

Accelerated Insertion of Materials – Composites



8 November 2002

Presented at
Penn State University
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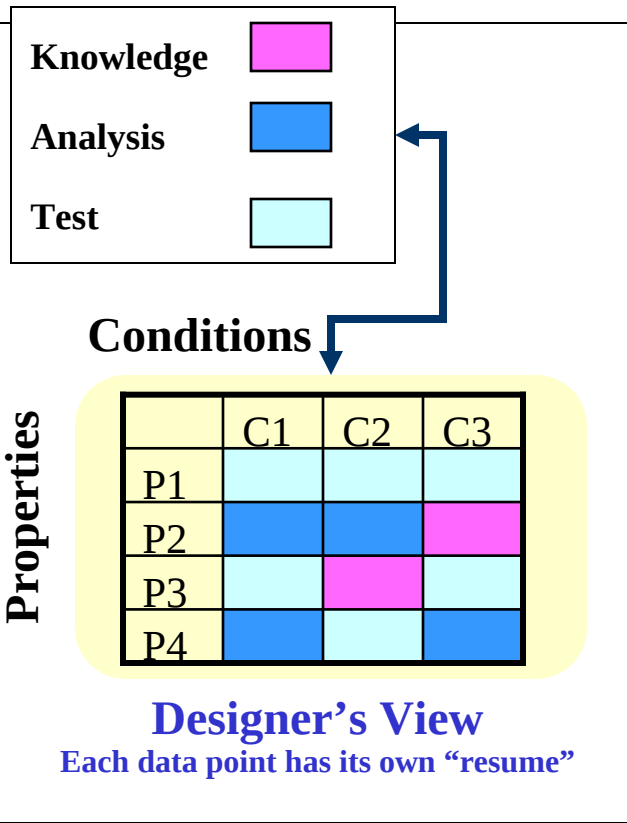
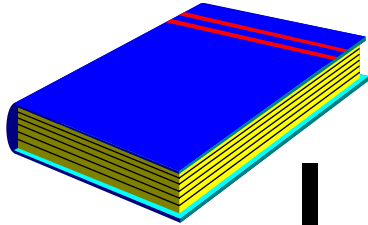
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Gail Hahn (PM), Charley Saff (DPM), & Karl Nelson (DPM) - Boeing Corp.

AIM-C Team - Boeing (St. Louis, Seattle, Canoga Park, Philadelphia), Northrop Grumman, Materials Sciences Corporation, Convergent Manufacturing Technologies, Cytec Fiberite, Inc, Massachusetts Institute of Technology, Stanford & NASA (Langley)

Accelerated Insertion of Materials Goals



Transform traditional materials database and qualification practice into an efficient and interactive process fully integrated into the available design tools and design community that retains/improves upon the robustness and reliability of traditional practice.

Use the right source (model, experiment, experience) to fill in the data

Reach for **robustness** not precision. Know the confidence in the data when needed.

Models can (and will) evolve – confidence in the knowledge of errors and uncertainty is what is needed



The AIM-C Team

- Boeing – Seattle and St. Louis – AIM-C CAT, Program Management
- Boeing – Canoga Park – Integration, Propagation of Errors
- Boeing – Philadelphia – Effects of Defects

CMT

- Convergent Manufacturing Technologies - Processing
- Cytec Engineered Materials – Constituent Materials, Supplier



- Materials Sciences Corporation – Structural Analysis Tools
- MIT – Dr. Mark Spearing – Lamina and Durability
- MIT – Dr. David Wallace – DOME, Architecture
- Northrop Grumman – Bethpage – Blind Validation
- Northrop Grumman – El Segundo – Producibility Module
- Stanford University – Durability – Test Innovation



NORTHROP GRUMMAN



Outline

- Introduction to AIM
 - Why AIM is Important
 - Technical Approach
 - Modeling Architecture
 - Methodology
 - Designer Needs
- Sample Problem 1
 - Cure Hardening Behavior of Epoxy
- Sample Problem 2
 - A Zero CTE Laminate
- Sample Problem 3
 - Cure Cycle Development
 - Processing Properties
 - Exotherm
 - Residual Stresses
- Design of Complex Structure
 - Hat Stiffened Panel
- Conclusions/Summary

Understanding the Current Process

Why We Test

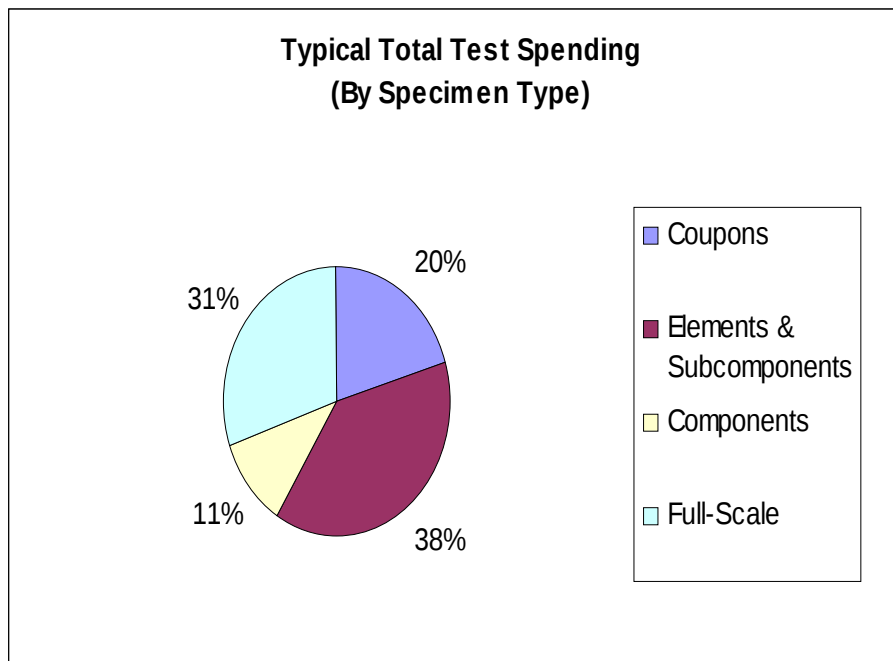
- Using an Un-augmented “Building Block Approach”, a Typical Composites Program Requires 6000 to 10,000* Specimens to:
 - Characterize the Material
 - Develop Design Allowables
 - Select/Develop the Design Concept
 - Calibrate Semi-Empirical Analysis Methods
 - Validate the Design and Analysis

