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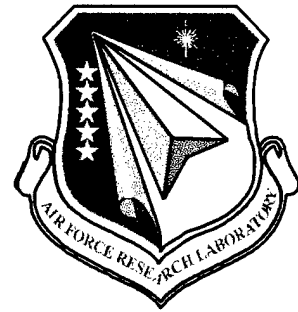
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AFRL-ML-TY-TR-1998-4541



## **CRYOGENIC SIZE REDUCTION OF SOLID PROPELLANT**

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**MAY 1992**

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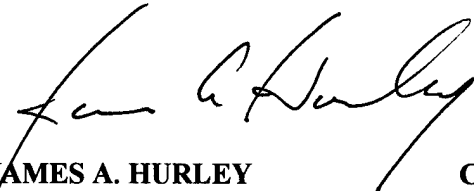
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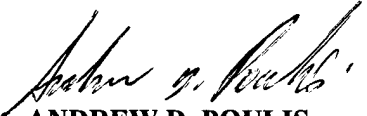
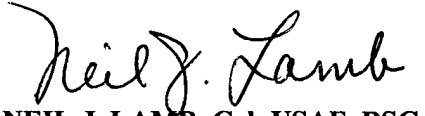
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## EXECUTIVE SUMMARY

General Atomics has performed laboratory, bench scale, and prototype tests to develop the dry washout concept for size reduction and removal of Class 1.1 double base and Class 1.3 composite propellants. Three propellant types were investigated: Class 1.1 composite modified double base (CMDB), Class 1.1 cross linked double base (XLDB), and Class 1.3 hydroxyl terminated polybutadiene (HTPB). In the laboratory tests (Task 1) standard methods were used to establish that essentially no change occurs in the sensitivity of the test propellants between ambient and cryogenic temperatures. The bench scale tests (Task 2) demonstrated the safety of cryogenic washout and established parameter ranges and test conditions for effective propellant removal. The prototype (Task 3) demonstrated cryogenic washout of several reduced scale rocket motors in a semi-automated process.

The Task 1 test consisted of impact, friction, low level shock, and electrostatic discharge sensitivity tests at ambient and cryogenic temperature. In addition, electrical properties, such as dielectric constant and volume resistivity, were measured at ambient and cryogenic temperatures. In all over 1000 sensitivity tests or measurements were made which showed little, if any, change between ambient and cryogenic temperatures. These results were used in a detailed hazards analysis of the Tasks 2 and 3 equipment to minimize hazards.

Throughout the Task 2 testing, in excess of 1000 separate propellant impacts with  $\text{LN}_2$  jets ranging in pressure from 10,000 psig to 16,500 psig. No initiations or reactions were detected. Propellant erosion rates were excellent with nominal removal rates of greater than 60 pounds per hour achieved for all three propellant types at an  $\text{LN}_2$  flow rate of less than 4 gallons per minute (gpm) through a single nozzle. A 200 scfm warm  $\text{GN}_2$  flow was used to augment the  $\text{LN}_2$  jet and prevent excessive cooldown of the propellant.

The best and worst propellant removal rates occurred during Task 3 testing using reduced scale rocket motors. Two motors were processed, one containing 40 pounds of XLDB propellant and another containing about 60 pounds of HTPB propellant. The most effective removal was during washout of the motor containing XLDB propellant. Thirteen thousand psig  $\text{LN}_2$  pressure, 3.9 gpm  $\text{LN}_2$  flowrate, and warm  $\text{GN}_2$  augmentation were used for this motor resulting in a mass removal rate of 156 pounds per hour. The worst removal rate occurred during washout of the motor containing HTPB propellant where removal rates varied from 8.3 to 23.3 pounds per hour. The propellant removal rates generally improved at higher  $\text{LN}_2$  jet pressures and with warm  $\text{GN}_2$  flow.

Carbon dioxide ( $\text{CO}_2$ ) pellets were also evaluated as an alternate to  $\text{LN}_2$  as a cryogenic medium.  $\text{CO}_2$  pellet blasting was tested on each of the three propellant types at supply pressures ranging from 250 to 600 psig with a  $\text{CO}_2$  flow rate of 150 pounds per hour. No initiations or reactions were detected. However, the mass removal rate was significantly worse than for high pressure  $\text{LN}_2$ . The most effective removal was observed during testing of HTPB propellant at 425 psig where the maximum cutting depth was 0.2 inches after a 38 second residence time on a 1 square inch area. This equates to a mass removal rate of 1.67 pounds per hour.

The test series demonstrated that cryogenic washout can be an effective means of solid propellant removal and size reduction. With modest scaleup to larger and/or multiple nozzles, propellant removal rates in excess of 500 pounds per hour could be achieved. Based on an  $\text{LN}_2$  price of about 25 cents per gallon, the demonstrated  $\text{LN}_2$  cost for propellant removal is about 0.38 dollars per pound of propellant removed. This should allow cryogenic washout to compete well with alternate processes which produce aqueous waste streams. Improvements are also needed in the warm  $\text{GN}_2$  system to extend the propellant removal rates of some propellant types such as HTPB.

Additional follow-on testing is recommended to establish the threshold initiation pressure for  $\text{LN}_2$  jet impingement, and to optimize key parameters such as jet pressure, surface speed, and  $\text{GN}_2$  augmentation effectiveness.

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## LIST OF ABBREVIATIONS, ACRONYMS, AND SYMBOLS

|                 |                                                                       |
|-----------------|-----------------------------------------------------------------------|
| AP              | ammonium perchlorate                                                  |
| CMDB            | composite modified double base                                        |
| CO <sub>2</sub> | carbon dioxide                                                        |
| CYH             | a specific type of CMDB propellant                                    |
| ESD             | electrostatic discharge                                               |
| FPC             | forty pound charge [40 pound motor filled with XLDB (WAY) propellant] |
| HMX             | cyclotetramethylenetetranitramine (an explosive)                      |
| HTPB            | hydroxyl terminated polybutadiene                                     |
| i.d.            | inside diameter                                                       |
| LAM             | 80 pound lightweight analog motor filled with HTPB (QDT) propellant   |
| LN <sub>2</sub> | liquid nitrogen                                                       |
| MNA             | N-methylnitroaniline                                                  |
| NC              | nitrocellulose                                                        |
| NG              | nitroglycerin                                                         |
| o.d.            | outside diameter                                                      |
| QDT             | a specific type of HTPB propellant                                    |
| TIL             | threshold initiation limit                                            |
| WAY             | a specific type of XLDB propellant                                    |
| XLDB            | cross linked double base                                              |
| 2-NDPA          | 2-nitrodiphenylamine                                                  |

## SECTION I

### INTRODUCTION

#### A. OBJECTIVE

A growing need exists to develop improved methods for the safe disposal and/or recovery of solid rocket propellants. Present methods generate waste streams that may limit or preclude their future use. Washout using a cryogenic medium has the potential to provide a safe, environmentally acceptable method of propellant removal and size reduction which eliminates aqueous waste streams. The objective of this program was to demonstrate the viability of the cryogenic washout process by performing safety tests and analyses, performing process development tests to establish effective process conditions, and demonstrate cryogenic washout of reduced scale rocket motors in a semiautomated process.

#### B. BACKGROUND

The most common methods presently used for removal and/or disposal of propellant from rocket motors are open burning, static firing, and water washout. Open burning and static firing are both cost effective methods of disposal, but environmental and public safety issues may limit their further use.

High pressure water washout of ammonium perchlorate (AP)-based propellants (Hazard Class 1.3) from solid rocket motors has been used to recover motor casings and AP, but the process produces aqueous waste streams which are hazardous and costly to dispose of. Consequently, improved methods are needed that remove and size reduce propellants, while minimizing the associated hazards and waste streams.

Cryogenic washout has been proposed as a means to remove and size reduce solid rocket propellants while eliminating aqueous waste streams. In this process, a cryogenic medium such as  $\text{LN}_2$  is used to remove the propellant from the inside of a solid rocket motor. The inert medium evaporates, eliminating waste streams. Subsequently, the propellant fragments can be fed to a recovery or disposal process. Cryogenic washout is expected to offer improvements in safety, waste minimization, protection of surface and groundwater, and control of air pollution.

### C. SCOPE

The test program has been structured in three tasks: Task 1 was performed to determine the variation in propellant sensitivity for the three propellant types (HTPB, XLDB AND CMDB) at cryogenic temperatures (-109°F and -320°F). Task 2 was carried out to determine the safety of cryogenic washout of propellant using small samples, to establish process parameters for effective removal and size reduction of propellant, and to verify the adequacy of the process equipment design and safety measures. Task 3 demonstrated cryogenic washout of subscale rocket motors using process parameters and procedures established during Task 2. All tasks were performed first with inert propellant samples prior to live propellant operations. All live propellant testing was performed remotely. All testing was performed in accordance with the Test Plan (Reference 1). Test activities were performed in accordance with General Operating Procedures (Reference 2). Test observations and data were recorded in the Test Logs (Reference 3) and Data Sheets (Reference 4).

Subcontractors contributing to the test program were Hercules Incorporated, Magna, Utah, and El Dorado Engineering of Salt Lake City, Utah.

## SECTION II

### TEST REQUIREMENTS

#### A. TASK 1: PROPELLANT SENSITIVITY TESTING

Propellant sensitivity testing was performed to determine the change in sensitivity of propellants to various stimuli at cryogenic temperatures (Reference 5). This task was performed prior to the Task 2 (bench scale) and Task 3 (prototype) propellant tests. Specific Task 1 test requirements were as follows:

- Determine the sensitivity of QDT (HTPB propellant), WAY (XLDB propellant), and CYH (CMDB propellant) to impact, friction, electrostatic discharge (ESD), and low level shock at -109°F, -320°F and ambient temperatures.
- Determine the sensitivity of the three propellants to impact, friction, ESD, and low level shock after repeated cycling to -109°F and -320°F.
- Determine the extent of electrical properties changes for all three propellants at -150°F.
- Determine the extent (if any) of nitroglycerin crystallization or migration and/or stabilizer depletion that might occur during planned Task 2 testing with the XLDB and CMDB propellants.

#### B. TASK 2: BENCH SCALE TESTS

Test were performed with two cryogenic media - LN<sub>2</sub> and CO<sub>2</sub> pellets.

##### 1. LN<sub>2</sub> Washout

Task 2 propellant washout tests using an LN<sub>2</sub> jet were planned to be performed on both inert and live propellant samples. Propellant types were the same as for Task 1. Requirements for this testing were:

- Develop a high pressure LN<sub>2</sub> system to achieve a high quality LN<sub>2</sub> jet.
- Verify that no initiations or reactions occur over the range of LN<sub>2</sub> test pressures for any of the three test propellants.
- Determine effective process parameters such as LN<sub>2</sub> pressure, LN<sub>2</sub> flowrate, and propellant surface speed to maximize propellant removal effectiveness for each propellant type.

## 2. CO<sub>2</sub> Pellet Blasting

CO<sub>2</sub> pellet blasting is a relatively new method for removal of paint and surface contaminants and was considered as a possible alternative method for cryogenic washout of solid propellant. Test requirements for the CO<sub>2</sub> pellet blasting were:

- Verify that propellant initiation or reactions do not occur during CO<sub>2</sub> pellet blasting for all three propellant types.
- Determine the propellant removal effectiveness of CO<sub>2</sub> pellet blasting for a range of delivery pressures.

## C. TASK 3: PROTOTYPE TESTS

Task 3 was planned to demonstrate cryogenic washout of two reduced scale rocket motors containing propellant types tested in Tasks 1 and 2 using process parameters (i.e., LN<sub>2</sub> nozzle design, LN<sub>2</sub> pressure, LN<sub>2</sub> flowrate, GN<sub>2</sub> propellant heater design, surface traverse speed, and nozzle standoff distance) developed during the Task 2 bench scale tests. The primary requirements of the Task 3 were:

- Demonstrate that the process parameters established during Task 2 could be applied to remove propellant from reduced scale rocket motors safely and efficiently.
- Verify that the test rig design features are adequate for the safe handling of propellant particles during cryogenic washout operations.
- Demonstrate that propellant particles generated during the cryogenic washout can be safely removed from the gas stream and collected for further processing.

### SECTION III

#### METHODOLOGY

##### A. TASK 1: PROPELLANT SENSITIVITY TESTING

A variety of sensitivity and electrical properties characterization tests were performed for Task 1 on HTPB, CMDB, and XLDB propellants at ambient temperature, cryogenic temperatures, and at ambient temperature following cyclic exposure to cryogenic temperatures. Table 1 shows the test matrix for Task 1. Four different sensitivity test series were performed to measure: (1) impact sensitivity, (2) friction sensitivity, (3) electrostatic discharge (ESD) sensitivity, and (4) low level shock sensitivity. Additionally, electrical properties tests were performed to determine the effects of cryogenic temperatures on volume resistivity, dielectric constant and dielectric breakdown. Tests were initially performed at ambient temperature to establish baseline data. Data at cryogenic temperatures and for temperature cycled propellant were then compared to the baseline data to determine the relative change in propellant sensitivity or electrical properties. Temperature cycling tests were planned to determine if sensitivities increased because of nitroglycerin (NG) migration. Since HTPB propellant contains no NG, temperature cycling tests were not performed on this propellant.

Probit analysis was used for all but low level shock sensitivity tests to determine by statistical methods the probability of initiation at a given energy level. For probit analyses, a sample is initially tested at a selected energy level. If no reaction is observed, the test is repeated at a higher energy level. If a positive reaction is detected, the input energy is decreased incrementally until no reaction is observed in twenty consecutive trials. The highest energy level at which no initiations occur is called the threshold initiation level (TIL). Ten trials are then conducted at each of four energy levels above the TIL, and the number of initiations at each level is determined. This quantal (all or nothing) propellant sample initiation data is then analyzed using statistical methods. These methods assume that the percentage of samples that initiate will increase in a fixed ratio as the magnitude of the energy input is increased. A linear regression equation is then used to describe the probability of response to the given stimulus from the measured regime to an extrapolated regime. The extrapolated regime represents the probability of initiation at low energy inputs. Probit analysis is further described in Reference 5.

TABLE 1. TASK 1 TEST MATRIX

| TEST                                   | SLICED PROPELLANT |      |      |      |      | TEMP. CYCLED SLICED PROP. |  | HAND GROUND PROP. |   |
|----------------------------------------|-------------------|------|------|------|------|---------------------------|--|-------------------|---|
|                                        | CMDB              | XLDB | HTPB | CMDB | XLDB | CMDB                      |  | CMDB              |   |
| <u>SENSITIVITY TEST</u>                |                   |      |      |      |      |                           |  |                   |   |
| Impact (Ambient)                       | X                 | X    | X    | X    | X    |                           |  | X                 | X |
| Friction (Ambient)                     | X                 | X    | X    | X    | X    |                           |  | X                 | X |
| ESD (Ambient)                          | X                 | X    | X    | X    | X    |                           |  | X                 | X |
| Low Level Shock (Ambient)              | X                 | X    | X    |      |      |                           |  |                   |   |
| Impact (-109°F)                        | X                 | X    | X    |      |      |                           |  |                   |   |
| Impact (-320°F)                        | X                 | X    | X    |      |      |                           |  |                   |   |
| Friction (-109°F)                      | X                 | X    | X    |      |      |                           |  |                   |   |
| ESD (-109°F)                           | X                 | X    | X    |      |      |                           |  |                   |   |
| ESD (-320°F)                           | X                 | X    | X    |      |      |                           |  |                   |   |
| Low Level Shock (-320°F)               | X                 | X    | X    |      |      |                           |  |                   |   |
| <u>ELECTRICAL PROPERTY MEASUREMENT</u> |                   |      |      |      |      |                           |  |                   |   |
| Dielectric Breakdown (Ambient)         | X                 | X    | X    | X    | X    |                           |  | X                 | X |
| Volume Resistivity (Ambient)           | X                 | X    | X    | X    | X    |                           |  | X                 | X |
| Dielectric Constant (Ambient)          | X                 | X    | X    | X    | X    |                           |  | X                 | X |
| Dielectric Breakdown (-150°F)          | X                 | X    | X    | X    | X    |                           |  |                   |   |
| Volume Resistivity (-150°F)            | X                 | X    | X    | X    | X    |                           |  |                   |   |
| Dielectric Constant (-150°F)           | X                 | X    | X    | X    | X    |                           |  |                   |   |
| Taliani Compatibility (Ambient)        | X                 | X    | X    | X    | X    |                           |  |                   |   |
| DSC Compatibility (Ambient)            | X                 | X    | X    | X    | X    |                           |  |                   |   |

Impact sensitivity tests determined the likelihood of propellant initiation as a result of an impact by a moving mass. In this test (conducted on a modified Bureau of Mines Tester), a 0.033 inch thick by 0.5 inch diameter propellant sample is compressed between a fixed anvil and a movable hammer, as shown in Figure 1. Impact energy (measured in energy per unit area) is supplied to the hammer by a 2 kilogram variable drop height weight. The hammer (which has a known contact area) was positioned above the sample, and the weight was dropped from a predetermined height. Sample initiation was detected by sound and/or sight. Sample cooling was performed using LN<sub>2</sub> just prior to each trial. Propellant sample temperature was measured using thermocouples.

Friction sensitivity tests determined the probability that a sample will initiate when subjected to a sliding friction force at a given velocity. In this test, the propellant sample was placed on an anvil and a known force was applied hydraulically as shown in Figure 2. A pendulum then slid the sample under the force at constant velocity, resulting in a friction energy input to the sample. Sample initiation was again detected by audible and/or visual means.

ESD sensitivity tests determined the probability of propellant initiation in response to a spark discharge at a prescribed energy level. Electrostatic energy stored in a charged capacitor at 5,000 Volts was discharged from a needle lowered towards the sample. Different capacitors were used to vary the energy delivered to a sample. Initiation was detected by infrared measurement of propellant decomposition products.

Low level shock sensitivity tests measured the sensitivity of propellants to explosive shock. For these tests, a 2 inch long by 3 inch diameter propellant sample was placed in a 1.25 quart stainless steel cylindrical pot. A circular piece of Detasheet explosive was used as an explosive donor, and shock attenuation was provided by various thicknesses of stainless steel sheets. The shock impacted the sample through the bottom of the pot. Samples were cooled with LN<sub>2</sub> as required.

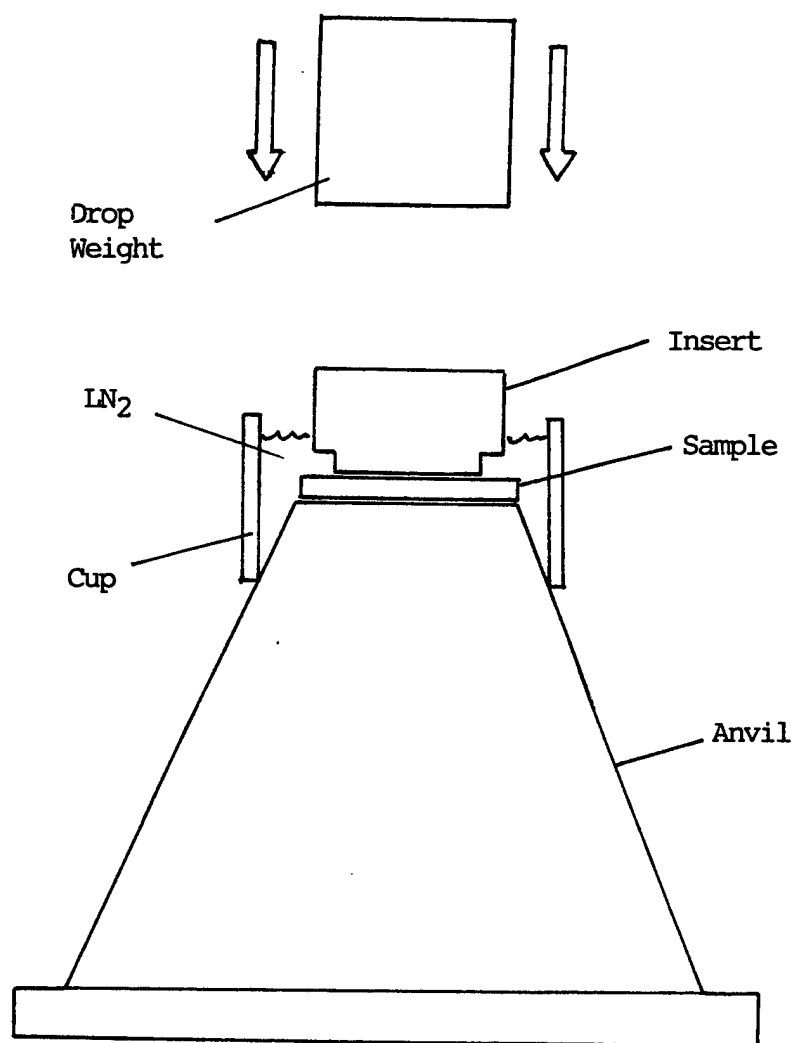


Figure 1. Task 1 Low Temperature Impact Sensitivity Test Configuration

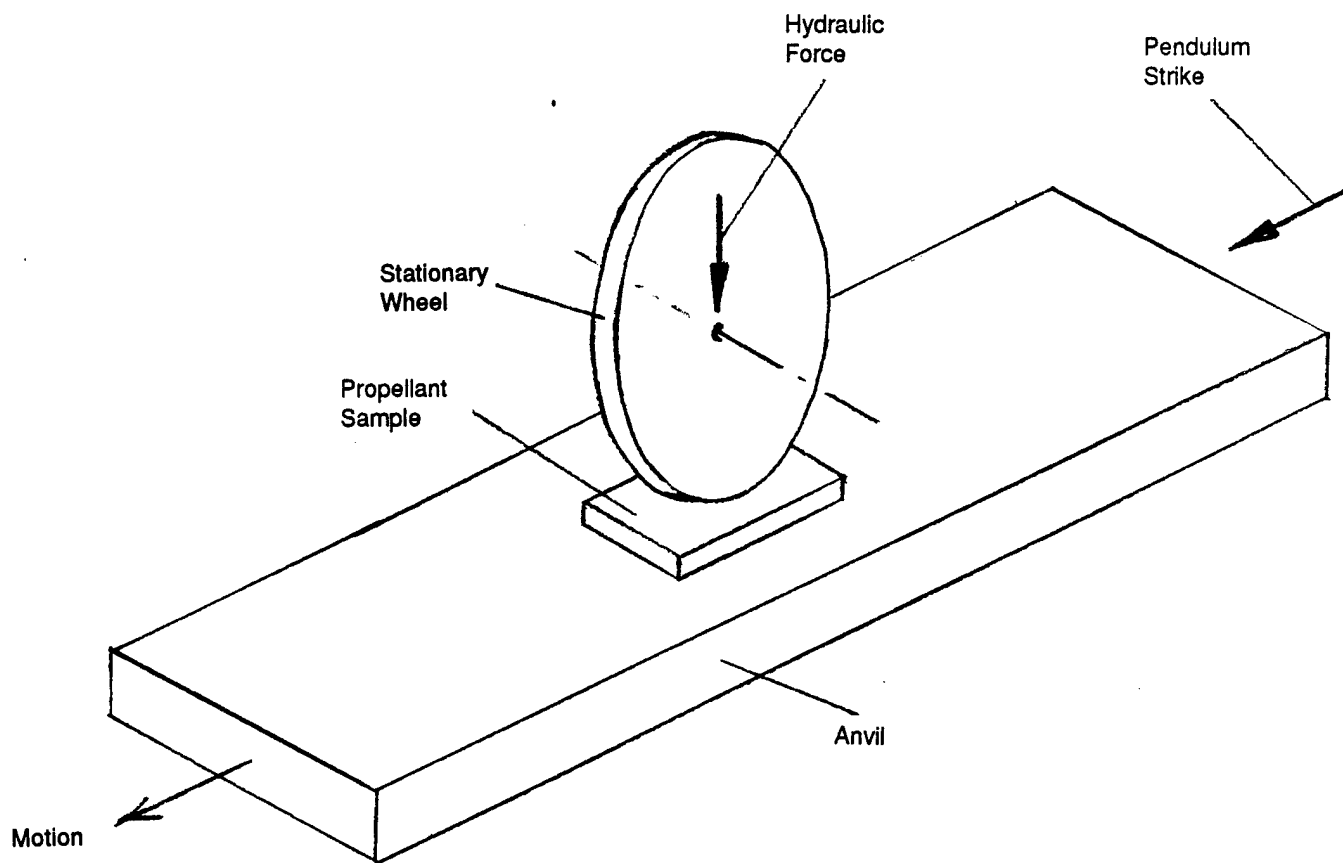


Figure 2. Task 1 Friction Sensitivity Test Configuration

## B. TASKS 2 AND 3 TEST FACILITY

Tasks 2 and 3 were conducted using a common test rig that was adaptable to both  $\text{LN}_2$  washout and  $\text{CO}_2$  pellet blasting of propellant samples as well as  $\text{LN}_2$  washout of a forty pound charge motor (FPC) and lightweight analog motor (LAM). Initial assembly and debugging of the test rig was done at GA facilities in San Diego, CA. as was early  $\text{LN}_2$  system development and initial  $\text{LN}_2$  washout testing (performed on inert propellant). Bench scale (Task 2) and Prototype (Task 3) testing was conducted at the Pit 38, site 2 explosive test facility at Hercules Inc. in Magna, Utah. The test equipment was shipped to the test facility and assembled as shown in Figure 3. This facility included an area to locate the test rig surrounded by a 20 foot high horseshoe shaped dirt berm and covered by a heavy wooden blast mat. These were designed to contain both overpressure and debris in the event of an explosion. Propellant sample preparation was done in a dedicated building in another adjacent bermed area. Next to the bermed areas was a control bunker from which all testing was conducted remotely. Hazards analysis of the Task 2 and Task 3 testing showed that proper protection would be provided for personnel in the control bunker in the event of an explosion.

The cryogenic size reduction test equipment consists of a washout test rig, high pressure  $\text{LN}_2$  supply system or  $\text{CO}_2$  pellet supply system, warm gaseous nitrogen ( $\text{GN}_2$ ) supply equipment, and a gas cleanup system which ensures proper containment of washed out propellant. Figure 4 shows a process schematic for the  $\text{LN}_2$  washout system.

The washout test rig (Figure 5) consists of the washout enclosure and knockout pot (both mounted on a remotely operated computer controlled X-Y table), rotary drive equipment, an  $\text{LN}_2$  lance/nozzle assembly, and a  $15^\circ$  inclined support stand on which the test rig is mounted. At both ends of the washout enclosure are rotors between which either bench scale propellant samples or subscale rocket motors can be mounted for propellant washout. The rotor between the washout enclosure and knockout pot (named the drive rotor) is driven by an DC electric motor at speeds from 0-38 rpm. Pin connections between the article to be washed out and both rotors ensure that the drive rotor, idler rotor, and propellant sample rotate as an assembly. The  $\text{LN}_2$  lance extends into the washout enclosure through the idler rotor and provides structural support for the  $\text{LN}_2$  nozzle mounted at the end of the lance. The  $\text{LN}_2$  jet is about 0.035 inch diameter, depending on the nozzle installed. The jet points out of the side of the lance and impinges onto the propellant at  $15^\circ$  from perpendicular.



Figure 3. Tasks 2 and 3 Cryogenic Size Reduction Test Equipment at Hercules, Inc.

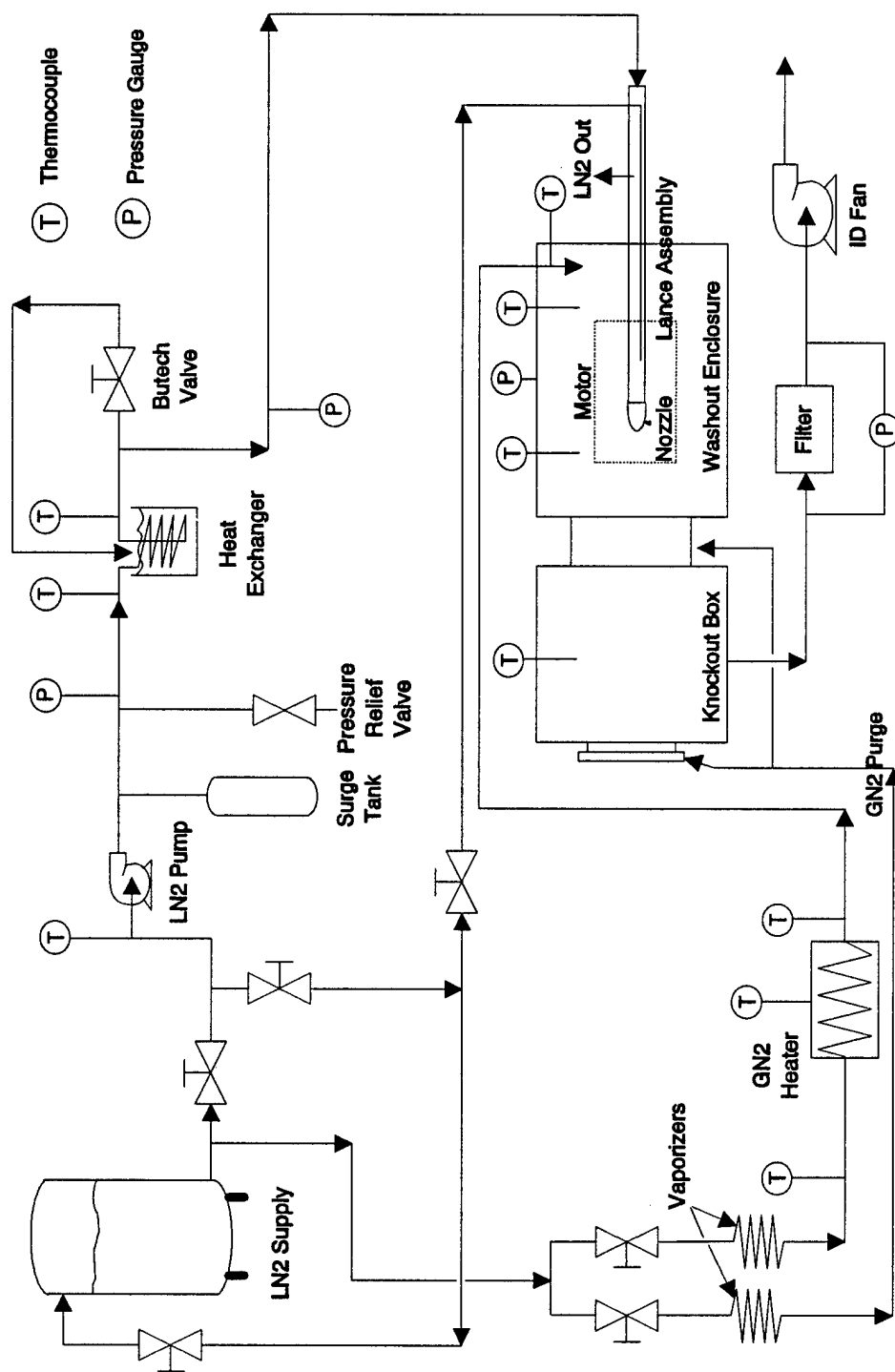


Figure 4. Tasks 2 and 3 LN<sub>2</sub> Washout System Process Schematic

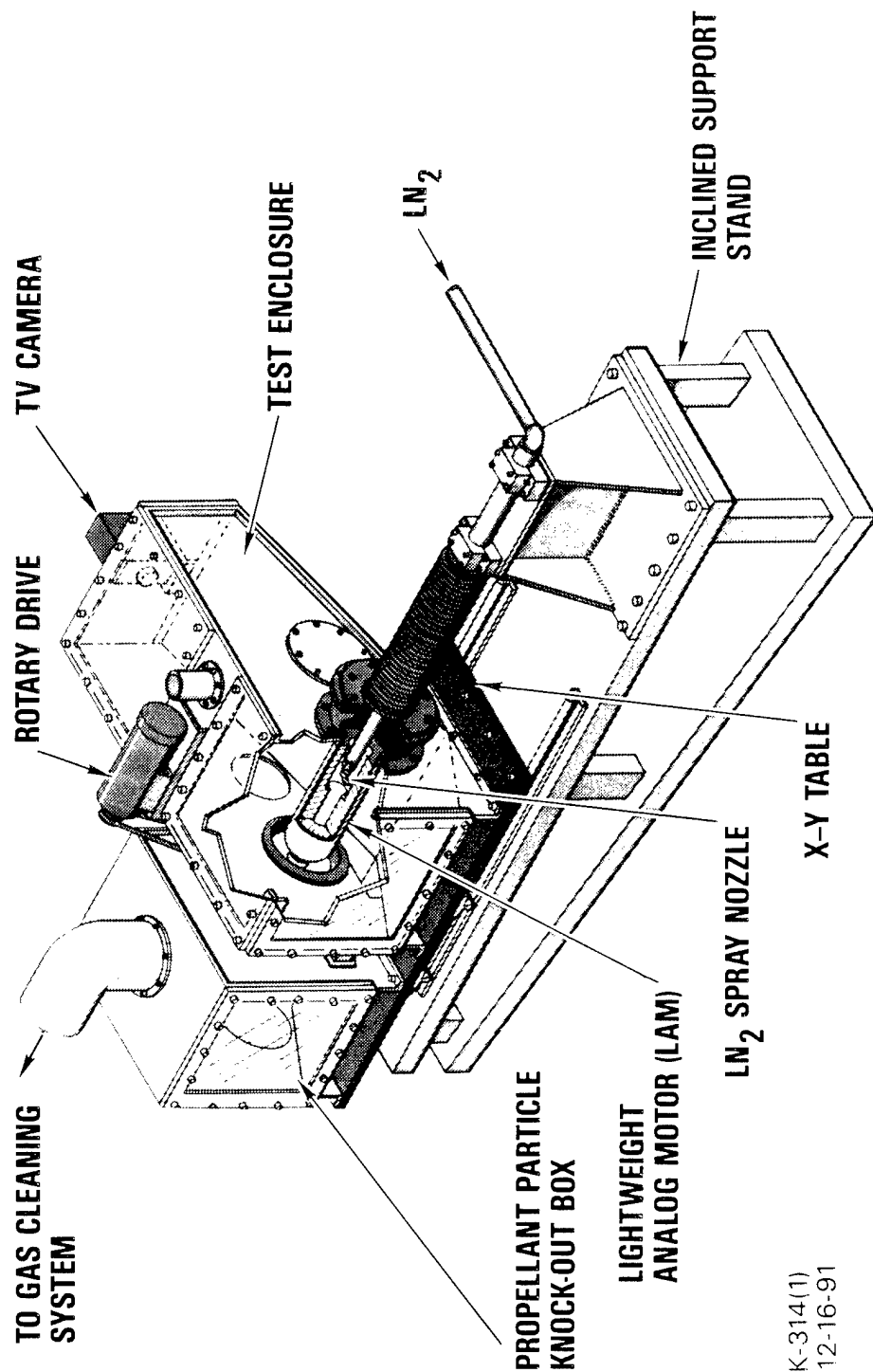


Figure 5. Tasks 2 and 3 Cryogenic Washout Test Rig

The lance is not mounted on the X-Y table. The X-Y table therefore provides relative motion between a rotating propellant sample and the LN<sub>2</sub> nozzle. Cutting on the sample is done by rotating the sample in front of the LN<sub>2</sub> jet while the X-Y table slowly moves the jet across the sample.

