs.

Key words: Solid waste collection, route optimization, energy efficiency

1. INTRODUCTION

At this level of development of human society, without making any difference between rich and poor, urban and rural areas, environmental degradation is one of the greatest problems and it is the result of increased solid waste generation. In order to find a solution for a concrete municipal problem at a level of one local community there are different functional elements (sub-systems) and each of them is part of one system known as municipal system for solid waste management. Furthermore, the main goal in solid waste management is optimization of the system with minimization of costs and increasing of energy efficiency, with the respect to all constancies adjusted by the users of the system. The system for solid waste management consists of:

- waste generation,
- storage and collecting of waste,
- waste transportation,
- waste treatment,
- waste disposal,

2. SYSTEM FOR SOLID WASTE MANAGEMENT

High level of complexity and variability are the main characteristics of the system for solid waste management. A lot of significant factors have influence on the system, and those factors are variable, especially talking about quantity and quality (morphology) of generated waste, number of citizens, characteristics of traffic, legal framework, etc.

The basic functional principle of system for solid waste management is to satisfy a global goals which are established by solid waste management strategy (at the state and local level) to seek for development and optimization of main elements. Techno-economical analyze of the system shows that the collection and transport of solid waste make almost the half of all expenses, therefore some improvements in those sub-systems are necessary in order to establish more efficient and economical sustainable municipal system for solid waste management.

Considering the improvement of system for solid waste management by improving collection and transport elements, 3 levels of improvement can be made: 1) strategic level – selection of lasting solid waste management technology 2) tactical level – selection of economical sustainable places for transfer stations 3) operational level – defining more efficient system for waste collecting at local (city's) level [1].

The first case appears in the process of planning long-term functioning of the system for solid waste management. Also in the analysis, revises or in adoption of new strategies for further development (the reason of obsolescence, the appearance of a new legal framework, or the appearance of new sustainable technologies). In this case it is necessary to consider all elements of waste management in order to determine the long-term development policies. The selection of treatment technologies significantly affects on the organization of transportation of waste, and time and costs, which indirectly has a broader impact on the environment. Different technologies lead to different transport subject, different destinations and distances. The more different fractions of waste that should be separately managed cause the more complex transportation system and more expensive vehicles. Therefore, choosing sustainable treatment technologies for optimization of system for solid waste management is a systematic approach to resolve this complex engineering problem. In the decision-making process it is necessary to include more optimization criteria that must be simultaneously taken into account.

Lower (tactical) level of optimization of system for solid waste management means the choice of economic sustainable locations for transfer stations appears when regional system for solid waste management is already established and/or when the area becomes too big. The introduction of transfer station in the system is of major importance for the rationalization and reduction of costs. Tactical decisions ensure the implementation of strategic decisions and criteria for their evaluation are performance of the system in whole.

Operational level of system improvement means defining more energy efficient system at local level and it is permanent task for each municipal company and this task should be carried out every several years. This level involves the solution for following problems: 1) adequate positioning of waste bins consistent with population density and the level of urbanity (improved or optimized frequency of waste bins discharges) 2) city area division consistent with vehicle fleet (better use of vehicle's capacity) 3) municipal vehicle route optimization (decrease in fuel and spare parts costs). This kind of optimization is necessary because the basic factors that affect environmental often vary. Some of the factors are: number of inhabitants, quantity of solid waste, types of vehicles used and their capacity, traffic volume details, etc.

Tactical and strategic levels of improvements of the system for solid waste management are limited to legal, economic and political framework and, as such, they are beyond the opportunities of typical municipal service.

Hence, the improvement of communal services, in order to create preconditions for defining energy efficient and economically sustainable system for solid waste at the local level, imposes itself as the only mode in which can guarantee the achievement of projected goals in precisely defined time frame.

3. RESEARCH IN OPTIMIZATION OF THE SOLID WASTE MANAGEMENT

In the last few years improvement and optimization of the municipal system for solid waste management is issue of interest and research in the whole world, especially in some segments of the system. Special emphasis is placed on routing optimization and optimization of waste bin locations.

