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**An Ultrasonic Testing Technique for
Monitoring the Cure and Mechanical
Properties of Polymeric Materials**

22 August 1993

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PREFACE

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INTRODUCTION

Large space booster solid-rocket motors (SRMs) contain composite propellant materials based on either a hydroxyl terminated polybutadiene (HTPB) or the terpolymer of butadiene, acrylic acid, and acrylonitrile (PBAN) polymer matrix. Mechanical tests have revealed significant batch-to-batch variances and age related changes in the propellant moduli¹ probably due to continued crosslinking of the system. This paper documents a work in progress directed toward testing the feasibility of using ultrasonic measurements of the propellant mechanical properties to monitor the condition and the degree of cure of the propellant. If the ultrasonic shear and longitudinal velocities, c_s and c_L , and the density, ρ , of the propellant are known, the Young's modulus, shear modulus, bulk modulus, and Poisson's ratio, E , μ , K , and σ , respectively, can be calculated via the familiar relations,

$$E = \frac{\rho c_L^2 (1 - 2\sigma)(1 + \sigma)}{1 - \sigma}, \quad \mu = \rho c_s^2, \quad K = \frac{E}{3(1 - 2\sigma)}, \quad \text{and} \quad \sigma = \frac{c_L^2 - 2c_s^2}{2c_L^2 - 2c_s^2} \quad (1)$$

Considerable effort under the NASA Solid Propulsion Integrity Program (SPIP) has been directed along a similar vein.² The work presented here is unique in that a simple ultrasonic resonance technique which permits measurement of the acoustic velocities of thin adhesive material specimens is employed. The technique incorporates a slight modification of what was presented in earlier work³ in that Fast Fourier Transforms (FFTs) are used to process the signals. The technique is characterized by a number of advantages. The same specimen and transducer pair is used to determine both the shear and longitudinal response. In addition, a fluid medium is employed to couple sound into the specimen, thereby eliminating many of the problems associated with the bonding of transducers. Preliminary SPIP results suggest that measurements of the propellant shear velocity are important, but difficult to perform, as the propellant material is very attenuative to shear waves. The hope is that use of thin specimens will serve to mitigate this difficulty.

TECHNIQUE

To understand the technique, consider first a thin medium having acoustic impedance, Z_2 , sandwiched between two semi-infinite media of acoustic impedance, Z_1 , as depicted in Fig. 1. Assuming a continuous plane-wave stimulation in one of the semi-infinite media, the coefficient of acoustic power transfer, P_T , across the thin medium can be calculated;

$$P_T = \frac{4Z_2^2 Z_1^2}{(Z_1^2 + Z_2^2)^2 \sin^2\left(\frac{2\pi x_2 f}{c}\right) + 4Z_2^2 Z_1^2 \cos^2\left(\frac{2\pi x_2 f}{c}\right)} \quad (2)$$

where f is the frequency of the plane wave, c is the acoustic velocity (either shear or longitudinal) and x_2 is the thickness of the thin medium (see Ref. 3).

In Fig. 2, P_T is plotted as a function of frequency for the case where $Z_1 = 17$ Rayls (aluminum) and $Z_2 = 1.48$ Rayls (water). It can be seen that the condition of maximum power transmission occurs when $f = f_R = nc/2x_2$, where n is an integer. Note that the thin medium was assumed to be lossless in the derivation of Eq. 2. Taking attenuation into account, one would expect the amplitude of the local maxima to decrease with increasing n .

The experimental apparatus is depicted in Fig. 3. Two aluminum blocks were cut from square rod stock, each having a 74° and 90° face with respect to one side of the block. A milled finish was determined to be adequate on the 74° faces. The 90° faces were lapped to ensure that the surfaces were flat. A thin uniform layer of the specimen being tested was sandwiched between the 90° faces. The spacing between these faces and hence, the specimen thickness, was determined by two identical, stainless-steel wire spacers. To hold this Al/specimen/Al sandwich together, a small rubber O-ring was stretched over a set of threaded pegs located on each of two opposite sides of the sandwich as shown. The depth of thread for these pegs was less than 0.125 inches. The resultant Al/specimen/Al sandwich was set upon a fixture (not included in Fig. 3 for clarity) and submerged in a water tank so as to be centered between a pair of plane wave, through-transmission, ultrasonic transducers. The fixture was designed to permit rotation of the specimen