The washout enclosure walls and roof are made primarily of transparent polycarbonate panels to allow external viewing of the rotating assembly and LN<sub>2</sub> lance. These walls are made strong and stiff enough so that the enclosure can be held at 2.0 inches of water vacuum. The floor of the washout enclosure and knockout pot was shaped so that propellant particles all tended to slide to a low spot at the knockout pot. This was facilitated by the inclination of the test rig. A port was installed at the low spot to allow faster cleanout of the enclosures. A closed circuit television (CCTV) camera was mounted on an extension of the washout enclosure to allow remote monitoring of sample rotation and X-Y table function. Another CCTV camera was mounted on a pole adjacent to the site, and was used to monitor the entire facility.

Test rig components were designed for cryogenic service if required by their operating temperature. The test rig mechanical design was heavily driven by relative thermal contraction issues and cold bearing friction concerns. Materials selection was made to preclude component embrittlement. All cryogenic issues were resolved satisfactorily during the test rig design.

In addition, the test rig design was strongly influenced by the safety requirements for the design of machinery exposed to propellant. Key design issues were that threaded fasteners were highly undesirable. Grinding of all welds to a smooth finish was required, and sliding motion of metal components relative to one another was prohibited.

The high pressure LN<sub>2</sub> supply system consisted of a 3000 gallon LN<sub>2</sub> tank, a reciprocating LN<sub>2</sub> pump adjacent to the LN<sub>2</sub> tank, 125 feet of 20,000 psig rated cryogenic tubing, a coil of high pressure tubing immersed in an open bath of LN<sub>2</sub>, and an air operated bypass valve. The LN<sub>2</sub> tank and pump were located to the south of the test rig, outside of the bermed area. 5/16 inch i.d. tubing that ran over the berm to the high pressure coil was wrapped with commercial foam piping insulation, as was the 2-inch diameter copper pipe between the tank and pump. The air operated bypass valve was located at the connection to the LN<sub>2</sub> lance. When open, this valve diverted flow from the nozzle to the open bath. The bypass valve allowed the bath to be filled before starting washout operations, as well as cooling the pump discharge line.

Two pressure indicators were fitted to the LN<sub>2</sub> system: a gauge at the discharge of the pump, and a pressure transducer at the LN<sub>2</sub> lance. Both were rated to 20,000 psig service.

The cryogenic pump purchased for washout testing could be set to deliver either 1.83, 2.34, 3.40, or 3.92 gpm by changing the drive motor pulley. Therefore, the flow rate was constant for a given test. It was crucial to ensure that the feed to the pump was single-phase, i.e. liquid. If the liquid temperature was high enough, the suction side pressure drop could reduce the liquid pressure until a portion of the liquid within the pump boiled. This condition is called partial cavitation. The consequences of pump cavitation were potential pump damage, partial or total loss of system pressure, and significant fluctuations in pressure during operation. Therefore, steps were taken to ensure that pump cavitation was avoided to the greatest extent possible, the most significant step being LN<sub>2</sub> supply tank venting and repressurization. Early testing confirmed the need to routinely vent the LN<sub>2</sub> supply tank, and this procedure was followed prior to each day of testing.

By varying the pressure of the LN<sub>2</sub> supply tank prior to the start of a test, it was possible to take advantage of a high supply pressure while still delivering a low temperature liquid. The procedure involved took advantage of the fact that the liquid can be cooled relatively quickly but warmed relatively slowly. The supply tank was vented to atmospheric pressure and the contents boiled, eventually reaching a low equilibrium temperature associated with the lower pressure. Prior to a test, the tank was repressurized to the desired supply pressure (about 35 psig) using an external buildup coil. The repressurization took several hours. Warming of the LN<sub>2</sub> back to equilibrium temperature at the higher pressure, however, took several days because of the efficient tank insulation. If testing continued for successive days, blowdown of the supply tank required significantly less time, relative to blowdown with the tank initially at equilibrium, and the associated LN<sub>2</sub> usage was less.

If at equilibrium at 35 psig, approximately 13 percent of the tank volume would be lost while venting to atmospheric pressure. LN<sub>2</sub> use due to tank blowdown was not 13 percent for each test day, however, because the LN<sub>2</sub> storage temperature did not have time to rise to equilibrium between successive days of testing.

As delivered, the cryogenic pump was rated for a continuous working pressure of 10,000 psig. Soon after testing started, it became evident that significantly higher pressures would be required to achieve acceptable propellant removal rates. The pump manufacturer was contacted about the

feasibility of operating the pump at 16,000 psig and responded with a cautious approval for short duration testing. The cold end (fluid contacting portion) of the pump was rated for 15,000 psig, but the warm end was rated for only 10,000 psig. However, the warm end could tolerate high pressures and accompanying high loads for an unspecified period of time. Pressures up to about 14,000 psig were used at GA and up to 16,500 psig at Hercules.

During CO<sub>2</sub> pellet blasting operations the LN<sub>2</sub> equipment was not used. Instead, commercial CO<sub>2</sub> blasting equipment was installed on the test rig. Other equipment, such as the gas cleanup and data acquisition systems were unmodified. CO<sub>2</sub> pellet blasting equipment was originally developed in order to offer an environmentally acceptable and clean alternative to chemical or grit blasting removal of surface coatings or contamination. In principle the system operates in a similar way to grit blasting equipment: A 250-600 psig GN<sub>2</sub> source is connected with flexible hoses to a blasting gun from which the gas exits at high velocity. The GN<sub>2</sub> source for this testing was three tube trailers, each containing ninety-six compressed gas cylinders. These trailers were parked adjacent to the LN<sub>2</sub> tank, outside of the bermed area. Inside the blasting gun the high velocity gas stream passed through a venturi which was used to pull a low velocity gas stream along a second flexible hose. The low velocity gas stream contained the CO<sub>2</sub> pellets which were accelerated by the high velocity gas stream before they impacted the surface to be cleaned. The pellets were metered into the low velocity stream from a hopper. The metering equipment and hopper were mounted on a skid that was installed adjacent to the test rig, within the bermed area.

The warm GN<sub>2</sub> supply equipment used during LN<sub>2</sub> washout testing consisted of two ambient LN<sub>2</sub> vaporizers connected in parallel to the LN<sub>2</sub> tank and installed just east of the tank, 2 inch PVC tubing running over the berm to a temperature controllable electric heater located adjacent to the test rig, and a 2 inch copper pipe at the discharge of the electric heater. This pipe was connected with a flexible hose to the Task 2 and Task 3 propellant heater systems installed on the test rig. The discharge of the warm GN<sub>2</sub> system was 200 scfm at approximately 200°F. In order to ensure that the discharge temperature remained within limits a redundant control system was installed that shut off power to the electric heater if the gas temperature at the entrance to the test rig rose over 220°F.

The gas cleanup system incorporated a Torit 2DF4 dust collector unit with four cartridge filters totaling 904 square feet area, and an exhaust fan driven by a 7.5 hp electric motor. Installed between the dust collector filters and the exhaust fan was an Autolok high efficiency (95 percent) filter designed to preclude propellant particles from impacting the fan if the dust collector filters ruptured.

Maximum gas flow for this unit was 2000 scfm. The dust collector unit was installed on a platform built up from railroad ties and installed to the north of the test rig, within the bermed area. The connection between the test rig and the dust collector was made by a inexpensive 10 inch diameter flexible aluminum duct purchased at a building supply center. This allowed for motion of the test rig on the X-Y table. At the connection of the flexible duct to the dust collector a dampered inlet allowed ambient air into the gas stream to raise the temperature of the cold gas coming from the test rig. The exhaust of the dust collector was also dampered. The dampers were adjusted to maintain washout enclosure pressure below -1.0 inch wc for all  $\text{LN}_2$  flows, while maintaining dust collector inlet temperature above  $-20^\circ\text{F}$ .

The Torit dust collector unit was modified extensively to be suitable for use with propellant dust. Modifications included eliminating crevices and cracks that could collect dust, and eliminating all threaded fasteners from inside the contaminated area. Beneath the unit a "slum pot" was installed that collected dust. This dust was knocked off the cartridge filters by a blowback system that pulsed the filters with compressed air every 30 seconds. This precluded plugging of the filters. Photohelic gauges were installed at the test rig to monitor washout enclosure pressure and cartridge filter pressure drop. If these parameters moved out of limits an alarm signal was activated on the data acquisition computer (DAS).

Transient data from thermocouple, and pressure inputs were collected on the computer-based DAS. The Cryogenic Size Reduction DAS consisted of: (1) three Metrabyte EXP-16 signal conditioning boards (48 possible channels), (2) a DAS-8 controller, and (3) a Datel 386SX personal computer and monitor. All DAS equipment was located in the control bunker. Data were continuously displayed on the color monitors and updated every 5 seconds. Data were stored on hard disk every 5 seconds.

## C. TASK 2: BENCH SCALE TESTS

### 1. LN<sub>2</sub> Washout

Task 2 was designed to confirm using small propellant samples that no initiations would occur during propellant removal, develop process parameters for efficient removal and size reduction, and verify the adequacy of safety measures. To perform these functions a Task 2 mandrel was designed to fit between drive and idler rotors in the washout test rig. Small samples of propellant could then be mounted on the mandrel, which would rotate to allow washout of the samples. The configuration is arranged such that the LN<sub>2</sub> jet is directed radially inward against a sample that is installed on the circumference of the Task 2 mandrel. The mandrel is effectively a rocket motor turned inside out; however, the radially inward jet direction requires a different idler rotor than that for rocket washout (Task 3). The mandrel design (shown in Figure 6) incorporates three wedge shaped slots at 120° into which propellant samples (like those shown in Figure 7) slide and are held in position. Propellant samples were mounted into one of the three slots for each trial. Three slots were incorporated in case it was necessary to wash out three propellant samples simultaneously for good propellant removal data, but this did not prove necessary. The entire Task 2 mandrel was fabricated from aluminum.

Task 2 was divided into two subtasks: Tasks 2A and 2B. Task 2A was originally planned to be conducted with small cubes of propellant installed in a hole on the Task 2 mandrel circumference. This did not work because the cubes of propellant were popped out of the hole by the jet. The solution to this problem was to make 3/4 inch long trapezoid section wedges to fit into the Task 2 mandrel slots and be held in place by a 4 inch long inert sample as shown in Figure 6. Cutting was done on the center 1/2-inch of the 3/4-inch long sample. Task 2B samples fit into the same slots as the Task 2A samples but cut length was 3 inches on longer (4-inch) propellant samples. Both Tasks 2A and 2B were originally planned to be conducted with wooden mandrels that would be replaced after each trial. This was done in an effort to match the erosion of the mandrel with the erosion of the propellant sample, and thereby limit the influence of edge effects on propellant washout data. However, it was determined that the wooden mandrels were heavily damaged by the LN<sub>2</sub> jet, and an aluminum mandrel was substituted. The aluminum mandrel was not damaged by the jet and was used for all Task 2 trials.

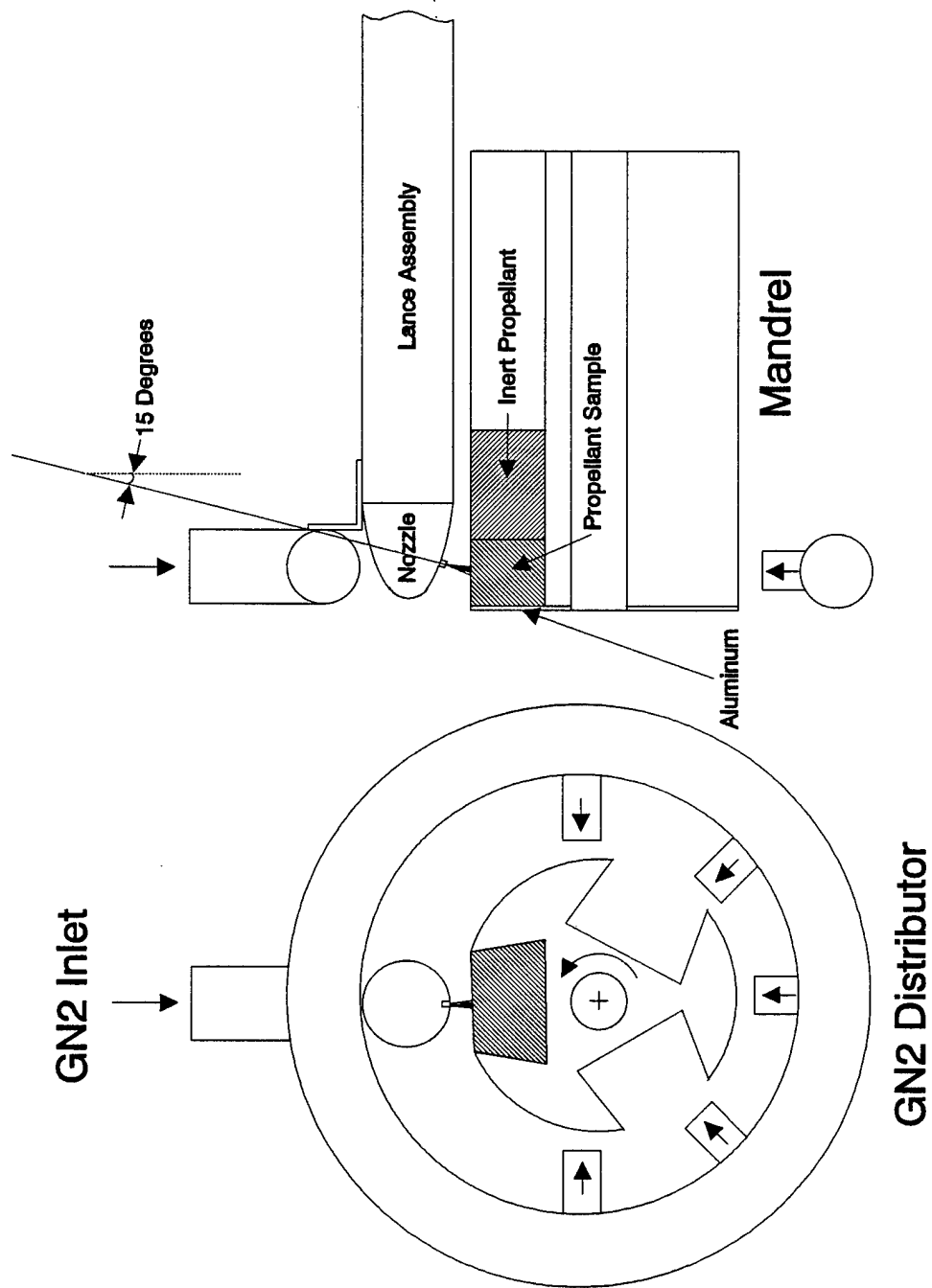


Figure 6. Task 2 LN<sub>2</sub> Washout Configuration

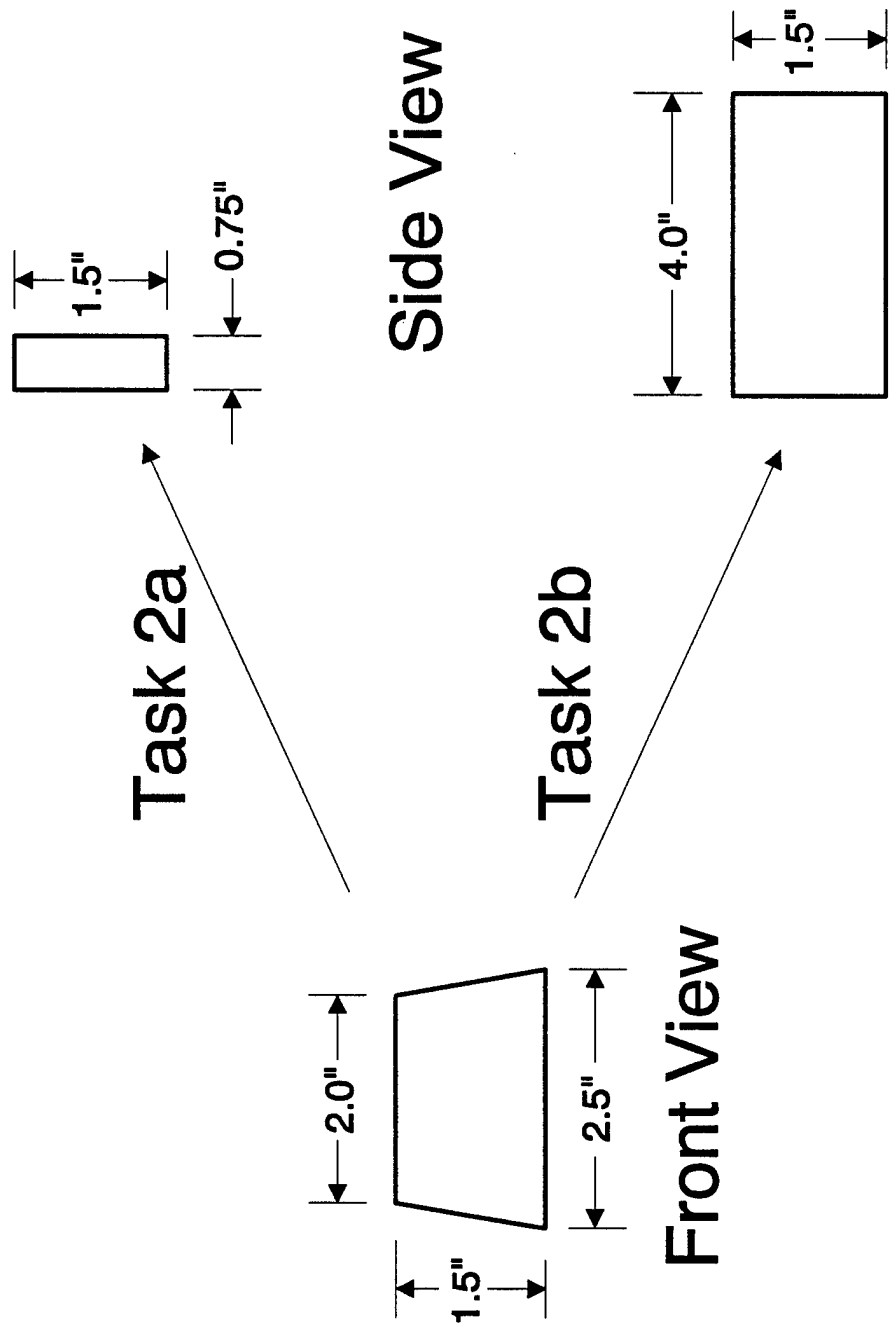


Figure 7. Task 2 Propellant Sample Configuration

The GN<sub>2</sub> heater design developed for Task 2 is also shown in Figure 6. This design incorporated a round aluminum manifold surrounding the Task 2 mandrel and bolted to the LN<sub>2</sub> lance. Pointing radially inward towards the Task 2 mandrel were five warm GN<sub>2</sub> nozzles. These nozzles covered 180° of the circumference of the mandrel and were aligned axially with the LN<sub>2</sub> nozzle so that the region of the propellant sample being cut was heated by the warm GN<sub>2</sub> gas stream as the mandrel turned. The GN<sub>2</sub> heater did not move with respect to the LN<sub>2</sub> lance, ensuring that the propellant sample was always heated in the correct location. The GN<sub>2</sub> nozzles were short stubs of 1/2-inch aluminum tubing positioned at 1/2-inch standoff with respect to the propellant sample. The measured gas pressure within the Task 2 GN<sub>2</sub> manifold was 8 psig.

The GN<sub>2</sub> manifold was connected to the warm GN<sub>2</sub> supply equipment with a 2-inch o.d. flexible hose routed through a fitting in the washout enclosure roof. This hose was band-clamped to a 3.5-inch long aluminum tube welded into the manifold.

The samples for Task 2 were cut from both inert and live propellant blocks. Inert propellant was developed by propellant manufacturers to simulate the physical properties of propellant while avoiding the explosion hazard. Inert samples were used to develop the LN<sub>2</sub> system for good jet cutting performance, develop the Task 2 configuration as described above, and create X-Y table programs for sample washout. The inert propellant composition is given in Table 2.

Three live solid propellants were tested in Task 2. These propellants were of composite modified double base (CMDB), cross linked double base (XLDB), and hydroxyl terminated polybutadiene (HTPB) compositions.

Solid propellants are categorized as Hazard Class 1.1 (mass detonating) or Hazard Class 1.3 (mass fire). Double base propellants like CMDB and XLDB are Hazard Class 1.1 and contain large amounts of nitroglycerin (NG), nitrocellulose (NC), and lesser quantities of other energetic materials. Composite propellants, such as HTPB, are Hazard Class 1.3. These propellants contain ammonium perchlorate (AP) and aluminum powder in a rubber-based binder. Class 1.1 propellants are more dangerous than Class 1.3 propellants because of the possibility of detonation following initiation. Table 3 provides compositions for the propellant types used during dry washout testing.

TABLE 2. INERT PROPELLANT COMPOSITION

| DESIGNATION                     | WEIGHT PERCENT |
|---------------------------------|----------------|
| R45M                            | 6.33           |
| DOS                             | 3.565          |
| POLUGARD                        | 0.12           |
| CYANOX                          | 0.2333         |
| HX-752                          | 0.3            |
| MA                              | 0.03           |
| DDI                             | 1.39           |
| AL(X-71)                        | 37.2           |
| NH <sub>4</sub> SO <sub>4</sub> | 50.8           |

A detailed procedure (Reference xx) was developed for this work that covered propellant sample preparation for Tasks 2 and 3, equipment preparation for testing, procedure for running washout trials, equipment lockout procedure, washout enclosure and dust collection system inspection and cleanup, and personnel requirements for each operation. This procedure, combined with the equipment installation and design, was subjected to Hercules Plant Process Control Board (PPCB) review and approval. This approval is required for all explosive operations at the test facility.

Preparation for daily washout testing during Task 2 consisted of equipment preparation and sample preparation. Equipment preparation included LN<sub>2</sub> tank preparation and pump cooldown, DAS system setup, air compressor startup, 480 V diesel generator startup, and exhaust fan startup. After the LN<sub>2</sub> system was ready for operation the LN<sub>2</sub> pump was started and the LN<sub>2</sub> bath filled. After fillup in the morning the bath was topped off two or three times during the day.

Samples for Task 2 were prepared before each day of testing, during equipment setup. This work was done in the sample preparation building. Samples were cut using a small hand operated shear. Knife trimming was then done as required to fit each sample into the Task 2 mandrel. After trimming was completed the samples were weighed. The sample number and weight (in grams) were then written on each sample.

TABLE 3. LIVE PROPELLANT COMPOSITIONS

| PROPELLANT TYPE | PROPELLANT DESIGNATION | STRATEGIC PROGRAM     | PROPELLANT TYPE COMPOSITION RANGES                                                                                                                                                                    |
|-----------------|------------------------|-----------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| CMDB            | CYH                    | Minuteman (Stage III) | Binder (50-60 Percent): Nitrocellulose, nitroglycerin, and inert triacetin plasticizer. Stabilizers are 2-NDPA<br>Solids (40-50 Percent): Ammonium perchlorate, aluminum, and HMX.                    |
| XLDB            | WAY                    | Peacekeeper           | Binder (25-30 Percent): PEG polymer with nitroglycerin and nitrocellulose. Stabilizers are 2-NDPA and MNA (N-methylnitroaniline).<br>Solids (70-75 Percent): Ammonium perchlorate, aluminum, and HMX. |
| HTPB            | QDT                    | Titan IV              | Binder (12 Percent): Polybutadiene with antioxidants.<br>Solids (88 Percent): Ammonium perchlorate and aluminum.                                                                                      |

Many inert Task 2 washout trials were conducted prior to live propellant trials. During inert trials development of the test rig and written procedure was carried out. Specific test rig development items were the LN<sub>2</sub> system, GN<sub>2</sub> heater system, Task 2 mandrel, and X-Y table programming. After enough inert testing had been performed to develop both the procedure and the hardware they were "frozen," (not changed) during the remainder of testing.

An important aspect of LN<sub>2</sub> system development was nozzle sizing. This determined the LN<sub>2</sub> pressure and velocity for a given LN<sub>2</sub> pump flowrate. For a given flowrate, the upstream pressure for an orifice is a very strong function of the orifice diameter. The governing equation for unchoked flow was used to generate the following relationship:

$$\Delta P = KW^2/D^4$$

where,  $\Delta P$  = pressure drop across orifice in psi

K = proportionality constant, 1.334 by 10<sup>-3</sup>

W = LN<sub>2</sub> flow rate in gpm

D = orifice diameter in inches

Using the above equation the orifice diameters necessary to achieve the target operating pressures for a given series of tests were identified. Nozzles containing these orifices were then fabricated from 316 SS and used for testing. The pressures observed during cryogenic washout trials agreed very well with predicted values.

A Task 2 LN<sub>2</sub> washout trial was run as follows: the sample was loaded into the mandrel, and the LN<sub>2</sub> nozzle standoff was manually set using Y axis motion (Y motion) of the X-Y table. After standoff was set, the LN<sub>2</sub> nozzle was positioned (using X motion) almost completely outside from the washout enclosure, near the idler rotor. This position was called the pump start position. The warm GN<sub>2</sub> system (if used) was then turned on and all personnel entered the control bunker. Mandrel rotation was then started and mandrel RPM set remotely from the control bunker. Mandrel RPM controlled cutting speed at the propellant surface. DAS system recording was then initiated, the LN<sub>2</sub> pump started and the bypass valve closed. This directed LN<sub>2</sub> flow through the nozzle allowing LN<sub>2</sub> pressure to build. After pressure stabilized the X-Y table program (named 2BMOVE) was run.

2BMOVE was written to control only X motion, the motion of the nozzle across the sample. Y position (the standoff of the LN<sub>2</sub> nozzle) was not varied during a trial. 2BMOVE initially moved the sample so that the LN<sub>2</sub> jet was positioned just inside the edge of the sample. The initial positioning was made at 1-inch/second. The program then slowed the table motion to about 0.020 inches per second, depending on the cutting pitch (distance between cuts) required. When cutting had progressed to the end of the sample, the table retracted at 1 inch per second. For Task 2A the cut width (slow X motion) was 1/2 inch on a 3/4 inch sample, for Task 2B the cut width was 3 inches on a 4 inch sample. Task 2A and 2B cutting durations were 25 seconds and 150 seconds, respectively. Due to Task 2 mandrel geometry the LN<sub>2</sub> jet was in contact with the propellant sample for 10.6 percent of the test trial time.

All significant events during a trial were recorded chronologically in the test logs (Reference 3). After each trial the sample was removed from the mandrel and weighed. The new weight was recorded, as were cutting depths at the start and finish of the cut. Data sheets (Reference 4) were prepared for each live propellant Task 2 washout trial. Cutting performance data, washout equipment data, and propellant sample/filter assembly inspection data were all recorded.

A total of 37 live Task 2 washout trials were completed on three types of propellant. These included 18 Task 2A trials and 19 Task 2B trials. Parameters varied were surface speed, cutting pitch,

LN<sub>2</sub> nozzle standoff, LN<sub>2</sub> pressure at constant flowrate, LN<sub>2</sub> flowrate at constant pressure, GN<sub>2</sub> flowrate, and GN<sub>2</sub> temperature. The test matrix for Task 2 is presented in Table 4.

It was not possible, due to the huge number of combinations possible, to test every combination of each LN<sub>2</sub> washout parameter. During Task 2B the primary goal of testing was to maximize propellant mass removal rate. With this in mind, the most important parameters to investigate were LN<sub>2</sub> pressure and GN<sub>2</sub> supply system condition (warm, ambient, or off). Surface speed, LN<sub>2</sub> nozzle standoff, and cutting pitch were of somewhat lesser importance because although they effect the mass removal efficiency and provide data for design purposes they have a less dramatic effect on the ability of the LN<sub>2</sub> jet to cut propellant.

The testing completed reflects the priorities outline above. Task 2A was primarily intended to provide hazards data that would allow washout of larger propellant samples. Task 2B trials were designed to maximize cutting effectiveness and were run over a range of pressures from 10,000 psig to 16,500 psig. Most combinations of propellant type and pressure were tested. The effects of surface speed, LN<sub>2</sub> nozzle standoff, and cutting pitch were investigated at one combination of propellant type, LN<sub>2</sub> pressure, and GN<sub>2</sub> condition (XLDB propellant, 13,000 psi, GN<sub>2</sub> off). This gave a general understanding of the effects of these parameters. The choice of where to expand was made based on data requirements for Task 3, propellant sample availability, and possible future program requirements.

## 2. CO<sub>2</sub> Pellet Blasting

For CO<sub>2</sub> pellet blasting trials during Task 2 a bracket was constructed to attach two CO<sub>2</sub> guns to the LN<sub>2</sub> lance. The guns were not used simultaneously; one gun was used for trials with 250 psig and 425 psi supply pressure and the other used for trials at 600 psig supply pressure. Pellet flow to the gun in use was controlled remotely from the control bunker. The CO<sub>2</sub> pellet gun mounting configuration is shown in Figure 8. The mandrel configuration for CO<sub>2</sub> pellet testing was identical to that for Task 2A LN<sub>2</sub> washout trials, as was the propellant sample geometry.

The CO<sub>2</sub> pellet nozzles were 0.5 inches in diameter. A standoff distance of 0.5 inches was used. Unlike for Task 2A LN<sub>2</sub> washout trials, translation of the sample past the nozzle was not required. Instead, the Task 2 mandrel was rotated in front of the CO<sub>2</sub> gun, making a 0.5 inch wide cut on the 0.75 inch wide sample. The X-Y table was not operated during CO<sub>2</sub> pellet blasting. No GN<sub>2</sub>

TABLE 4. TASK 2 TEST MATRIX

| TYPE OF PROPELLANT | CUT X-LENGTH, PROPELLANT NAME | 1/16 INCH PITCH 10000 PSI<br>3.4 GPM |                         |                       | 1/16 INCH PITCH 13000 PSI<br>3.9 GPM |                        |                                                                     | 1/32 INCH PITCH 16000 PSI<br>2.34 GPM |                        |                       | 1/16 INCH PITCH 16500 PSI<br>3.9 GPM |                        |                       |
|--------------------|-------------------------------|--------------------------------------|-------------------------|-----------------------|--------------------------------------|------------------------|---------------------------------------------------------------------|---------------------------------------|------------------------|-----------------------|--------------------------------------|------------------------|-----------------------|
|                    |                               | WARM<br>GN <sub>2</sub>              | AMB.<br>GN <sub>2</sub> | NO<br>GN <sub>2</sub> | WARM<br>GN <sub>2</sub>              | AMB<br>GN <sub>2</sub> | NO<br>GN <sub>2</sub>                                               | WARM<br>GN <sub>2</sub>               | AMB<br>GN <sub>2</sub> | NO<br>GN <sub>2</sub> | WARM<br>GN <sub>2</sub>              | AMB<br>GN <sub>2</sub> | NO<br>GN <sub>2</sub> |
| HTPB 1.3           | 1/2 inch, QDT                 | 2A5B                                 |                         | 2A6                   | 2A11                                 | 2A14                   |                                                                     | 2A17                                  | 2A20                   |                       |                                      |                        |                       |
|                    | 3 inch, QDT                   | 2B18                                 |                         | 2B25                  | 2B20                                 |                        | 2B22                                                                |                                       |                        | 2B24                  | 2B31                                 |                        | 2B27                  |
| XLDB 1.1           | 1/2 inch, WAY                 | 2A7                                  |                         | 2A8                   | 2A12                                 | 2A15                   |                                                                     | 2A18                                  | 2A21                   |                       |                                      |                        |                       |
|                    | 3 inch, WAY                   | 2B19                                 |                         | 2B36                  | 2B21                                 |                        | 2B23<br>2B34 <sup>*</sup><br>2B35 <sup>Δ</sup><br>2B32 <sup>□</sup> |                                       |                        |                       | 2B30                                 |                        | 2B28                  |
| CMDB 1.1           | 1/2 inch, CYH                 | 2A9                                  | 2A10                    |                       | 2A16                                 | 2A13                   |                                                                     | 2A19                                  | 2A22                   |                       |                                      |                        |                       |
|                    | 3 inch, CYH                   |                                      |                         |                       | 2B33                                 |                        | 2B26                                                                |                                       |                        |                       |                                      |                        | 2B29                  |

\* 5/8 inch standoff; all other trials 3/8 inch standoff.

Δ 3/32 inch pitch; all other trials 1/16 inch pitch.

□ 11 inch/second surface speed; all other trials 6 inches/second surface speed.

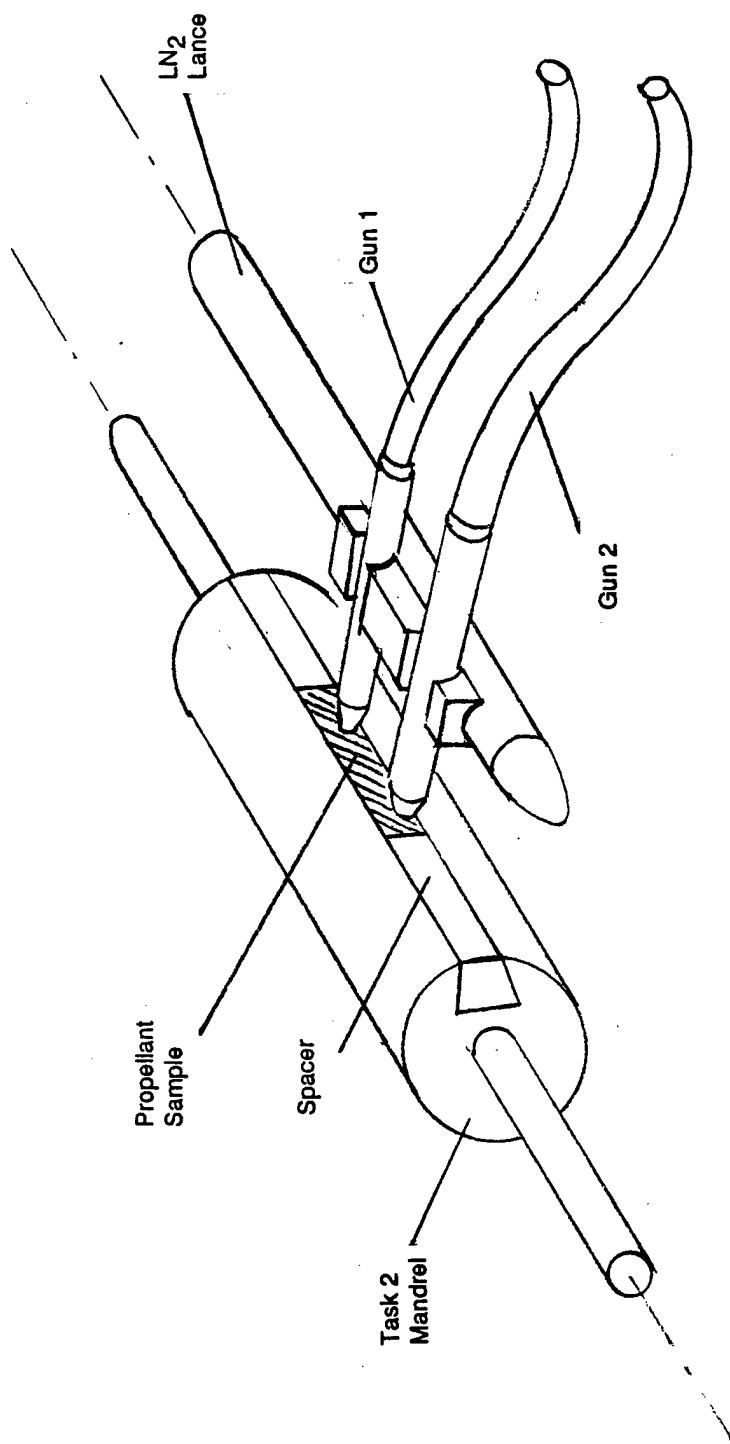


Figure 8. Task 2 CO<sub>2</sub> Pellet Blasting Configuration

heater was installed for Task 2 CO<sub>2</sub> pellet testing. In addition no components in the high pressure LN<sub>2</sub> system were operated during CO<sub>2</sub> pellet blasting.