The routing optimization problem belongs to model known as Vehicle Routing Problem (VRP). Application of VRP model leads to feature of many new models which include most of constrains from the real life waste collection [2]. Geographical Information System (GIS) also plays a vital role in finding the "cheapest"/shortest routes for communal vehicles [3, 4]. Particularly, in the simulation process and making the variant solutions for communal vehicle routes GIS provides much necessary information, such as geo-referenced maps, name of the roads and their width, location of storage bins, demographics data, etc. Constrains from the real life waste collection should be taken into account in VRP optimization models. Most important constrains are capacity and number of communal vehicles, work shift duration, variability of traffic conditions, variation of waste production over year, limited time of waste storage in bins, etc. All of the mentioned things lead to very complex models which are very hard for implementation. Furthermore, usage of the strictly models is reduced to simple models, and in the other side complex models had to be solved by including heuristic methods such as tabu-search or genetic algorithms. Thus, the final conclusion is that there is no universal solution for optimization of system for solid waste management and each problem is unique and has to be taken into consideration as unique.

As far as the published results of the research are concerned, a several typical examples can be identified.

Lakshumi [4] presented the results of study for the city of Chennai in India which has a population of 4.5 million. The aim was to determinate the optimal route for solid waste collection and to compare the cost of new optimized and present routes. The commercial software package ArcGis was used and at the example of one treated route the savings in length of 41,5% in day shift and 44% in night shift was made.

Apaydin [5] published results of the research in route optimization for solid waste collection for the city of Trabzon in Turkey. The city of Trabzon is as large as the city of Kragujevac and has 185.000 inhabitants. For 39

districts in the city, a shortest path model was used in order to optimize solid waste collection/hauling processes, as minimum cost was aimed. The Route View ProTM software as an optimization tool was used for that purpose and the success was around 4-59% for distance and 14-65% for time. The total benefit was 24% in total costs or about 18.014\$ monthly.

Karamidas [6] showed the results of research in optimization the number and the positions of the waste bins in the Municipality of Athens. Spatial database were made in GIS and were taken into account for calculating in ArcGis software package. According to calculations in the area under study the number of waste bins has been decreased from 162 to 112 which is the 30% and presents the great saving in used energy for the waste collection.

In our neighborhood some research can be identified in Croatia, published by Carić [7]. The municipal vehicles paths were analyzed in the city of Zagreb and some improvements were made with the developed numerical method. The results indicated possibility of decreasing the number of vehicles from 7 to 6 and saving of 30% in the traveled path.

4. SITUATION IN SERBIA AND THE CITY OF KRAGUJEVAC

Up to date significant research effort in Serbia in area of optimization of solid waste management is not indicated. The fact is that public companies in Serbia do not have recorded infrastructure of system for solid waste management at the level of GIS application. The region city division, spatial distribution of sites for waste collecting and discharge rate of waste bins are often the result of experience, and not the principle of minimum energy expenditure. Considering the municipal vehicle paths the situation gets more complicated and without making prerequisites through implementation of system's resource database (by GIS requirements) every optimization attempt is already made to be a failure. Therefore, development and implementation of basic system's database model could have a possibility to be used in every company with similar activities.

The city of Kragujevac or the municipal company Čistoća, has about 4000 waste bins placed at 2000 locations within 12 city divisions. Currently there is no electronic record of spatial distribution of waste bins and municipal vehicle paths. Hence, development of software tools and methodology, organization procedures and technology for database resource processing could be example of good practice for all other local communities in Serbia.

5. IMPLEMENTATION OF SYSTEM FOR MONITORING OF WASTE COLLECTION

The complete history of municipal vehicle paths is necessary for the full control of waste collection and disposal process. For this purpose, system for satellite vehicle tracking "G-target AVL" developed by company Eforte was used. At the moment this system is implemented in one truck but the plan is to implement in all vehicles. G-target AVL is integrated system for monitoring and control of the vehicles which use system for global positioning (GPS), GSM network (GPRS) and Internet. The system consists of **G-Target** devise (figure 1) which is installed in vehicle, server's software **G-Target SRV** which receives and send data from G-Target devise to client's software **G-Target CLI** installed on user's computer. The system allows user to remotely collect information about vehicle movement at the city map.



