Research on Detection Method of Sheet Surface Defects Based on Machine Vision

Yuanmin Huang*, Ming Yi, Weihang Yang and Man Yang
Electro mechanic Engineering Institute, Foshan Polytechnic, Foshan, 528137, Guangdong, China
*Corresponding author: fzhym27@fspt.net

Abstract. The paper is based on machine vision technology to study the detection of sheet surface defects, designs the hardware system and software processing flow of online detection, introduces processing methods such as image preprocessing, image segmentation and target extraction, and processes the defect images accordingly. Use C# software to design the human-computer interaction interface and online debugging and online detection for the online detection of sheet defects. The experimental results show that the detection method is feasible, the false detection rate is low, and it can be well applied to the online detection of wood automatic production process.

1. Introduction
With the development of the national economy and society, my country's timber consumption has increased year by year, becoming the world's second largest timber consumption country. My country's total forest stock is less than 3% of the world's total, and a large amount of timber needs to be imported and processed every year. Wood processing is gradually developing in the direction of mechanization, automation and scale. Due to the production environment, natural conditions and other factors, there are knots, corrosion, worm eyes, cracks and other defects on the surface or inside of the wood, which greatly affects the utilization rate of wood boards. The utilization rate of wood in China is about 60%, which is comparable to that of the world. The utilization rate of more than 90% in developed countries varies greatly. The use of automated production and automated detection technology can effectively improve production efficiency and wood utilization. If it can increase by one percentage point, my country will save 750,000 m³ of wood every year. Therefore, wood defect detection technology in the automated production process has become an important part of the wood processing process. The log processing process, the sorting and grading of the boards mainly rely on artificial vision and experience, and the evaluation is based on the texture structure, color and lustre of the boards. Due to the different types and sizes of defects of the sheet, and the different working environment and work intensity of human eyes, it is easy to cause missed inspections and wrong inspections. Moreover, the efficiency of manual detection is not high, which causes a lot of waste of human and financial resources and wood resources. At present, the inspection of sheet metal processing mainly adopts manual inspection, mechanical inspection, radiographic inspection, ultrasonic inspection and machine vision inspection. Manual detection has disadvantages such as low efficiency, high false detection rate and strong interference. Mechanical testing is usually contact testing, which has disadvantages such as limited detection range, low efficiency, and possible damage to the plate. Although radiographic testing can improve efficiency and accuracy,
it has disadvantages such as complex methods and high costs. Ultrasonic detection is also a contact detection, mainly based on the attenuation and scattering signals of the ultrasonic wave in the medium propagation process. However, this detection still has some technical problems that need to be solved, and it is not suitable for large-scale online detection [1]. At present, the most research applications are the application of digital image processing technology, computer vision technology, BP neural network technology to wood defect detection, combining fractal theory, wavelet analysis, pattern recognition and other technologies to study image enhancement of wood surface defects, Texture segmentation, feature extraction, pattern recognition and other issues. Based on the defect types and characteristics of raw pine imported from Canada in the Putin Wood Processing Zone and the production line speed requirements of the automated log processing and production process, the author designed the hardware structure of visual inspection, selected camera parameters and light source categories, and designed software processing procedures and software for the defect types Realize, and perform image extraction and defect feature extraction.

2. System solution

In a machine vision system, the pros and cons of light source and camera selection are the key to directly determining the success of the machine vision system. In two-dimensional image processing, generally the image taken by the camera is first transformed into a grayscale image, and the required data is obtained after further processing. However, the Gray-scale image of the sheet surface is very susceptible to the color change of the sheet pattern, and sometimes it cannot effectively reflect the defect information such as the pits or convex nodes on the sheet surface, which makes it difficult to extract the characteristics of these defects. Therefore, the Locator 2380 integrated 3D smart camera that can obtain grayscale images and height maps is selected in the machine vision system for sheet defect recognition. The camera is produced by Canadian LMI company. It uses a monochromatic laser to obtain high-precision brightness images with a maximum Z-direction resolution of 0.092mm.

The visual system architecture of sheet defect detection with 3D smart camera is shown in Figure 1. The camera is fixed horizontally directly above the plate, and the plate is kept flat and moved relative to the camera under the action of the driving roller and the pressure roller. The pressure roller is equipped with an incremental encoder whose output signal is used as the enable signal for camera scanning. When the plate moves, the pulse signal of the encoder triggers the camera to emit a monochromatic laser, which irradiates the plate to form reflected light into the camera lens, and the camera forms an image of the plate according to the different characteristics of the reflected light. Another function of the encoder is to record the length of the camera sweep, so that the image obtained by the camera is coordinated with the actual object size. The Locator smart camera transmits the scanned image to the computer for image processing through the Ethernet interface. For the convenience of programming, the image processing program uses the machine vision algorithm package HALCON developed by the German M Tech company. HALCON has a widely used machine vision integrated development environment, and its flexible architecture facilitates the rapid development of machine vision systems [2].
2.1. **CCD camera**
CCD is a semiconductor imaging device, which has the advantages of high sensitivity, anti-glare, small distortion, small size, long life, and anti-vibration. This system uses a domestic MTV-1881EX black-and-white camera. Its working method is to focus the image of the object on the CCD chip through the lens. The CCD accumulates a corresponding proportion of charge according to the intensity of light, and the charge accumulated by each pixel under the control of the video sequence, it is moved out point by point, filtered and amplified by the video capture card, and A/D converted to form a video signal output.