A total of nine CO<sub>2</sub> pellet trials were conducted on all three types of propellant according to the test matrix shown in Table 5. Pellet mass flow was held constant at 150 pounds per hour

TABLE 5. CO<sub>2</sub> BLASTING TEST MATRIX SHOWING TRIAL NUMBER DESIGNATION

| PROPELLANT<br>NAME | PROPELLANT<br>TYPE | PRESSURE, PSIG     |                    |                    |
|--------------------|--------------------|--------------------|--------------------|--------------------|
|                    |                    | 250 <sup>(a)</sup> | 425 <sup>(a)</sup> | 600 <sup>(b)</sup> |
| QDT                | HTPB               | C3                 | C5A                | C11A               |
| WAY                | XLDB               | C6                 | C8                 | C10                |
| CYH                | CMDB               | C7                 | C9                 | C12                |

<sup>(a)</sup>Pellet nozzle #1 used

<sup>(b)</sup>Pellet nozzle #2 used

The test procedure for CO<sub>2</sub> pellet blasting was similar to that for Task 2A. The propellant samples used for Task 2 CO<sub>2</sub> pellet blasting and Task 2A LN<sub>2</sub> washout were the same. Propellant preparation and weighing procedures were identical.

Daily equipment preparation for CO<sub>2</sub> testing included DAS system setup, high pressure GN<sub>2</sub> supply setup, and exhaust fan startup. High pressure GN<sub>2</sub> setup consisted of connecting the blasting equipment to a tube trailer having adequate pressure for the trial, or trials, to be run.

A Task 2 CO<sub>2</sub> pellet blasting trial was conducted as follows:

1. The high pressure GN<sub>2</sub> and pellet hoses were connected to the correct nozzle for the planned GN<sub>2</sub> operating pressure.
2. The X-Y table was moved manually to align the nozzle with the sample location.

3. The sample was loaded into the Task 2 mandrel.
4. The hopper was filled with adequate CO<sub>2</sub> pellets for the planned trial.
5. The high pressure GN<sub>2</sub> supply valve was opened.
6. GN<sub>2</sub> flow was started to the nozzle by opening the control valve located at the CO<sub>2</sub> pellet metering equipment skid.
7. The pressure regulator was set at the GN<sub>2</sub> supply to obtain the correct pressure at the CO<sub>2</sub> pellet metering skid.
8. All personnel moved into the control bunker.
9. Data acquisition system recording was started.
10. Sample rotation was started and timed.
11. Pellet flow was remotely started and maintained for six minutes.
12. Pellet flow and sample rotation were shut off. Personnel could leave the bunker.
13. High pressure GN<sub>2</sub> flow was shut off.
14. Sample was removed from mandrel and weighed. Manual data was recorded.

#### D. TASK 3: PROTOTYPE WASHOUT TESTS

Task 3 was designed to demonstrate cryogenic washout of two different design subscale rocket motors. Process parameters developed in Task 2 (LN<sub>2</sub> nozzle design, LN<sub>2</sub> pressure, LN<sub>2</sub> flowrate, GN<sub>2</sub> propellant heater parameters, surface traverse speed, and nozzle standoff) were applied. The two motors tested were a forty pound charge (FPC) containing WAY (XLDB) hazard class 1.1 propellant, and a lightweight analog motor (LAM) containing QDT (HTPB) hazard class 1.3 propellant. The propellant types were the same as used for Task 2 testing, and described in Table 3. Prior to washout of the live motors, inert motors of both types were processed to insure correct operation of the test rig and X-Y table software. Both inert motors contained the same type of inert propellant as used for Task 2 (described in Table 2).

The live FPC Motor (shown in Figures 9 and 10) washed out during Task 3 was a cylindrical constant section motor with an outside diameter of 8.8 inches, inside diameter of 4.8 inches, and a propellant web thickness of 1.8 inches. The outer casing or beaker was a 0.2 inch thick phenolic tube. The WAY (XLDB) propellant forming the propellant web was cast so as to be flush with one end of

the phenolic beaker, and recessed 0.4 inches at the other end. The total weight of the FPC motor (including the beaker) was 40.0 pounds before washout.

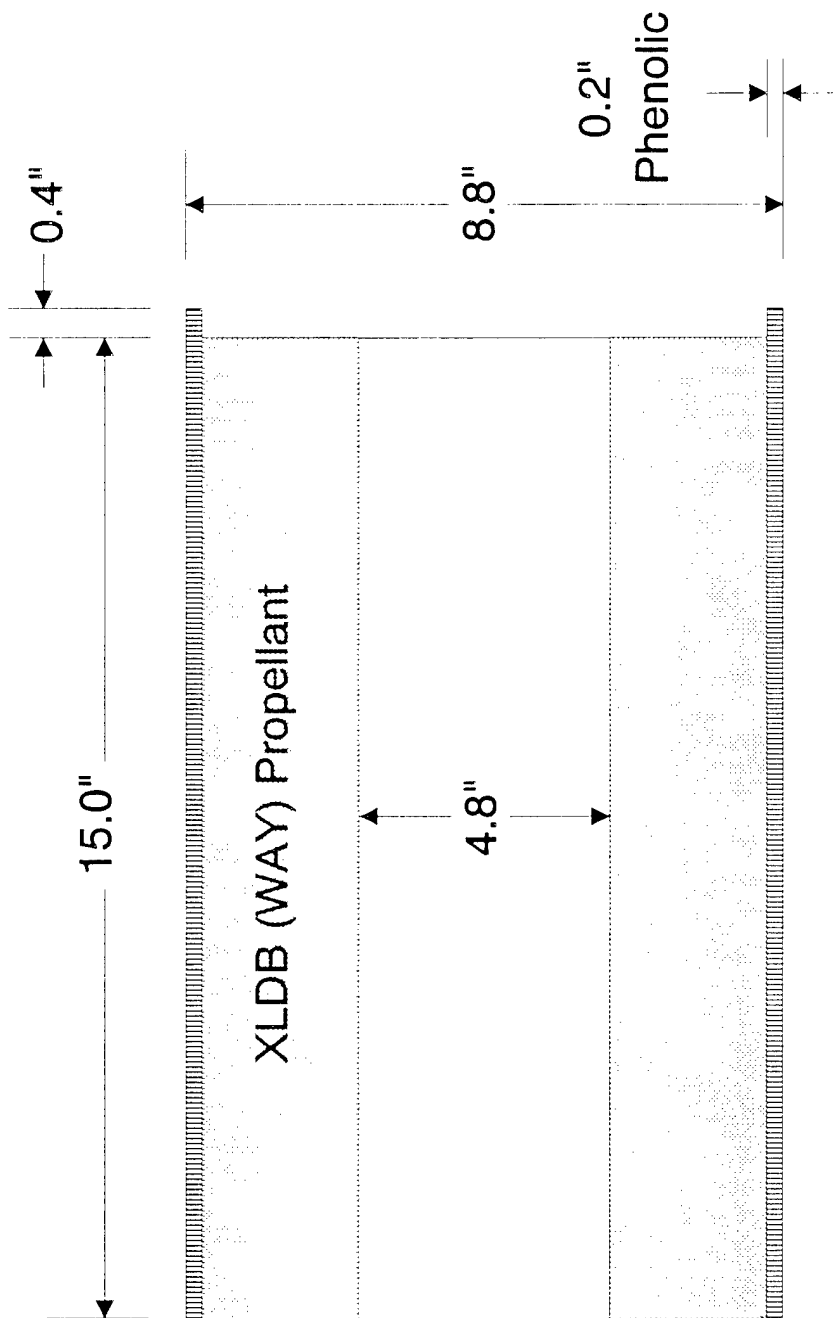


Figure 9. Forty Pound Charge (FPC) Rocket Motor Cross Section



Figure 10. Live FPC End View Prior to  $\text{LN}_2$  Washout

The Titan LAM (Figure 11) is a larger, more sophisticated subscale motor than the FPC. The LAM outer case is 25.7 inches long, 10 inches in diameter and is constructed of filament wound Kevlar. The total weight of a Titan LAM is 84 pounds. The LAM does not have constant cross-section but rather has a rounded nose with a 2.75 inches diameter hole where an igniter can be flange mounted. The aft skirt of the LAM is open, allowing access to the propellant, which is recessed 8 inches. The live LAM processed contained approximately 60 pounds of QDT (HTPB) propellant. The manufacturing drawings of the Titan LAM show the inside diameter as 3.4 inches, which was the i.d. of the inert motor tested. However, the live motor had 3.1 inches i.d.

The FPC motors were mounted in the washout enclosure with clamp-on aluminum adapters. These adapters allowed an FPC to be mounted between rotors inside the washout enclosure. The LAM was mounted in the test rig with aluminum pins that located the LAM between rotors at both nose and aft ends. At the aft end a ring was fabricated which was a slip fit on the i.d. of the aft skirt. Pins passed through this ring into holes that were hand drilled into the aft skirt. The nose pins were screwed into the igniter flange.

Before washout of the FPC motors, washout trials were conducted on a bare phenolic beaker with no propellant. The trial on the bare beaker determined that the phenolic material was damaged by a 13,000 psig  $\text{LN}_2$  jet. The mounting scheme for the FPC was originally designed so that the FPC would be self supporting between the drive and idler rotors and therefore might fall from between the rotors if the phenolic beaker was heavily damaged. To solve this problem a 0.050 inch thick stainless steel sleeve was installed around the FPC.

During inert LAM testing it was determined that under some conditions the Kevlar aft skirt (which is not coated with propellant) could be damaged by the  $\text{LN}_2$  jet as the X-Y table advanced the jet from the pump start position to the propellant. In order to prevent this damage a 0.1 inch thick aluminum sleeve was fabricated which fitted inside the aft skirt.

For Task 3, the FPC and LAM rocket motors were washed out with a radially outward  $\text{LN}_2$  jet direction impacting the propellant surface at a 15 degree angle. The  $\text{LN}_2$  lance was positioned on the inside of the motor using the same nozzles as for Task 2. Nozzle standoff was adjusted with the X-Y

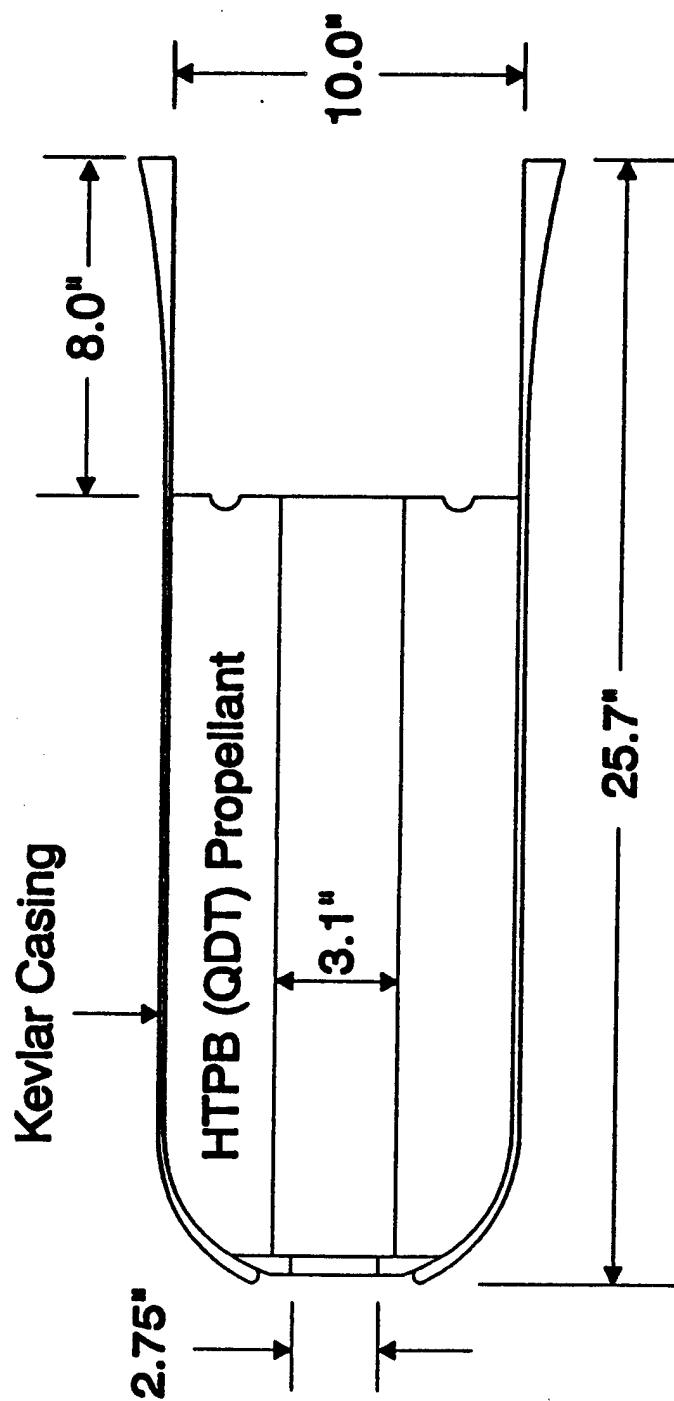


Figure 11. Lightweight Analog Motor (LAM) Cross Section

table. For Task 3, a specific warm  $\text{GN}_2$  nozzle arrangement (shown in Figure 12) was installed which attached to the  $\text{LN}_2$  lance. This nozzle directed gas flow radially outward through five holes positioned in the same plane as the  $\text{LN}_2$  jet. The warm  $\text{GN}_2$  nozzle was machined from a block of G10 fiberglass that was attached to the end of the  $\text{LN}_2$  lance with a stainless steel bracket sandwiched between the  $\text{LN}_2$  nozzle and lance.  $\text{GN}_2$  was routed to the nozzle through two 3/4 inch PTFE insulated stainless steel tubes running parallel to the  $\text{LN}_2$  lance. The assembly was designed to fit into a 3.4 inch diameter rocket motor bore. The standoff with this  $\text{GN}_2$  heater nozzle arrangement varied as the rocket motor inside diameter increased during washout. Since the  $\text{LN}_2$  nozzle standoff was held constant as the motor was washed out, the warm  $\text{GN}_2$  nozzle standoff was increased after each pass. The increase in warm  $\text{GN}_2$  nozzle standoff was twice the cutting depth during the previous pass. Increased  $\text{GN}_2$  standoff affected the cutting performance during the washout of the LAM motor.

Prior to washout of each live motor, an inert motor was processed. This allowed development of the X-Y table software for each motor, verified that no problems would occur during the planned washout sequence, and provided experience required to gain PPCB approval for live motor operations. Both inert motors contained the same type of inert propellant as used for Task 2 (described in Table 2). Inert motors were about 50 percent washed out before live motor washout was initiated. Complete inert motor washout was not performed because efficient inert propellant removal required 16500 psig  $\text{LN}_2$  pressure with 3.9 gpm flow. This combination (maximum possible pump flow with the highest pressure tested) caused intermittent pump cavitation. This phenomenon damaged the pump during inert FPC washout and subsequent operation under these conditions was as short in duration as possible. Partial washout was adequate for the purposes of inert rocket motor washout described above.

The procedure for washout operations during Task 3 was similar to that for Task 2 washout trials. Site setup, DAS setup, warm  $\text{GN}_2$  system operation, and  $\text{LN}_2$  system cooldown procedure and operation were the same. For the FPC motors the propellant was removed in a series of three  $\text{LN}_2$  jet passes running lengthwise along the bore of the motor (X direction) while the motor rotated at 30 rpm.  $\text{LN}_2$  pressure for live FPC washout was 13,000 psig. Each pass ran the length of the propellant grain starting from the idler end of the FPC and progressing towards the drive end. Prior to a pass the  $\text{LN}_2$  system was pressurized with the nozzle positioned at the idler rotor end of the motor. This startup position allowed the  $\text{LN}_2$  jet to be directed into the washout enclosure, through a slot in the idler rotor,

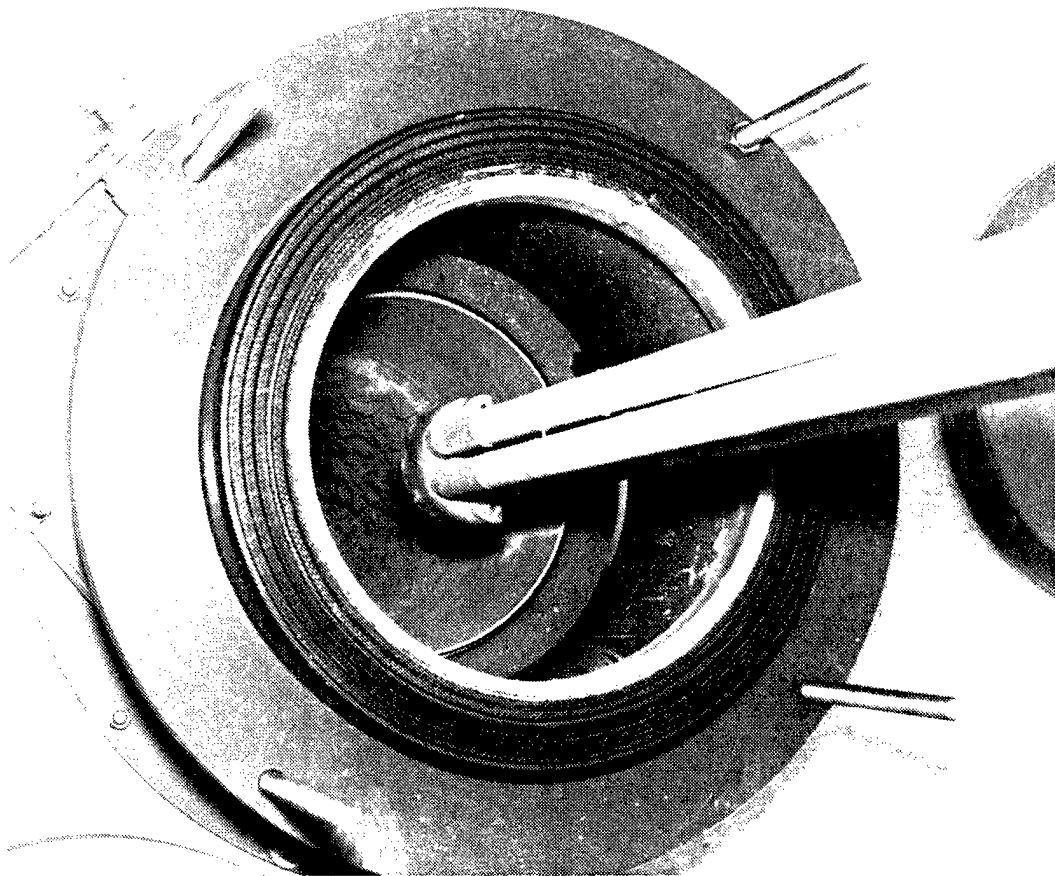


Figure 12. Task 3 Nozzle/ $\text{GN}_2$  Heater Configuration

prior to establishing proper LN<sub>2</sub> pressure. The live FPC bore was inspected after each pass to determine the cutting depth and manually adjust LN<sub>2</sub> nozzle standoff (Y direction motion). Y direction movements were not made during a pass. The X-Y table program was run without LN<sub>2</sub> flow, but with the warm GN<sub>2</sub> system operating. This warmed the FPC bore for inspection and may have helped cutting performance on the next pass.

The LAM was washed out with the same methodology as the FPC, except that each pass was a different X length because of the round nose shape of the LAM. Pass length was set so that the LN<sub>2</sub> lance extended as far as possible into the motor without hitting the inside of the rounded nose shape. The pass length changed as propellant was removed and the nozzle was moved in the Y direction to maintain 1/2 inch standoff. The pass length and standoff were set manually between passes.

The live HTPB filled LAM was completely washed out in a total of 21 passes. GN<sub>2</sub> flow was not used for the first 5 passes because the bore of the live LAM was 3.1 inches in diameter versus 3.4 inches on the manufacturing drawings. This meant that the Task 3 warm GN<sub>2</sub> nozzle did not fit. After the first 5 passes the bore of the LAM was large enough so that the GN<sub>2</sub> nozzle could be installed and cutting rate was improved. Warm GN<sub>2</sub> only passes were made between each cutting pass after installation of the GN<sub>2</sub> heater nozzle.

The first 6 passes on the live LAM were made at 13000 psig LN<sub>2</sub> pressure and 3.4 gpm flowrate. Due to the change in GN<sub>2</sub> nozzle configuration between Tasks 2 and 3 the cutting performance was less for the HTPB propellant in the LAM versus Task 2 HTPB samples. This is discussed in Section IV.C. In order to partially counteract this effect, a new nozzle was fabricated to increase LN<sub>2</sub> pressure to 15,000 psig at 3.4 gpm. This nozzle was installed after pass number 6. This combination of pressure and flow was less prone to cause partial pump cavitation than the 16,500 psig/3.9 gpm combination used for inert propellant washout, primarily because the lower flowrate reduced pump inlet pressure drop.

## SECTION IV

### RESULTS

#### A. TASK 1: PROPELLANT SENSITIVITY TESTING

The results of Task 1 testing (Reference 5) show that propellant at cryogenic temperatures, whether CMDB, XLDB, or HTPB, was no more sensitive to initiation from impact, friction, low level shock, or ESD than ambient temperature propellant. In addition, propellant tested at ambient temperature after cycling to between ambient and cryogenic temperatures showed no increase in sensitivity to external stimuli.

Data for probit analyses, conducted as described in Section III, was generated for all sensitivity tests except low level shock sensitivity. The time and propellant samples required for each low level shock sensitivity trial precluded gathering enough data for complete probit analysis. Instead, enough low level shock testing was done to establish the TIL for ambient, cryocooled, and temperature cycled propellant. Probit analyses generated plots of energy vs probability of initiation. Sensitivities for cooled or temperature cycled propellant samples were unchanged within the limits of the statistical analysis. The probit plots showing data for ambient, -109°F, and -320°F propellant samples, are presented in Figs. A1 through A18 in Appendix A.

Electrical properties characterization tests determined that the hazard class 1.1 propellants (CMDB and XLDB), which are electrically conductive at room temperature, had high volume resistivity at -150°F. The hazard class 1.3 propellant (HTPB), which is normally nonconductive, showed a slight increase in volume resistivity at -150°F. The dielectric constants for CMDB and XLDB decreased significantly at -150°F, while the dielectric constant for HTPB was unchanged.

The data from electrical properties tests for 1.1 propellants show a tradeoff in the propensity for propellants to build static voltages high enough for electrostatic discharge. Propellants at -150°F require higher voltages relative to ambient propellant before they break down. This makes them less susceptible to ESD. However, their charge dissipation is much slower. This increases the possibility

that charge will build up to the voltage required for breakdown. Table 6 contains the quantitative results for electrical properties testing.

TABLE 6. RESULTS OF TASK 1 ELECTRICAL PROPERTIES TESTING

| PROPELLANT | TEST SERIES | VOLUME RESISTIVITY<br>(ohm-cm) | DIELECTRIC CONSTANT<br>(at 1 kHz) |
|------------|-------------|--------------------------------|-----------------------------------|
| CMDB       | Baseline    | $17 \times 10^2$               | 51                                |
|            | Cycled      | $7.5 \times 10^2$              | 70                                |
|            | -150°F      | $2.2 \times 10^{15}$           | 3.6                               |
| XLDB       | Baseline    | $6.2 \times 10^6$              | 1800                              |
|            | Cycled      | $1.0 \times 10^7$              | 2200                              |
|            | -150°F      | $1.4 \times 10^{15}$           | 4.3                               |
| HTPB       | Baseline    | $1.1 \times 10^{13}$           | 9.1                               |
|            | -150°F      | $1.3 \times 10^{15}$           | 6.4                               |

Prior to testing there was concern that temperature cycling of class 1.1 propellant during washout might lead to nitroglycerin (NG) migration out of its stable form in the propellant. Laboratory tests and a literature search were conducted that indicated that this phenomena would be unlikely for the testing planned. After the completion of Task 3 (rocket motor washout testing) laboratory analyses were done on XLDB propellant washed out of the FPC motor. These analyses determined that no NG migration and no stabilizer depletion occurred as a result of  $\text{LN}_2$  washout operations.

## B. TASK 2: BENCH SCALE TESTS

### 1. $\text{LN}_2$ Washout

#### a. Pretests at GA

During preliminary  $\text{LN}_2$  washout system testing at GA, development work on the  $\text{LN}_2$  system was completed. This development resulted in a good quality jet. In addition, simple cutting trials were performed using wood and inert propellant. Parallel cuts at 1/16 inch to 1/4 inch pitch

were made.  $\text{LN}_2$  pressure,  $\text{LN}_2$  flowrate, and  $\text{GN}_2$  heater configuration were varied to determine the approximate parameters that would be required for live testing using the Tasks 2 and 3 test rig.

The first tests of the  $\text{LN}_2$  system resulted in a two phase flow out of the nozzle that was ineffective at cutting soft wood. Thermocouple measurements showed that pumping to high pressure raised the temperature of the liquid between  $30^\circ\text{F}$  and  $60^\circ\text{F}$ , depending on pump discharge pressure. To counteract the pump heating a cooling coil was incorporated in the pump discharge line. This coil was immersed in  $\text{LN}_2$  at ambient pressure and was effective at removing the heat added by the pump. Placement of the coil was as close to the nozzle as possible so that the liquid at the entrance the nozzle was at the minimum possible temperature.

Calculations indicated that the original nozzle design could be improved, resulting in less nozzle friction and attendant fluid heating. This improved nozzle design had a  $40^\circ$  included angle converging cone to gradually accelerate the fluid, followed by a short (0.080 inch) straight section. With these modifications the quality of the jet was markedly improved. Depending on pressure, cuts of up to 1 inch depth could be made through warm inert propellant. Surface speeds between 1 and 10 inches/second were tried with little difference in cutting depth. However, cryocooling the inert propellant by immersion in  $\text{LN}_2$  resulted in very little erosion at 11,000 psig  $\text{LN}_2$  pressure, due to the change in physical properties of the sample.

An increase in cutting depth on cryocooled inert samples was achieved by reheating the sample with warm air as it was cut by the  $\text{LN}_2$  jet. Two configurations were tried, both utilizing approximately  $200^\circ\text{F}$  air. The first configuration utilized high supply pressure (100 psig), low flow rate (14.6 scfm) air directed through a 1/4 copper tube. This tube was pointed at the area cut by the  $\text{LN}_2$  jet so that the sample was reheated after each cutting pass. Cutting depth for cryocooled inert samples was 3/8 inch with gas nozzle standoff of 3/8 inch. The second configuration utilized a room heater that blew a much higher volume of air across the sample at low velocity. The cutting efficiency was comparable to that achieved with the smaller flow, higher velocity air stream. Higher  $\text{LN}_2$  pressures also increased cutting depth on cryocooled inert samples. Preliminary, short duration tests on inert propellant were performed at GA with  $\text{LN}_2$  pressure as high as 14,000 psig. During these tests cutting depth as high as 1/2 inch was achieved with warm gas augmentation.

b. Task 2A and 2B Tests

After construction of the Tasks 2 and 3 test rig all test equipment was shipped to the Hercules site installed and checked out. Task 2 testing then began. The  $\text{GN}_2$  supply system and Task 2  $\text{GN}_2$  distributor described in Section III were designed using data from preliminary testing and installed. Dry  $\text{GN}_2$  flow, instead of air, was used at the Hercules site to reduce condensation of water vapor inside the washout enclosure.

Inert Task 2A and 2B testing confirmed the need for high  $\text{LN}_2$  pressures to effectively cut inert propellant. One-quarter inch cutting depth required 16,500 psig  $\text{LN}_2$  pressure. Warm  $\text{GN}_2$  was necessary for best mass removal. Cutting depth with the same  $\text{LN}_2$  pressures was less than for preliminary testing at GA. This difference in performance may be due to the slight differences in test conditions such as atmospheric pressure between San Diego and Magna, Utah. Also, the testing at GA was conducted outdoors and the cooling effect of the  $\text{LN}_2$  was less pronounced than inside the washout enclosure at the Hercules site.

During live Task 2 testing over 1000 impacts were made with high pressure  $\text{LN}_2$  jets on samples of HTPB, XLDB, and CMDB propellant. No initiations or reactions occurred for the test pressure range of 10,000 to 16,500 psig. The best mass removal rates of 60 to 80 pounds per hour were achieved during Task 2B for the three propellants tested.  $\text{LN}_2$  flow was less than 4 gallons per minute. All three live propellants required less  $\text{LN}_2$  pressure for a given mass removal rate than inert propellant. The test parameters and mass removal for all Task 2 trials are given in Table 7.

Eighteen Task 2A propellant samples were tested; 6 HTPB samples, 6 XLDB samples, and 6 CMDB samples. The primary purpose of Task 2A was to demonstrate that no initiations would occur using small 75 gram samples (density for each of the propellants was the same). These samples would cause minimum equipment damage if they did initiate. Task 2A trials were run at 10,000, 13,000, and 16,000 psig  $\text{LN}_2$  pressure. At each test pressure 16 or more total impacts were made. Each propellant type was impacted more than 50 times by the high pressure jet. This resulted in a significant safety data base indicating that planned Task 2B and Task 3  $\text{LN}_2$  pressures were below the threshold initiation limit (TIL) for each propellant type.

During Task 2A the  $\text{LN}_2$  nozzle standoff was held at 3/8 inch. The Task 2A mandrel rotated at a surface speed of 6 inches per second while the mandrel translated 1/16 inch per revolution in the X (axial) direction. The  $\text{LN}_2$  jet impinged on each Task 2A sample 8 times. Trials were made with and without warm  $\text{GN}_2$  flow.  $\text{GN}_2$  temperature was varied from ambient to 200°F, and  $\text{GN}_2$  flow was held constant at 200 scfm. Propellant erosion during Task 2A was very effective. Cutting depths as great as 0.9 inches were achieved. However, the short test duration caused a transient thermal effect that complicated interpretation of the mass removal data. This effect was caused by propellant cooling as each of the eight parallel cuts were made on the samples. The initial cut was the deepest, because the sample was at ambient temperature. Cutting depth then decreased for subsequent cuts. Equilibrium cutting depth was not reached during Task 2A testing because of the limited number of cuts on each sample. In addition, Task 2A samples occasionally displaced slightly along the mandrel slot due to the impact loading of the jet. This resulted in the sample moving too far under the jet, which invalidated the mass removal data.

A total of 19 Task 2B trials were performed. These trials were begun after the Task 2A trials for each propellant type were completed.  $\text{LN}_2$  pressure,  $\text{LN}_2$  flowrate, propellant surface speed, pitch (distance between cuts),  $\text{LN}_2$  standoff, and  $\text{GN}_2$  flow were varied to characterize propellant mass removal rate. Photographs of the Task 2B test configuration are presented in Figures 13 and 14.

The best mass removal rates during Task 2B for HTPB, XLDB, and CMDB propellants were 80.3, 68.4, and 60.0 pounds per hour respectively. These rates were achieved during trials number 2B31 for HTPB, 2B30 for XLDB, and 2B29 for CMDB. Mass removal efficiencies (expressed in pounds of propellant removed per pound of  $\text{LN}_2$ ) were 0.050, 0.042, and 0.038 pounds/pound for HTPB, XLDB, and CMDB. This performance is considered acceptable for scaleup to larger systems. Figure 15 is a photograph of representative Task 2B propellant samples following testing. A complete set of photographs of Task 2 propellant samples is presented in Figures B-1 through B-18 in Appendix B. Photographs of the eroded propellant particles are presented in Figures B-19 through B-21 in Appendix B. Figures 16-18 are plots of mass removal data versus  $\text{LN}_2$  pressures, with and without warm  $\text{GN}_2$  flow, for each of the propellant types.

Examination of the data in Table 7 shows that mass removal rates for the double base propellants (XLDB and CMDB) were less affected by the warm  $\text{GN}_2$  flow than the HTPB propellant.