Figure 1: G-Target devise

G-Target device determinate the vehicle's position using GPS module built in the device (latitude, longitude, velocity, driving direction, time, etc.), compress the attained data and send them over the GSM network and Internet to server's software G-Target SVR. G-Target SRV receives the data from the devise and put them into

database. In the same way it receives the commands from the user and sends them to the device over the client's software G-Target CLI (figure 2).

The Functional possibilities of the system are:

- The possibility of the real time GPS/GPRS vehicle tracking and displaying the data at city map. The user can supervise the vehicles and thus reduces the costs and prevents misuses (in the municipal vehicles case this forces drivers to drive the paths defined by the management and not the one they choose)
- Internet archives of the history of movement. The vehicles don't have to be supervised all the time, there is the possibility to see the history with simulation
- Points of interests can be placed at the city map (waste bin position), and then it is possible to see in report if the vehicle passed nearby some points in the radius which is defined by the user of the system
- Detection of activated sensors means that the device can detect if the engine is turned on, if the door is open, etc. For the municipal vehicle would be very interesting to build in the sensor for waste bin lifting, and in that case if the sensor is activated then the bin was emptied for sure.
- Transferred data over the Internet is compressed so the price of exploitation is low
- If the GSM network is unavailable the device records the data to own memory and transfers when the network becomes available again thus the history is always accessible. The built-in memory is big enough to record the path over 30 days.

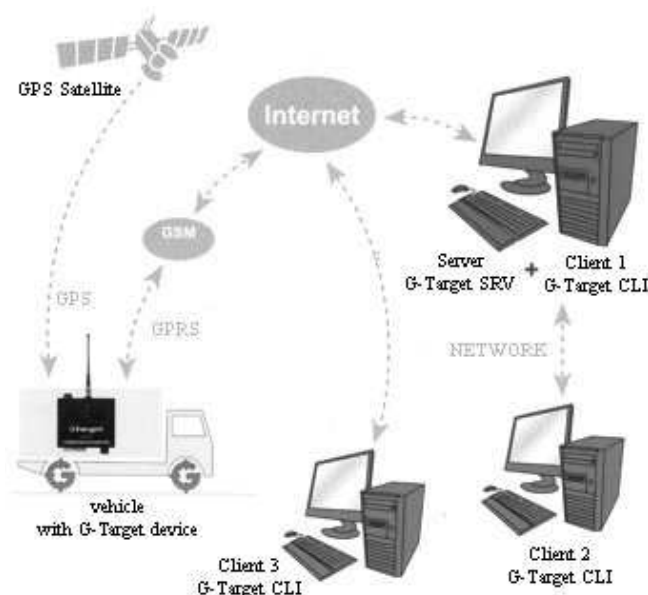


Figure 2: G-Target AVL system

6. ENVIRONMENTAL INFORMATION SYSTEM OF KRAGUJEVAC

Locale environmental information system of Kragujevac is using the existing frame of that system which came as the result of earlier research at the Faculty of Mechanical Engineering in Kragujevac. This system is directed on collecting, storing and processing significant information which are about volume-energy properties and balance as the dynamic of the system. The aim of the system is to raise the level of energy efficiency and environmental protection of Kragujevac and Šumadija.

To create a waste bin locations database which is the part of the system beside the existing data it was necessary to collect GPS coordinates of each location, number and type of bins and the photography.

For recording of present situation, locations of waste bin and the vehicle's tracks the GPS device Garmin Colorado 300 was used. The data recorded by this device was transferred to city map (SCG Route 1.9) and store in electronic form for further analyses.

Figure 3 shows the typical path of one municipal vehicle in Kragujevac. Showed route involves the waste bins in city's areas Erdoglija, Bagremar and Stanovo. Also the figure shows 2 characteristically segregate locations of waste bins at park near Zastava automobile factory.



Figure 3: Vehicle route



Figure 4: Modified vehicle route

Length of existing route is 22 kilometers. Route analyze shows that it would be economical sustainable to except those locations from the route and in that case the route length would be 19 kilometers. The excepted locations could be added to route showed at the bottom of the figure 3. This vehicle which route was analyzed runs nearby the Zastava automobili factory and if 2 mentioned locations were added the route would increase for 500 meters (showed on figure 4). Furthermore, by combination of those 2 routes the saving would be 2,5 km which is the 11,5% of the first route length. Keeping in mind the fact that the truck runs this route 6 times per week the conclusion is that modification of route brings the savings of 800 km yearly.