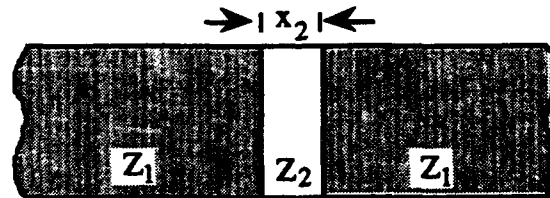


Figure 1. A thin medium of acoustic impedance, Z_2 , and thickness, x_2 , sandwiched between two semi-infinite media of acoustic impedance, Z_1 .

with respect to the transducers. The apparatus was designed to approximate the conditions leading to the derivation of Eq. 2. The Al blocks correspond to the semi-infinite media, the specimen to the thin medium.

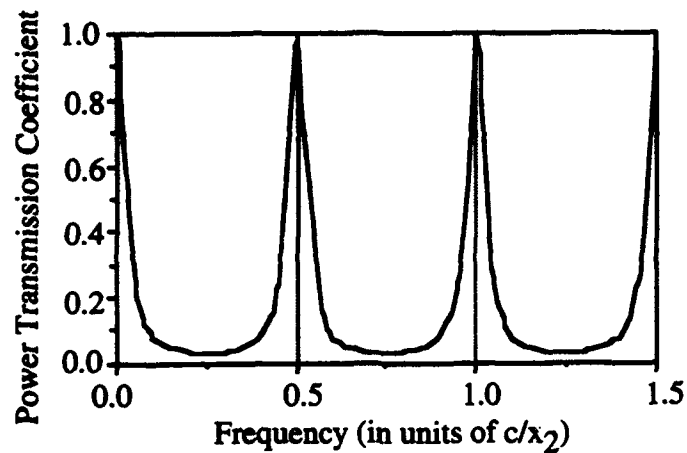


Figure 2. The coefficient of acoustic power transmission across the thin medium as a function of frequency (Eq. 2) for the three layer system depicted in Fig. 1, where $Z_1 = 17$ Rayls (Al) and $Z_2 = 1.48$ Rayls (water).

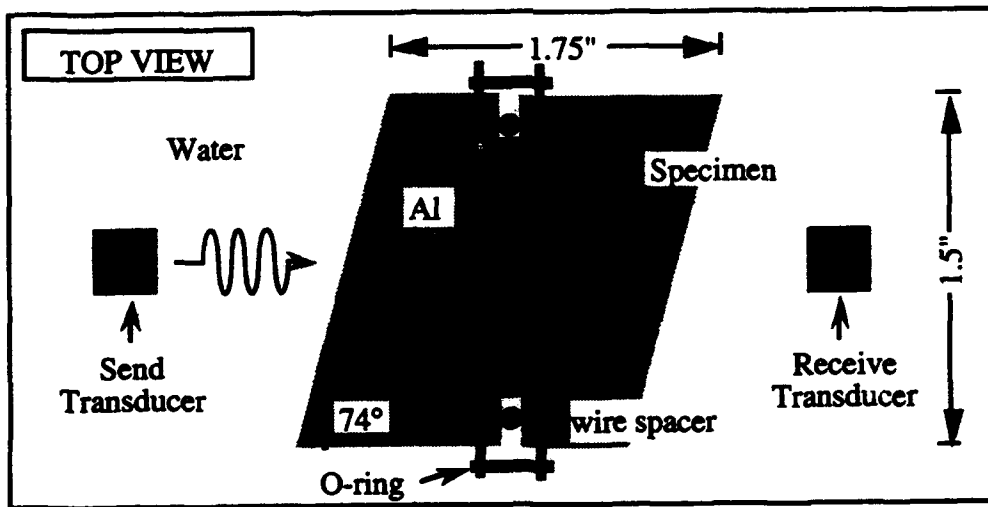


Figure 3. The experimental apparatus as described in the text. As indicated, this is a top view. The Al/specimen/Al sandwich extends 1.5 inches from top to bottom into the page. The transducers and O-ring are bisected by a plane parallel to that of the page and 0.75 inches into the page.