Figure 13. Photograph of Task 2 Test Setup



Figure 14. Photograph of Task 2B Propellant Sample in Mandrel

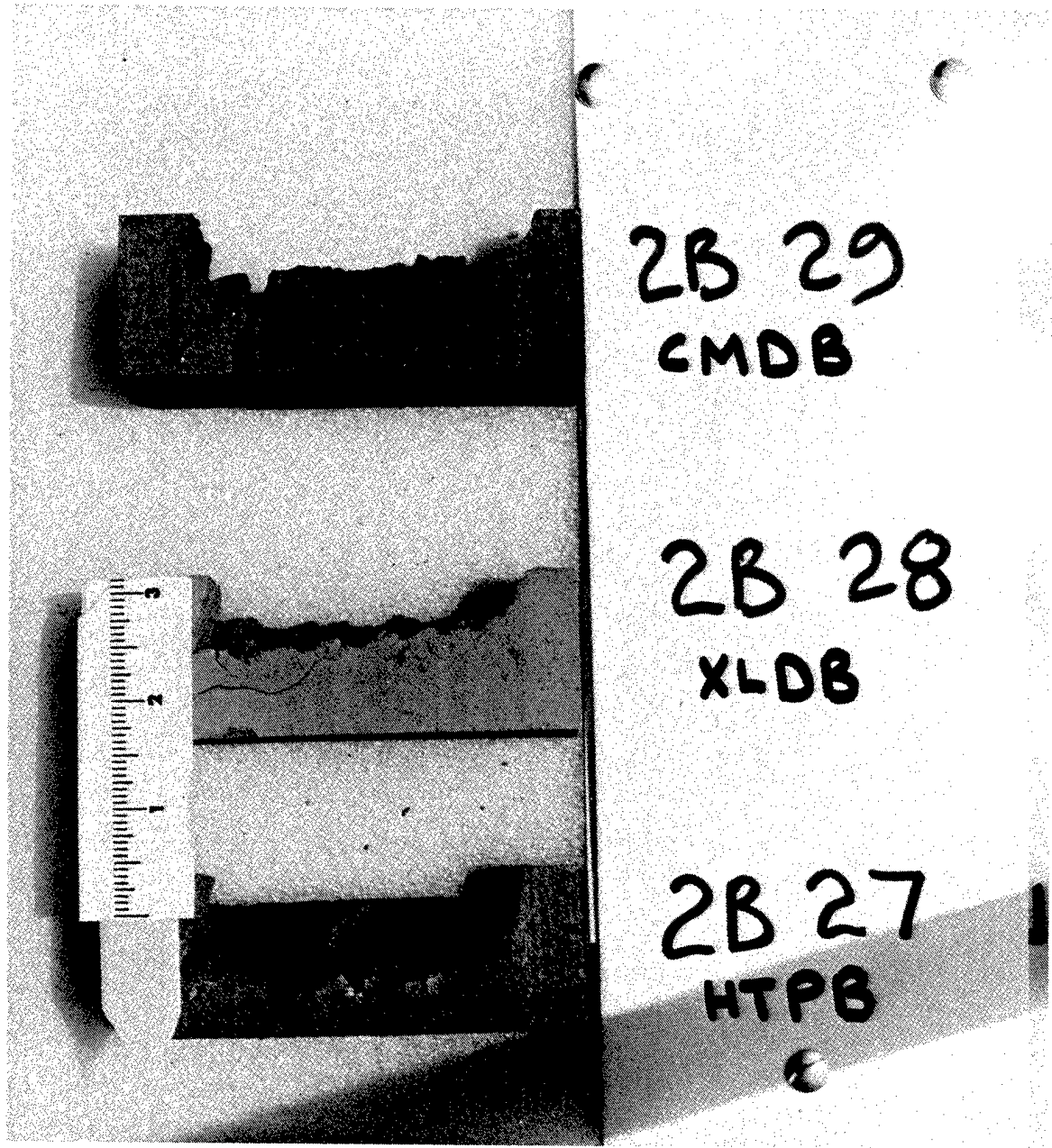


Figure 15. Representative Task 2B LN<sub>2</sub> Washout Samples

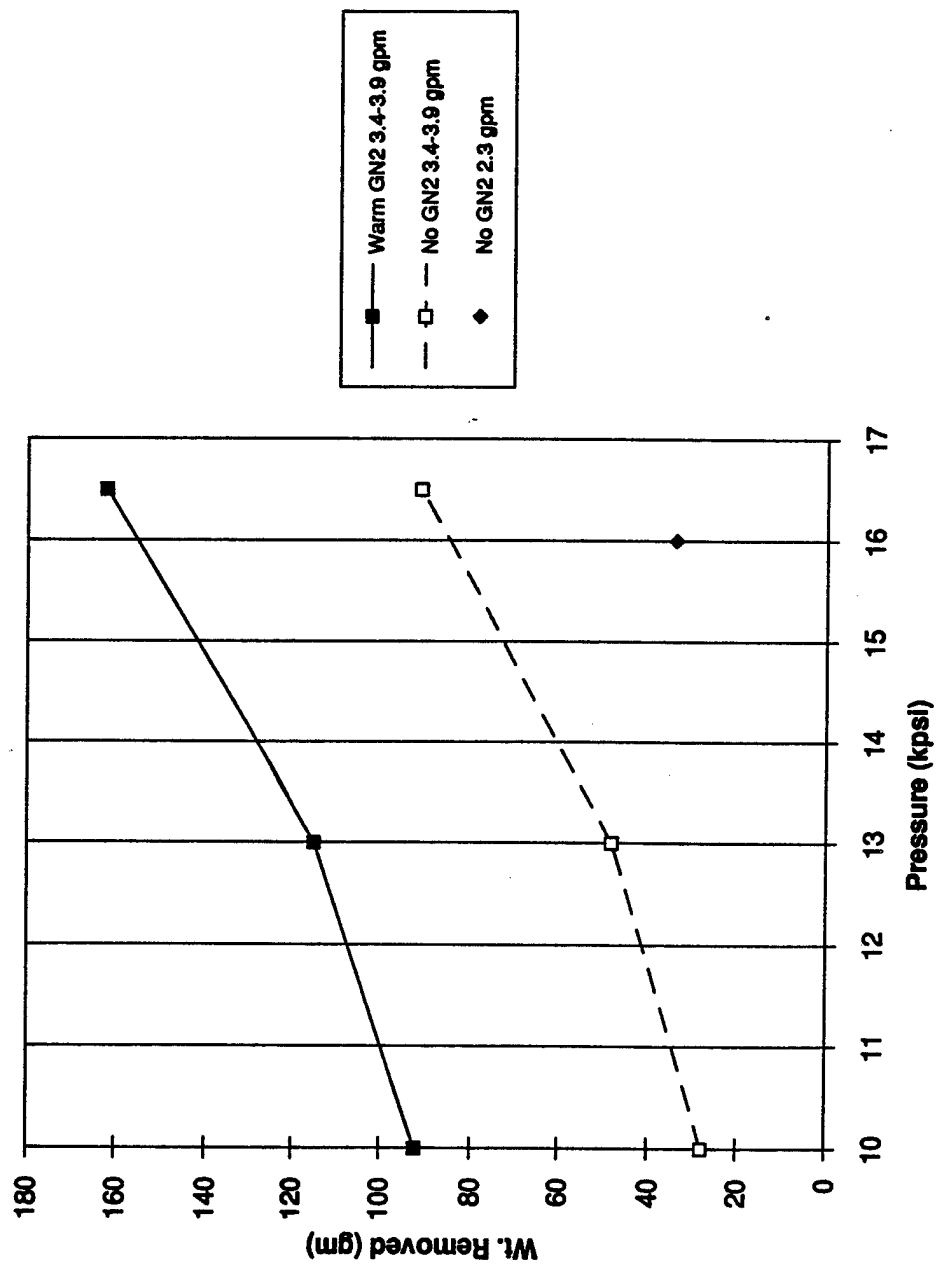


Figure 16. HTPB Propellant Removal Versus LN<sub>2</sub> Pressure for Task 2B

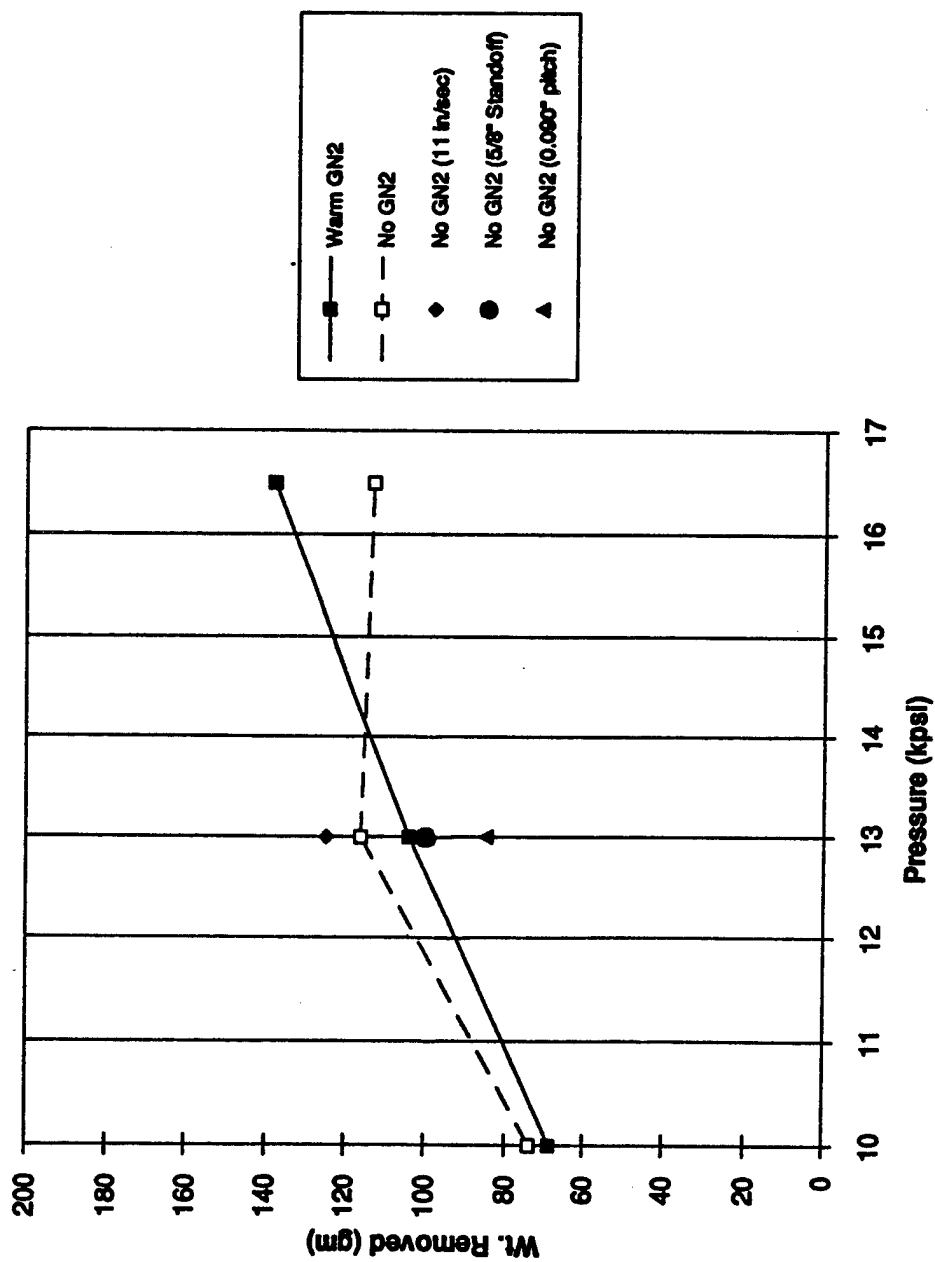


Figure 17. XLDB Propellant Removal Versus LN<sub>2</sub> Pressure for Task 2B

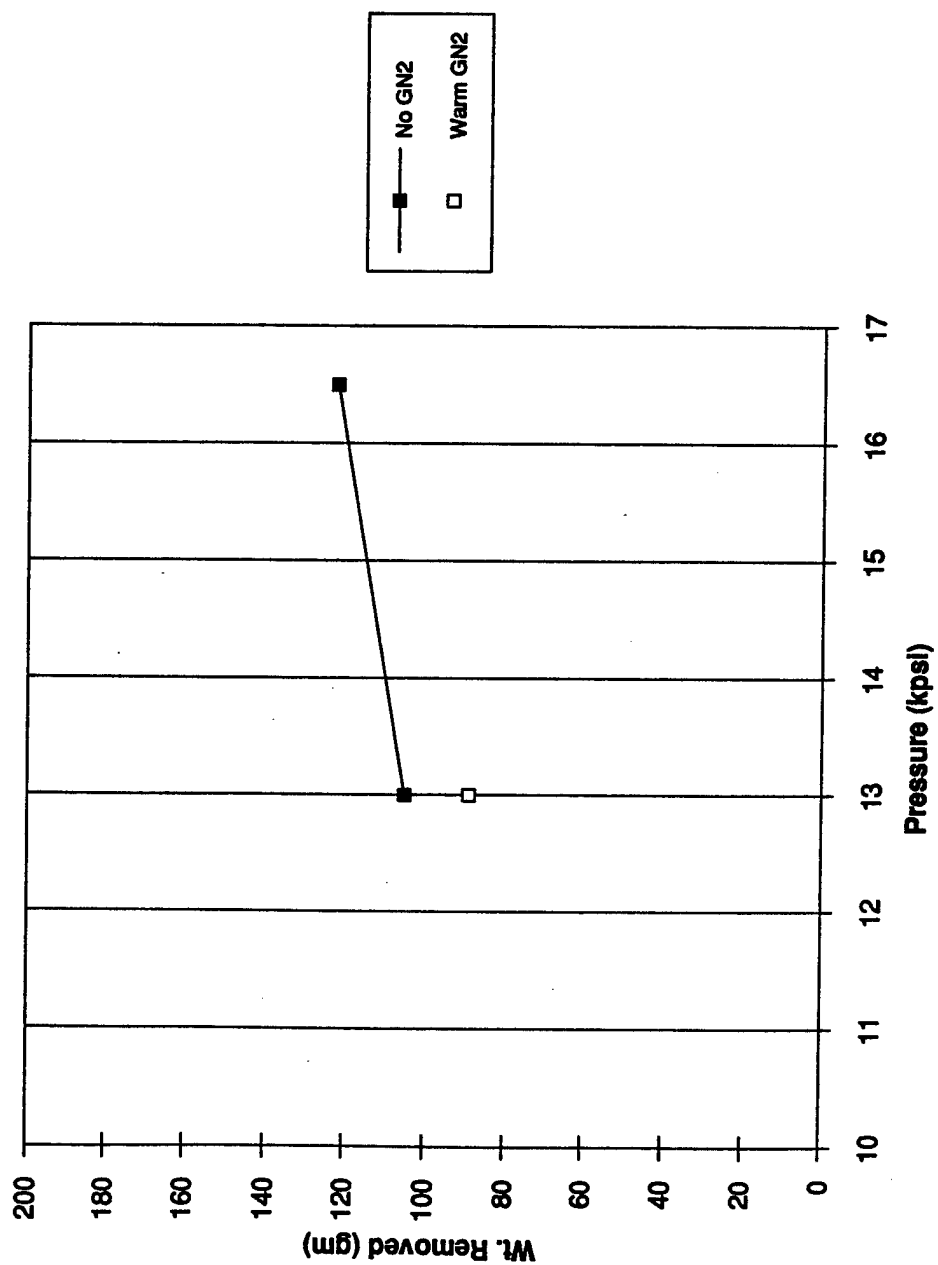


Figure 18. CMD B Propellant Removal Versus LN<sub>2</sub> Pressure for Task 2B

TABLE 7. TEST PARAMETERS AND MASS REMOVAL FOR TASK 2 LN<sub>2</sub> WASHOUT TRIALS

| Trial No. | Propellant Type | LN <sub>2</sub> Pressure (kpsi) | LN <sub>2</sub> Flowrate (gpm) | GN <sub>2</sub> Condition | Surface Speed (in./s) | LN <sub>2</sub> Nozzle Standoff (in.) | Pitch (in.) | Mass Removal (grams) |
|-----------|-----------------|---------------------------------|--------------------------------|---------------------------|-----------------------|---------------------------------------|-------------|----------------------|
| 2A5B      | HTPB            | 10                              | 3.4                            | WARM                      | 6                     | 3/8                                   | 1/16        | 21                   |
| 2A6       | HTPB            | 10                              | 3.4                            | OFF                       | 6                     | 3/8                                   | 1/16        | 9                    |
| 2A11      | HTPB            | 13                              | 3.9                            | WARM                      | 6                     | 3/8                                   | 1/16        | 16                   |
| 2A14      | HTPB            | 13                              | 3.9                            | AMBIENT                   | 6                     | 3/8                                   | 1/16        | 13                   |
| 2A17      | HTPB            | 16                              | 2.34                           | WARM                      | 6                     | 3/8                                   | 1/16        | 10                   |
| 2A20      | HTPB            | 16                              | 2.34                           | AMBIENT                   | 6                     | 3/8                                   | 1/16        | 9                    |
| 2B18      | HTPB            | 10                              | 3.4                            | WARM                      | 6                     | 3/8                                   | 1/16        | 92                   |
| 2B25      | HTPB            | 10                              | 3.4                            | OFF                       | 6                     | 3/8                                   | 1/16        | 28                   |
| 2B20      | HTPB            | 13                              | 3.9                            | WARM                      | 6                     | 3/8                                   | 1/16        | 115                  |
| 2B22      | HTPB            | 13                              | 3.9                            | OFF                       | 6                     | 3/8                                   | 1/16        | 48                   |
| 2B24      | HTPB            | 16                              | 2.34                           | OFF                       | 6                     | 3/8                                   | 1/16        | 34                   |
| 2B31      | HTPB            | 16.5                            | 3.9                            | WARM                      | 6                     | 3/8                                   | 1/16        | 162                  |
| 2B27      | HTPB            | 16.5                            | 3.9                            | OFF                       | 6                     | 3/8                                   | 1/16        | 91                   |
| 2A7       | XLDB            | 10                              | 3.4                            | WARM                      | 6                     | 3/8                                   | 1/16        | 21                   |
| 2A7       | XLDB            | 10                              | 3.4                            | OFF                       | 6                     | 3/8                                   | 1/16        | 13                   |
| 2A12      | XLDB            | 13                              | 3.9                            | WARM                      | 6                     | 3/8                                   | 1/16        | 12                   |
| 2A15      | XLDB            | 13                              | 3.9                            | AMBIENT                   | 6                     | 3/8                                   | 1/16        | 17                   |
| 2A18      | XLDB            | 16                              | 2.34                           | WARM                      | 6                     | 3/8                                   | 1/16        | 15                   |
| 2A21      | XLDB            | 16                              | 2.34                           | AMBIENT                   | 6                     | 3/8                                   | 1/16        | 8                    |
| 2B19      | XLDB            | 10                              | 3.4                            | WARM                      | 6                     | 3/8                                   | 1/16        | 8                    |

TABLE 7. TEST PARAMETERS AND MASS REMOVAL FOR TASK 2 LN<sub>2</sub> WASHOUT TRIALS  
(CONTINUED)

| Trial No. | Propellant Type | LN <sub>2</sub> Pressure (kpsi) | LN <sub>2</sub> Flowrate (gpm) | GN <sub>2</sub> Condition | Surface Speed (in./s) | LN <sub>2</sub> Nozzle Standoff (in.) | Pitch (in.) | Mass Removal (grams) |
|-----------|-----------------|---------------------------------|--------------------------------|---------------------------|-----------------------|---------------------------------------|-------------|----------------------|
| 2B36      | XLDB            | 10                              | 3.4                            | OFF                       | 6                     | 3/8                                   | 1/16        | 74                   |
| 2B21      | XLDB            | 13                              | 3.9                            | WARM                      | 6                     | 3/8                                   | 1/16        | 104                  |
| 2B23      | XLDB            | 13                              | 3.9                            | OFF                       | 6                     | 3/8                                   | 1/16        | 116                  |
| 2B34      | XLDB            | 13                              | 3.9                            | OFF                       | 6                     | 5/8                                   | 1/16        | 100                  |
| 2B35      | XLDB            | 13                              | 3.9                            | OFF                       | 6                     | 3/8                                   | 3/32        | 85                   |
| 2B32      | XLDB            | 13                              | 3.9                            | OFF                       | 11                    | 3/8                                   | 1/16        | 125                  |
| 2B30      | XLDB            | 16.5                            | 3.9                            | WARM                      | 6                     | 3/8                                   | 1/16        | 138                  |
| 2B28      | XLDB            | 16.5                            | 3.9                            | OFF                       | 6                     | 3/8                                   | 1/16        | 113                  |
| 2A9       | CMDB            | 10                              | 3.4                            | WARM                      | 6                     | 3/8                                   | 1/16        | 8                    |
| 2A10      | CMDB            | 10                              | 3.4                            | AMBIENT                   | 6                     | 3/8                                   | 1/16        | 15                   |
| 2A16      | CMDB            | 13                              | 3.9                            | WARM                      | 6                     | 3/8                                   | 1/16        | 17                   |
| 2A13      | CMDB            | 13                              | 3.9                            | AMBIENT                   | 6                     | 3/8                                   | 1/16        | 11                   |
| 2A19      | CMDB            | 16                              | 2.34                           | WARM                      | 6                     | 3/8                                   | 1/16        | 8                    |
| 2A22      | CMDB            | 16                              | 2.34                           | AMBIENT                   | 6                     | 3/8                                   | 1/16        | 3                    |
| 2B33      | CMDB            | 13                              | 3.9                            | WARM                      | 6                     | 3/8                                   | 1/16        | 89                   |
| 2B26      | CMDB            | 13                              | 3.9                            | OFF                       | 6                     | 3/8                                   | 1/16        | 105                  |
| 2B29      | CMDB            | 16.5                            | 3.9                            | OFF                       | 6                     | 3/8                                   | 1/16        | 122                  |

The double base propellants tended to crack and break up when exposed to LN<sub>2</sub>, which improved the mass removal rate. The mass removal rate for HTPB was more affected by the presence of warm GN<sub>2</sub> flow than for XLDB or CMDB. HTPB propellant did not tend to crack and break up as did the double base propellants. The Task 2 warm GN<sub>2</sub> system was very effective at limiting cryo-induced hardening of HTPB propellant, such that HTPB exhibited the highest Task 2B mass removal rate (80.3lb/hr).

In general, better mass removal rate and efficiency were produced with higher LN<sub>2</sub> pressure, as shown in Figures 16-18. However, XLDB propellant with no GN<sub>2</sub> flow, did not follow this trend (See Fig. 17). For this case the mass removal was about the same at 13,000 and 16,500 psig. This can be explained by the fact the XLDB propellant tended to crack into larger chunks than the other propellants, and the mass removal rate was dependent on the pattern of cracks through a given sample.

Comparison of the mass removal data at approximately 16,000 psig with either 2.34 or 3.9 gallons per minute appears to show a strong effect due to  $\text{LN}_2$  flow rate at least for HTPB propellant (See Fig. 16). The limited data available imply that increasing flow rate per nozzle (and thereby nozzle diameter) will increase cutting efficiency. One trial (2B35) was performed with pitch increased by a factor of approximately 1.5 (See Fig. 17). This resulted in a significant decrease in cutting performance (relative to trial number trial 2B23). Another trial (2B32) was performed during which surface speed was increased by a factor of 1.83. Mass removal actually increased during this trial (again relative to 2B23), suggesting that the range of surface speeds used during this testing is low, and higher cutting efficiency will result from higher surface speed. Another trial (2B35) was performed with a standoff distance increased by a factor of 1.77 (See Fig. 17). The mass removal decreased about 15% during this trial relative to trial 2B23, suggesting that small standoff distances should be maintained for effective propellant removal.

## 2. $\text{CO}_2$ Pellet Blasting

Table 8 shows the test parameters and results for the 9 live Task 2B  $\text{CO}_2$  pellet blasting trials conducted. No initiations or reactions were detected at any time during  $\text{CO}_2$  pellet blasting trials. Very little propellant was removed for XLDB and CMDDB samples at any blasting pressure between 250 and 600 psig. For HTPB samples some abrasion was apparent at 250 and 425 psig, but very little at 600 psig. The mass removed during the 250 psig and 425 trials was virtually the same: 7 grams at 250 psig, 8 grams at 425 psig. The minimal mass removal at 600 psig may have been because a different, and possibly less effective, nozzle was used for all trials at this pressure. If the nozzle designed for 600 psig was less effective at accelerating the  $\text{CO}_2$  pellets than the nozzle used for lower pressures, then mass removal could be less even though the driving force was higher.

It should be noted when comparing  $\text{CO}_2$  pellet blasting trials with  $\text{LN}_2$  washout trials that the trial length for  $\text{CO}_2$  trials was 6 minutes - 14.4 times longer than for Task 2A trials, and 2.4 times longer than Task 2B trials. The best mass removal rate for  $\text{CO}_2$  pellet blasting trials was 1.67 pounds per propellant blasting hour, during trial number C5A. This rate is significantly lower than for the Task 2B  $\text{LN}_2$  washout trials.

TABLE 8. TEST PARAMETERS AND MASS REMOVAL  
FOR TASK 2 CO<sub>2</sub> PELLET BLASTING TRIALS

| TRIAL NO. | PROPELLANT TYPE | BLASTING PRESSURE (psig) | NOZZLE NO. | MASS REMOVAL (grams) | CUTTING DEPTH (inches) |
|-----------|-----------------|--------------------------|------------|----------------------|------------------------|
| C3        | HTPB            | 250                      | 1          | 7                    | 0.2                    |
| C5A       | HTPB            | 425                      | 1          | 8                    | 0.2                    |
| C11A      | HTPB            | 600                      | 2          | 1                    | 0.04                   |
| C6        | XLDB            | 250                      | 1          | 1                    | 0.04                   |
| C8        | XLDB            | 425                      | 1          | <1                   | ~0                     |
| C10       | XLDB            | 600                      | 2          | <1                   | 0.03                   |
| C7        | CMDB            | 250                      | 1          | <1                   | ~0                     |
| C9        | CMDB            | 425                      | 1          | <1                   | ~0                     |
| C12       | CMDB            | 600                      | 2          | <1                   | ~0                     |

On samples for which little or no mass removal occurred the surface of the sample and of the aluminum mandrel often changed slightly in texture, becoming slightly rougher. During LN<sub>2</sub> washout trials the liquid jet had no effect on the surface of the mandrel but was far more effective at cutting propellant. This implies that the physical mechanism for mass removal by pellet blasting is different than for LN<sub>2</sub> washout. LN<sub>2</sub> washout is a cutting process, dependent on the strength of the material being cut. In contrast, CO<sub>2</sub> pellet blasting is an abrasive process that removes mass very slowly but scrubs the surface very thoroughly, even for strong, hard materials.

### C. TASK 3 - PROTOTYPE WASHOUT TESTS

During Task 3 one inert FPC, one live FPC, one inert LAM, and one live LAM were processed in that order. About 50 percent of the propellant was washed out from the inert motors, in order to conserve LN<sub>2</sub> pump life. All of the propellant was removed from the live FPC and all but about five pounds were removed from the live LAM motor.

Inert motors were processed using 16,500 psig LN<sub>2</sub> pressure with 3.9 gpm flow rate. This was the highest flow and highest pressure used during testing and was required for washout of inert

propellant. Warm GN<sub>2</sub> flow was used for both inert motors because Task 2 results indicated that inert propellant was quite sensitive to propellant temperature.

During processing of the inert FPC, partial cavitation of the LN<sub>2</sub> pump began to occur. Symptoms were loss of pump prime and unstable LN<sub>2</sub> pressure. As inert FPC washout continued, LN<sub>2</sub> pressure became more and more unstable until variations of plus or minus 2000 psig were occurring. Washout operations were halted and an external inspection of the LN<sub>2</sub> system was made. No problems were found but upon resumption of testing LN<sub>2</sub> pressure would not rise above 3000 psig. A more detailed inspection was made which indicated that the LN<sub>2</sub> pump was faulty. The pump cold end was returned to the manufacturer, inspected and found damaged. The pump was returned with the recommendation to minimize operation at combined high flow rate and high pressure unless the LN<sub>2</sub> tank pressure could be raised to stop the cavitation problem. This was not possible with the tank at the test site so inert FPC washout was discontinued and live FPC washout was begun. Task 2 results indicated that the live FPC washout could be done with pump parameters that would not damage the pump.

The live FPC washout was performed in three passes. Table 9 lists the cutting parameters and mass removal results for each pass. The live FPC was rotated at 30 rpm throughout the washout operation. This resulted in surface speeds ranging from 7.5 inches per second for the first pass to 13.2 inches per second at the outermost propellant radius. Cutting pitch was 1/16 inch for all passes. Figure 19 contains a plot of propellant mass removed versus pass number. During the first pass, slightly over two pounds of propellant were removed using an LN<sub>2</sub> jet at 13,000 psig and 3.92 gpm. For the second pass warm GN<sub>2</sub> was used to augment the LN<sub>2</sub> jet and 21 pounds of propellant were removed. On the third pass, about 17 pounds of propellant was removed together with most of the phenolic beaker (liner). The last several pounds of loose propellant and phenolic pieces were removed by hand following completion of the third pass. Propellant removal was measured by cleaning out the washout enclosure between passes. A photograph of the removed propellant is presented in Figure 20. The removed propellant was examined to determine the size range of the particles. The particles ranged from 1 inch to less than 4  $\mu$ m. Most particles were similiar in size to coarse sand.

TABLE 9. LIVE ROCKET MOTOR CRYOGENIC WASHOUT TEST SUMMARY

| ROCKET<br>MOTOR | PASS<br>NO. | LN <sub>2</sub><br>PRESSURE<br>(kpsig) | LN <sub>2</sub><br>FLOW<br>(gpm) | GN <sub>2</sub><br>CONDITION | MASS<br>REMOVAL<br>(POUNDS) | MASS REMOVAL<br>RATE<br>(POUND/HOUR) |
|-----------------|-------------|----------------------------------------|----------------------------------|------------------------------|-----------------------------|--------------------------------------|
| FPC             | 1           | 13                                     | 3.92                             | OFF                          | 2                           | 14.9                                 |
|                 | 2           | 13                                     | 3.92                             | WARM                         | 21                          | 156.2                                |
|                 | 3           | 13                                     | 3.92                             | WARM                         | 17                          | 126.4                                |
| LAM             | 1-2         | 13                                     | 3.4                              | NONE                         | 2.5                         | 8.3                                  |
|                 | 3           | 13                                     | 3.4                              | NONE                         | 2.8                         | 11.2                                 |
|                 | 4           | 13                                     | 3.4                              | NONE                         | 3.1                         | 20.7                                 |
|                 | 5           | 13                                     | 3.4                              | NONE                         | 2.1                         | 14.0                                 |
|                 | 6           | 13                                     | 3.4                              | WARM                         | 3.5                         | 23.3                                 |
|                 | 7           | 15                                     | 3.4                              | WARM                         | 2.7                         | 18.0                                 |
|                 | 8           | 15                                     | 3.4                              | WARM                         | 2.1                         | 14.0                                 |
|                 | 9           | 15                                     | 3.4                              | WARM                         | 2.6                         | 17.3                                 |
|                 | 10          | 15                                     | 3.4                              | WARM                         | 2.4                         | 16.0                                 |
|                 | 11-13       | 15                                     | 3.4                              | WARM                         | 5.6                         | 12.4                                 |
|                 | 14-16       | 15                                     | 3.4                              | WARM                         | 5.7                         | 12.7                                 |
|                 | 17-21       | 13                                     | 3.4                              | WARM                         | 14.6                        | 19.7                                 |

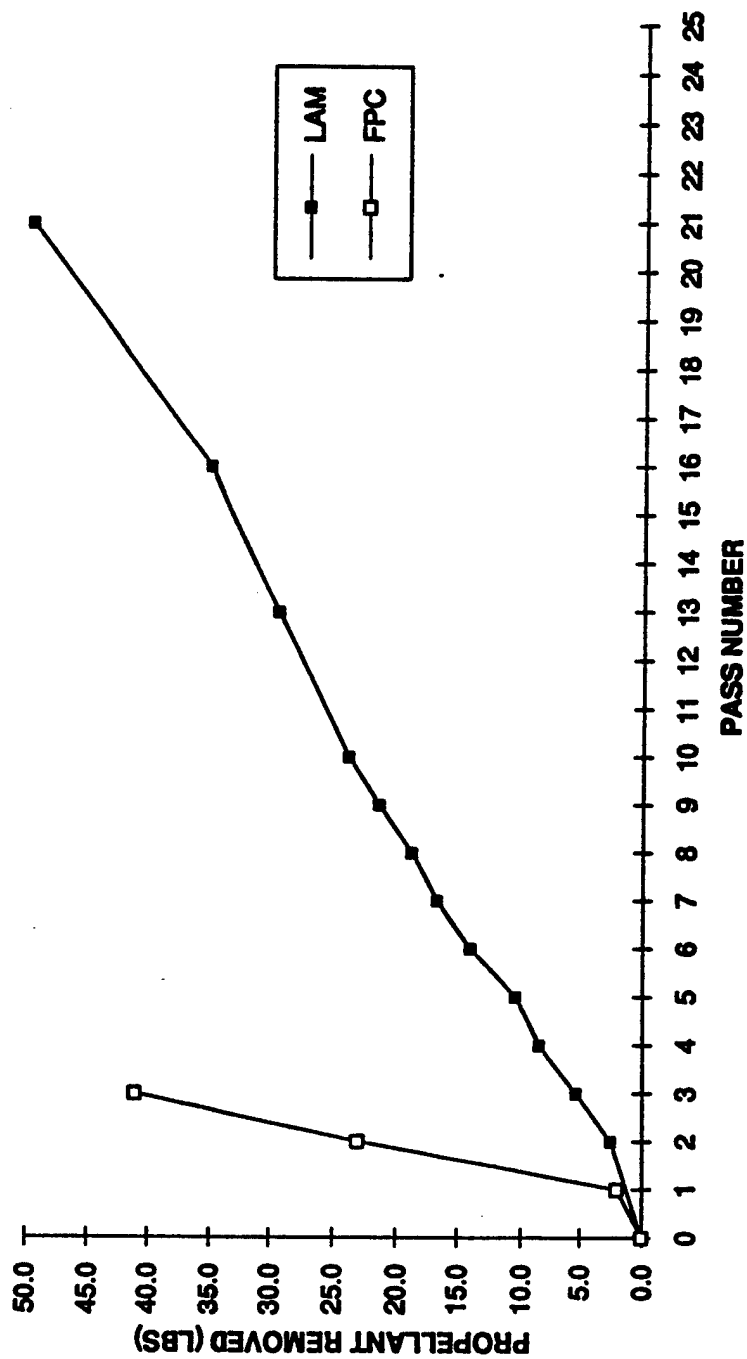


Figure 19. Propellant Removal Versus Pass Number for Task 3 Rocket Motor Washout



Figure 20. Washed out Propellant from FPC Rocket Motor (Largest Propellant Particles at Left)

Warm GN<sub>2</sub> flow was not used during the first pass because Task 2 results showed no increase in cutting effectiveness resulting from heating XLDB propellant. However, much improved mass removal rates occurred during the second and third passes, when warm GN<sub>2</sub> flow was utilized. This change in the effect of warm GN<sub>2</sub> likely results from the change in geometry between the Task 2 configuration and the Task 3 configuration. For the Task 2 configuration, the LN<sub>2</sub> falls away from the sample after impacting the propellant surface. In contrast, the LN<sub>2</sub> is relatively confined within the rocket motor bore during Task 3 washout. Warm GN<sub>2</sub> helped to counteract the results of the confined rocket motor geometry, resulting in a higher mass removal rate.

During pass 2 the mass removal rate was 156 lb/hr with a cutting efficiency of 0.10 pounds of propellant removed per pound of LN<sub>2</sub>. This performance is an improvement over that achieved during Task 2, during which the best mass removal rate for XLDB propellant was 68.4 lb/hr at 0.043 pounds per gallon. The increase in mass removal rate likely results from the lack of support for the propellant web during Task 3. Mandrel edge restraint during Task 2 likely prevented many of the particles created by propellant cracking from being released from the surface of the sample. These edge effects were not present during FPC washout, resulting in the higher propellant removal rate. Photographs of the FPC testing are presented in Fig. X through X in Appendix B.

During inert LAM processing the symptoms of partial cavitation again appeared. Therefore, washout was discontinued after enough operation to develop LAM washout methodology. The live LAM was then mounted in the test rig and washed out. The live LAM washout was performed in 21 passes. Table 9 shows the cutting parameters and mass removal for each pass. Figure 19 contains a plot of propellant mass removed versus pass number.

Prewashout inspection showed that the live LAM bore was undersize: 3.1 inches in diameter versus 3.4 inches stated on the drawings used for test rig design. The Task 3 warm GN<sub>2</sub> nozzle was designed to be a close fit inside the LAM bore and could not be inserted into the live motor. The first passes on the live LAM were therefore performed with the GN<sub>2</sub> nozzle removed and GN<sub>2</sub> flow off. After five passes the bore was large enough to accept the GN<sub>2</sub> nozzle and subsequent passes were made with warm GN<sub>2</sub> flow.

The design of the Task 3  $\text{GN}_2$  nozzle allowed increased clearance as the LAM was washed out. In addition, the small diameter motor bore and closed geometry resulted in an increased need for effective warm  $\text{GN}_2$  flow, as discussed above for the live FPC. These combined factors resulted in lower mass removal rate for the live LAM, relative to Task 2 HTPB propellant washout trials. The best mass removal rate for HTPB propellant during Task 2 was 80.3 pounds per hour with mass removal efficiency equal to 0.050 pounds removed per pound of  $\text{LN}_2$ . During live LAM washout the mass removal was a maximum of 23.3 pounds per hour, with an efficiency of 0.014 pounds of propellant per pound of  $\text{LN}_2$ . These results suggest that the design of the warm  $\text{GN}_2$  nozzle system is an important consideration for improved cutting performance and efficiency. In addition, larger rocket motors with less confined internal geometry may be less sensitive to  $\text{GN}_2$  nozzle performance.

During preparation for pass number 7, symptoms of partial cavitation began with  $\text{LN}_2$  pressure set at 13,000 psig and flow equal to 3.92 gpm. This combination had not previously caused problems, indicating a possible degeneration in pump performance. Experiments determined that a lower flowrate and higher pressure combination did not cause pump cavitation, and the balance of live LAM washout was performed at 15,000 psig  $\text{LN}_2$  pressure with 3.4 gpm flow. Cutting performance appeared to be unaffected by the change.

On the final 5 passes of live LAM, mass removal rate was markedly improved. As portions of the case were exposed the angled  $\text{LN}_2$  jet could start to penetrate between the case and propellant, popping loose sections of propellant from the case.

