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Pneumatic De-Flashing Machine

R. S. Shelke, Ghule Dhiraj V, Jadhav Rahul N, Sahane Vishal B

Abstract: In the small-scale rubber manufacturing industry, the process of de-flashing plays a crucial role in improving the quality and aesthetics of rubber components. Flashing, which results from excess material during molding, is a common issue that requires efficient removal to ensure product precision and surface finish. This study focuses on the design, development, and optimization of a cost-effective rubber component de-flashing machine tailored to meet the needs of small-scale rubber industries. The research aims to enhance the de-flashing process by addressing challenges such as material wastage, energy consumption, and time efficiency.

The proposed machine utilizes a combination of mechanical and automated processes to remove flash from rubber components effectively. Key design features include adjustable cutting mechanisms, efficient waste collection systems, and minimal power consumption, all while maintaining a high throughput rate. Prototypes of the de-flashing machine were designed and tested to evaluate its performance across different rubber materials and component sizes. The results demonstrate a significant reduction in flash removal time, improved product quality, and a more sustainable manufacturing process.

This work contributes to the advancement of low-cost, high-efficiency machinery for small-scale rubber manufacturers, ultimately enhancing their production capacity, reducing operational costs, and improving the overall quality of rubber products.

I. INTRODUCTION

The rubber industry is a significant sector in manufacturing, catering to a wide array of products from automotive components to consumer goods. The molding process is central to rubber production, where raw rubber is shaped into various components using molds. However, during the molding process, excess rubber often flows into the gaps between the mold parts, creating a layer of unwanted material known as "flash." This flashing, though a natural by-product of molding, needs to be removed to ensure that the finished product meets required dimensional tolerances and surface quality standards.

In small-scale rubber manufacturing, the removal of flash is often carried out manually or using rudimentary machinery, leading to inefficiencies, high labor costs, increased wastage, and inconsistent quality. The lack of effective de-flashing equipment can also result in slower production cycles, affecting overall productivity and competitiveness in the market. This situation is particularly challenging for small-scale rubber manufacturers, who typically operate with limited resources and face the dual pressures of reducing production costs while improving product quality.

The objective of this study is to address these challenges by designing and developing an efficient, cost-effective de-flashing machine tailored for the needs of the small-scale rubber industry. The proposed machine is intended to automate the de-flashing process, reducing the need for manual labor, minimizing waste, and improving the overall quality and consistency of the final rubber components. By focusing on key aspects such as material handling, energy efficiency, ease of operation, and adaptability to various component sizes, the new machine aims to optimize the de-flashing process for small-scale manufacturers.

This study will explore the design considerations, operational principles, and performance testing of the proposed de-flashing machine. By providing small-scale rubber manufacturers with a reliable, low-cost solution, this research intends to improve the efficiency and competitiveness of this sector, ultimately contributing to the sustainability and growth of the rubber industry.

II. CONSTRUCTION & WORKING

The project consisting of following components:-

1) Pneumatic Double-acting Cylinder
2) Single Solenoid 5/2 way valve
3) Flow Control valve
4) Punch-Die
5) Compressor
6) Machine Body/Frame
7) Push Switch