To perform measurements, the send transducer was stimulated with a spike pulse. The fixture was aligned so that this pulse would strike the first 74° face of the Al/specimen/Al sandwich at a particular angle of incidence, θ_i , to its normal, giving rise to both a longitudinal and a shear wave pulse within the aluminum. The longitudinal and shear wave emergence angles for a particular θ_i can be determined using Snell's law.

In the first phase of the experiment, θ_i was set at $\sim 3.7^\circ$ so that the longitudinal pulse transmitted through the first 74° face would strike the Al-specimen interface at normal incidence, and then travel through the remainder of the Al/specimen/Al sandwich to produce a pulse at the receive transducer. This pulse will be referred to as the longitudinal response. Because the longitudinal velocity in Al exceeds that of the shear, the longitudinal response was the first pulse detected after each drive pulse. This first pulse was followed by others due to the shear wave transmitted through the first 74° face and various internal reflections within the sandwich. Upon reception by the receive transducer, the longitudinal response was isolated and its FFT computed. To isolate the effect of the specimen, this FFT was divided by an FFT of the longitudinal response for a reference block comprised of solid Al and having the same dimensions as the Al/specimen/Al sandwich. The corrected data set was then normalized and stored for analysis. A computer was used to automate the system so that the longitudinal response could be measured repeatedly as a function of a specimen's cure time, t . Peaks in the longitudinal response FFT, which in accordance with Eq. 2 occur when $f = f_{RL} = nc_L/2x_2$, could then be used to determine c_L , the longitudinal acoustic velocity of the specimen for each measurement.

In the second phase of the experiment, θ_i was set to $\sim 7.5^\circ$ so that the direction of the transmitted shear wave was normal to the Al-specimen interface. The first received pulse resulting from this normal shear wave will be referred to as the shear response. Following each drive pulse, the shear response was preceded by not only the longitudinal response, but also other signals resulting from internal reflections involving the faster longitudinal pulse. To positively identify the shear response, one could increase θ_i beyond the critical angle for longitudinal wave production in the aluminum so that the shear response would be the first remaining pulse. One could then track this signal while decreasing θ_i to the appropriate value. The FFT of the shear response was then computed, normalized, and stored in the same manner as that of the longitudinal response. Peaks in the shear response FFT, occurring when $f = f_{RS} = nc_S/2x_2$, could then be used to determine the shear acoustic velocity of the specimen, c_S .

RESULTS

Three materials were tested: water; EPON 828, a Shell bisphenol-A/epichlorohydrin-based epoxy system, cured with diethylenetriamine (TETA); and an inert HTPB propellant mixture with sodium chloride substituted for the ammonium perchlorate found in live propellant.

Water was tested first to provide an end-to-end system check, as its acoustic velocity is well known. An Al/H₂O/Al sandwich with wire spacers of diameter $x_2 = 6$ mil was prepared. The longitudinal response for the 6-mil water specimen and its FFT are plotted in Figs. 4a and 4b, respectively. The longitudinal response and its FFT for the reference block under the same conditions are plotted in Figs. 4c and 4d. The FFT for the reference block (Fig. 4d) reflects the fact that 5-MHz transducers were used for the measurement. Comparison of Fig. 4a with Fig. 4c (and Fig. 4b with 4d) reveals that the 6-mil water specimen functioned like a bandpass filter for the input pulse. Dividing the reference block FFT (Fig. 4d) into that of the 6-mil water specimen (Fig. 4b) and normalizing the result yielded the plot depicted in Fig. 5. Note that as expected (compare with Fig. 2), multiple, equally spaced peaks of diminishing amplitude are present. The results for frequencies outside the active range of the transducer, $\sim 2 - 7.5$ MHz (Fig. 4d),