Motor rotation was held at a constant 30 rpm during live LAM washout, with 1/16 inch pitch. Surface speed varied from 5 inches per second for the first pass to 16 inches per second at the case. Improved cutting efficiency would most likely have occurred if the motor was rotated faster for the first few passes. The washed out LAM case is shown in Figure 21. Most of the particles of removed propellant were similar in size to coarse sand and much more uniform in size than for the XLDB propellant. A small amount of propellant (approximately 5 lbs.) remained at the nose of the case. This could not be removed because of the fixed nozzle geometry used for the testing. Had resources allowed a nozzle with greater than a 15 degree angle could have been used to wash out this area without difficulty.

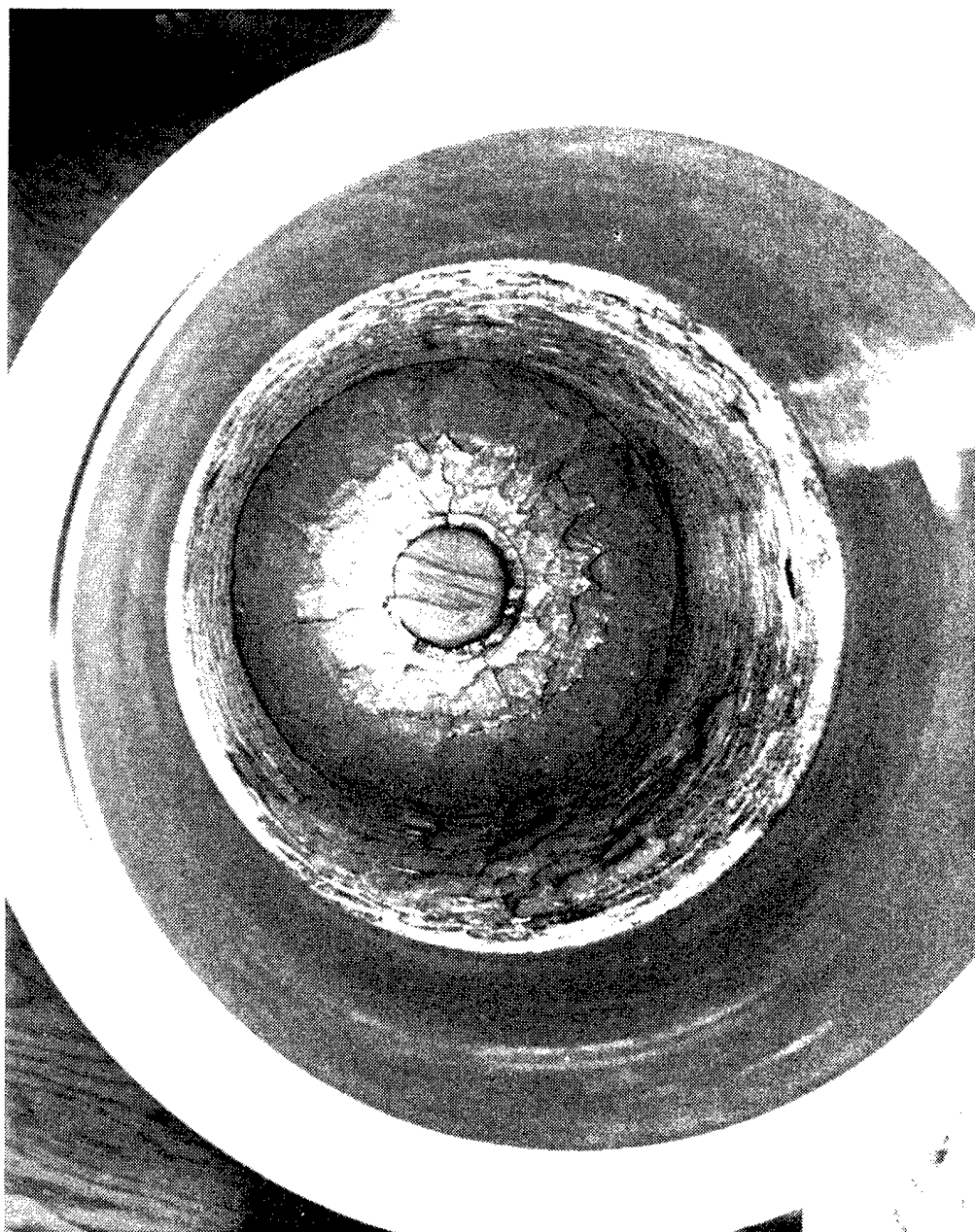


Figure 21. Live LAM Rocket Motor after LN<sub>2</sub> Washout of HTPB Propellant

## SECTION V

### CONCLUSIONS

Based on the results of the Task 1, 2 and 3 tests, the following conclusions are drawn:

- Good propellant cutting effectiveness was achieved during cryogenic washout of solid propellants. Maximum mass removal rates were 80.3 pounds per hour for HTPB propellant, 156 pounds per hour for XLDB propellant, and 60.0 pounds per hour for CMDB propellant. All testing was conducted at less than 3.92 gallons per minute  $\text{LN}_2$  flow through a single nozzle. Maximum cutting efficiencies were 0.05, 0.10, and 0.038 pounds per pound of  $\text{LN}_2$  for HTPB, XLDB, and CMDB propellants respectively.
- Sensitivity of the HTPB, XLDB, and CMDB propellants tested was essentially unchanged from room temperature to  $-320^\circ\text{F}$ . The sensitivity of temperature cycled propellant (between ambient and  $-320^\circ\text{F}$ ) was also unchanged from uncycled propellant. No changes in nitroglycerin or stabilizer concentrations were observed during post test analysis of washed out XLDB propellant. Electrical resistance increased for all three propellants; markedly so for XLDB and CMDB propellants. However, the dielectric breakdown voltages decreased for all three propellants. Thus a tradeoff in electrical properties occurred at cryogenic temperatures which suggested that electrostatic charges build up more slowly, but reach breakdown more quickly.
- Warm  $\text{GN}_2$  flow used to warm the propellant surface during  $\text{LN}_2$  washout increased cutting effectiveness. HTPB propellant was particularly affected by the use of warm  $\text{GN}_2$  flow.
- Cracking of the double base propellants (XLDB and CMDB) under thermal stress resulting from  $\text{LN}_2$  jet impingement increased mass removal by promoting breakup of the propellant surface. HTPB propellant did not exhibit this tendency to crack during  $\text{LN}_2$  washout.

- A wide range of propellant particle sizes was produced during  $\text{LN}_2$  washout. Most particles were similiar in size to course sand, with a few large chunks in the size range of 50 to 90 gms, and a small amount of fine dust.
- No initiations were detected during  $\text{CO}_2$  pellet blasting trials. However, mass removal rates were poor compared with high pressure  $\text{LN}_2$  washout.

## SECTION VI

### REFERENCES

1. Test Plan: Cryogenic Washout of Solid Propellants, General Atomics Inc. Report No. 758001, January 1992.
2. DeNevers, C.C., Cryogenic Size Reduction General Operating Procedure, Hercules Aerospace Inc. CSR-001 Rev 1, May 1992.
3. Creedon, W.P., Test Logs (#1 - #2): Solid Propellant Cryogenic Size Reduction Program, General Atomics Inc. Report No. 758004, May 1992.
4. Creedon, W.P. Task 2 Data Sheets: Solid Propellant Cryogenic Size Reduction Program, General Atomics Inc. Report No. 758003, May 1992.
5. Risk Management/Hazards Analysis Report for Solid Propellant Cryogenic Washout Bench Scale (Task 2) and Prototype (Task 3) Tests and Laboratory Sensitivity and Hazard Test Report (Task 1), General Atomics Inc. Report No. 758002, March 1992.

**APPENDIX A**  
**TASK 1 PROPELLANT SENSITIVITY PLOTS**

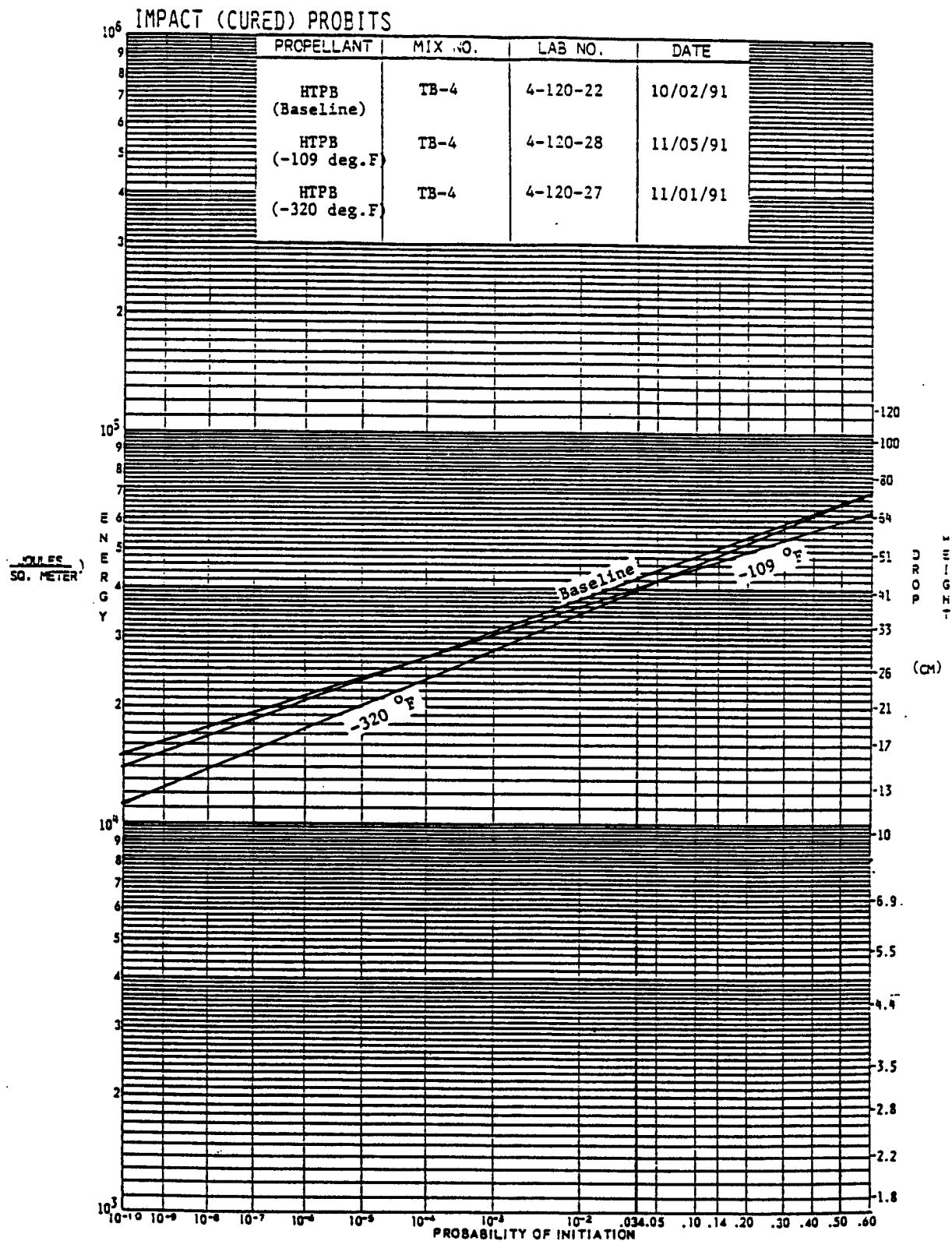


Figure A1. Impact Sensitivity for HTPB Propellant at Ambient and Cryogenic Temperatures

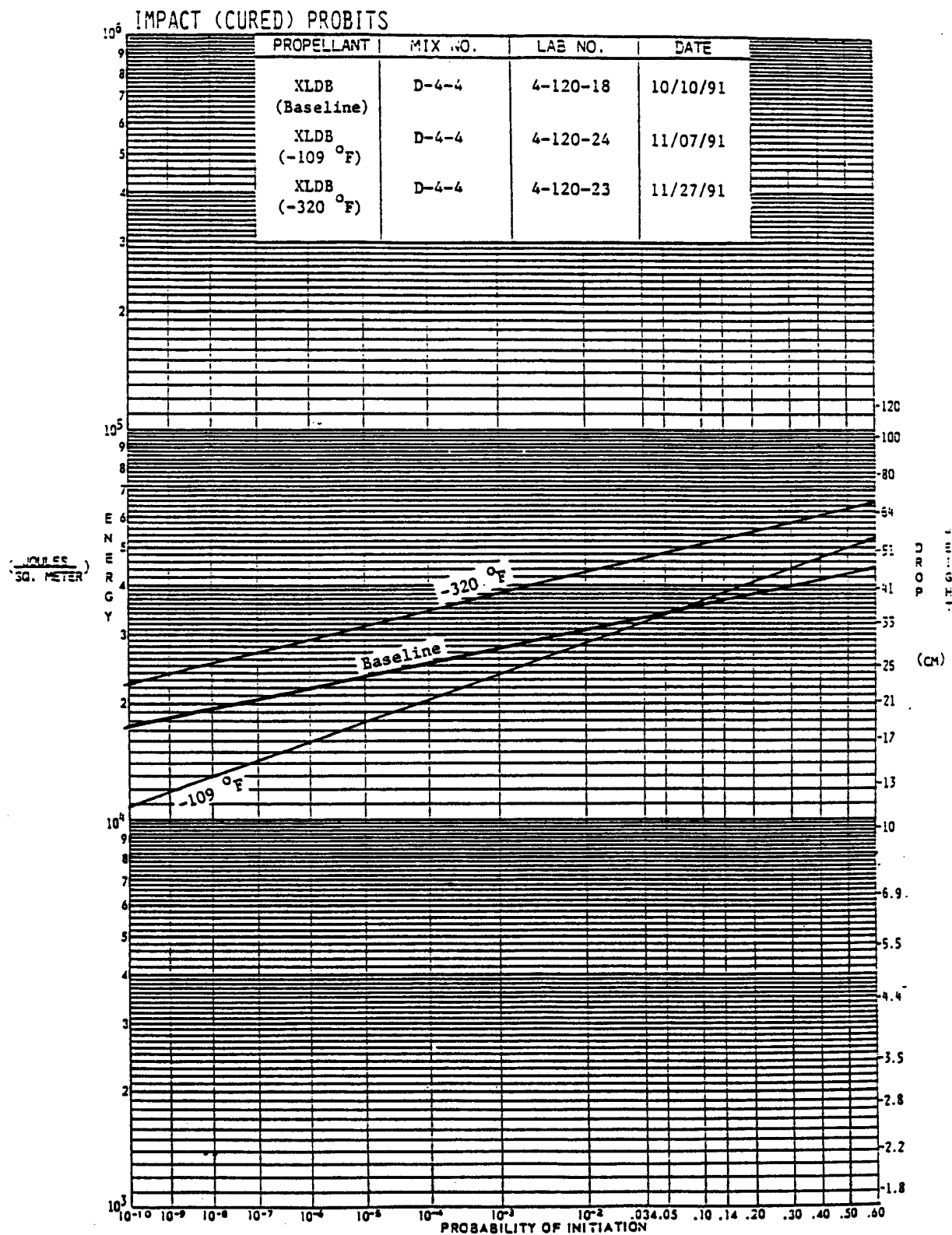


Figure A2. Impact Sensitivity for XLDB Propellant at Ambient and Cryogenic Temperatures

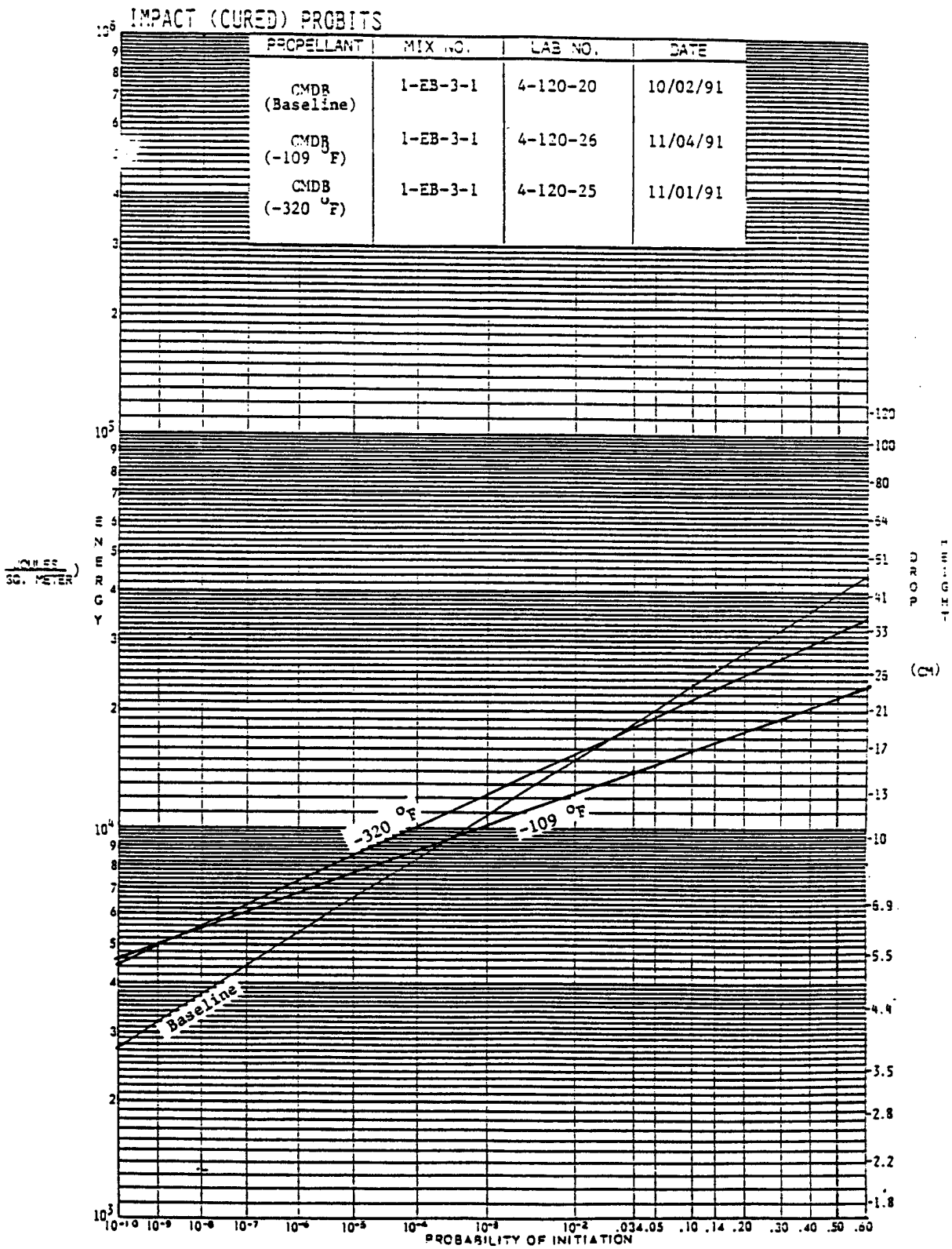


Figure A3. Impact Sensitivity for CMDB Propellant at Ambient and Reduced Temperatures

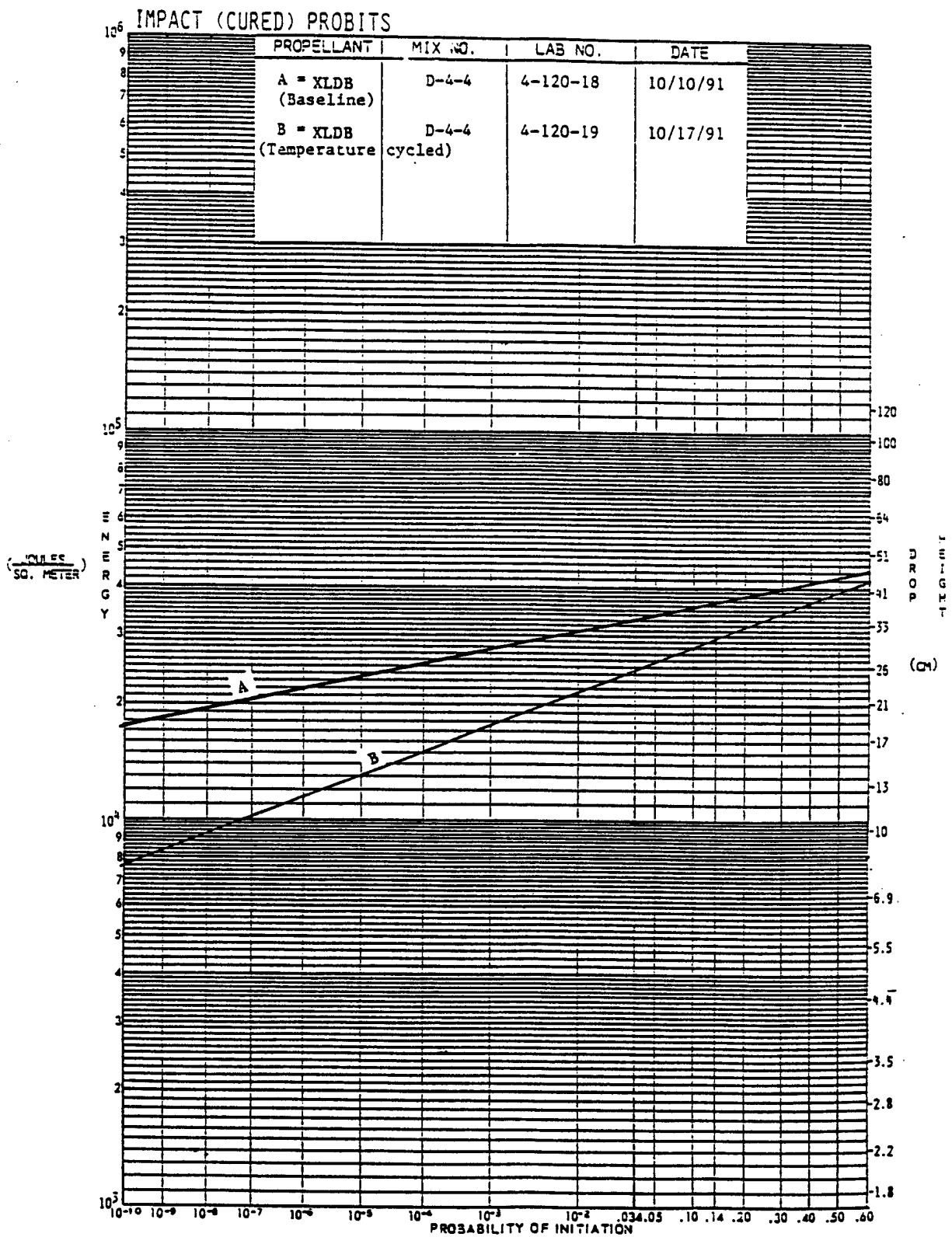


Figure A4. Impact Sensitivity for Temperature Cycled XLDB Propellant

٤٠:

| PROPELLANT                       | MIX NO.  | LAB NO.  | DATE     |
|----------------------------------|----------|----------|----------|
| A = CMDB<br>(Baseline)           | 1-EB-3-1 | 4-120-20 | 10/02/91 |
| B = CMDB<br>(Temperature cycled) | 1-EB-3-1 | 4-120-21 | 10/18/91 |

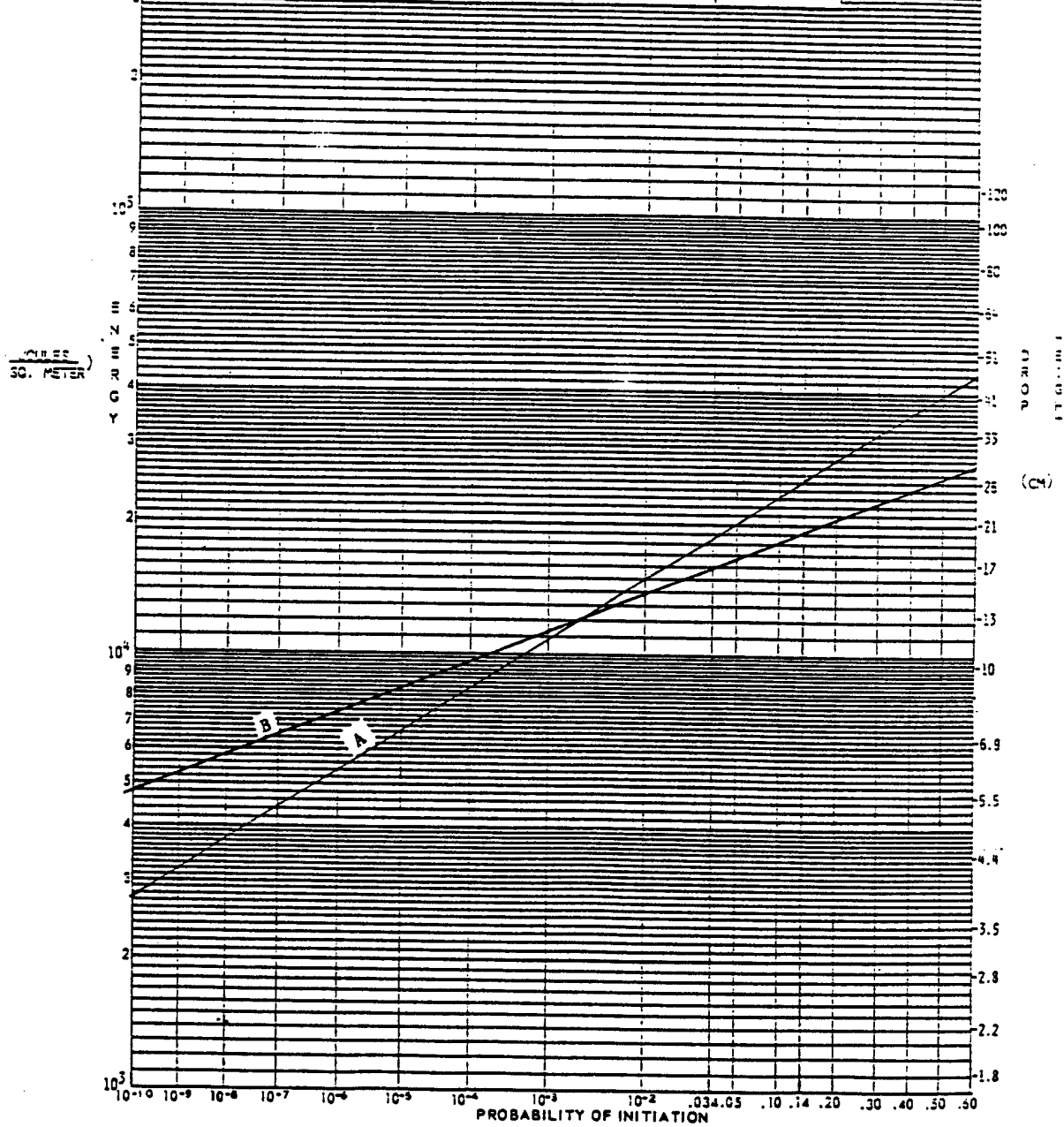


Figure A5. Impact Sensitivity for Temperature Cycled CMDB Propellant

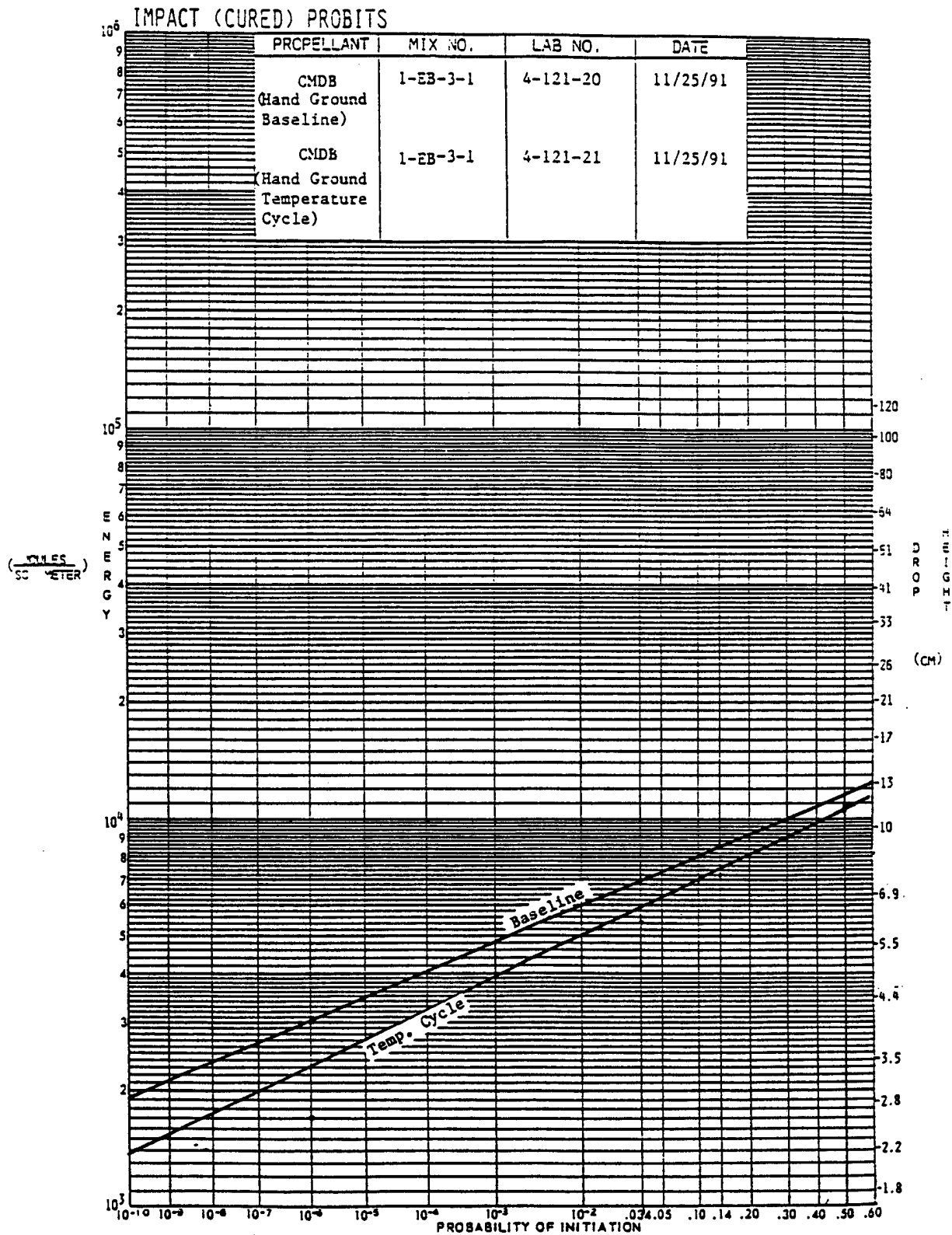


Figure A6. Impact Sensitivity for Temperature Cycled Hand Ground CMDB Propellant

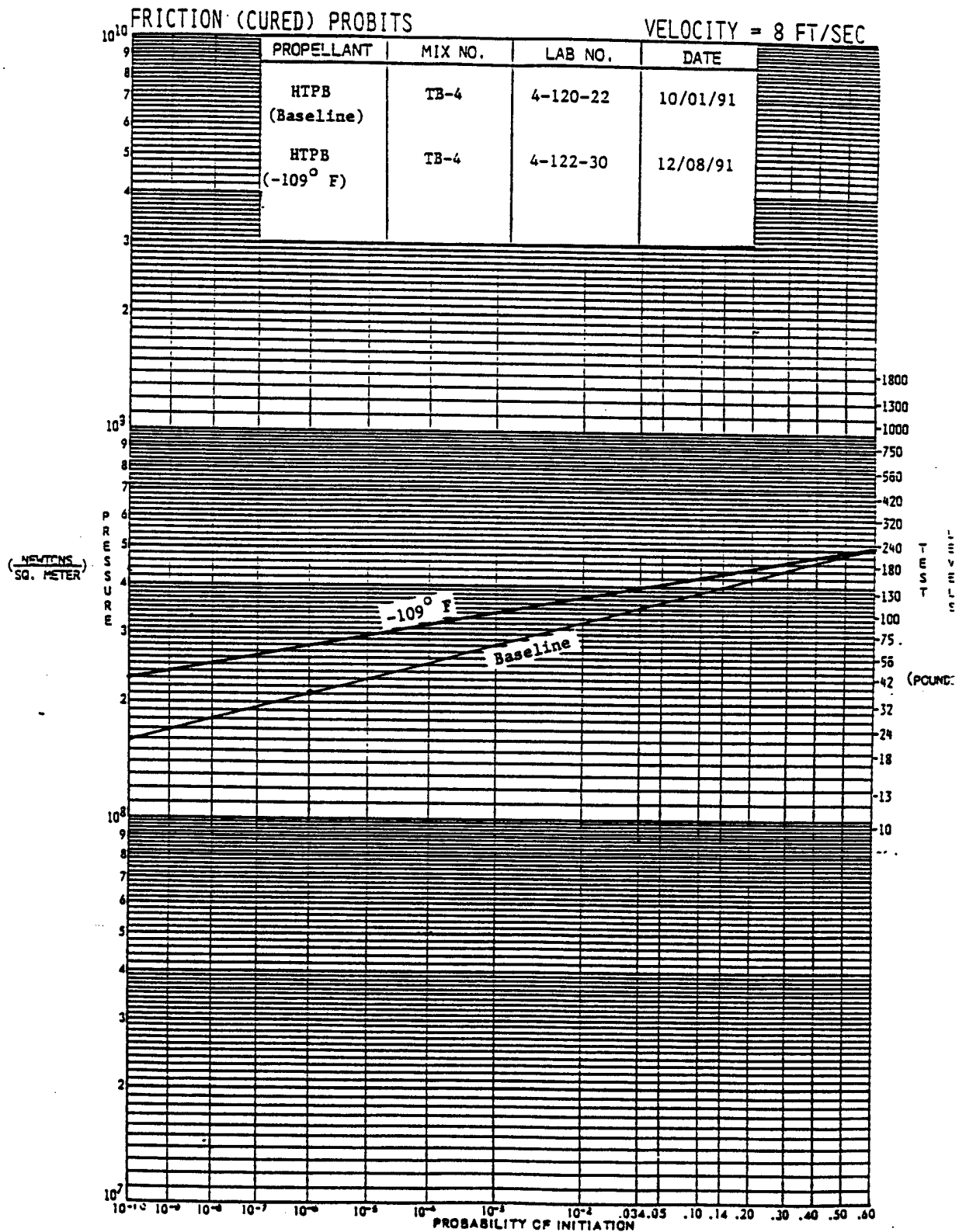


Figure A7. Friction Sensitivity for HTPB Propellant at Ambient and Cryogenic Temperatures