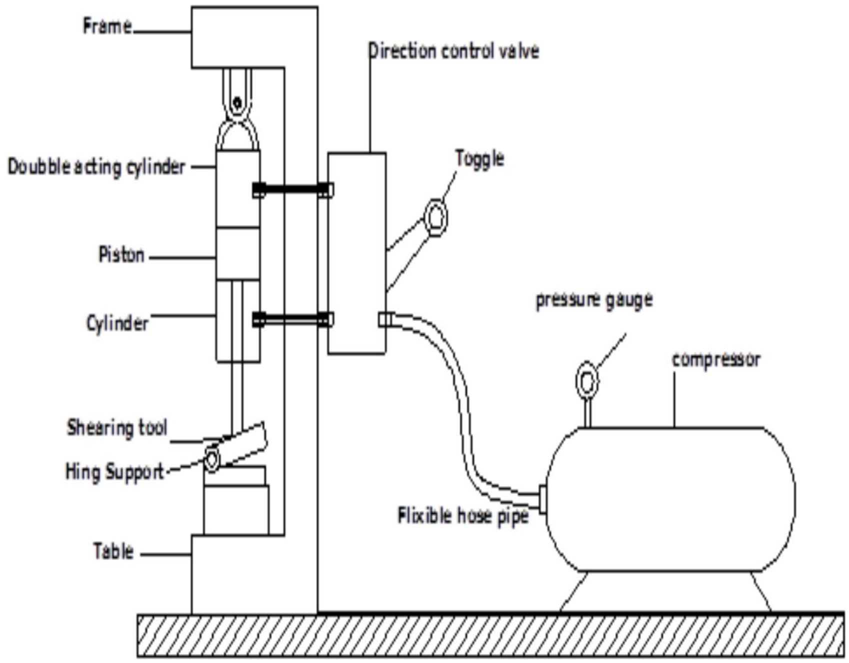

Fig. 2.1 Working Diagram of Pneumatic Punching Machine

A. Working

Compressed air from a compressor is used to press the work by means of the piston and piston rod, cylinder through a lever. The high pressurized air striking against the piston tends to push it upwards. This force is transmitted to a punch by means of a lever by its mechanical advantage. The punch forced downward pierces the work material. This is the main principle of this punching machine unit.

Punching is a metal forming process that uses a punch press to force a tool, called a punch, through the work piece to create a hole via shearing. The punch often passes through the work into a die. A scrap slug from the hole is deposited into the die in the process. Depending on the material being punched this slug may be recycled and reused or discarded. Punching is often the cheapest method for creating holes in sheet metal in medium to high production volumes. When a specially shaped punch is used to create multiple usable parts from a sheet of material the process is known as blanking. In forging applications the work is often punched while hot, and this is called hot punching

Punch tooling (punch and die) is often made of hardened steel or tungsten carbide. A die is located on the opposite side of the work-piece and supports the material around the perimeter of the hole and helps to localize the shearing forces for a cleaner edge. There is a small amount of clearance between the punch and the die to prevent the punch from sticking in the die and so less force is needed to make the hole. The amount of clearance needed depends on the thickness, with thicker materials requiring more clearance, but the clearance is always less than the thickness of the work-piece. The clearance is also dependent on the hardness of the work-piece. The punch press forces the punch through a work-piece, producing a hole that has a diameter equivalent to the punch or slightly smaller after the punch is removed. All ductile materials stretch to some extent during punching which often causes the punch to stick in the work-piece. In this case, the punch must be physically pulled back out of the hole while the work is supported from the punch side, and this process is known as stripping. The hole walls will show burnished area, rollover, and die break and must often be further processed. The slug from the hole falls through the die into some sort of container to either dispose of the slug or recycle it This Pneumatic hole Punching machine Have Pneumatic cylinder, 5/2 solenoid valve, Tool Arrangements, bolts Nut Supporting pillar. When the air from compressor, it will be taking a decision to move the tool down. Also it will up and down movement when the obstacle crossing time that will also press sheet with the help of pneumatic cylinder, and it will be given to the solenoid valve. And then it will move up or down depends upon the air speed. The tool movement and Up, down can be done with the help of pneumatic cylinder. This machine are mostly used in Industrial use to Mass Production It can punch hole rapidly and Multi size Jobs. It Have 10 bar maximum Pressure capacity . It can clamp 1 mm to 2mm thickness work pieces. It cost also less, high efficiency, work loading time is less.

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The compressed air from the compressor at the pressure of 5 to 7bar is passed through a pipe connected to the Solenoid valve with one input. The Solenoid Valve is actuated with Control Timing Unit. The Solenoid valve has two outputs and one input. The air entering into the input goes out through the two outputs when the timing control unit is actuated. Due to the high air pressure at the bottom of the piston, the air pressure below the piston is more than the pressure above the piston. So these moves the piston rod upwards which move up the effort are, which is pivoted by control unit. This force acting is passed on to punch which also moves downwards. The punch is guided by a punch guide who is fixed such that the punch is clearly guided to the die. The materials are in between the punch and die. So as the punch comes down the materials are sheared to the required profile of the punch and the blank is moved downwards through the die clearance. When the piston is at the extreme point of the stock length, the exhaust valve is opened and the air is exhausted through it and the pressurized air come in at the top of the piston and it pushes the piston downwards. So the one side of the air is pulled downwards and the other side is lifted upwards. So the punch is therefore pulled upwards from the die. Now the piston reaches the bottom point of the required stroke length. Now the material is fed and the next stroke of the piston is made ready. When the material is correctly positioned then this machine is again actuated automatically. The time duration of the succeeding punching is adjusted with the help of control timing unit.