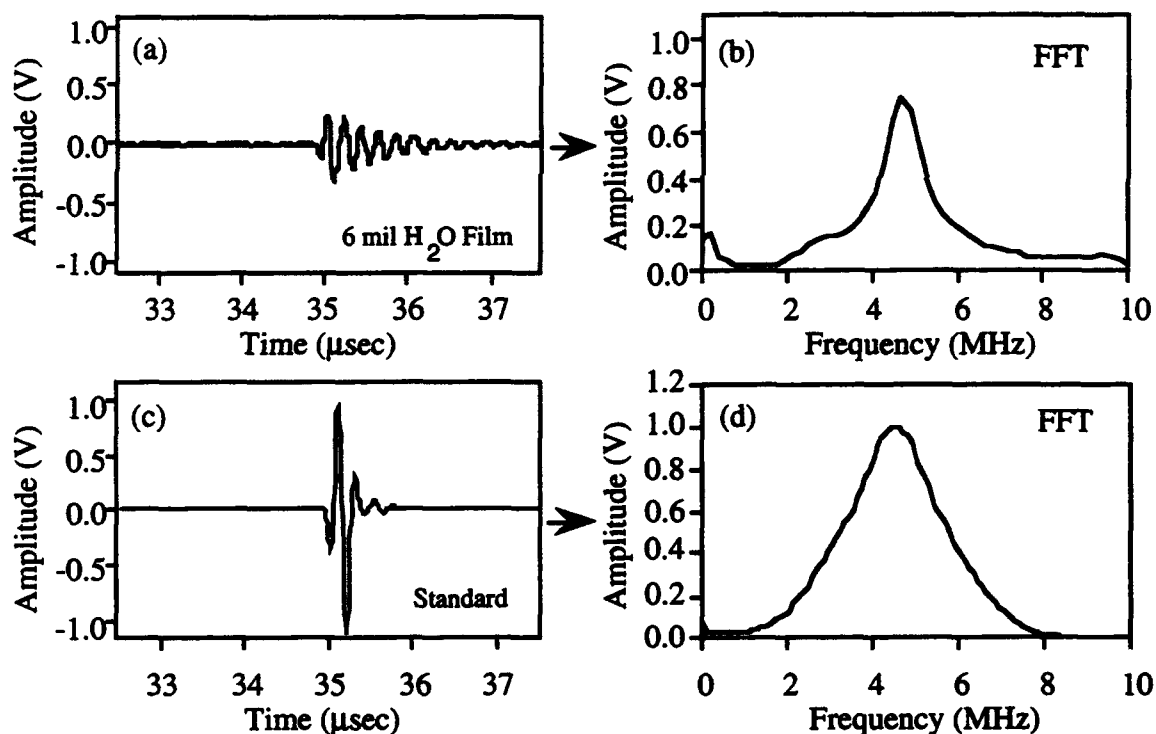


Figure 4. System check: (a) Longitudinal response of the Al/H₂O/Al sandwich. (b) FFT of the Al/H₂O/Al sandwich longitudinal response. (c) Longitudinal response of Al reference block. (d) FFT of the reference block longitudinal response.

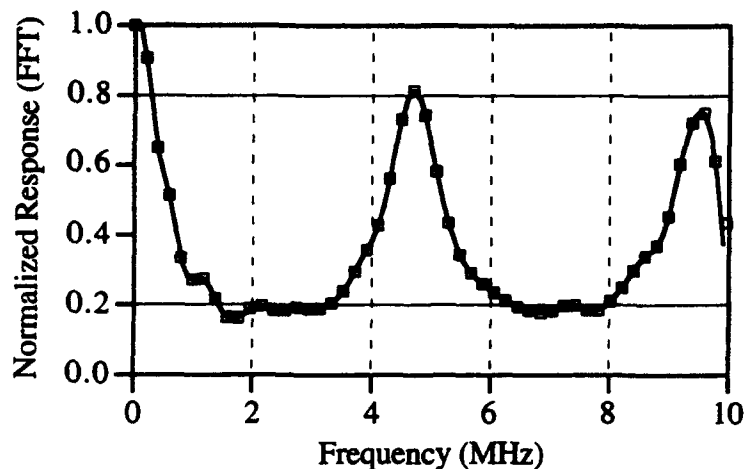


Figure 5. System check: Normalized results from division of the FFTs in Figure 4b and 4d. The first non-zero maxima occurs at 4.69 MHz.

however, should be accepted with caution. From the position of the first non-zero maxima one can calculate $c_L = 2f_{RL}x_2 = 0.056$ in./ μ s, which compares favorably with the literature value for water of 0.058 in./ μ s. The slight difference was traced to the fact that the reference block was not cut from the same Al stock as the blocks used for the 6-mil water specimen.