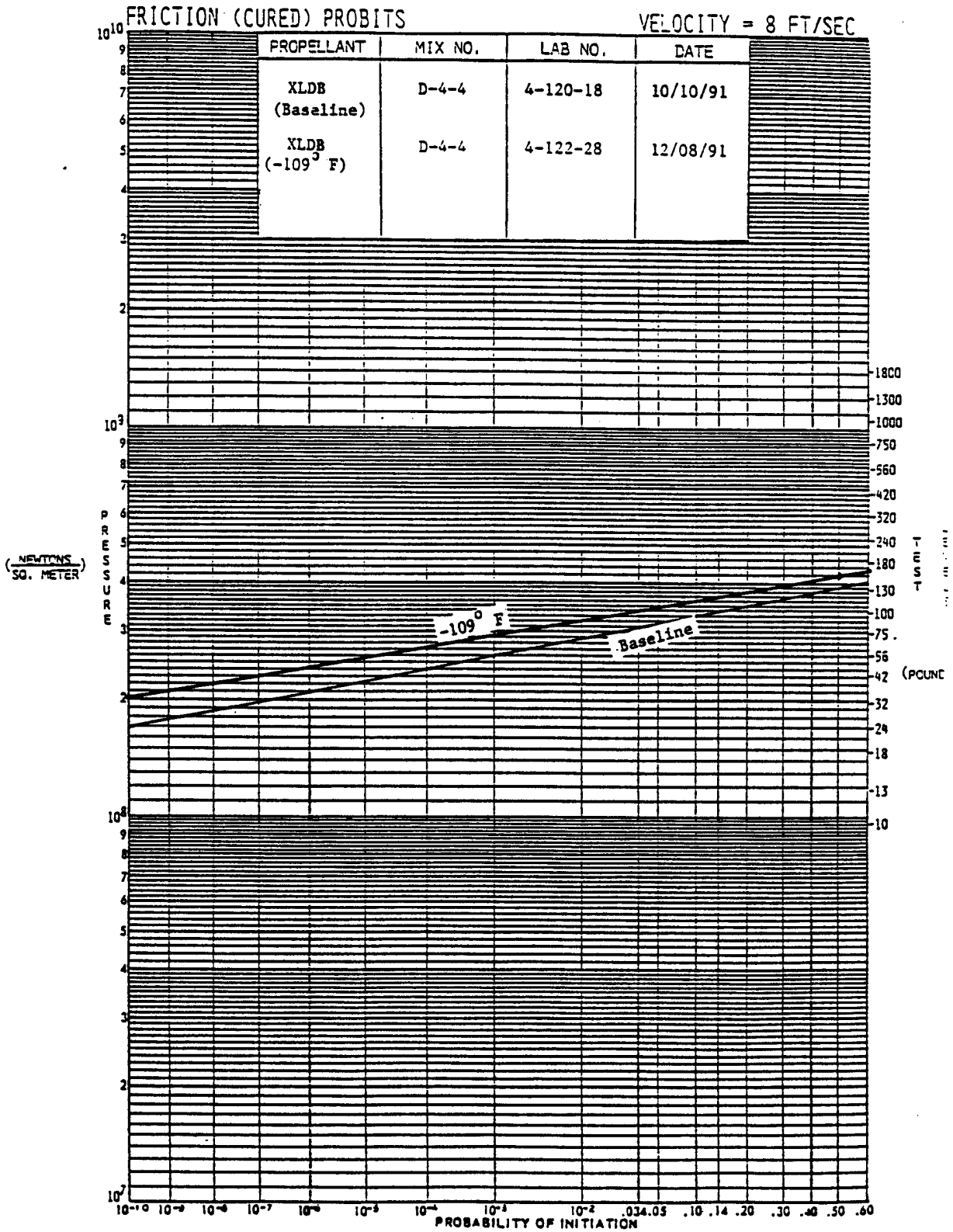


Figure A8. Friction Sensitivity of XLDB Propellant at Ambient and Cryogenic Temperatures

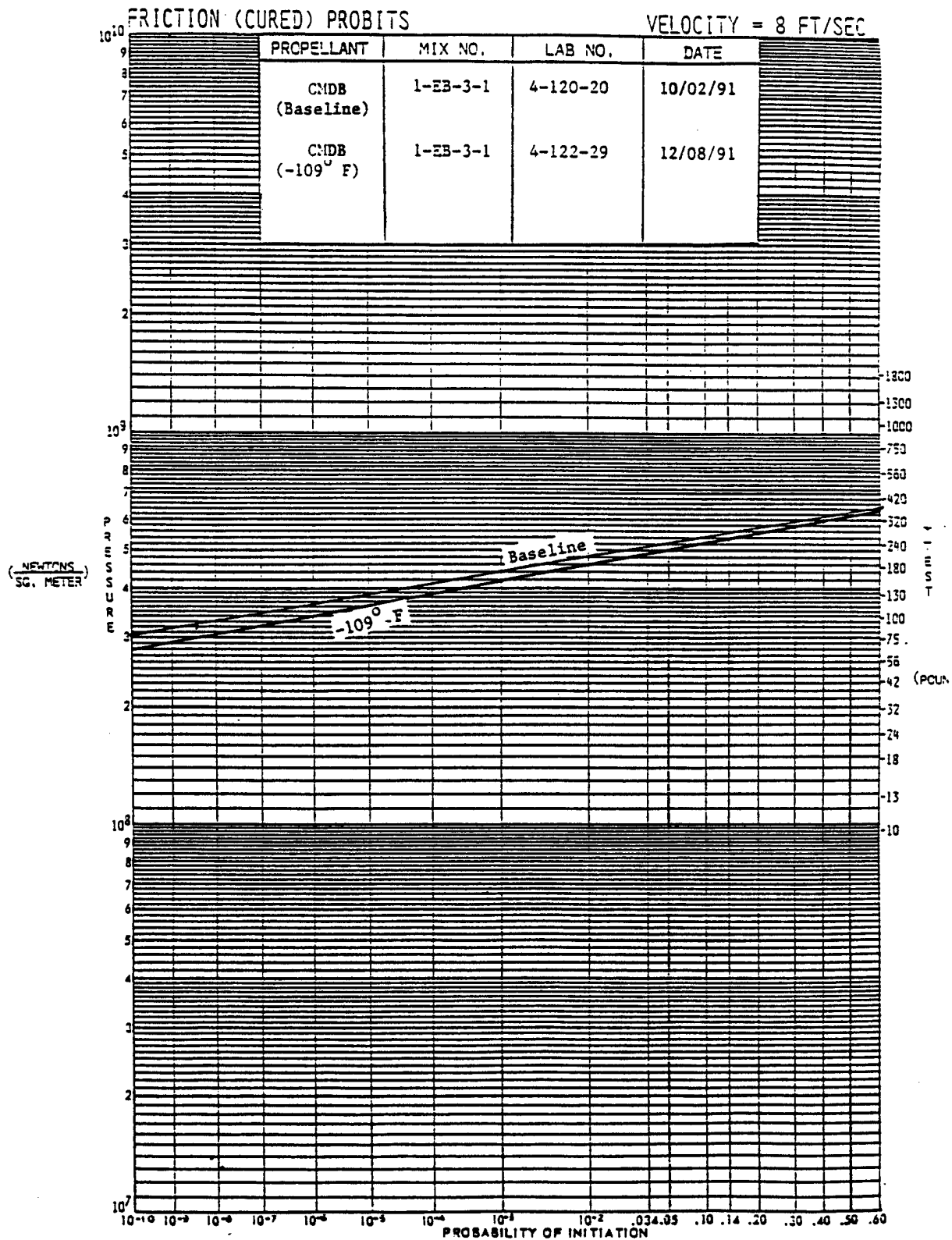


Figure A9. Friction Sensitivity of CMDB Propellant at Ambient and Cryogenic Temperatures

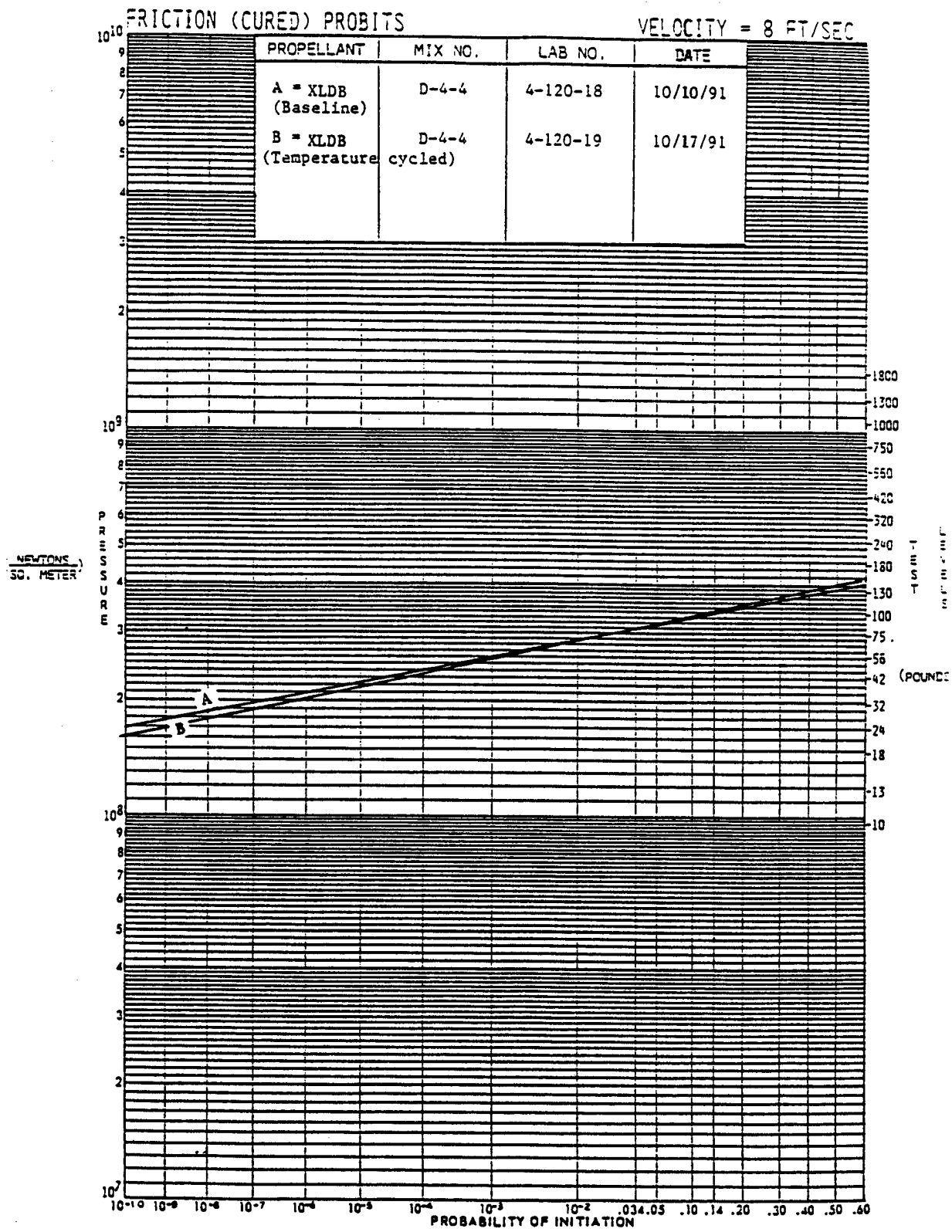


Figure A10. Friction Sensitivity for Temperature Cycled XLDB Propellant

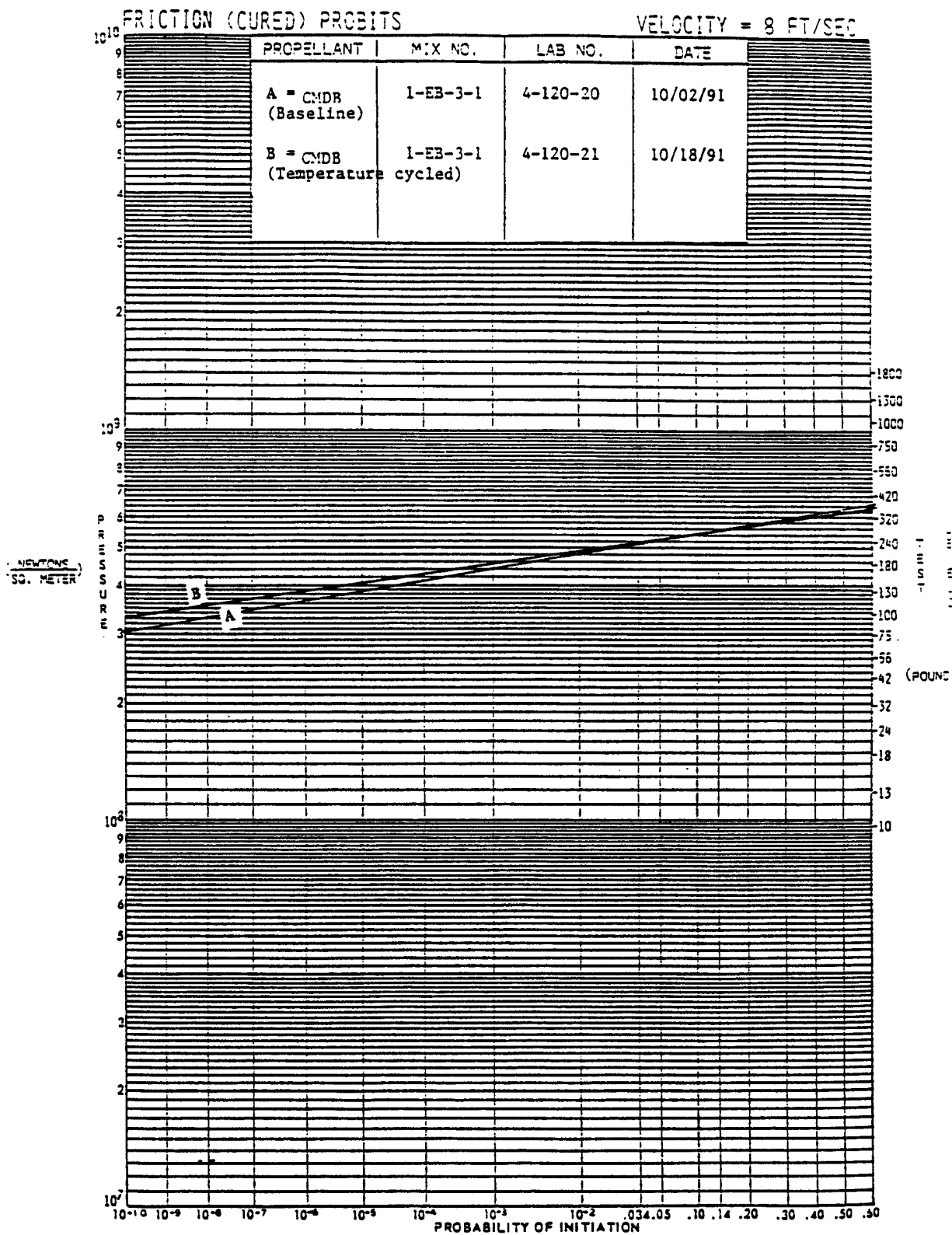


Figure A11. Friction Sensitivity for Temperature Cycled CMDR Propellant

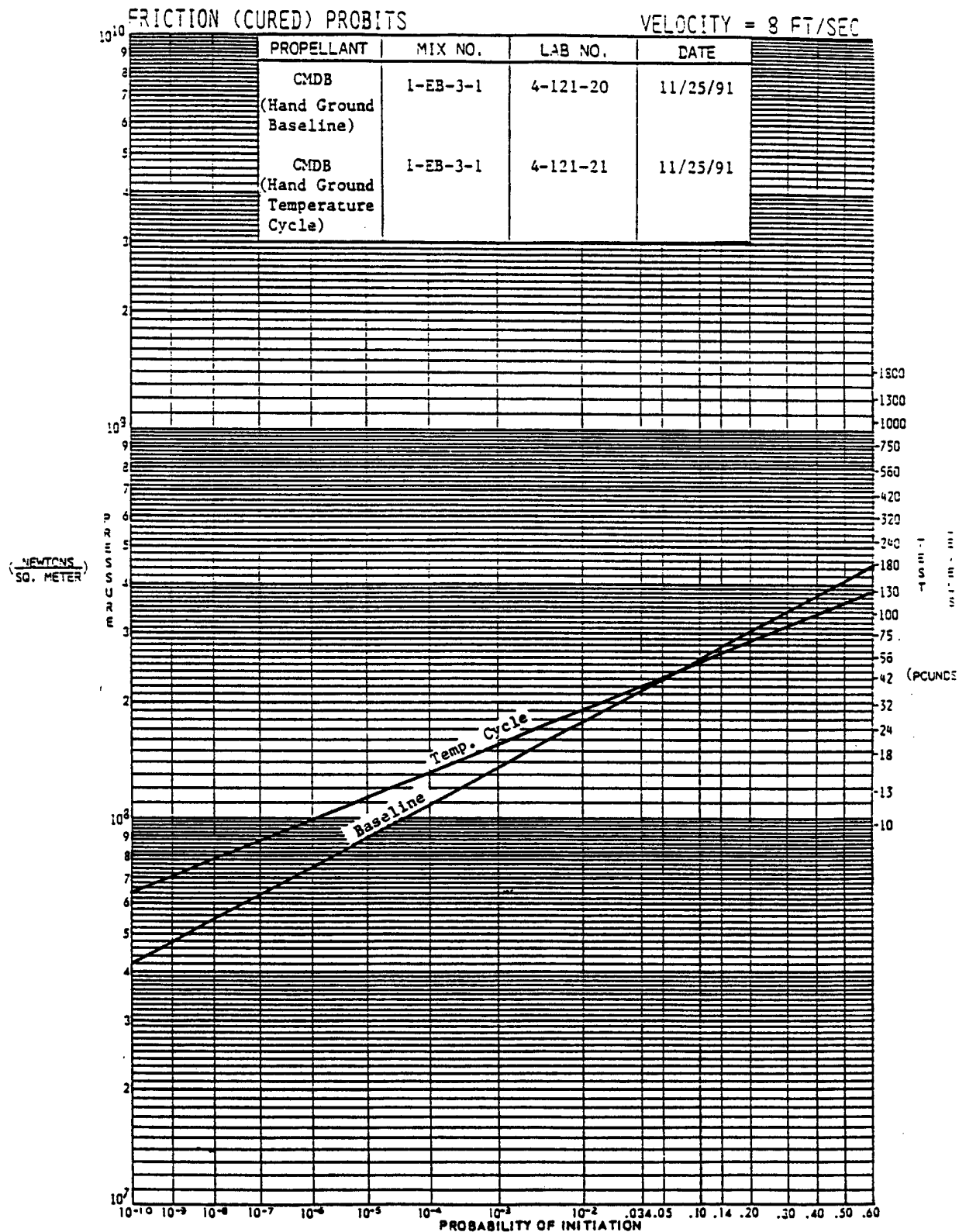


Figure A12. Friction Sensitivity for Hand Ground Temperature Cycled CMDB Propellant

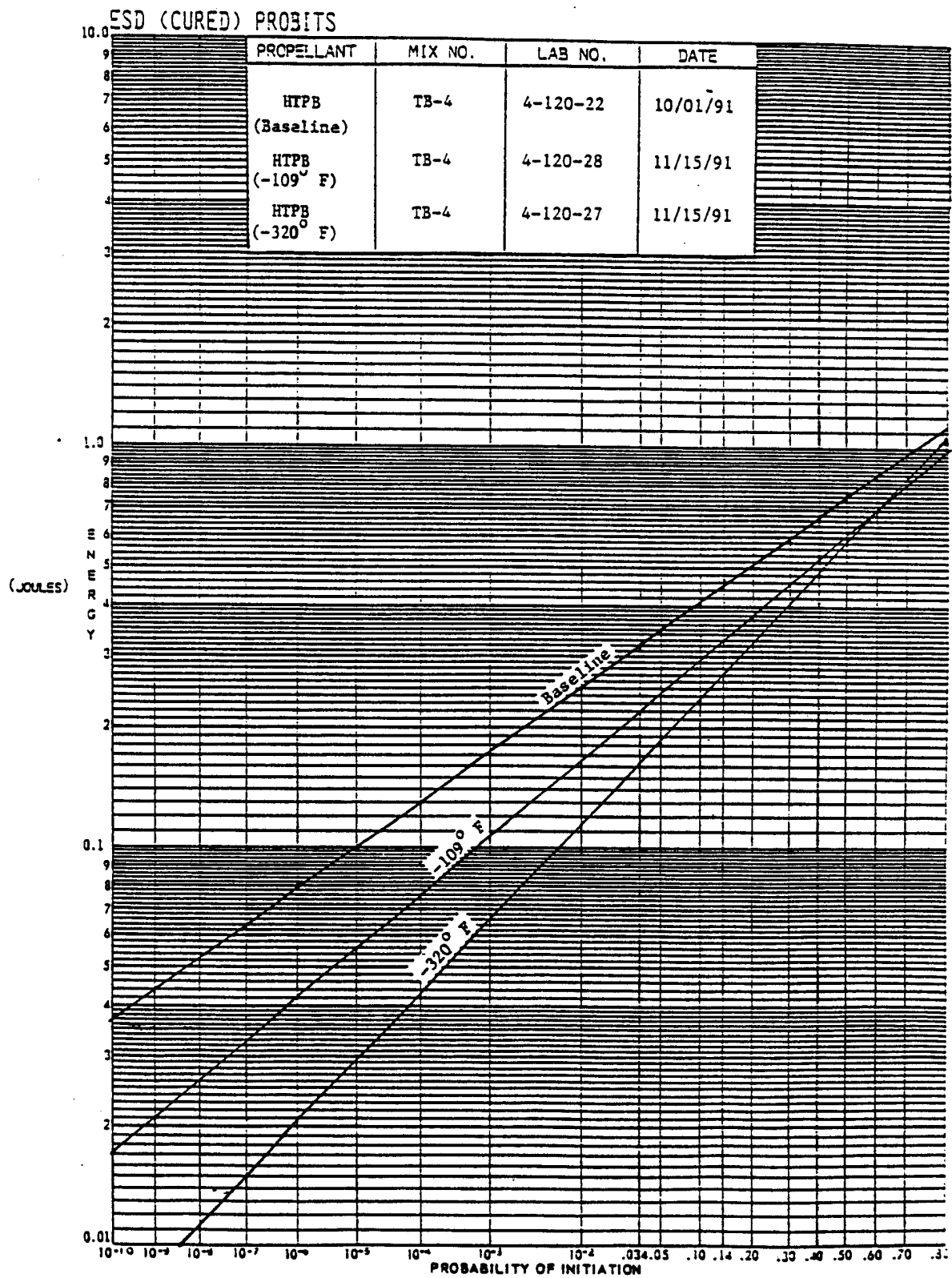


Figure A13. Electrostatic Discharge Sensitivity for HTPB Propellant at Ambient and Cryogenic Temperatures

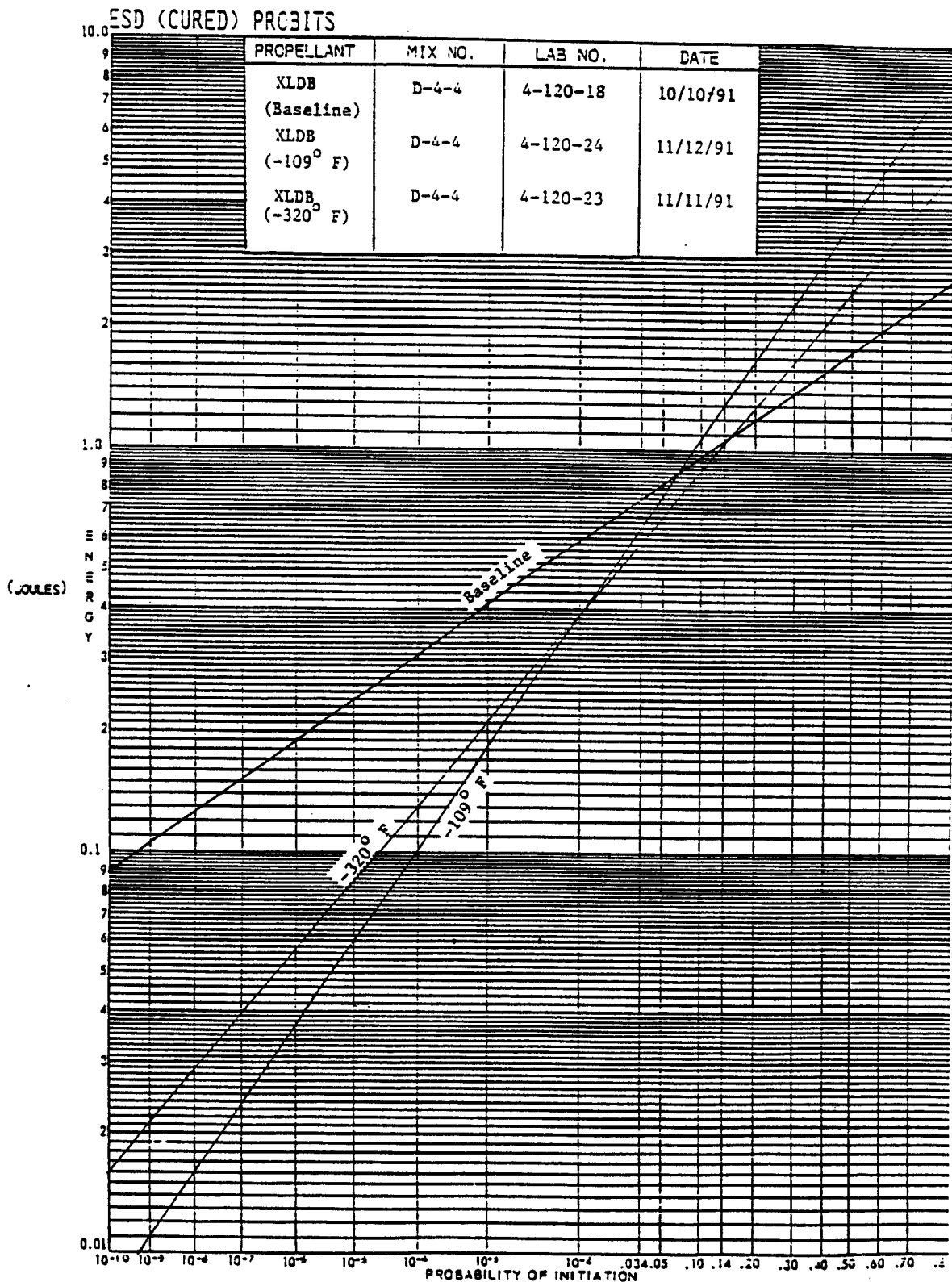


Figure A14. Electrostatic Discharge Sensitivity for XLDB Propellant at Ambient and Cryogenic Temperatures

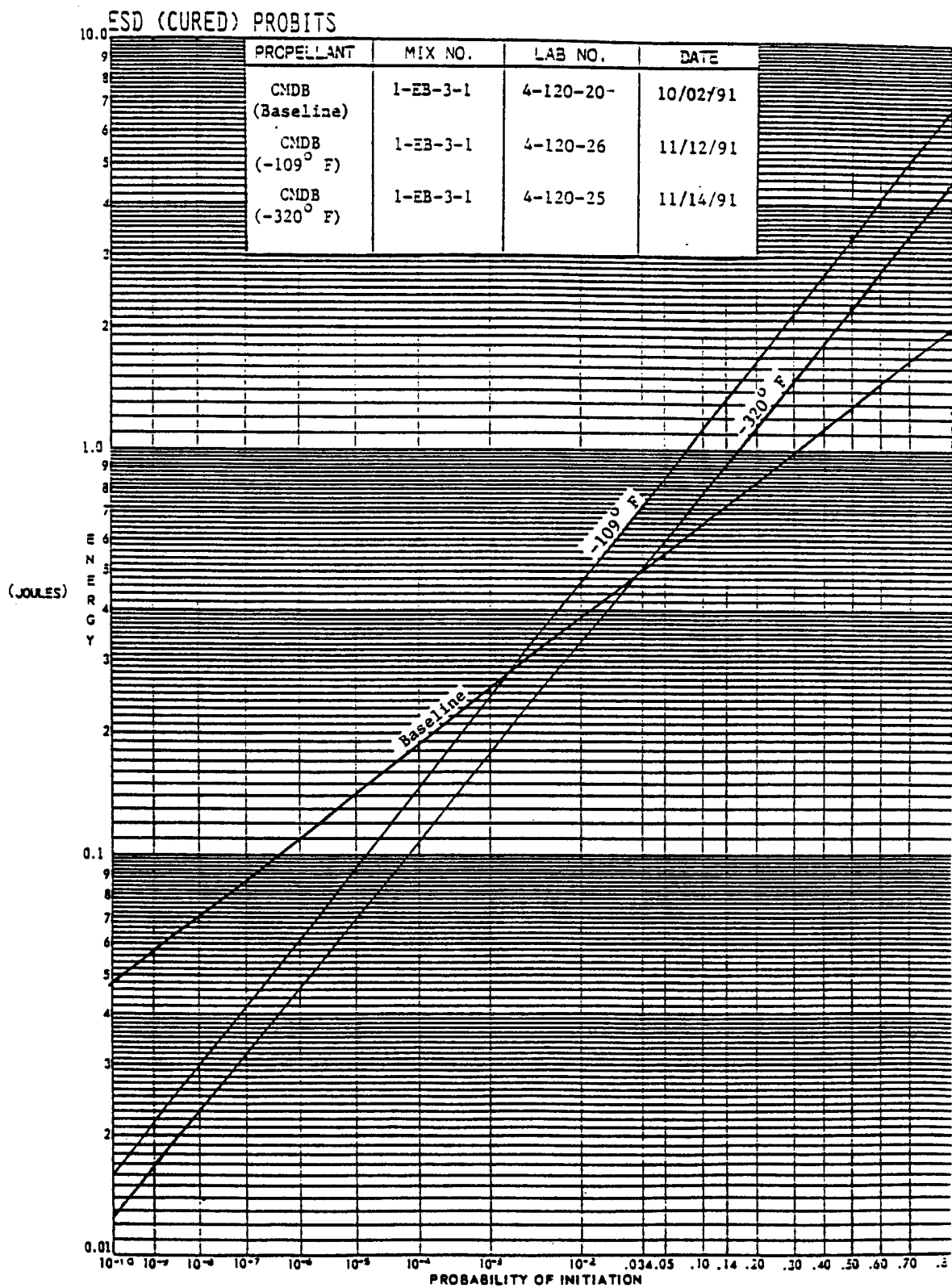


Figure A15. Electrostatic Discharge Sensitivity for CMDB Propellant at Ambient and Cryogenic Temperatures

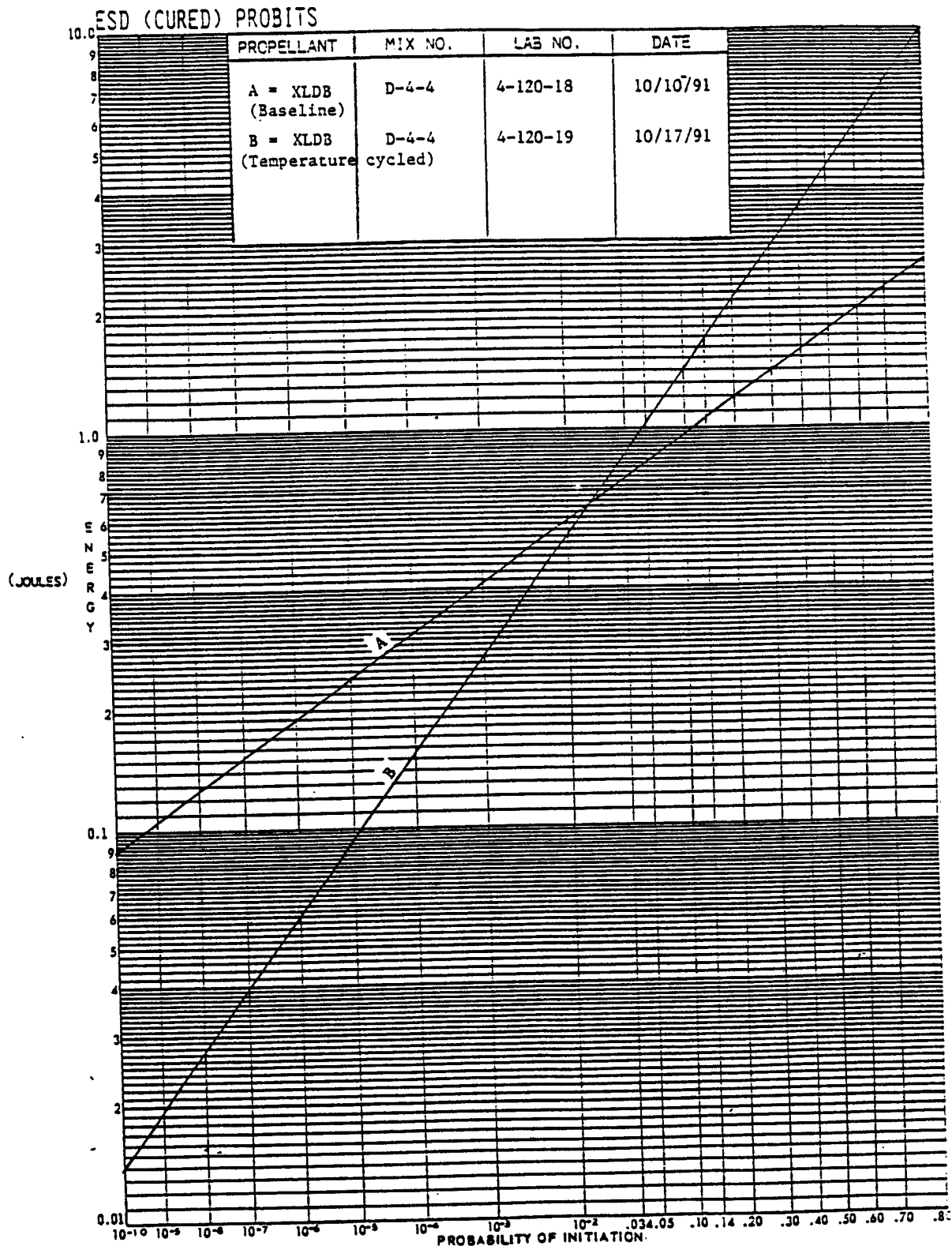


Figure A16. Electrostatic Discharge Sensitivity for Temperature Cycled XLDB Propellant