III. METHODOLOGY

The methodology of this study involves a systematic approach to the design, development, and testing of a cost-effective de-flashing machine for small-scale rubber manufacturers. The methodology includes the following key stages: Design Approach, Materials Selection, System Architecture, Prototyping and Testing, and Performance Evaluation.

A. Design Approach

The design approach for the rubber component de-flashing machine is based on the principles of cost-effectiveness, energy efficiency, and ease of use. The machine will be designed to accommodate a variety of rubber component sizes and shapes, with adjustable features to ensure adaptability. The primary objective is to develop a machine that minimizes manual labor, reduces flash removal time, and ensures consistent quality in the final rubber components. Key design considerations include:

- Modularity: The de-flashing machine will have modular components to allow easy replacement, maintenance, and adjustment for different types of rubber parts.
- Simplicity: The machine will be designed with minimal complexity to ensure ease of operation, especially for small-scale manufacturers who may not have highly skilled operators.
- Cost-Effectiveness: The design will prioritize affordable materials and production techniques while maintaining performance and durability.
- Sustainability: The system will incorporate waste collection and recycling features to minimize material loss and environmental impact.

B. Materials Selection

The materials used in the construction of the de-flashing machine are critical to ensuring both performance and longevity. The following materials were selected based on their cost, availability, and compatibility with rubber processing:

- Frame Material: The frame of the machine will be constructed from mild steel for durability and cost-effectiveness, with some parts possibly being made of aluminum for reduced weight in certain components.
- Cutting Tools: Hardened steel blades will be used for cutting the flash due to their ability to withstand the mechanical stresses involved in the de-flashing process.
- Drive Mechanism: The motor will be selected based on the required power to drive the rotary cutting system, ensuring a balance between energy consumption and cutting speed.
- Waste Collection System: The waste collection system will utilize a **cyclone separator** or simple **suction fan** to collect the removed flash and prevent it from contaminating the production environment.

C. System Architecture

The de-flashing machine will be composed of several key subsystems, each optimized for specific functions. The following are the main components and their roles:

- Cutting Mechanism: The cutting mechanism is central to the de-flashing process. It consists of a rotating cutter (e.g., disc blades, rotary knives) driven by an electric motor. The cutter speed and rotational direction will be adjustable to accommodate different component sizes and materials.
- Material Feeding System: The rubber components will be fed into the machine using a conveyor system that guides the components to the cutting area. The conveyor will be designed to handle components of varying sizes and will be adjustable to maintain consistent feed rates.
- Adjustable Fixtures: The de-flashing machine will include adjustable fixtures that can hold rubber components securely in place during the flash removal process. These fixtures will accommodate various sizes and shapes of components, making the machine versatile for different types of production runs.
- Waste Collection and Recycling System: A key component of the machine will be a system for collecting and recycling the removed flash. The collected waste will be directed into a container for disposal or reprocessing.
- Control System: The machine will be controlled via a simple **programmable logic controller (PLC)**, which will allow operators to adjust settings such as cutting speed, conveyor speed, and fixture position. The control panel will include a user-friendly interface for ease of operation.

D. Prototyping and Testing

Once the design parameters are finalized, a prototype of the de-flashing machine will be constructed. This stage involves the following steps:

- Prototype Development: A scaled-down version of the machine will be built to evaluate the feasibility of the design. This prototype will be equipped with basic cutting and material handling components, as well as a waste collection system.
- Testing the Prototype: The prototype will undergo a series of tests to assess its performance. Key performance indicators (KPIs) will include:
  - Flash Removal Time: The time it takes to remove flash from a rubber component.
  - Quality of Flash Removal: The degree to which flash is effectively removed without damaging the rubber component.
  - Machine Throughput: The number of components processed per hour, which is a measure of the machine's efficiency.
  - Energy Consumption: The amount of energy used during operation, to ensure the machine is energy-efficient.
- Design Iterations: Based on the results of prototype testing, necessary design modifications will be made to improve performance. This could include adjusting cutting speeds, modifying fixture designs, or enhancing the waste collection system.

E. Performance Evaluation

Following the successful development of the prototype, the final machine will be subjected to detailed performance evaluations under real-world operating conditions. These evaluations will be conducted in collaboration with small-scale rubber manufacturers to gather feedback on usability, efficiency, and overall impact on production.