Secondly, tests were performed on the system consisting of a 10:1 mixture of EPON 828 and diethylenetriamine (TETA) hardener. A typical plot of the longitudinal FFT for this system is presented in Fig. 6a. This plot was produced from data acquired following a cure time of $t = 14.5$ min. Three maxima are clearly evident. The third peak is distorted, but it occurs beyond the normal operating range of the 5.0-MHz transducers employed. The thickness of the longitudinal specimen was 10.25 mils. The position of the first maxima implies that $c_L = 0.062$ in./ μ s. Measurements of the shear response for the EPON 828 system were more difficult. The FFTs obtained varied erratically during the early part of the cure. This is not surprising as liquids do not support shear waves, but at some point a transition must take place. The shear response FFT for $t = 2$ days is plotted in Fig. 6b. A pair of 2.25-MHz transducers were used to accumulate these data. Again, as expected, multiple peaks of diminishing amplitude were observed. The thickness of this specimen was 10.25 mils. The position of the first non-zero maxima implies that $c_S = 0.022$ in./ μ s. More work involving the shear response will be required before consistent trends can be identified.

The value of c_L for the EPON 828/TETA system changed significantly as the specimen cured, so that the peak positions shifted as depicted in Fig. 7a, where plots for $t = 6.3$ min and $t = 96.3$ min are presented. The position of the primary longitudinal peak as a function of cure time is plotted as a solid line in Fig. 7b. It can be observed that the peak position, and hence longitudinal velocity, increased by $\sim 45\%$ during the first 6 hours of cure. The amplitude of the longitudinal FFT peaks also changed as a function of cure as indicated by the curve with open boxes in Fig. 7b. The amplitude change is not evident in Fig. 7a, because the data have been normalized. It can be seen that the amplitude decreased during the first 1.5 hours of cure, suggesting that the specimen became more attenuative to sound. The amplitude then rebounded, increasing to

slightly above its original value, before decreasing abruptly to a value which remained essentially constant for the last hour recorded.

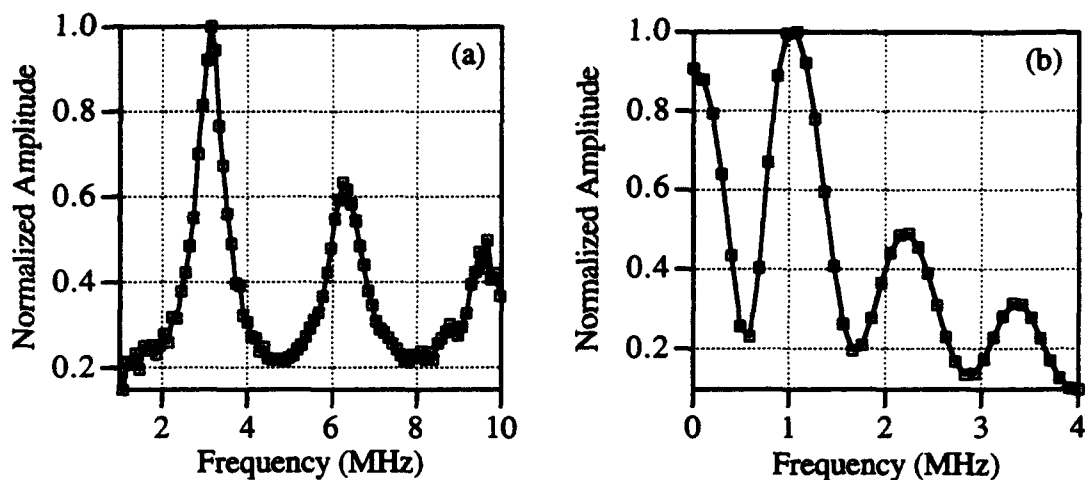


Figure 6. (a) Longitudinal response FFT of EPON 828/TETA mixture at $t = 14.5$ min. (b) Shear response FFT of EPON 828/TETA mixture at $t = 2$ days.