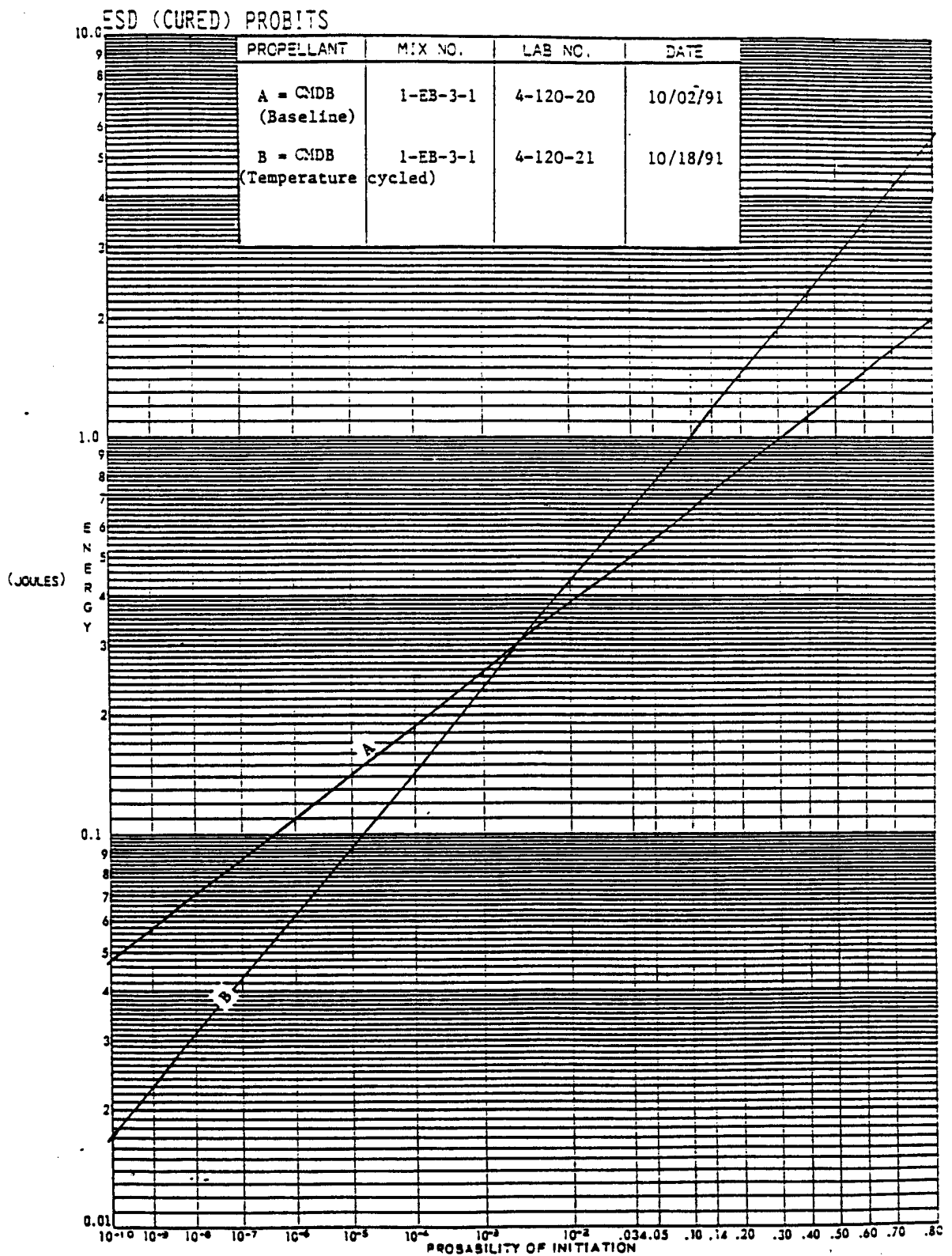


Figure A17. Electrostatic Discharge Sensitivity for Temperature Cycled CMDB Propellant

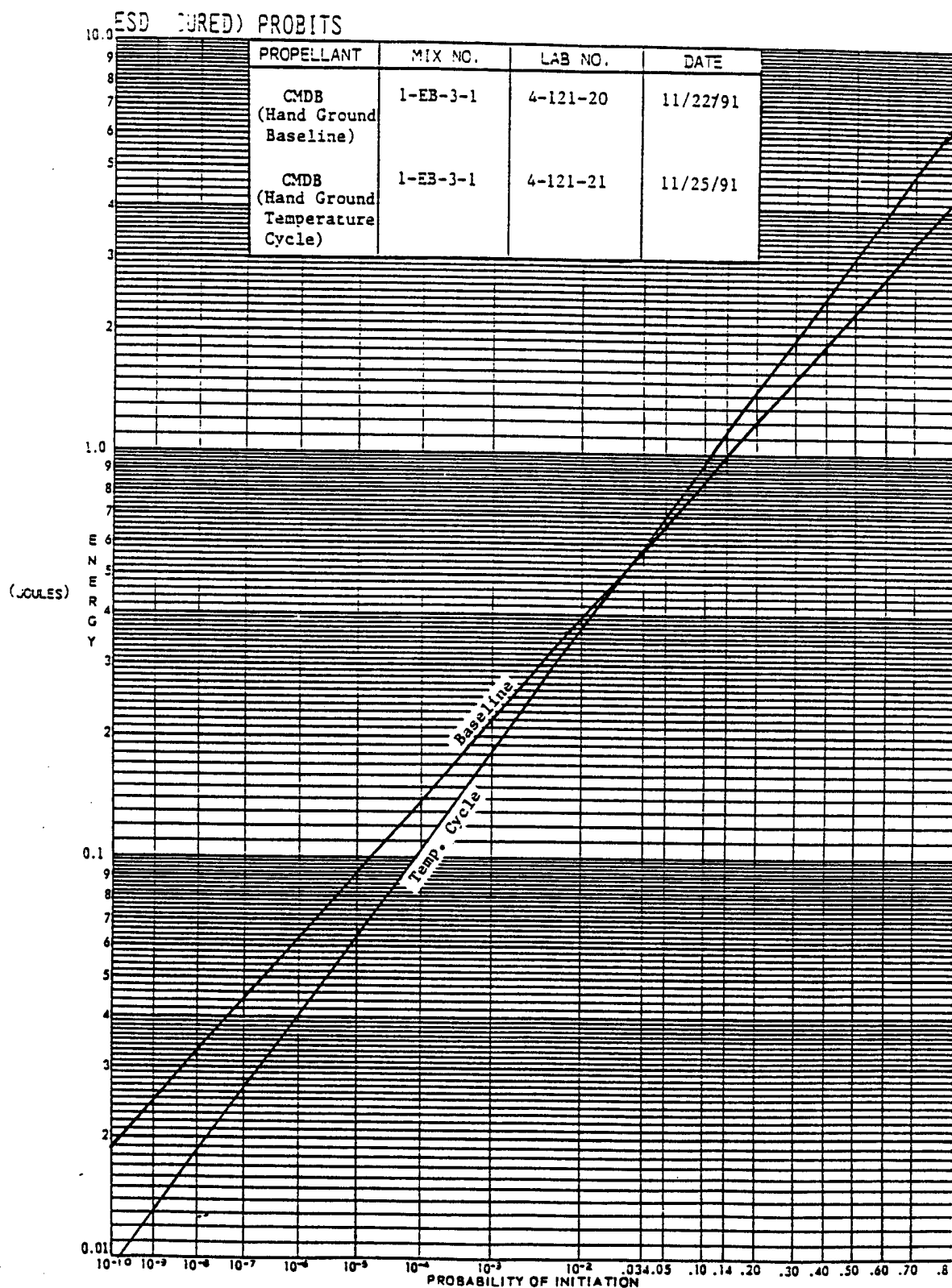


Figure A18. Electrostatic Discharge Sensitivity for Hand Ground Temperature Cycled CMDB Propellant

**APPENDIX B**  
**TASK 1 PROPELLANT SAMPLE PHOTOGRAPHS**

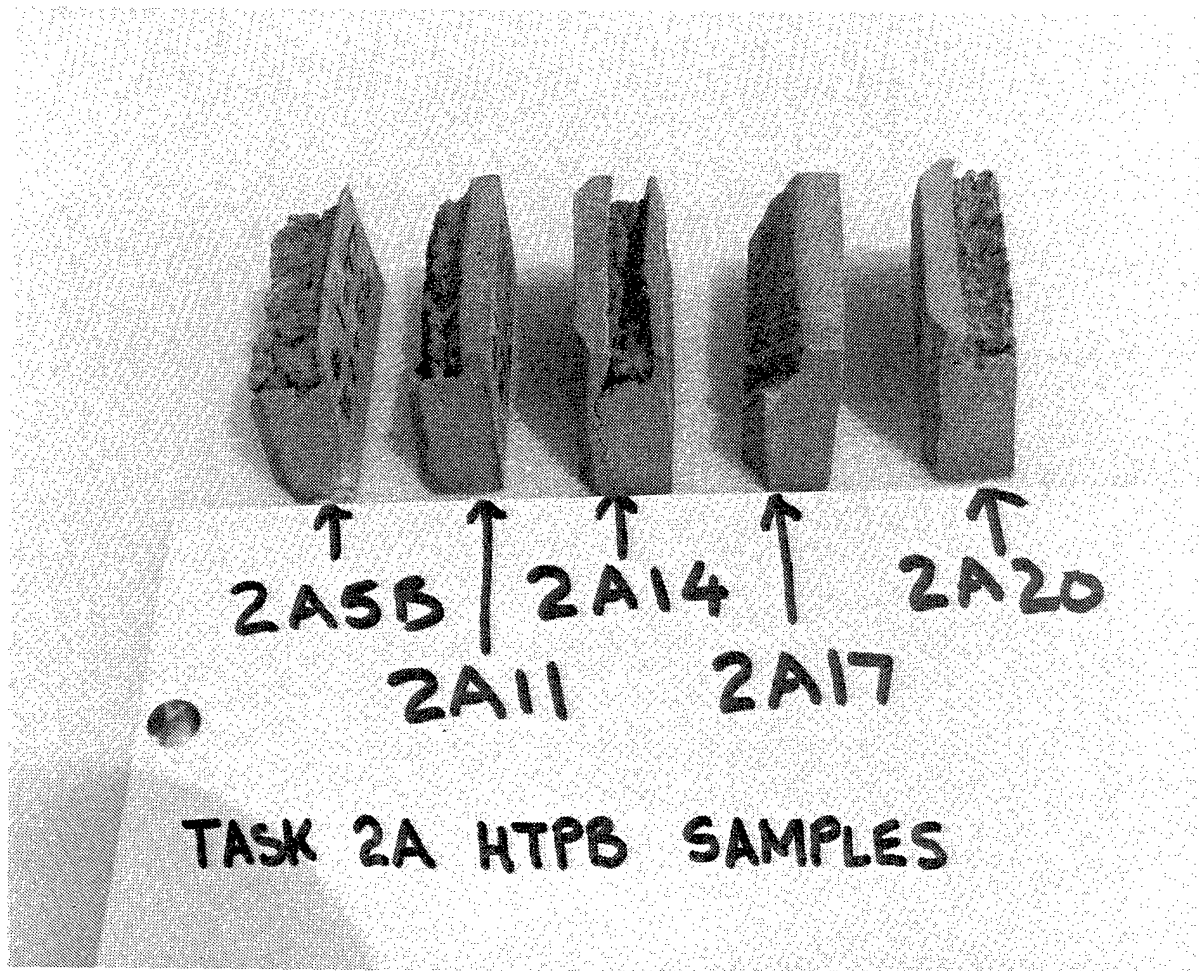


Figure B1. Task 2A HTPB Samples

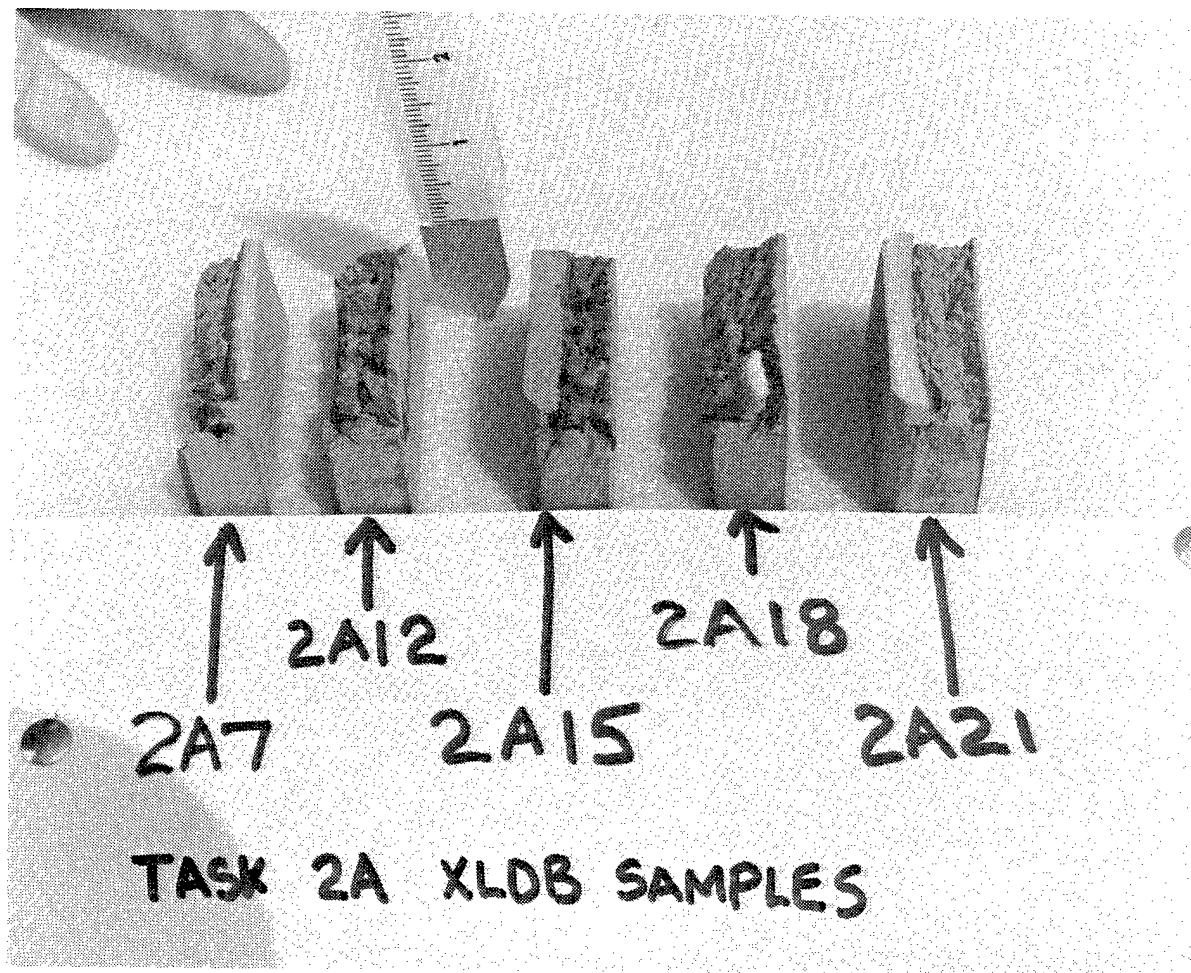


Figure B2. Task 2A XLDB Samples

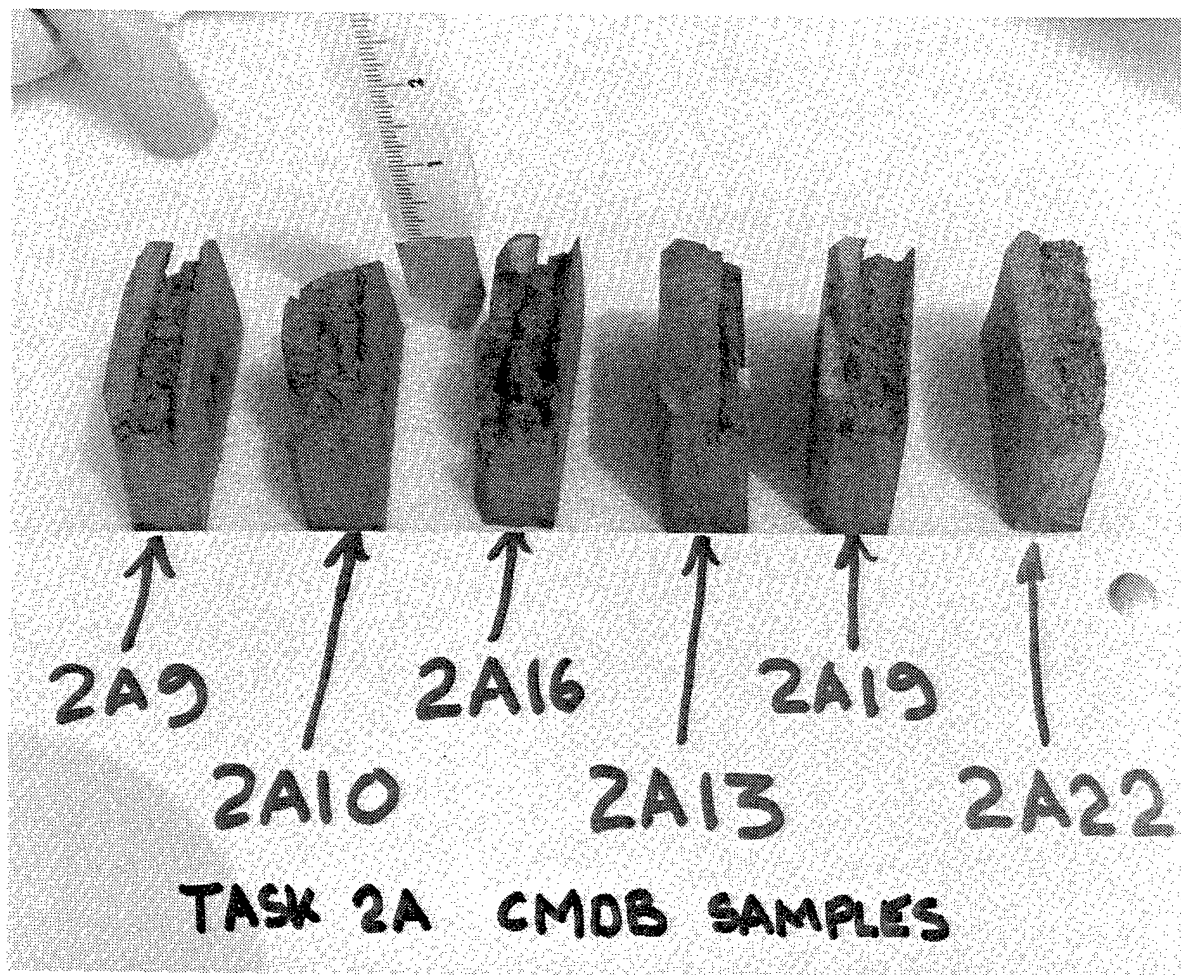


Figure B3. Task 2A CMDB Samples

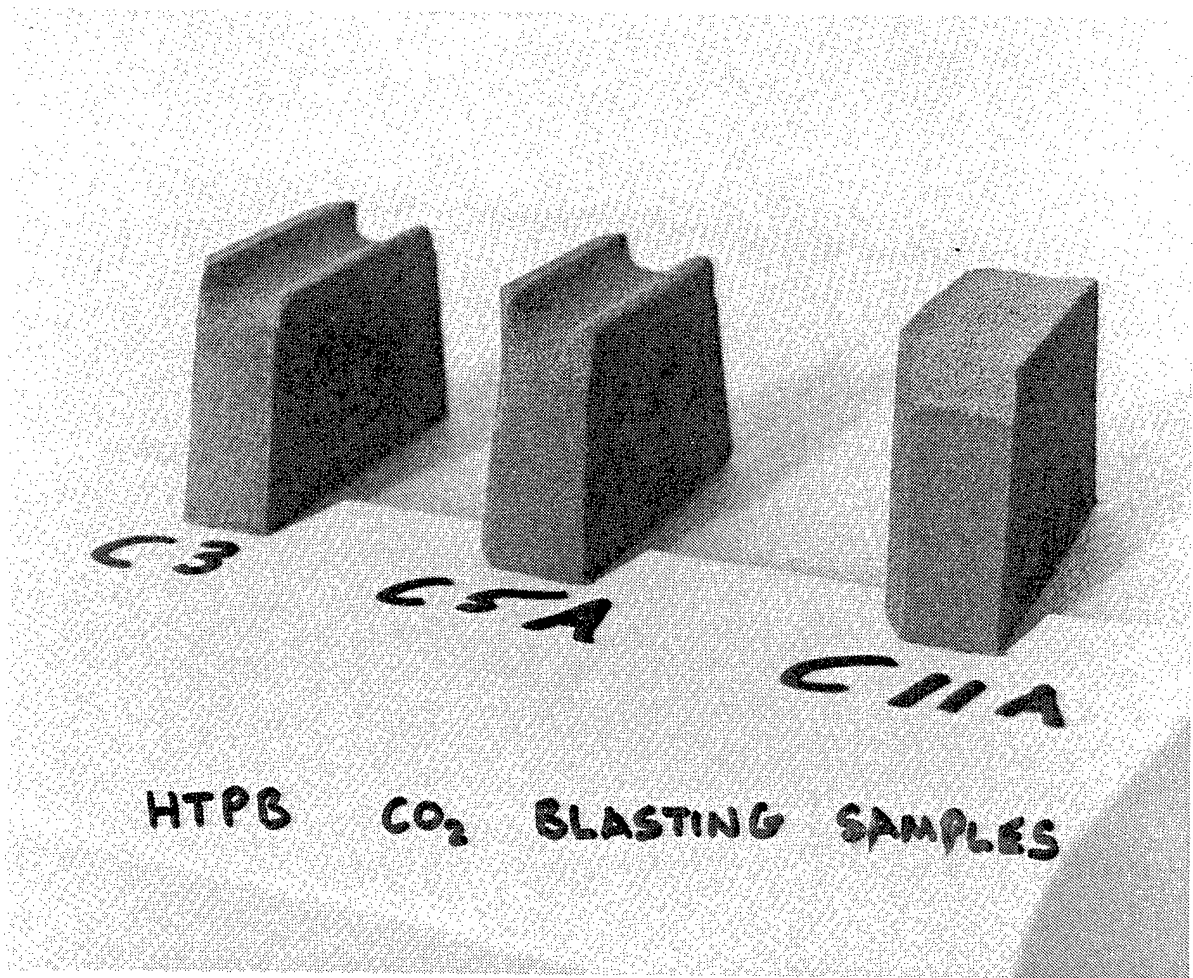


Figure B4. Task 2 HTPB CO<sub>2</sub> Pellet Blasting Samples

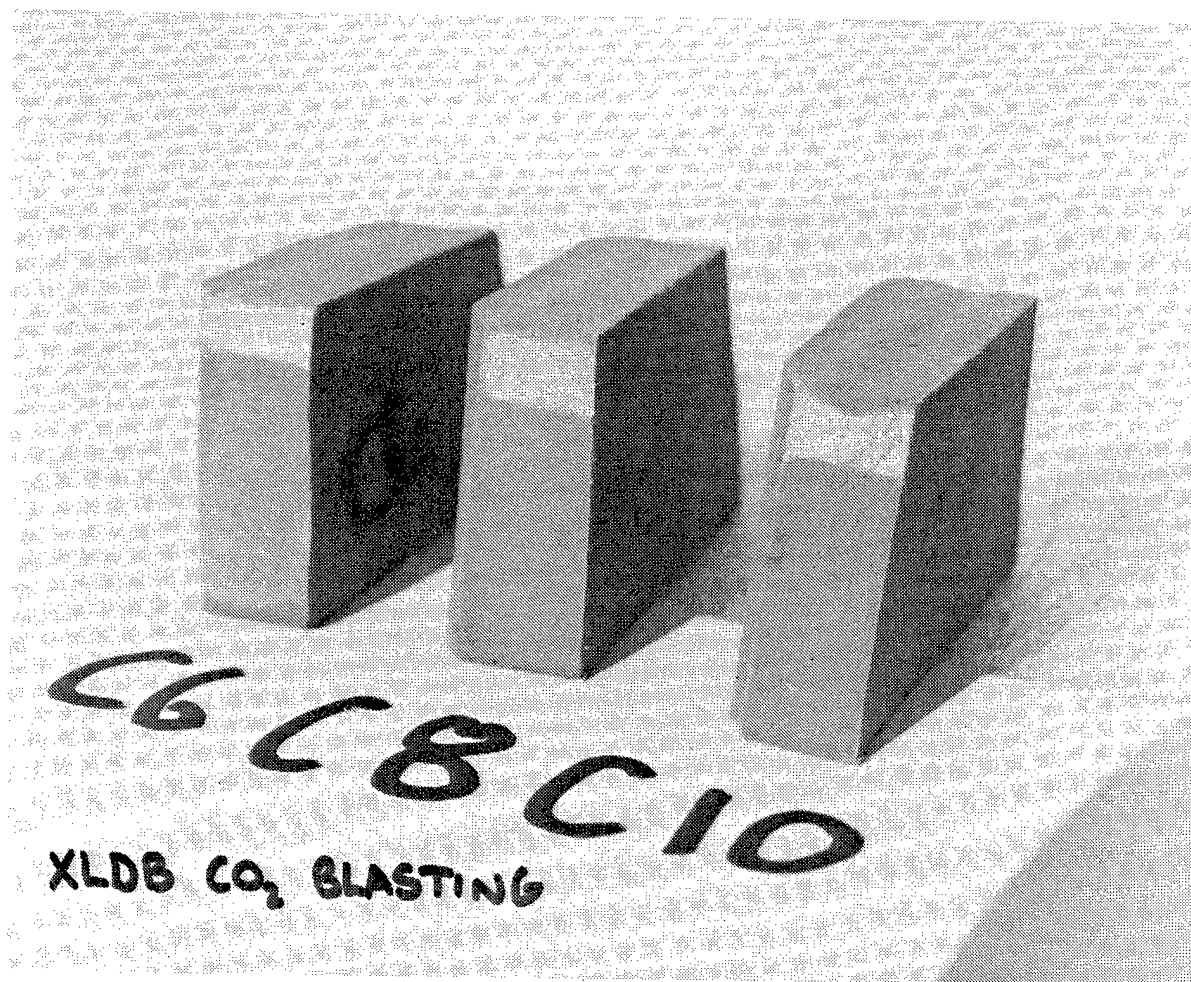


Figure B5. Task 2 XLDB CO<sub>2</sub> Pellet Blasting Samples

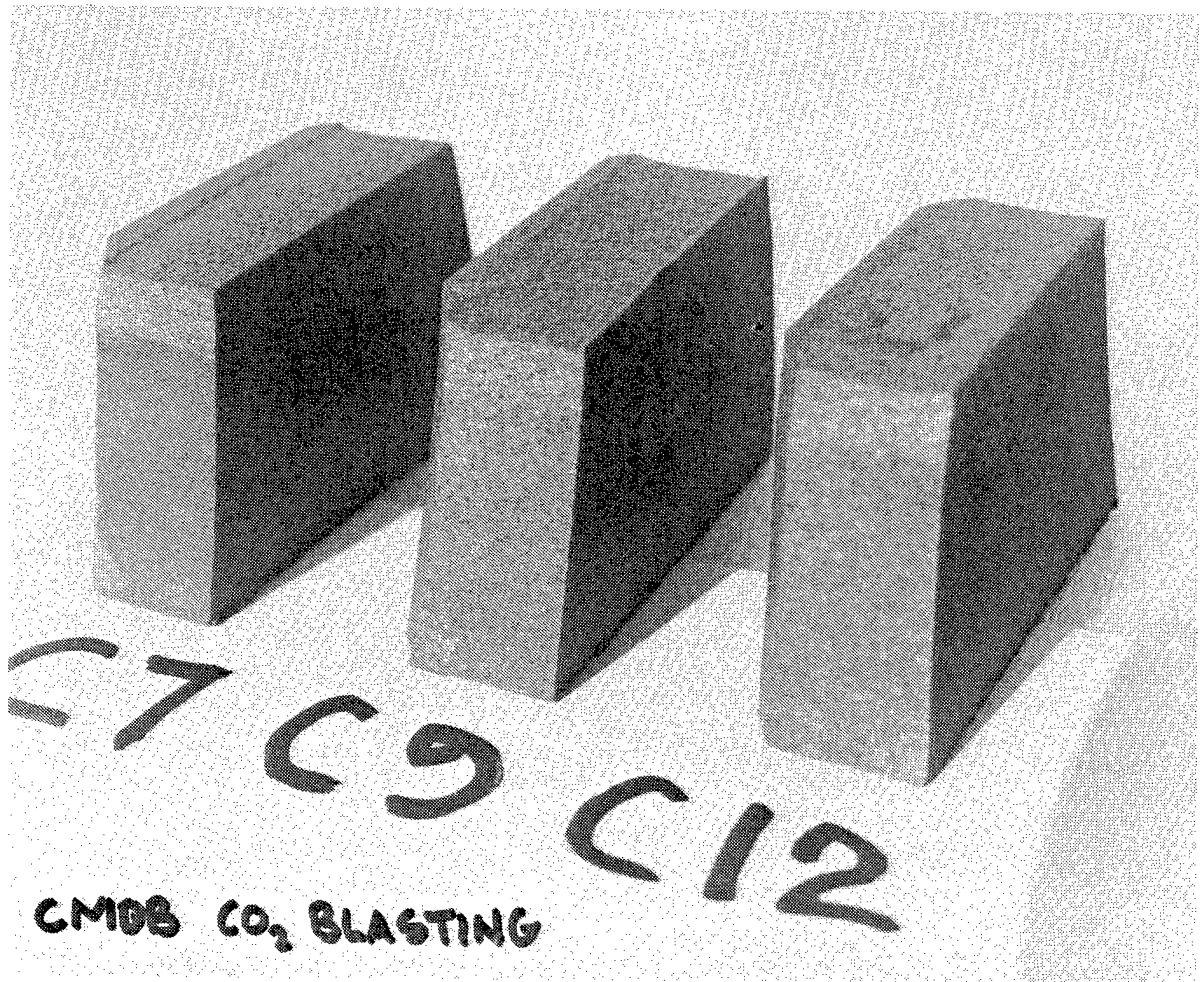


Figure B6. Task 2 CMDB CO<sub>2</sub> Pellet Blasting Samples

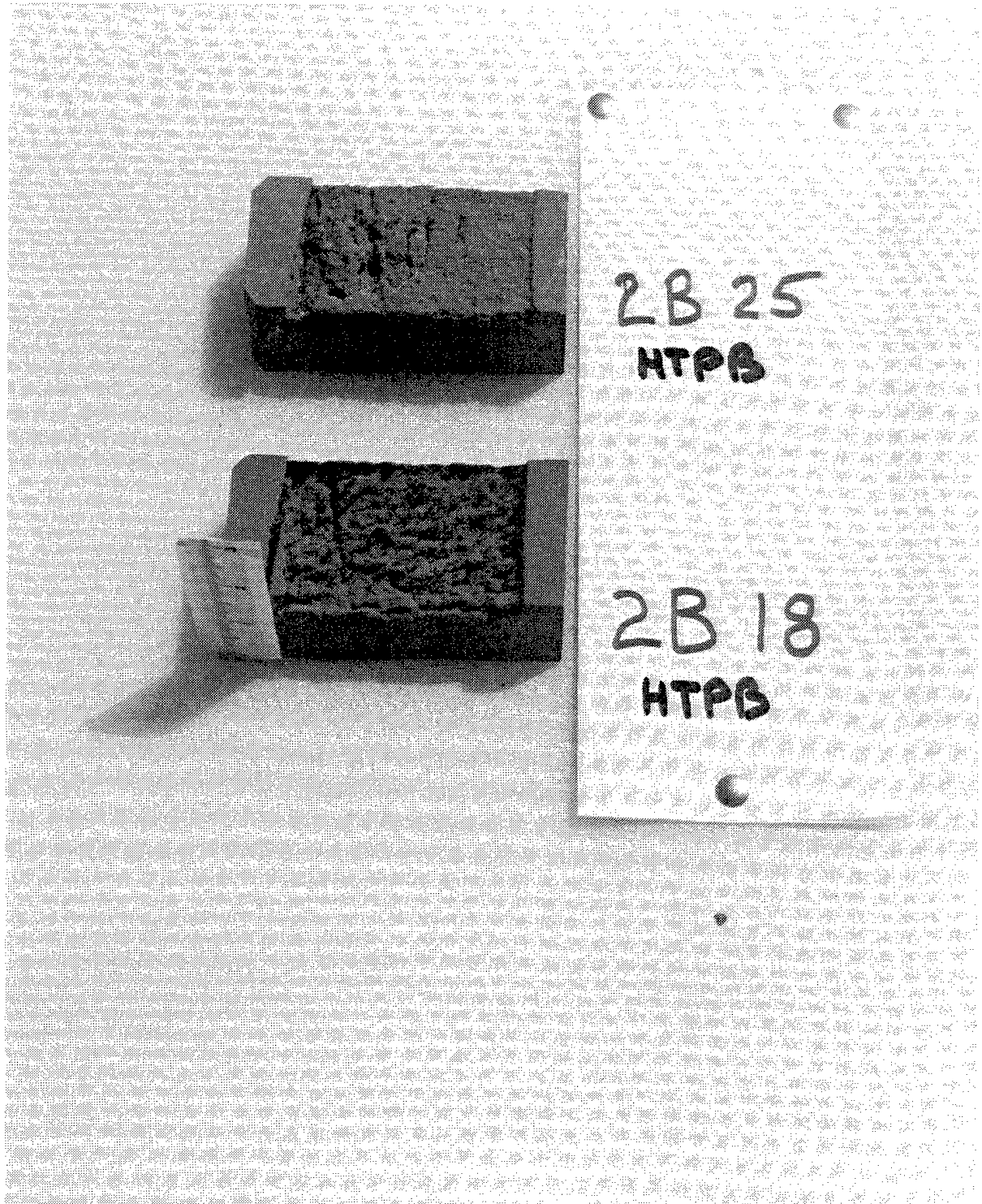


Figure B7. Task 2B HTPB Samples 2B18 and 2B25  
(Top view)

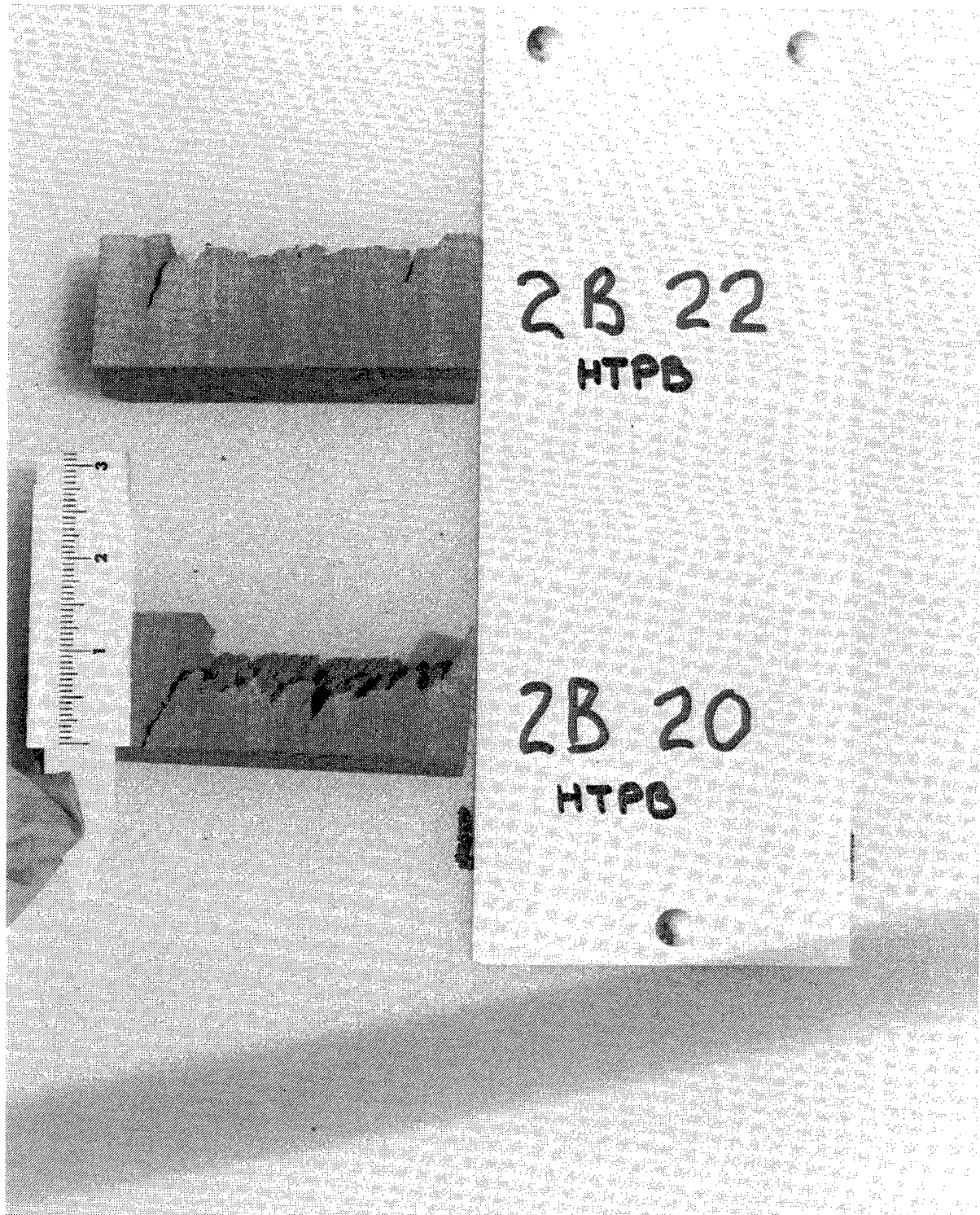


Figure B8. Task 2B HTPB Samples 2B20 and 2B22  
(Sectioned)