This is one of the possible savings that could be made by recording and analyzing present situation. By developing and using specific software tools for route optimizing (or using the expensive commercial software) the municipal system for solid waste management could become more efficient.

7. CONCLUSIONS

The City of Kragujevac produces about 57.000 tons of solid waste per year. According to the accessible information during 2008, 20 municipal vehicles were engaged. For the collection and transport of solid waste 237.354 liters of fuel and 8770 liters of oil were spent. Total maintenance costs were 5.800.000 RSD. By the available facts system for solid waste management in Kragujevac spends about 30 million RSD each year.

According to published world experiences in this field the total savings vary from 20 to 40% in collection and transport of solid waste. Keeping in mind this fact it is fair to expect 20% of savings in total costs. This means 50.000 liters of fuel, 1.500 liters of oil and 1.200.000 RSD in spare parts less per year or 6 million RSD (65.000 €) in total costs.

Emission of CO₂ for typical municipal vehicle (with Euro 1 engine) is 900g/km and when is multiplied with number of kilometers and number of vehicles it goes to 213.618 kg of CO₂ emissions in the atmosphere per year. Route optimization leads to great savings in total costs and also it would be a great benefit in environmental protection, 40 tons of CO₂ less each year. To keep in mind the fact Kragujevac produces about 1000 tons of solid waste per week, Novi Sad and Nis 1700-2000 tons and Belgrade over 10.000 tons per week it can be concluded that significance of this research is much wider.

As it was already emphasized there is no record of significant research in field of improvement and optimization in solid waste management in Serbia. Consequently, development and implementation of basic model of municipal system for solid waste management database would have the great influence on functionality of typical municipal service. Methodology establishing for improvement of energy efficiency in solid waste management gives an opportunity to each municipal company to solve following problems:

- Adequate positioning of waste bins consistent with population density and the level of urbanity (improved or optimized frequency of waste bins discharges)
- City division consistent with vehicle fleet (better use of vehicle's capacity)
- Municipal vehicle route optimization (decrease in fuel and spare parts costs)

REFERENCES

- [1] Erdelez, A.; Margeta, J.; Knezić, S.: Integralni pristup upravljanja sustavom prikupljanja komunalnog otpada, *Građevinar*, Vol. 59, No. 6, pp. 505-516, 2007 UDK 628.443.002.3.
- [2] Kim, B.; Kim, S.; Sahoo, S.: Waste collection vehicle routing problem with time windows, *Computers & Operations Research*, Vol. 33, No. 12 (2006). pp. 3624-3642. ISSN 0305-0548.
- [3] Karadimas, N.; Loumos, V.: GIS-based modelling for the estimation of municipal solid waste generation and collection, *Waste Management Research*, Vol. 26, No.4 (2008), pp. 337-346, DOI 10.1177/0734242X07081484.
- [4] Lakshumi, A.; Ramiya, A.; Sstha, R.: Optimal Route Analysis for Solid Waste Disposal Using GIS, *MAP India 2006, International Conference of Land Registration and Cadastre*, New Delhi, India, 2006
- [5] Apaydin, O.; Gonullu, M.T.: Route Optimization for Solid Waste Collection: Trabzon (Turkey) Case Study, *Global NEST Journal*, Vol. 9. No. 1 (2007). pp. 6-11.
- [6] Karadimas, N.; Doukas, N.; Kolakathi, M.; Defteraiou, G.: Routing Optimization Heuristic Algorithms for Urban Solid Waste Transportation Management, *WSEAS Transaction on Computers*, Vol. 7, No. 12 (2008).
- [7] Carić, T.: Unapređenje organizacije transporta primenom heurističkih metoda, *Doktorska disertacija*, Sveučilište u Zagrebu, 2006
- [8] Jovičić, N.; Kalinić, Z.; Jovičić, G.; Bošković, G.: Lokalni ekološki sistem Grada Kragujevca, 2. *nacionalna konferencija o kvalitetu života*, Kragujevac, 2007.