The performance evaluation will focus on the following aspects:

- Effectiveness of Flash Removal: The machine's ability to remove flash consistently and efficiently, without compromising the integrity of the rubber components.
- Ease of Operation: The simplicity and user-friendliness of the machine, especially for operators with limited experience.
- Economic Viability: The cost-effectiveness of the machine, considering both initial capital investment and ongoing operational costs.
- Environmental Impact: The amount of material waste generated during the de-flashing process and how effectively the machine collects and recycles removed flash.

Feedback from these evaluations will be used to make any final adjustments to the machine's design before proposing it for full-scale adoption by small-scale manufacturers.

F. Data Collection and Analysis

Data will be collected throughout the testing phase to evaluate the performance of the de-flashing machine. This data will be analyzed to determine:

- Flash Removal Efficiency: Comparison of the time and labor required for manual versus machine-assisted flash removal.

- Cost Reduction: Comparison of the total cost of flash removal, considering labor costs, material waste, and machine maintenance.
- Production Output: Evaluation of machine throughput and the impact on the overall production efficiency of small-scale rubber manufacturers.

IV. PROPOSED SYSTEM

The proposed system aims to develop a low-cost, efficient, and easy-to-operate de-flashing machine specifically designed for small-scale rubber manufacturers. The system is intended to automate the flash removal process, reduce labor costs, improve production efficiency, and enhance the overall quality of rubber components. The design of the de-flashing machine incorporates several innovative features to address the unique needs of small-scale manufacturers.

A. System Overview

The proposed rubber component de-flashing machine consists of the following core subsystems:

- Material Handling System: Conveyor system for feeding rubber components into the machine.
- Cutting and Flash Removal Mechanism: Rotary cutter or blade system for removing excess rubber (flash).
- Adjustable Fixtures: Mechanisms to hold and secure components during the flash removal process.
- Waste Collection and Recycling System: Efficient system for capturing and recycling removed flash.
- Control System: A simple and intuitive control panel with user-friendly interface for setting operational parameters.

The machine will be designed to handle a wide range of rubber components, from small parts to larger, more complex shapes, while maintaining consistent cutting accuracy.

B. Key Components of the Proposed System

1. Material Feeding System:

- Conveyor Belt: A motorized conveyor belt will automatically feed rubber components into the de-flashing machine. The belt will be adjustable in speed, allowing it to accommodate different sizes and shapes of components. The feeding system will ensure that the rubber components enter the cutting area at a consistent rate for optimal flash removal.
- Orientation Mechanism: To ensure proper alignment of rubber components during the flash removal process, an automated system of rollers or guides will be used to orient the components correctly as they enter the machine.

2. Cutting Mechanism:

- Rotary Cutter System: The cutting mechanism will consist of high-speed rotary blades (or disc cutters) made from durable materials such as hardened steel. The blades will rotate at variable speeds, ensuring that flash is cleanly trimmed without damaging the rubber component. The cutting system will be adjustable to accommodate various component sizes and materials.
- Adjustable Cutting Height: To accommodate different thicknesses of flash, the cutting system will feature adjustable height settings. The operator can modify the cutting depth based on the size and thickness of the rubber component, ensuring precision and minimizing material loss.

3. Adjustable Fixtures:

- Clamping System: The de-flashing machine will feature adjustable clamps or fixtures to securely hold rubber components in place during the cutting process. These fixtures will be designed to handle components of varying sizes and geometries.
- Quick-Change Fixtures: For increased flexibility, the system will have quick-change fixtures that allow users to easily swap between different types of rubber components. This feature ensures that the machine can be quickly adapted to various production runs without extensive downtime.

4. Waste Collection and Recycling System:

- Flash Collection Tray: A collection tray or container will be placed beneath the cutting area to catch and collect the removed flash. This ensures that the removed material is not scattered around the machine, reducing cleanup time and improving workplace safety.
- Cyclone Separator: A cyclone separator or suction fan system will be integrated to collect small flash particles and debris. This ensures that the machine’s environment remains clean and minimizes waste dispersion, which can lead to material loss.

- Recycling System: The removed flash can be either disposed of or, if feasible, sent through a recycling system for reprocessing. The design will include a simple material recycling process to minimize waste and make the system more sustainable.