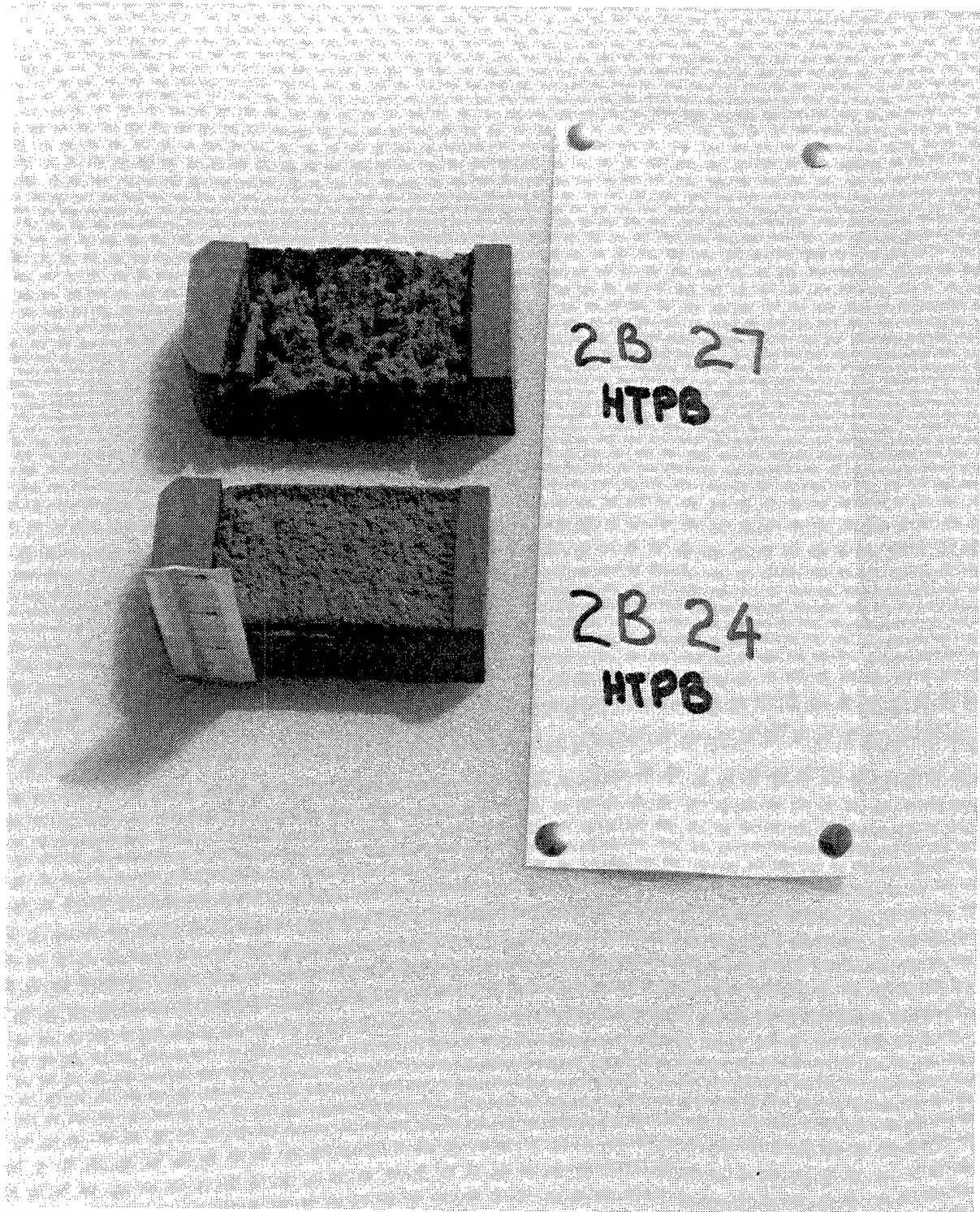


Figure B9. Task 2B HTPB Samples 2B24 and 2B27  
(Top view)

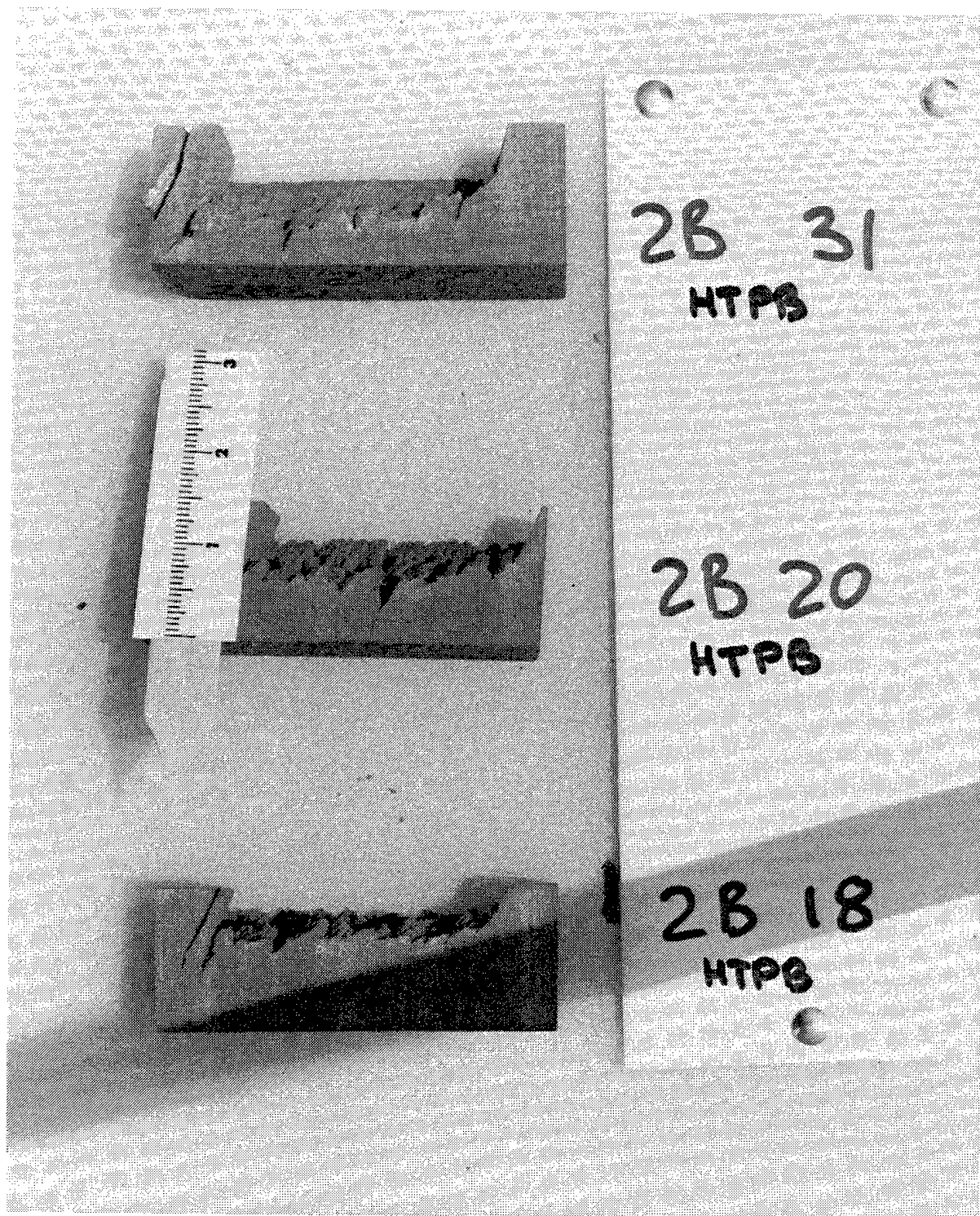


Figure B10. Task 2B HTPB Samples 2B18, 2B20, and 2B31  
(Sectioned)



Figure B11. Task 2B XLDB Samples 2B19, 2B21, and 2B30  
(Top view)

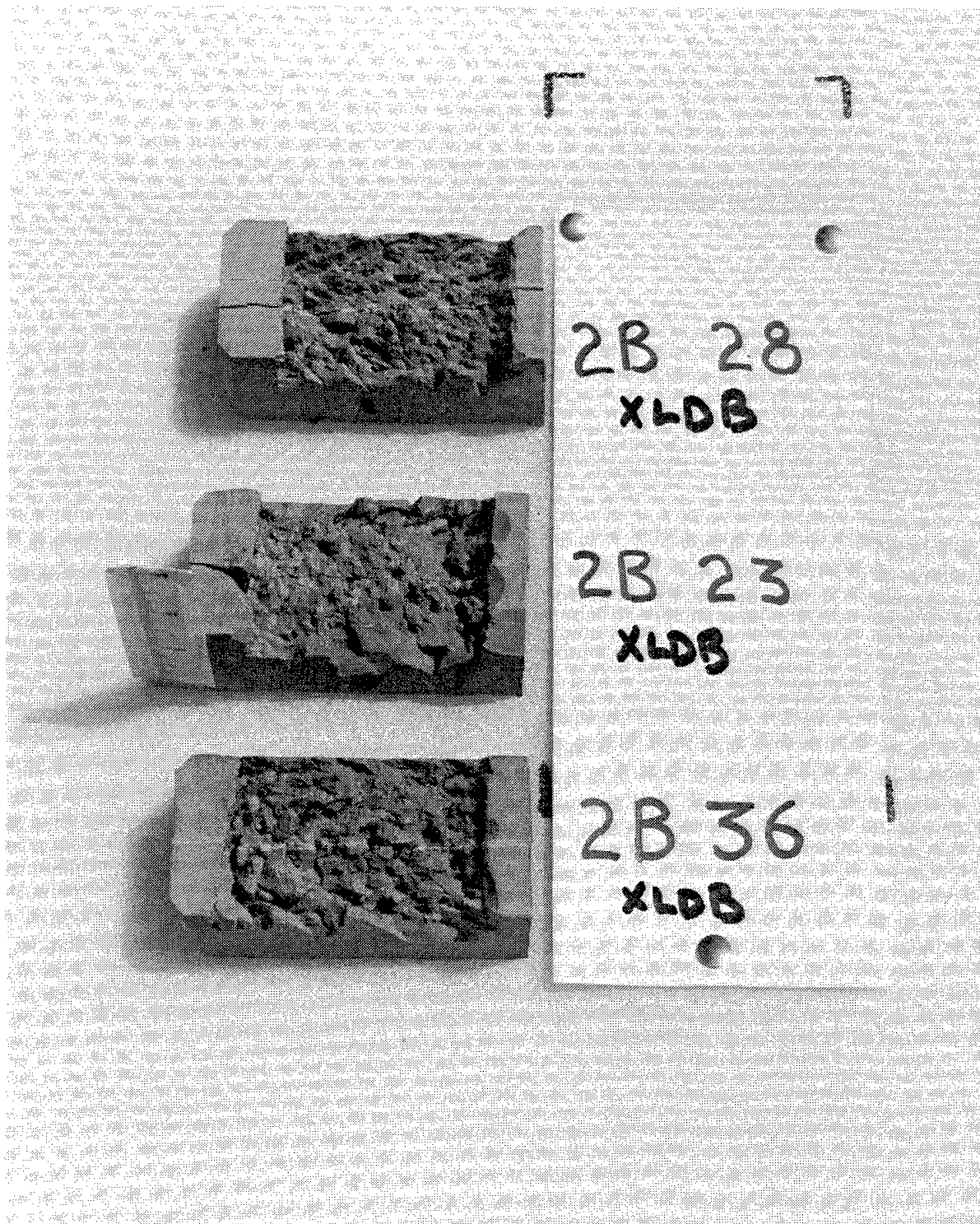


Figure B12. Task 2B XLDB Samples 2B36, 2B23, and 2B28  
(Top view)

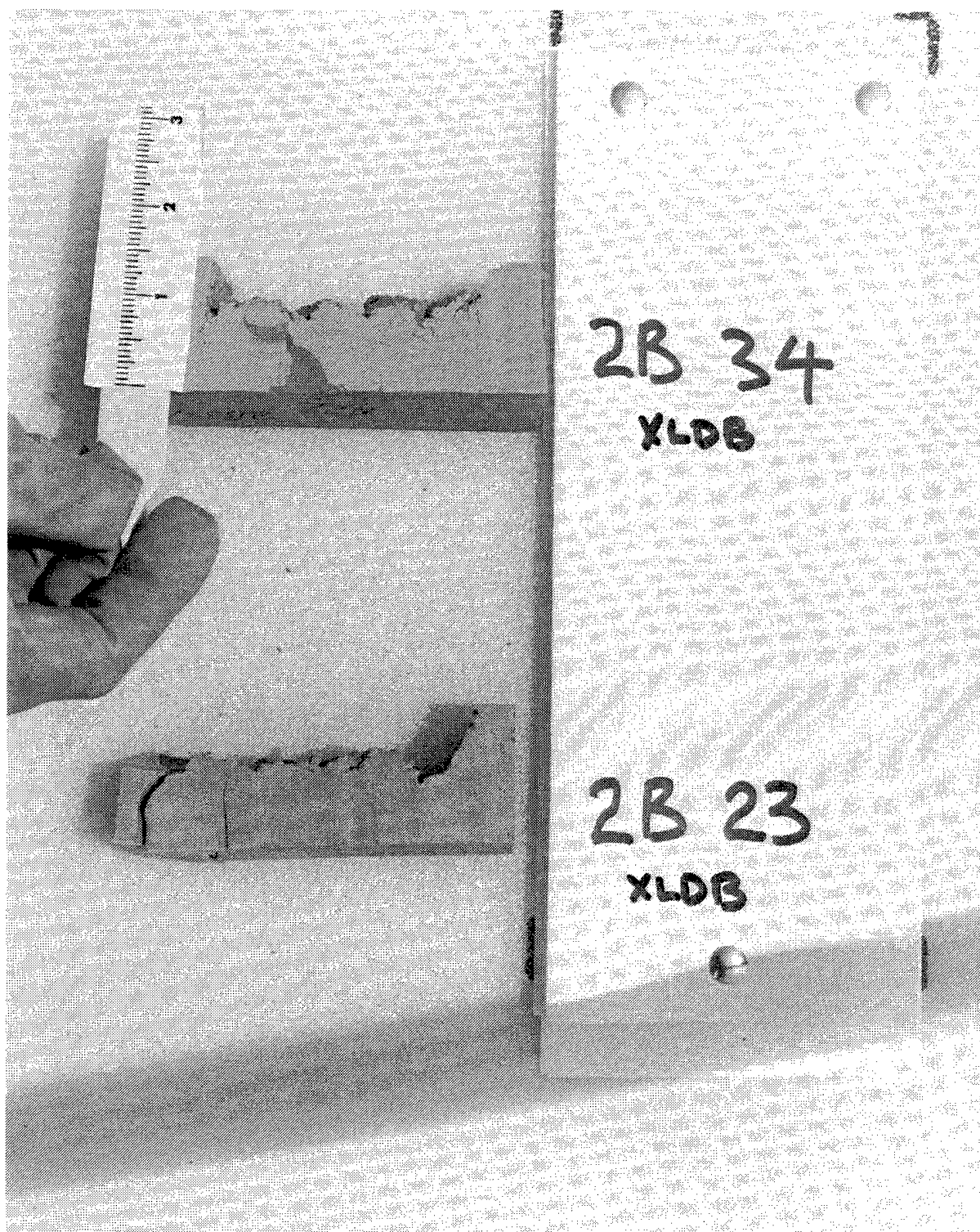


Figure B13. Task 2B XLDB Samples 2B23 and 2B34  
(Sectioned)



Figure B14. Task 2B XLDB Samples 2B23 and 2B32  
(Sectioned)

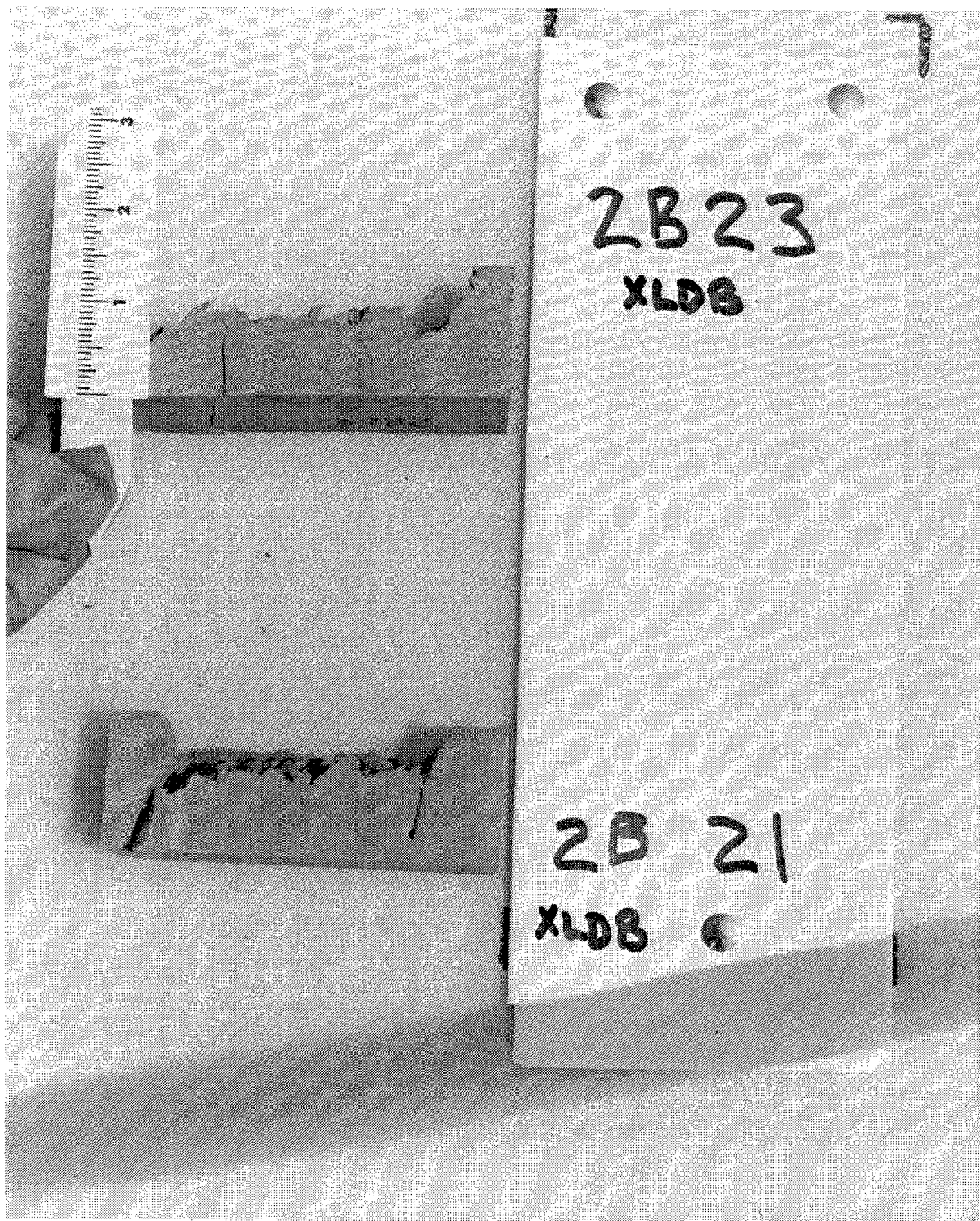


Figure B15. Task 2B XLDB Samples 2B21 and 2B23  
(Sectioned)

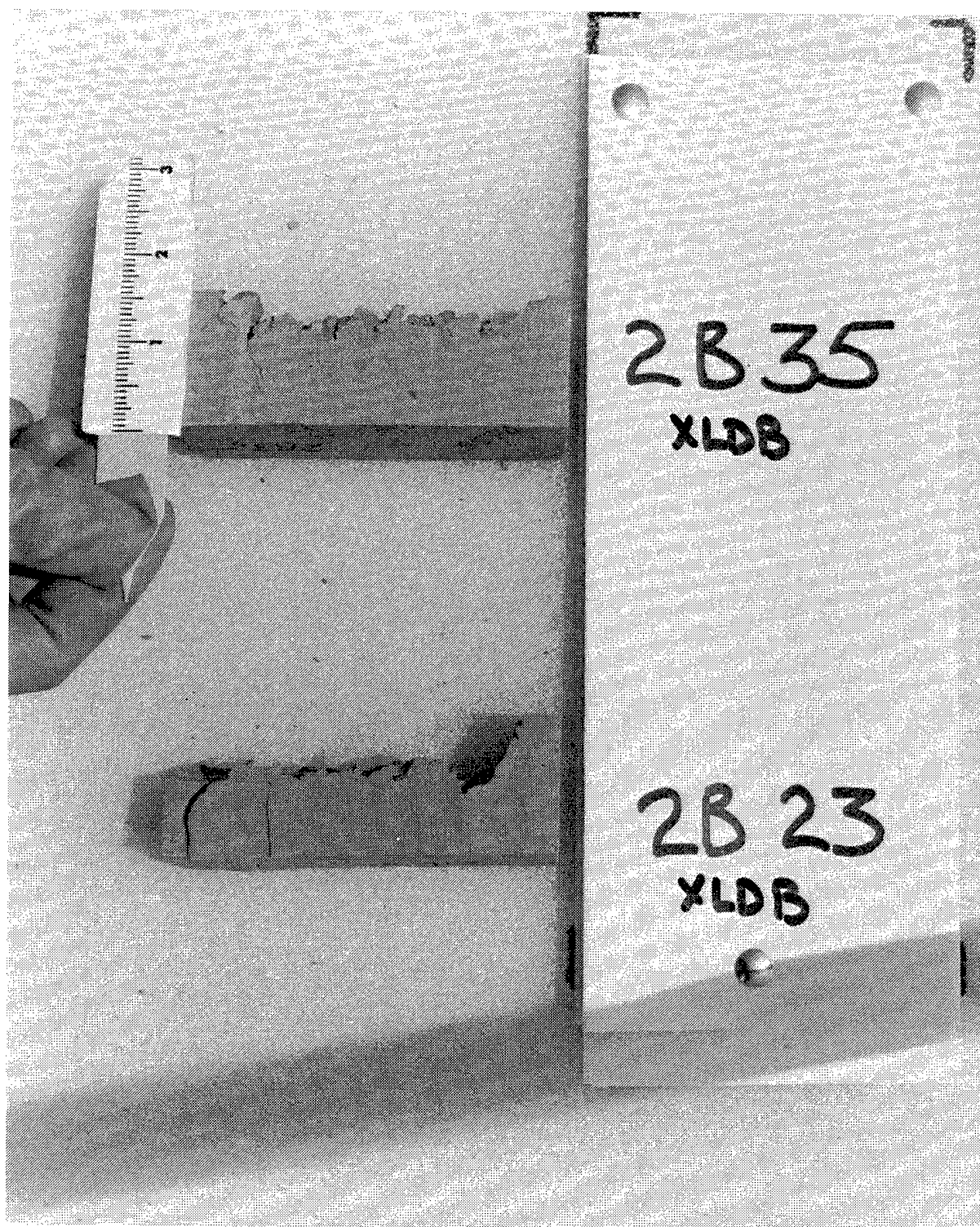


Figure B16. Task 2B XLDB Samples 2B23 and 2B35  
(Sectioned)

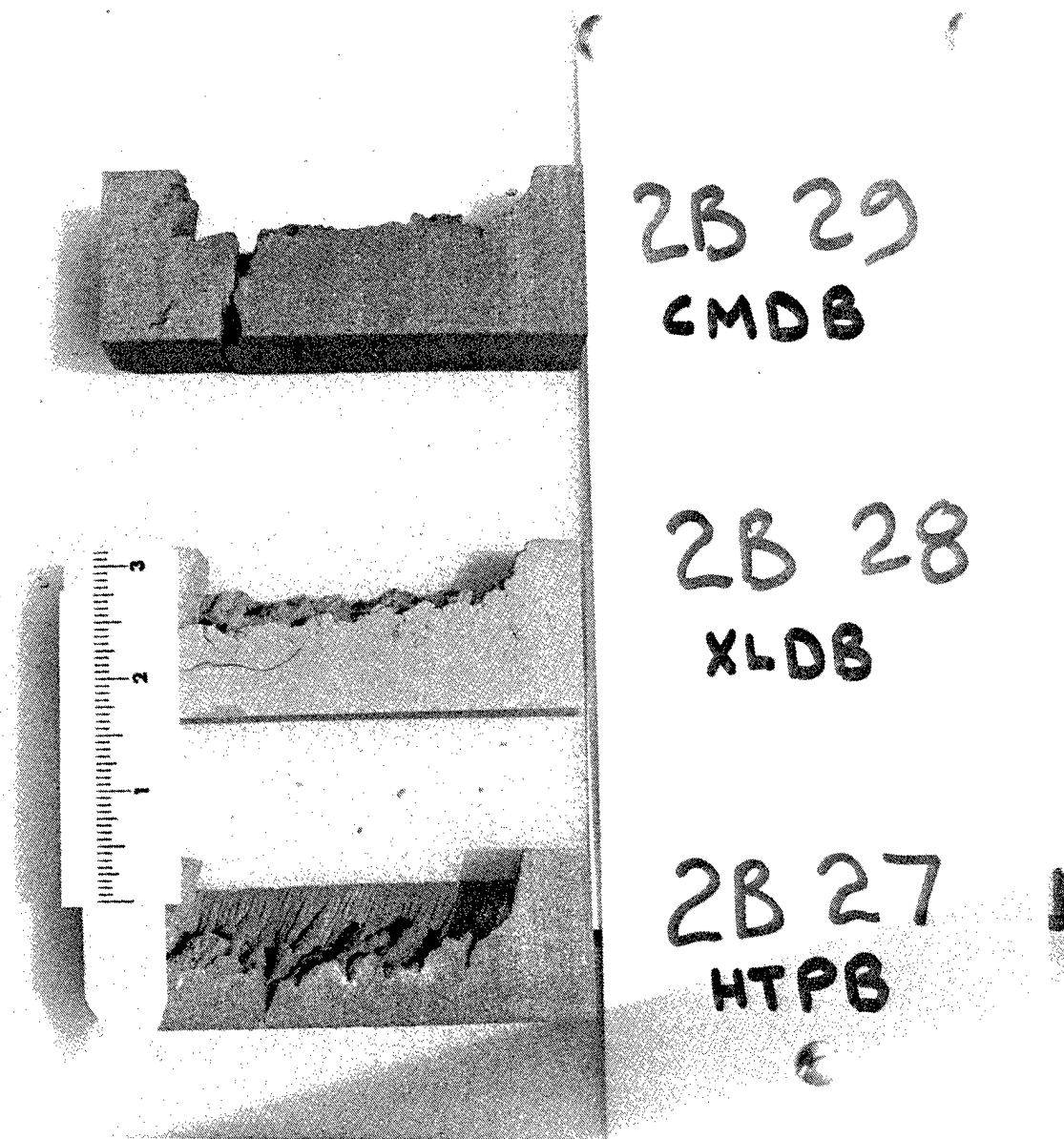


Figure B17. Task 2B Samples 2B27, 2B28, and 2B29  
(Sectioned)

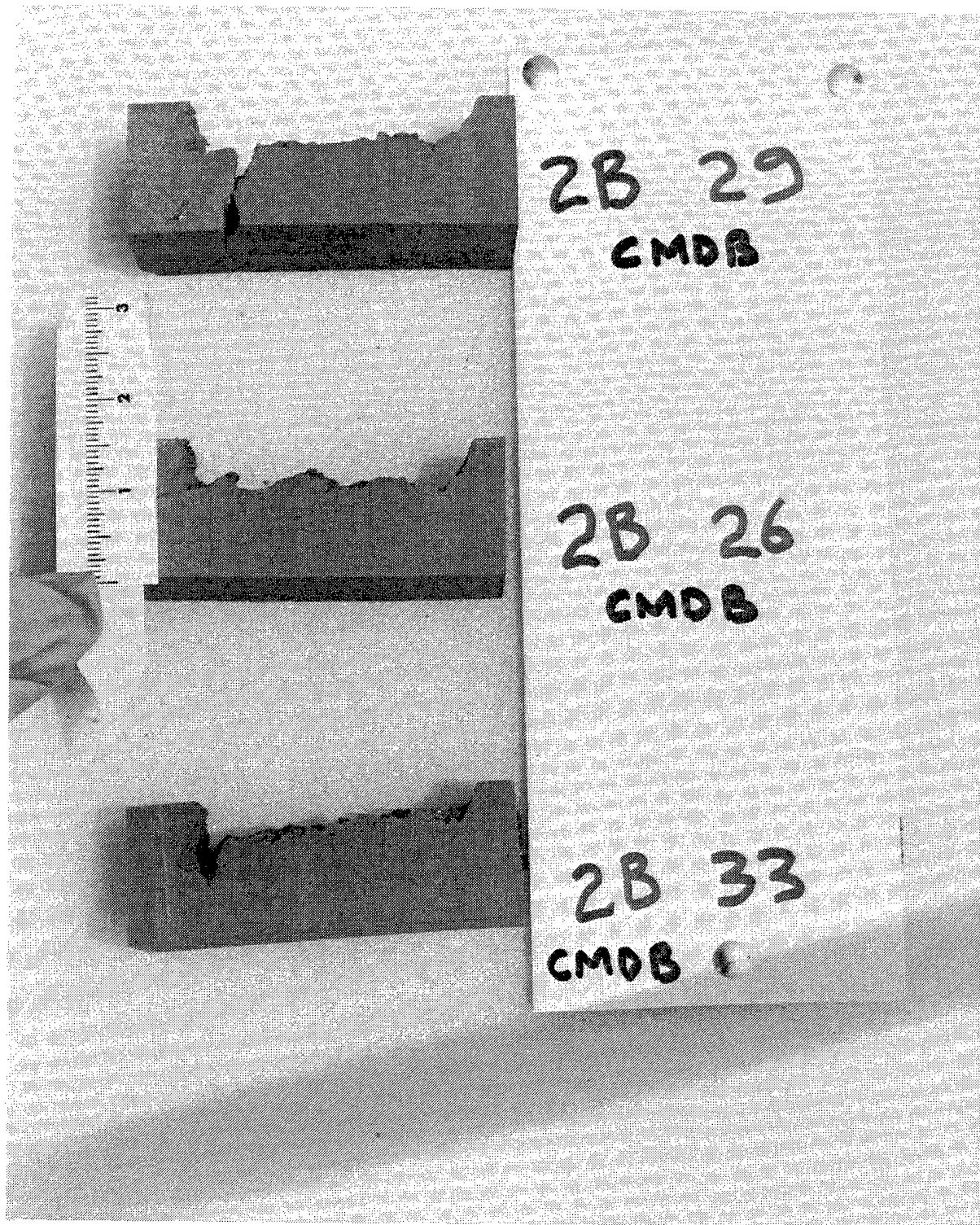


Figure B18. Task 2B CMDB Samples 2B33, 2B26, and 2B29  
(Sectioned)

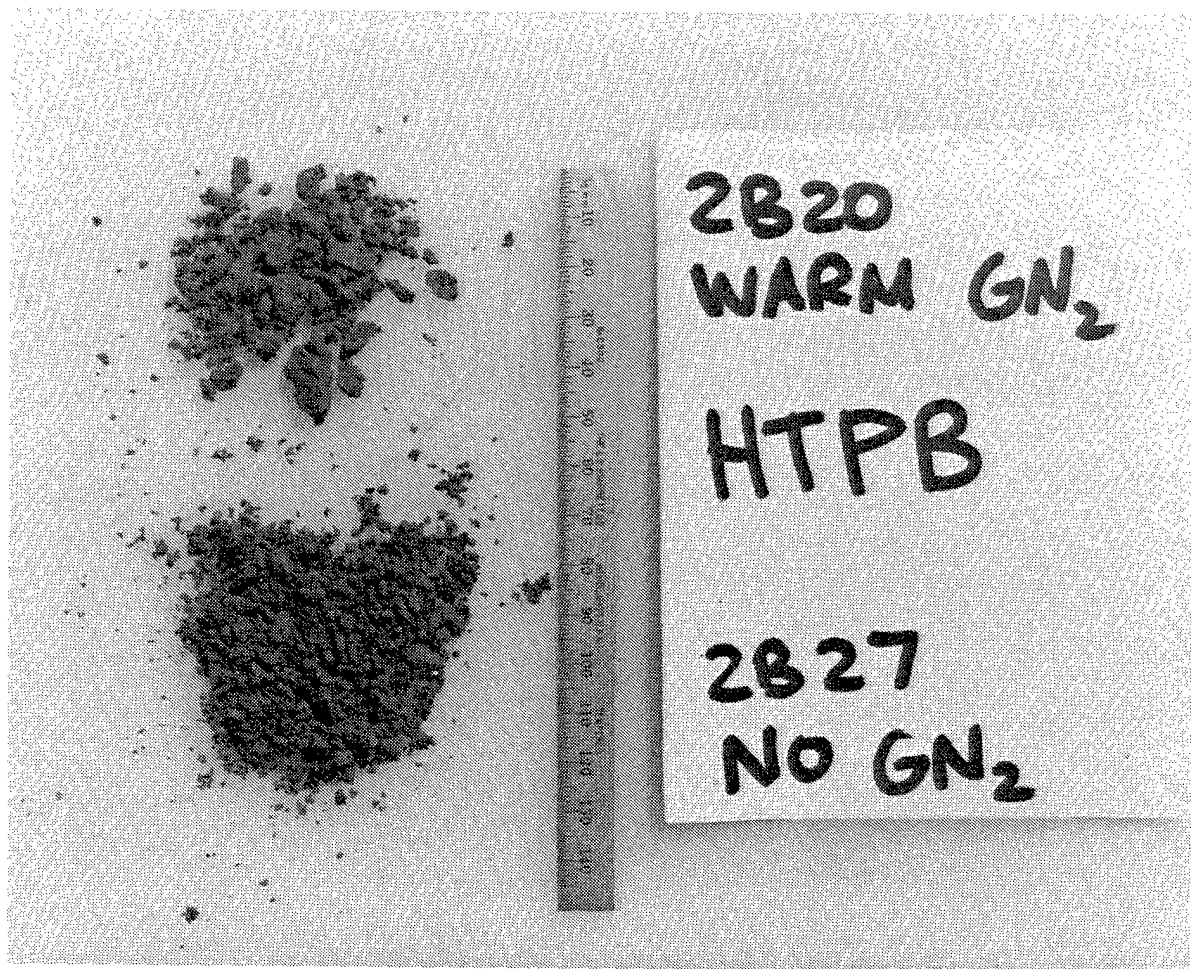


Figure B19. Washed out HTPB Propellant from Task 2B



Figure B20. Washed out XLDB Propellant from Task 2B



Figure B21. Washed out CMDB Propellant from Task 2B