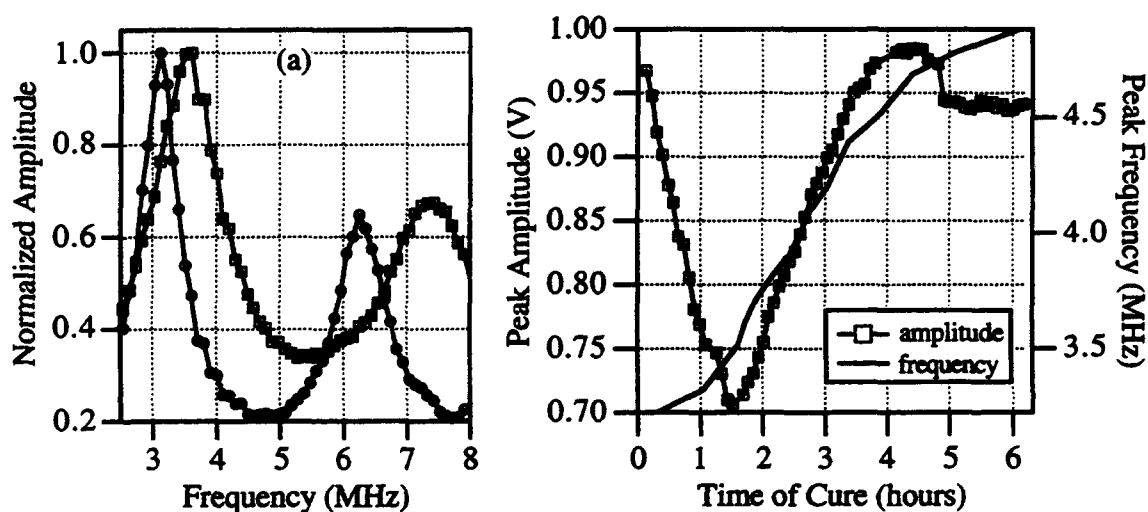


Figure 7. (a) Longitudinal response FFT at $t = 6.3$ min (circles) and $t = 96.3$ min (squares) and (b) the change in amplitude and resonant frequency as a function of t for an EPON 828/TETA specimen.

For comparative purposes, differential scanning calorimetry (DSC) was performed on a number of EPON 828 samples. By measuring the heat of reaction (ΔH) as a function of time beginning with the mix, one can estimate the degree of cure. The ΔH measured for a sample at $t = 0$ corresponds to 0% cure, and when $\Delta H = 0$ the system is considered 100% cured. Thus a plot of ΔH versus time provides a correlation between the degree of cure and time, which can then be applied to the peak amplitude and frequency versus time data (Fig. 7b). The ΔH measurements were performed on a Mettler DSC 30 with a Mettler TC 10A TA processor. The DSC results for a sample taken from the same mix as that which led to Fig. 7 are plotted in Fig. 8. Each data point in Fig. 8 was measured on a separate sample and represents the residual heat of reaction remaining in the sample at time x . For the EPON 828/TETA system there is a significant amount of heat generated as the two oxirane groups of the EPON 828 react with the amine group of the TETA (an aliphatic polyamine) to produce a three-dimensional, crosslinked network. This reaction occurs at room temperature (RT) and requires several days (at RT) or one to two hours at 100°C to reach complete cure.

In addition to DSC, a Rheometrics RDA II was employed to measure the epoxy system's viscosity, elastic modulus (G'), viscous modulus (G''), and damping or loss tangent ($\tan \delta = G''/G'$) as a function of time from initial mixing. The RDA measures these viscoelastic parameters in dynamic shear using a parallel-plate fixture. The measurements were made at a constant temperature of 27°C . The RDA II results, which are presented in Fig. 9, give insight into the behavior exhibited by the peak amplitude curve of Fig. 7b. As expected, the viscosity increases with time. This is due to the constant increase in molecular weight of the epoxy as crosslinking occurs. Similarly, G' and G'' (the real and imaginary parts of the dynamic shear modulus) increase with time. The G' begins its ascent at approximately the same time that the peak-amplitude curve of Fig. 7b exhibits a minimum. The slight difference in time is probably related to the fact that the ultrasonic measurements were performed at RT as opposed to 27°C . This same phenomenon is reflected as a maximum in the $\tan \delta$ curve and is most likely associated with the onset of crosslinking for the epoxy. The gel point is traditionally defined as the point at which G' and G'' cross.⁴ The dynamic mechanical testing was terminated at ~ 2.2 hours as the viscosity of the sample exceeded the torque limits of the instrument.

