Investigation of the influence of heat transfer on screen printed textile conductor

I Kazani1, G De Mey3, C Hertleer2, G Guxho1 and L Van Langenhove2

1Polytechnic University of Tirana, Faculty of Mechanical Engineering, Textile and Fashion Department, “Mother Tereza” Square, No. 1, Tirana, Albania
2Ghent University, Department of Textiles, Belgium
3Department of Electronics and Information Systems, Ghent University, Belgium

Email: ikazani@fim.edu.al

Abstract. Two different textile substrates were screen printed with silver-based inks in order to be electrically conductive. In every textile four conductors were printed with different widths in order to investigate the influence of heat transfer on each conductor. This was done, by using the thermographic camera and through the evaluation of each conductor’s profile. It was found that the conductors printed on the white textile had higher values of heat transfer compared to the other conductors printed on the dark textiles.

1. Introduction

Over the last years smart textiles have become popular as a concept. In order to manufacture these wearable textile systems, electroconductive textiles are needed. Electroconductive textiles can be achieved by using conductive fibres, yarns coatings, polymers or inks [1-14]. Nowadays the last method, the conductive inks, have found use in many smart applications such as printed circuit boards (PCBs), Radio-frequency identification (RFID tags), wiring boards, textile antennas, sensors, etc. [14-21]. These conductive printed lines show a rather high electric resistivity when silver inks were used during the screen printing process [9]. Wherefore with this research were given more information about the textile conductors in order to have the perfect smart textile, without hotspots.

Infrared thermography is the method used in this research, which is rapidly gaining popularity amongst the researchers in various fields like medicine, biology, material science, civil engineering, etc. Many researchers has explored the potential of infrared thermography to investigate several thermo physical phenomena like heat transfer, measurement of thermal properties, non-destructive testing (NDT), greenhouse gas exchange or diagnosis of diseases, as any of processes that leads to a variation in temperature of the object can be subjected to thermographic investigation. In textile research infrared thermography, is applied in different applications such as: synthetic fibre spinning, clothing comfort, non-destructive testing of composite, product development, mechanical property and failure analysis, thermal property, heat transfer and drying [13, 22-24].

In this paper were used two different textiles, where four conductors were screen printed with silver-based inks. In order to observe the thermal property and heat transfer a thermographic camera was
used showing that the white textile has a higher value of the heat transfer for all four conductors compared to dark textiles. This research may help

2. Experimental work
In this study two woven textiles were selected, made of Cotton/Polyester (33/67%) and Polyamide (100% PA). The physical and mechanical properties were determined by ISO standards and are listed in the Table 1.

| Woven textile materials | Colour  | Yarn density of fabric | The type of textile weave | Basic weight (g/m²) | Specific heat (J/kg/KT) |
|-------------------------|---------|------------------------|---------------------------|---------------------|------------------------|
| Cotton/Polyester (CO/PES) | Dark blue | 32                     | Twill 2/1                 | 240                 | 1166                   |
| Polyamide (PA)          | White   | 45                     | Twill 2/2                 | 99                  | 1600                   |

The conductive ink used for these textiles was provided by Henkel and the screen printed method is used [9]. The design has four lines with different width and a square as reference (Figure 1).

3. Method for thermal analysis
In order to analyse the thermal properties of the printed samples a thermographic camera FLIR T420 25°, is used.

The samples were hanged and a current was supplied to each printed line separately, from a DC power supply (EL301R Power Supply). The measurements were completed at room temperature.

Each line was measured separately from the others. On each line two contacts were glued with electroconductive glue on the both edges of the conductive sample, in order to have a good electroconductive contact.

The current supplied was increased from 0.200, 0.500 to 1.050 A and the voltage is measured. To stabilize the temperature, was waited for 15 minutes and this was recorded with the thermal camera.

The data were collected for the line X (recording line) (see figure 1) and the profiles for the two transmission lines were taken.

4. Results and Discussion
After the evaluation of the profiles for each transmission line \(L_1, L_2, L_3\) and \(L_4\) some calculations of the slopes were done in order to calculate the total heat transfer and the thermal conductivity, concluding with theoretical calculations of the slopes.