5. Control System:

- Programmable Logic Controller (PLC): The control system will be based on a PLC to manage machine operations, including motor speed, conveyor speed, and cutting blade speed. The PLC will be programmed to handle different types of rubber components and adjust settings based on user input.
- User Interface: A simple control panel with an intuitive interface will allow operators to adjust settings such as cutting speed, material feed rate, and waste collection options. The control system will also include emergency stop functions for safety.
- Sensor Integration: Proximity sensors or optical sensors will be used to detect the presence and position of rubber components on the conveyor belt. These sensors will automatically trigger the cutting mechanism once the component reaches the cutting area, improving automation and reducing the need for manual intervention.

C. Operational Workflow

The proposed system will operate as follows:

1) Material Feeding: Rubber components are placed onto the conveyor belt, which automatically feeds them into the machine. The speed of the conveyor belt can be adjusted based on the size and quantity of components being processed.
2) Orientation and Clamping: The rubber components are guided into the cutting area, where adjustable clamps or fixtures hold them securely in place. The clamping system will prevent any movement of the components during the de-flashing process, ensuring precise cutting.
3) Flash Removal: As the rubber components enter the cutting zone, the rotary cutter blades are activated. The cutting depth and speed are adjusted based on the size and thickness of the flash. The rotary blades trim off the excess material, leaving behind clean, finished components.
4) Waste Collection: The removed flash is immediately captured by the waste collection system, which funnels the material into a designated container or waste management system. The integrated cyclone separator ensures that smaller flash particles are also collected and redirected for recycling or disposal.
5) Exit: Once the de-flashing process is complete, the cleaned rubber components are released from the clamps and move to the exit area, where they are ready for further processing, inspection, or packaging.

D. Advantages of the Proposed System

- Increased Efficiency: Automation of the flash removal process reduces the time and labor required compared to manual methods, resulting in faster production cycles.
- Cost Savings: The system’s low-cost design and energy-efficient features make it an affordable solution for small-scale manufacturers.
- Improved Product Quality: The rotary cutter system ensures consistent and precise flash removal, resulting in higher-quality rubber components with fewer defects.
- Flexibility: The adjustable fixtures and cutting mechanisms allow the machine to handle a wide range of component sizes and shapes, making it suitable for diverse production needs.
- Waste Reduction: The integrated waste collection and recycling system minimizes material loss and helps manufacturers operate more sustainably.
- Ease of Use: The user-friendly control panel and automated features simplify operation, making it accessible even for operators with minimal technical expertise.

V. EXPECTED OUTCOME

A. Improved Efficiency in Flash Removal

- Faster Cycle Times: One of the main objectives is to reduce the time spent on flash removal. By automating the de-flashing process, the machine will significantly speed up production. This reduction in flash removal time will allow manufacturers to process more rubber components per hour, leading to increased throughput.

- Consistency in Process: The automated cutting system ensures that the flash removal is consistent for each component, minimizing variations in quality that are common with manual trimming. This will lead to a more streamlined production process, with fewer interruptions or reworks.

B. *Cost Savings*

- Labor Cost Reduction: Traditional de-flashing methods require significant manual labor, which adds to the overall production costs. With the introduction of the automated de-flashing machine, the need for manual intervention is greatly reduced, thereby lowering labor costs. This will be particularly beneficial for small-scale manufacturers, who often face tight budgets.
- Reduced Material Waste: The precision of the rotary cutting mechanism ensures that flash is removed without damaging the rubber components, reducing the loss of valuable material. Additionally, the waste collection and recycling system will help capture the removed flash for reuse or recycling, further reducing material wastage.
- Energy Efficiency: The machine's design prioritizes energy efficiency, with optimized motor and drive systems that minimize electricity consumption. This will result in lower operational costs over time, contributing to long-term savings for the manufacturer.

C. *Enhanced Product Quality*

- Consistent Flash Removal: One of the primary benefits of the proposed system is the precision and consistency in flash removal. Unlike manual methods, where flash removal is often uneven and prone to human error, the rotary cutter system ensures uniform trimming, leading to consistently high-quality components.
- Improved Dimensional Accuracy: The precise cutting action minimizes the risk of over-trimming or under-trimming the rubber components, ensuring that they meet the required dimensions. This will help in reducing defects and improving the overall quality of the final product.
- Better Surface Finish: The de-flashing machine will provide a cleaner and smoother finish on the edges of the rubber components, which is crucial for both aesthetic appeal and functional purposes, especially for components that need to fit into assemblies with tight tolerances.