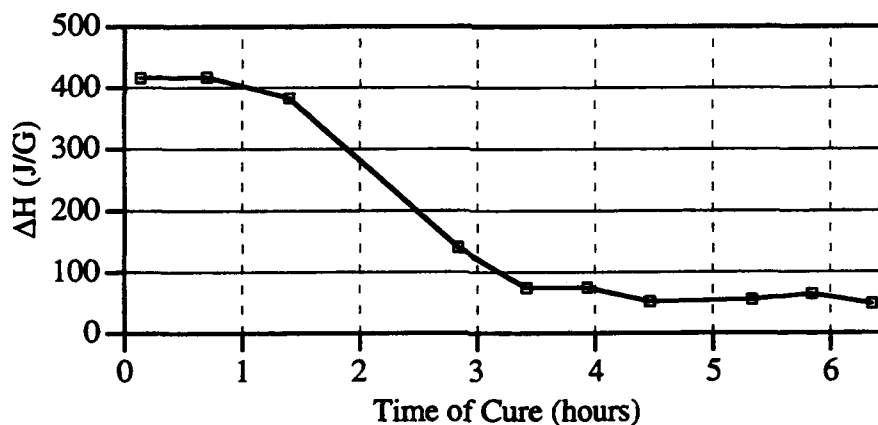


Figure 8. Heat of reaction (ΔH) versus time of cure for the same EPON 828/TETA mixture as that used for the data of Fig. 7.

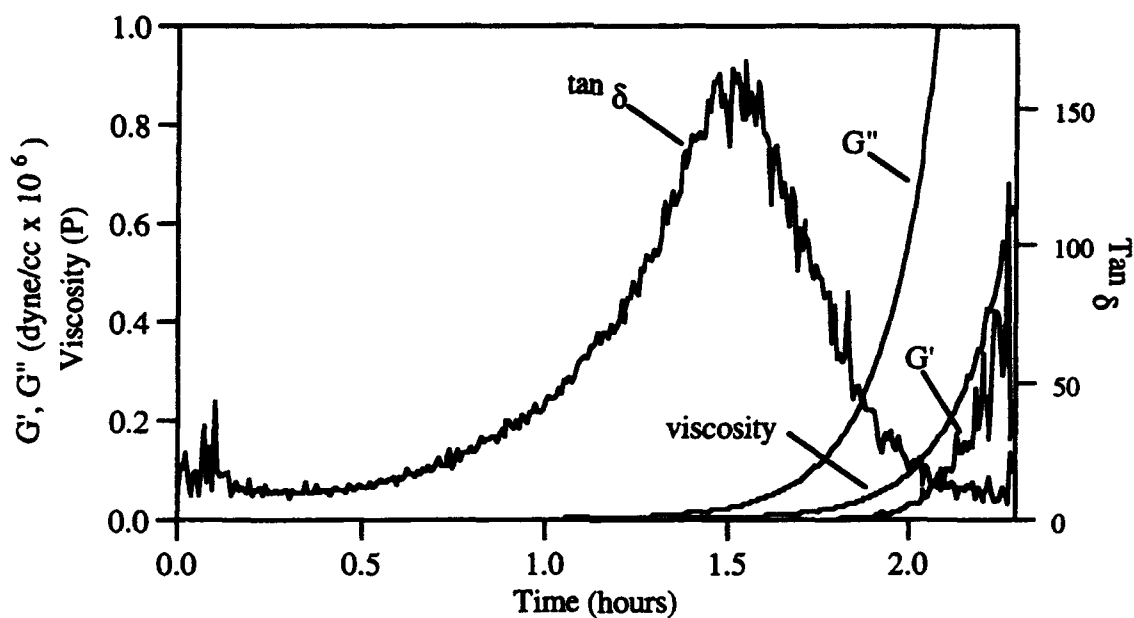


Figure 9. Viscosity, G' , G'' , and $\tan \delta$ vs time for the EPON 828/TETA mixture.