All transmission lines of the two textiles were given the same current, so they will have the same heat energy (depending from the width) as a result of conductive heat transfer. Regarding to the color of
After the evaluation of the profiles some theoretical calculations of the slopes were done:

\[ L = \frac{\Delta T H}{h_c + h_r} \]  

(1)

Where: \( x_1 \) and \( x_2 \) - the start and the end point of the slope

In order to calculate the total heat transfer the equation (2) is used:

\[ h = h_c + h_r \]  

(2)

Where:

\( h_c \) – heat transfer convection

\( h_r \) – heat transfer radiation

\[ h_c = 1.485 \left( \frac{\Delta T}{H} \right)^{0.2} \]  

(3)

\[ h_r = 4\sigma T^3 \]  

(4)

\( \Delta T \) - the average temperature difference

\( H \) - The height of textiles sample = 0.235m

\( \sigma \) - Stefan Boltzmann constant = 5.6703 × 10^{-8} (Wm-2K^{-4})

\( T \) – Absolute temperature in Kelvin

In order to find the thermal conductivity the formula (4) is used:

\[ L = \frac{\frac{Kt_s}{\sqrt{2h}}}{t_s} \Rightarrow k = \frac{2ht_s^2}{t_s} \]  

(5)

Where: \( t_s \) - the thickness of the textile

In the Figure 3 the profiles for the printed textile 1 are shown. Each profile is evaluated separately by drawing slopes, such as Line 1-1, Line 1-2 and Line 1-3 (Figure 4). The first number of the Lines shows the printed conductor (Figure 1) and the second number the slopes of the profile in evaluation.
Figure 4. Evaluation of the profile through the slopes for the conductors 1, 2, 3 and 4 of the Textile 1

In the Figure 5 the profiles for the printed textile 2 are shown. Each profile is evaluated as explained above.

Figure 5. Four profiles for the Textile 2
Figure 6. Evaluation of the profile through the slopes for the conductors 1, 2, 3 and 4 of the Textile

In the table 2 and 3 are shown the results of the theoretical calculations of the slopes, done after the evaluation of the profiles for each conductor (L1, L2, L3 and L4).

Table 2 and 3. Theoretical results of the slopes for Textile 1 and Textile 2

| Textile 1 | Textile 2 |
|-----------|-----------|
| Nr        | x1 (mm)   | x2 (mm) | log T1 | log T2 | H (W/m²K) | L² | k (W/m K) |
| Line 1-1  | 15.35     | 12.95   | 0.00   | 9.27   | 10.17     | 0.44 |
| Line 1-2  | 37.17     | 42.02   | 0.57   | 9.27   | 24.42     | 1.05 |
| Line 1-3  | 42.82     | 45.23   | 0.07   | 9.27   | 279.10    | 12.04|
| Line 2-1  | 37.17     | 42.02   | 1.07   | 10.76  | 13.13     | 0.66 |
| Line 2-2  | 36.36     | 21.82   | 0.46   | 10.76  | 208.71    | 10.45|
| Line 2-3  | 52.52     | 56.36   | 1.07   | 10.76  | 15.47     | 0.77 |
| Line 2-4  | 57.37     | 61.41   | 0.59   | 10.76  | 533.89    | 16.71|
| Line 2-5  | 61.41     | 64.64   | 0.50   | 10.76  | 38.22     | 1.91 |
| Line 2-6  | 65.45     | 67.87   | 0.20   | 10.76  | 522.65    | 26.16|
| Line 2-7  | 68.68     | 70.30   | 0.14   | 10.76  | 30.05     | 1.50 |
| Line 3-1  | 55.75     | 52.52   | 1.35   | 12.68  | 8.04      | 0.47 |
| Line 3-2  | 51.71     | 42.02   | 0.80   | 12.68  | 143.05    | 8.44 |
| Line 3-3  | 41.21     | 37.17   | 0.37   | 12.68  | 54.32     | 3.20 |
| Line 3-4  | 36.36     | 23.43   | 0.13   | 12.68  | 2123.81   | 127.01|
| Line 3-5  | 62.25     | 65.45   | 1.39   | 12.68  | 17.87     | 1.05 |
| Line 3-6  | 65.45     | 67.87   | 1.06   | 12.68  | 215.69    | 12.61|
| Line 3-7  | 67.87     | 70.72   | 0.60   | 12.68  | 50.92     | 3.00 |
| Line 3-8  | 72.72     | 81.61   | 0.49   | 12.68  | 319.21    | 18.83|
| Line 3-9  | 82.42     | 92.92   | 0.41   | 12.68  | 429.78    | 25.35|
| Line 4-1  | 64.64     | 61.41   | 1.69   | 15.82  | 7.09      | 0.52 |
| Line 4-2  | 60.60     | 55.75   | 1.09   | 15.82  | 108.59    | 7.99 |
| Line 4-3  | 55.75     | 52.52   | 0.89   | 15.82  | 17.14     | 1.26 |
| Line 4-4  | 51.71     | 42.02   | 0.50   | 15.82  | 421.75    | 31.4 |
| Line 4-5  | 42.11     | 33.94   | 0.26   | 15.82  | 445.10    | 32.61|
| Line 4-6  | 33.13     | 17.78   | 0.13   | 15.82  | 5485.61   | 403.72|
| Line 4-7  | 16.16     | 10.50   | 0.35   | 15.82  | 2359.09   | 1733.84|
| Line 4-8  | 68.68     | 71.10   | 1.63   | 15.82  | 10.05     | 0.74 |
| Line 4-9  | 79.91     | 78.38   | 1.02   | 15.82  | 161.29    | 11.87|
| Line 4-10 | 80.80     | 84.84   | 0.03   | 15.82  | 33.74     | 2.48 |