2.2. **Frame grabber**
This system uses Dashing PCI-XR video capture card, with high-quality video capture performance, high-speed PCI bus, the capture frequency is 3D frames/sec, the display screen is smooth and uninterrupted; the display resolution is 640X480. Dynamically captured images are saved as static images, and multiple save formats such as BMP, JPG, TIP, TGA, etc. are provided. Its working principle is shown in Figure 2:
Figure 2. Working principle of the VIDEO-PCI-XR image acquisition film.

The four-channel composite video input is multi-channel switch. The software selects one of them as the current input, and outputs it to A/D for analogy/digital conversion. After various image processing, the digitized image signal is transmitted to the VAG card for display or Computer memory storage. Since the two surfaces of the board need to be detected, two video inputs are required on the hardware, and each channel collects images of a different surface. The sampling frequency is adjustable within a certain range to meet the needs of different occasions.

2.2.1. Video input signal and sampling frequency. The image signal output by the video equipment that conforms to the PAL standard (625 lines, 50 fields/sec) and NTSC standard (525 lines, 60 fields/sec) can be used as the input source of the video capture card. In general, video equipment such as cameras and video recorders meet the above standards. The sampling frequency is adjustable within a certain range to meet the needs of different occasions.

2.2.2. Video input window and display window. The video input window refers to the digitized input image size. In PAL format, the maximum size of the input window is 768 X 576. The NTCS format is 648 X 480. The image display window refers to the size of the image displayed on the VAG monitor, and the maximum value cannot exceed the input image window. When the image display window is smaller than the video input window, there are two methods that can be used. One method is to reduce the size of the video input window, that is, reset the start line, end line, start column, and end column. Match the video input window with the image display window. The processed result shows only a part of the entire input image. This method is called cropping. The other method is to reduce the size of the video input window by squeezing points and lines, that is, setting the reduction ratio coefficient according to the relative size of the video input window and the image display window, and the processed result shows all the reduced input Image, this method is called scaling down. You can also combine the two methods to achieve the desired result [3].

2.3. Software design
The image processing algorithms in this subject are all simulated using the MATLAB programming language. MATLAB provides a highly integrated one that integrates scientific computing, programming and visualization. In order to design practical and effective software, it is necessary to carry out sufficient phased analysis and design in accordance with the theory of software engineering. Adopting modular structure design, its characteristics are: 1) Modifiable. Modifications to the inside of the module have no effect on the outside of the module; adding or deleting several modules does not affect the entire program; 2) readability. The meaning and responsibility of each module are clear, and the interface relationship between the modules is clear, which is convenient for users and designers to maintain the system code; 3) Verification. Independent of other modules, the correctness of a module can be verified separately, which is convenient for debugging. The modular principle is adopted to make the software structure clear, easy to read, understand and maintain. In this system, the subroutines are designed according to the algorithm requirements.
Automatic detection of sheet surface defects is a new application of machine vision image processing technology. The inspection is carried out in the environment of the production line, the quality of the collected images is low, and the signal-to-noise ratio is poor. The image processing process is the process of noise removal, feature defect extraction and recognition. The software processing flow of the defect image is shown in Figure 3. First, extract the target image from the collected image, remove the background interference, obtain the target image to be processed, and perform a series of pre-processing on the target image to highlight the image features; then perform the feature extraction on the image, that is, a series of parameters to be detected. According to its characteristics, find suitable methods to describe its characteristics; finally, analyse and save the results, and judge whether there are defects and defect types according to the test results of the parameters [4].

3. Surface defect image detection algorithm design

In order to accurately and timely obtain the current state of the image, it is necessary to continuously read the image information of the CCD camera system directly into the computer memory through the image capture card, and perform other subsequent processing in the computer memory, such as: image filtering, image measurement, and defects Detection and so on [5].

Because there is noise or other interference in the actual image, the background of the image is not the ideal pure Gray level. Therefore, when scanning the entire image pixel by pixel, the detected image information will also contain interference information, that is, there are gross errors. Once a measurement value with gross errors is found, it should be removed from the measurement result. Suppose the measured true value is $L_0$, and a series of measured values are $l_i$, then the random error $\delta_i$ in the measurement column is

$$\delta_i = l_i - L_0$$

(1)
The distribution density \( f(\delta) \) of the normal distribution is:

\[
f(\delta) = \frac{1}{\sigma \sqrt{2\pi}} e^{-\delta^2/(2\sigma^2)}
\] (2)