D. *Increased Production Capacity*

- Higher Throughput: By automating the flash removal process, the machine will be capable of handling higher volumes of rubber components compared to manual methods. The increase in production capacity will allow small-scale manufacturers to meet higher demand, improve lead times, and scale up production when necessary.
- Reduced Downtime: The automated system requires less supervision and fewer adjustments compared to manual labor, which results in lower machine downtime and more consistent production. As a result, the overall production efficiency is improved, and manufacturers can focus on other critical areas of their operations.

E. *Improved Workplace Safety and Reduced Labor-Related Hazards*

- Reduced Manual Handling: Since the de-flashing process will be automated, there will be a decrease in the amount of manual labor required for cutting and handling rubber components. This reduction in manual handling will reduce the risk of injuries associated with sharp tools or repetitive strain.
- Safer Work Environment: The system's automated features will help maintain a safer work environment by minimizing the need for workers to be in direct contact with the machine during operation. Additionally, the waste collection system ensures that removed flash is contained, reducing the potential for slip-and-fall accidents due to scattered debris.

F. *Environmental Benefits*

- Material Recycling: The waste collection and recycling system built into the machine will capture most of the removed flash, allowing it to be either disposed of properly or recycled. This recycling system reduces the environmental footprint of the manufacturing process by preventing material wastage and lowering the consumption of raw materials.
- Sustainability in Production: With the reduced material loss, less waste is generated in the production cycle, and the overall sustainability of the operation is improved. Manufacturers can adopt greener production methods without sacrificing efficiency or product quality.

G. Flexibility and Versatility for Small-Scale Manufacturers

- Adaptability for Various Component Sizes: The de-flashing machine will be designed with adjustable features, such as changeable cutting heads and variable conveyor speeds, to handle a wide range of rubber component sizes and shapes. This flexibility makes the machine suitable for small-scale manufacturers who often deal with diverse product types.
- Ease of Operation: The user-friendly control panel allows operators to easily adjust settings such as cutting speed, fixture positioning, and material feed rate. This simplicity ensures that small-scale manufacturers with limited technical expertise can operate the machine without difficulty.

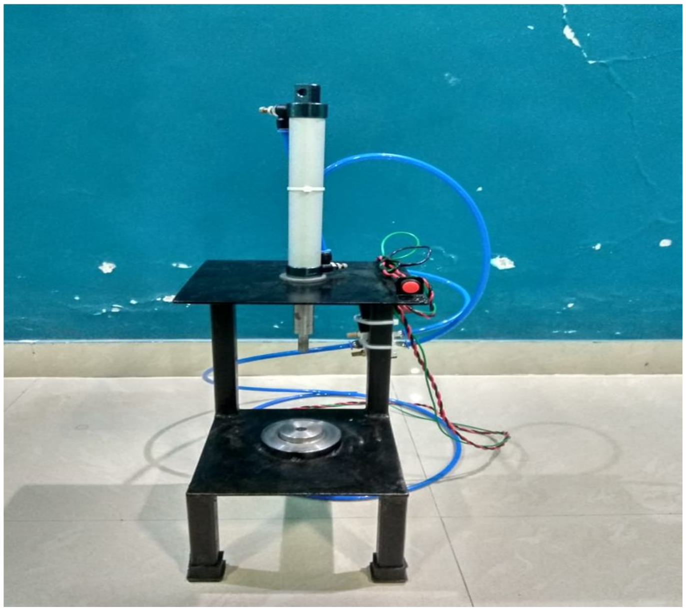
H. Reduced Maintenance Requirements

- Durable Components: The machine will be designed using durable materials, such as hardened steel blades and corrosion-resistant frames, which will reduce wear and tear and extend the life of the machine.
- Low Maintenance Costs: The simplicity of the machine design, along with easy-to-replace components, will ensure that maintenance requirements are minimal and cost-effective. Routine maintenance, such as blade replacements and motor servicing, can be performed without significant downtime or cost.

I. Overall Impact on Small-Scale Manufacturers

- Economic Viability: The reduced capital expenditure and operating costs associated with the machine make it an economically viable solution for small-scale manufacturers, who typically have limited financial resources. The expected return on investment (ROI) will be achieved through savings in labor costs, material waste, and increased production capacity.
- Competitiveness in the Market: By increasing operational efficiency and product quality, the de-flashing machine will help small-scale manufacturers remain competitive in the global market. The machine will enable them to meet stricter industry standards, improve customer satisfaction, and expand their market share.