As it can be seen at the tables, 2 and 3, textile 2 has a white background show to have a higher value of the heat transfer for all four conductors, compared to the other two textiles. This can explain by the fact that dark surfaces absorb radiant energy while white ones reflect it.

All conductors of the two textiles were given the same current, so they will have the same heat energy (depending from the width) as a result of conductive heat transfer. Regarding to the colour of textiles, the white will radiate the heat to surrounding printed conductors, more slowly than the dark textiles.
In table 4, is given a summary of the heat transfer for all the textiles. Here, one can observe that for the two textiles, the heat transfer increase with the decrease of the conductor width. As it can be seen the Line 4 with a width of max 3 mm has the highest values than Line 1 with a width of max 20.5 mm.

**Table 4.** Total heat transfer for the textiles

|       | Textile 1 | Textile 2 |
|-------|-----------|-----------|
| Line 1 | 9.27      | 10.19     |
| Line 2 | 10.76     | 12.43     |
| Line 3 | 12.68     | 15.57     |
| Line 4 | 15.82     | 19.54     |

5. Conclusion
In this paper the investigation of the influence of heat transfer on screen printed textile transmission lines is presented. Based on the experimental results of the two textile screen printed transmission lines, was conclude that textile 2, which has a white background show to have a higher value of the heat transfer for all four transmission lines, compared to the textile 1. Moreover was observe that the heat transfer increase with the decrease of the conductor width. So it is important to mention that in order to have the right textile conductors, one has to make the right combination of textile materials, design and conductive inks.

References
[1] X. Tao, M-Y. Leung, H. Zhang P. Xue, 2007, "Electromechanical properties of conductive fibres, yarns and fabrics," in Wereable electronics and photonics., pp. 81-103.
[2] J. Hakuzimana. E. Gasana, P. Westbroek, L. Van Langenhove, A. Schwarz, 2008."Gold Coated Polyester Yarn," Advances in Science and Technology, vol. 60, pp. 47-51,
[3] W. Chen, C. Doty B. S. Shim, 2008 "Smart electronic yarns and wearable fabrics for human biomonitoring made by carbon nanotube coating with polyelectrolytes," Nano Letters, vol. 8, pp. 4151-4157.
[4] C. L. Shen, C. F. Tang C. T. Huang, 2008. "A wearable yarn-based piezo-resistive sensor", Sensors and Actuators A, vol. 141, pp. 396-403,
[5] W. M. Au, Y. Li L. Li, 2009, "A novel design method for an intelligent clothing based on knitting technology and garment design", Textile Research Journal, vol. 79, pp. 1670-1679.
[6] J. Hakuzimana, A. Kaczynska, J. Banaszczyk, P. Westbroek, E. McAdams, G. Moody, Y. Chronis, G. Prinotakis, G. De Mey, D. Tseles, L. Van Langenhove A. Schwarz, 2010. "Gold coated para-aramid yarns through electroless deposition" Surface & coatings Technology, vol. 204, no. 9-10, pp. 1214-1418.
[7] M. W. Au, Y. Li L. Li, 2010, "Design of intelligent garment with transcutaneous electrical nerve stimulation function based on the intarsia knitting technique", Textile Research Journal, vol. 80, pp. 279-286.
[8] T. Akkan, E. Y. Bulgun Y. Senol, 2011, "Active T-shirt", International Journal of Clothing Science and Technology, vol. 23, pp. 249-257.
[9] I. Kazani, C. Hertleer, G. De Mey, A. Schwarz, G. Guhrho, L. Van Langenhove 2012, "Electrical conductive textiles obtained by screen printing", FIBRES & TEXTILES IN EASTERN EUROPE, vol. 20, no. 1, pp. 57-63.
[10] J. Eichhoff, T. Gries R. Alagirusamy, 2013, "Coating of conductive yarns for electro-textile applications", Journal of The Textile Institute, vol. 104, pp. 270-277.