Finally, measurements were performed on HTPB inert-propellant specimens. The first difficulty encountered was that it was difficult to compress the material to form samples thinner than 10 mils. The longitudinal response FFT for a 10-mil specimen is plotted in Fig. 10a. Two peaks are clearly visible; the second riding on the tail of the first. The position of the primary peak implies that $c_L = 0.043$ in./ μs , a value $\sim 20\%$ slower than that of water. This value remained essentially constant as a function of cure, perhaps a reflection of the high solid content of the inert propellant. The amplitude of the primary peak did, however, vary significantly with cure time, as indicated by the plot depicted in Fig. 10b. The form of the plot is similar to that of the EPON 828/TETA mixture in that the amplitude decreases during the beginning stages of the cure and then rebounds to nearly its initial value. The results differ in that following the rebound, the signal drops monotonically, except for a curious upswing at $t_c \sim 30$ hours, to a lower value than that achieved in the early stages of the cure. Preliminary attempts to perform a DSC of the inert propellant were unsuccessful. This is attributed to the high filler content. For the purposes of thermal analysis, the filler, which has a high specific heat, absorbs energy and reduces the exotherm temperature. Additionally, because the DSC sample size is small, on the order of 20 mg, the filler has the effect of reducing the amount of material involved in the curing reaction, and thus reducing the exotherm. Measurements of the shear response of the inert propellant were less successful than those for the EPON 828/TETA mixture. Again, more work involving the shear response will be required before consistent trends can be identified.

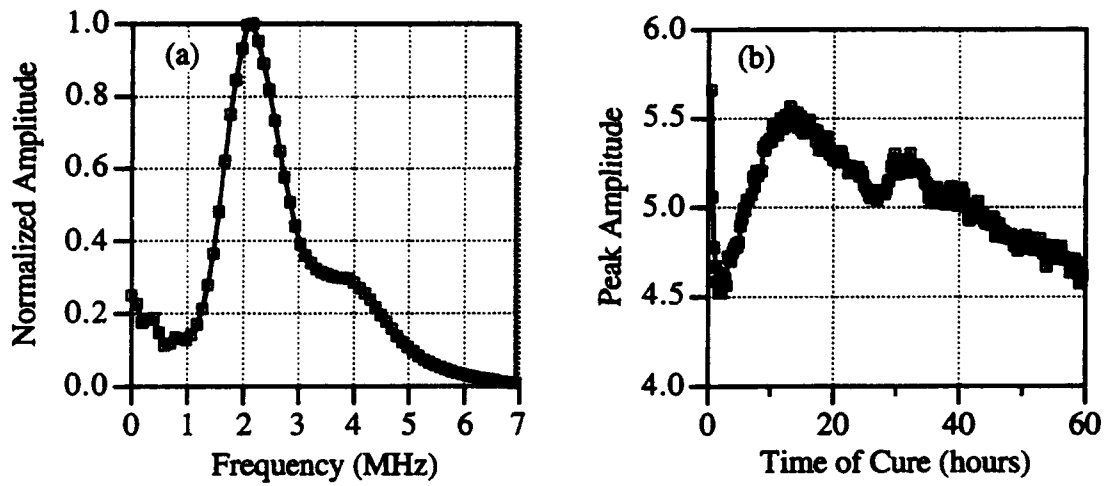


Figure 10. (a) Longitudinal response FFT and (b) the change in amplitude as a function of cure time for a HTPB inert propellant specimen.

DISCUSSION

The ultrasonic resonance technique described in this work exhibits potential as a means of monitoring the degree of cure as well as cure- and age-related mechanical property changes in polymers. Preliminary results indicate that the changes in the peak frequency (ultrasonic velocity) data can be correlated with the degree of cure and that the changes in the peak amplitude can be related to the results of dynamic mechanical tests. The results presented in this report suggest that SRM propellants are particularly difficult materials to characterize, especially in the frequency range employed in these tests. Much of the difficulty probably stems from the high solid content of the propellant. It may be prudent to perform similar tests on unfilled HTPB specimens. In addition, future tests (particularly for the shear mode) should be performed at lower frequencies and, perhaps, different temperatures.

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TECHNOLOGY OPERATIONS

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