VI. RESULTS



VII. CONCLUSION

The proposed rubber component de-flashing machine is expected to bring substantial improvements in production efficiency, cost savings, product quality, and environmental sustainability for small-scale rubber manufacturers. By automating the flash removal process, the system will help these manufacturers reduce labor costs, improve throughput, and enhance product consistency. Additionally, the machine’s low-cost, user-friendly design and flexibility will make it an ideal solution for small-scale manufacturers looking to optimize their production processes and remain competitive in the market.

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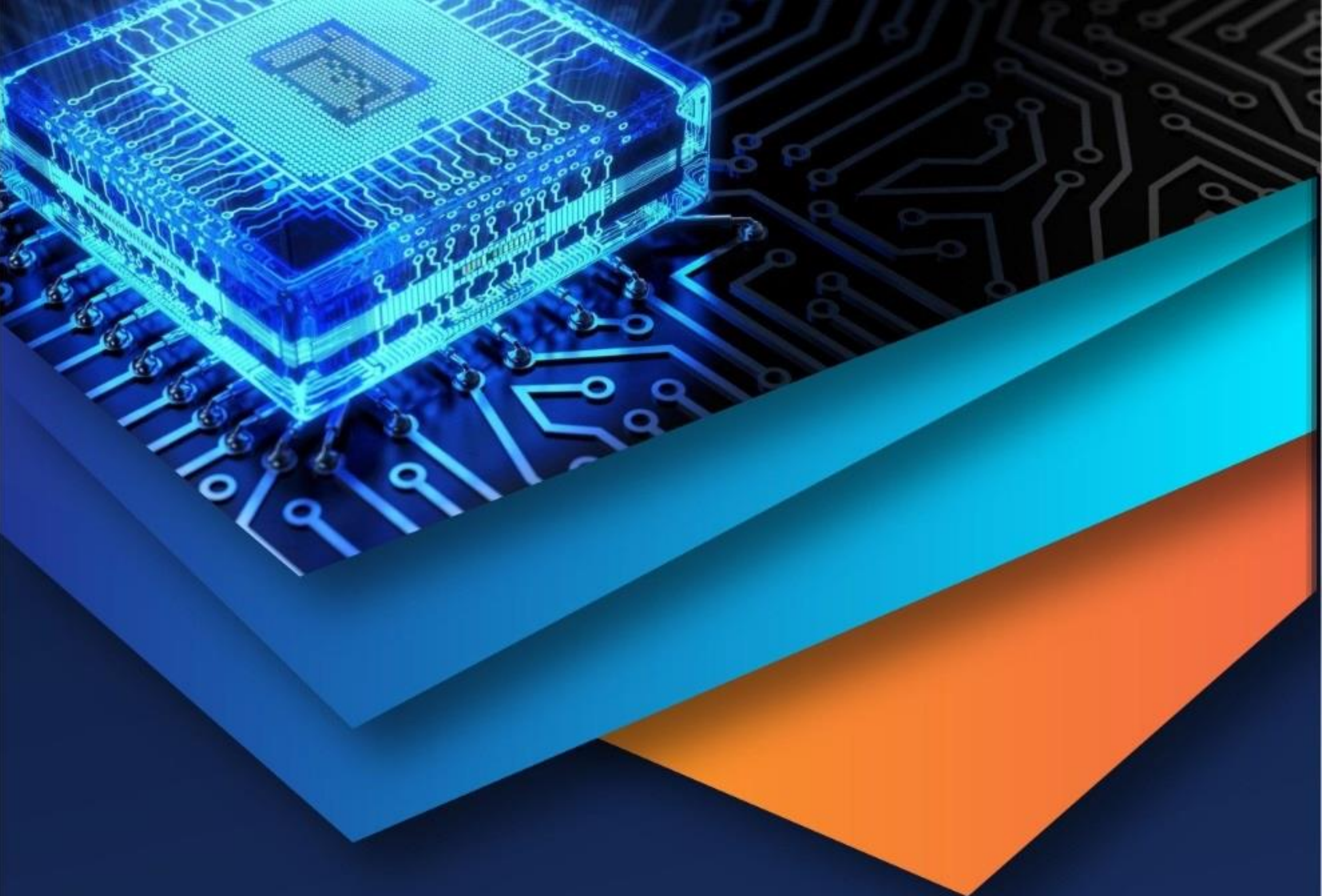

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