[11] P. Potluri, A. Fernando S. T. A. Hamadani, 2013, "Thermo-mechanical behaviour of textile heating fabric based on silver coate", Materials, vol. 6, pp. 1072-1089.

[12] A. Schwarz, I. Kazani, L. Cuny, C. Hertleer, F. Gheliker, G. De Clercq, L. Van Langenhove, 2011, "Comparative study on the mechanical properties of elastic, electro-conductive hybrid yarns and their input materials", Textile Research Journal, vol. 81, no. 16, pp. 1713-1723.

[13] G. De Mey, M. Ozcelik, A. Schwarz, I. Kazani, C. Hertleer, L. Van Langenhove, N. C. Gursoy, 2014, "Designing of conductive yarn knitted thermal comfortable shirt using battery operated heating system", TEKSTIL VE KONFEKSIYON, vol. 1, pp. 64-67.

[14] I. Kazani, F. Declercq, M. L. Scarpello, C. Hertleer, H. Rogier, D. Vande Ginste, G. De Mey, G. Guixho, L. Van Langenhove, 2014, "Performance study of screen-printed textile antennas after repeated washing", AUTEX RESEARCH JOURNAL vol. 14, no. 2, pp. 47-54.

[15] M. L. Scarpello, I. Kazani, C. Hertleer, H. Rogier, D. Vande Ginste, 2012, "Stability and efficiency of screen-printed wearable and washable antennas," IEEE ANTENNAS AND WIRELESS PROPAGATION LETTERS, vol. 11, pp. 838-841.

[16] B. Karaguzel, T.-H. Kang, J. M. Wilson, P. D. Franzon, H. T. Nagle, B. Poudeyhimi, E. Grant C. R. Merritt, 2005, "Electrical characterisation of transmission lines on nonwoven textile substrates", Material Research Society, vol. 870E.

[17] C. Hertleer, G. De Mey, G. Guixho, L. Van Langenhove I. Kazani, 2014, "Electrochemical properties of screen-printed textiles electrodes," in 23rd Congress of Chemists and Technologists of Macedonia, pp. 275-275.

[18] G. Troster I. Locher, 2007, "Screen-printed textile transmission lines", Textile Research Journal, vol. 77, pp. 837-842.

[19] H. Kim, H. J. Yoo Y. Kim, 2010, "Electrical characterisation of screen-printed circuits on the fabric", IEEE Transaction on Advanced Packaging, vol. 33, no. 1.

[20] S. Manich, R. Rodriguez, M. Ridao J. Rius, "Electrical characterisation of conductive ink layers on textile fabrics: model and experimental results". [Online]. http://dit.upc.es/lpndtt/rius/web/paper29.pdf

[21] H. T. Nagle, E. Grant C. R. Merritt, 2009, "Textile-Based Capacitive Sensors for Respiration Monitoring", IEEE Sensors Journal, vol. 9, pp. 71-78.

[22] S. K. Chattopadhyay, S. Tuli D. Banerjee, 2013, "Infrared thermography in material research - A review of textile applications", Indian Journal of Fibre & textile Research, vol. 38, pp. 427-437.

[23] S. K. Bahadir, Y. E. Boke, F. Kalaoglu H. Sezgin, 2014, "Thermal analysis of e-textile structures using full-factorial experimental design method", Journal of Industrial Textiles, pp. 1-13.

[24] T. Häkkinen, J. Hämmikäinen, J. Vanhala T. Pola, 2013, "Thermal Performance Analysis of 13 Heat Sink Materials Suitable for Wearable Electronics Applications", Science and Technology, vol. 3, no. 3, pp. 67-73.