In the formula, \( \sigma \) represents the standard deviation (or root mean square error); \( e \) represents the base of the natural logarithm, the value is 2.7182... It can be seen that the smaller the value of \( \sigma \), the greater the absolute value of the exponent of \( \sigma \), and the faster \( f(\delta) \) decreases, that is, the curve becomes steeper. The smaller the value of \( \sigma \), the larger the value of the coefficient in front of \( \sigma \), that is, the large r the ordinate corresponding to the error of zero \( G (\sigma = 0) \), and the higher the curve. Conversely, the larger \( \sigma \) is, the slower the decrease of \( f(\delta) \) will be, and the curve will be flat. At the same time, the ordinate corresponding to the error of zero is also small, and the curve will be lower. The standard deviation \( J \) is also different, and \( K \). In the equal precision measurement column, the standard deviation of a single measurement is calculated as follows:

\[
\sigma = \frac{\delta_1^2 + \delta_2^2 + \ldots + \delta_n^2}{n}\n\]

(3)

In the formula, \( n \) represents the number of measurements (should be sufficiently large); \( \delta \) represents the difference between the measured value and the measured true value; \( \delta_i \) represents the measured value; \( v_i \) represents the residual error of the measured value (abbreviated as residual); \( \bar{x} \) represents the measured value. The average value of the value. In order to remove the gross errors from the scan, the 3 criterion is used to determine whether each detected data has errors. That is |\( v_i \)| > 3\( \sigma \). If the above formula is satisfied, it should be eliminated.

4. Experimental testing

We set the judgment thresholds of corners, scratches, knife marks and pits of the sheet with the specification of D9.2*d4.02*1.2 and the sheet with the specification of D9.2*1.2 as shown in Table 1 and Table 2 shown.

| Type of defect | Drop corner area | Drop corner perimeter | Scratches area | Scratches perimeter | Knife mark area | Knife mark perimeter | Ma Hang area | Ma Hang perimeter |
|----------------|------------------|-----------------------|----------------|---------------------|-----------------|---------------------|--------------|------------------|
| Value          | 36               | 17                    | 53             | 31                  | 384             | 98                  | 31           | 14               |

Table 1. Judgment Threshold of Sheet Metal Defects.

| Type of defect | Drop corner area | Drop corner perimeter | Scratches area | Scratches perimeter | Knife mark area | Knife mark perimeter | Ma Hang area | Ma Hang perimeter |
|----------------|------------------|-----------------------|----------------|---------------------|-----------------|---------------------|--------------|------------------|
| Value          | 51               | 27                    | 65             | 40                  | 455             | 112                 | 38           | 15               |

Table 2. Judgment Threshold for Defects of Round Plate (Unit: Pixel).

20 pieces of qualified products, 10 pieces of corners, 10 pieces of scratches, 10 pieces of cracks, 10 pieces of knife marks, which are manually detected with a specification of D9.2*d4.02*1.2 (D9*1.2) (D9*1.2) 10 pieces of pits and 10 pieces of sand holes, a total of 80 pieces of plates are mixed together, and put into the surface defect automatic detection system that has been initially developed to detect and classify defects. After repeated experiments, the data analysis results are recorded.
Analysing the above data, on the one hand, it can be seen that the hardware sorting mechanism of the surface defect inspection system can correctly eliminate all the defects identified by the software inspection system, indicating that the coordination and repeatability of the sheet sorting mechanism is relatively reliable; On the one hand, it can be seen that the detection rate of dropped corners, pits and knife marks is relatively high, reaching 80%, the detection rate of scratches has reached 74%, and the detection rate of cracks is only 65%. It can be seen from the collected images of the cracked and scratched plates that are judged to be qualified products, the cracked plates are very deep due to the small defect surface, and the current imaging system cannot fully display the defect information of the plates, so appropriate lighting should be redesigned Light source; and the reason for the misjudgement of scratches is that the defects on the surface of the sheet are relatively shallow, and the collected images are discontinuous lines or flakes. After image processing, they become intermittent short lines and dots, which makes the defects the characteristic parameter is less than the threshold value of the corresponding defect judgment, which causes the misjudgement as a qualified product. Moreover, due to the limitations of the existing defect identification methods, the familiarity of the shape of cracks and scratches, and the randomness of the defect location, the two types of defects can be distinguished There are difficulties [6]. In the detection results, these two kinds of defects are mixed with each other. Therefore, in addition to improving the image quality obtained, it is necessary to find a suitable image processing algorithm to improve the detection rate and recognition rate.

5. Conclusion
The wood-based panel surface defect detection system based on machine vision realizes the online detection of large-format panels on the continuous press production line. The defect location is accurate. The defect detection results and the inspection time of a single panel meet the design requirements. The system can adjust parameters flexibly and conveniently according to the type and format of the man-made panels produced; the design is simple, the hardware equipment is easy to configure and maintain, and the software can be modified and re-developed according to the actual production needs of the enterprise, providing technical support for popularization and application.

Acknowledgment
This article is the research result of the 2018 Foshan self-funded technology project "Research and Application of Surface Defect Detection Technology Based on Industrial Machine Vision" (Project Number: 2018AB003831).

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