* Ref. F/A -18 and 777 empennage



How Much It Costs

- The Total Cost of Building and Testing These Specimens is between \$50M and \$100M and takes at least several years.
- Despite several very expensive component tests, much of this money and time is spent on the numerous coupons, elements, and subcomponents.



• **Specimen types and numbers are averages based on various test plans**

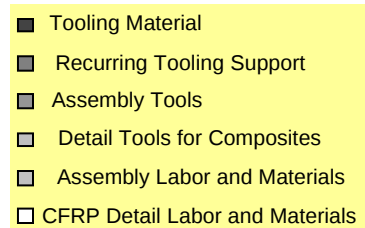
- New composite material specimens only
- Only 1 full-scale Test Component testing includes items such as fuel box, side-of-body joint, large fittings, etc.

• **Fab. And Test Hours/specimen (for each type) based on internal Boeing estimating documents**

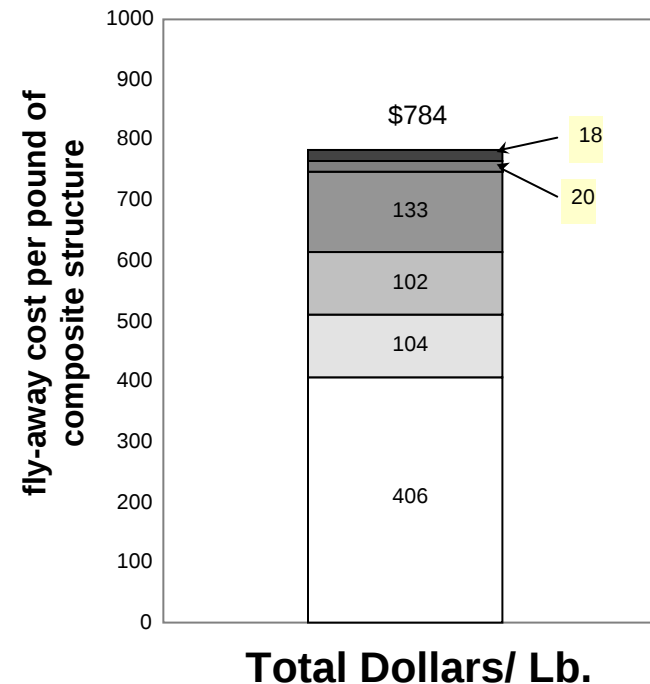
• **Typical Industry Labor Rates**

• **Fabrication and Test Cost Only –Facilities, Equipment, Material, and Design/Analysis Costs not included**

Boeing is the World's Largest Manufacturer of Composite Aerospace Parts



- 4 Million Pounds Annually
- ~ \$300M Spent on Raw Material
- We Add ~ 5 times to the value
- \$2B Annually Fly Away

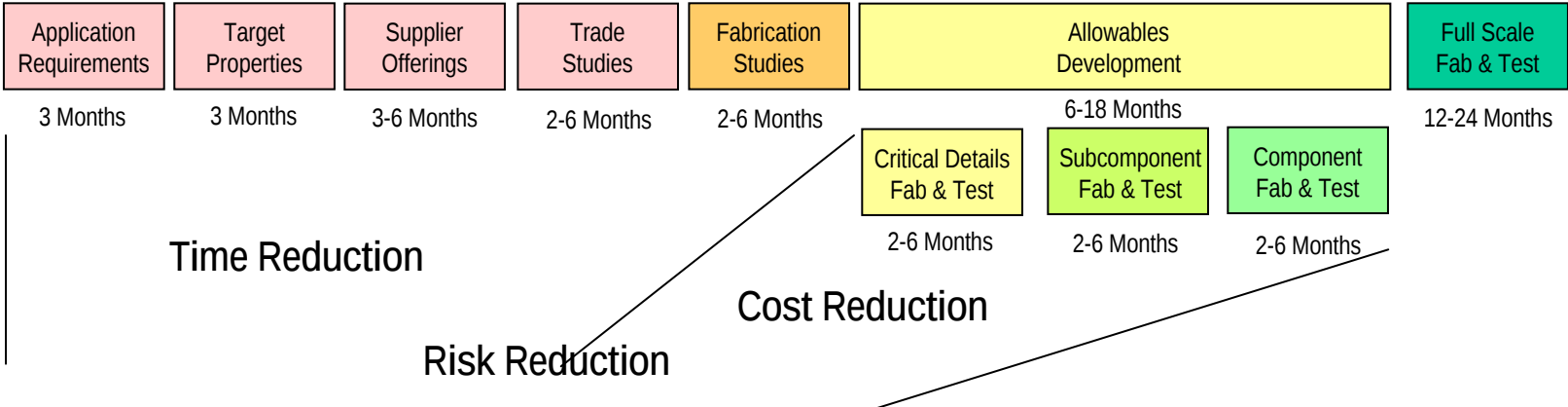




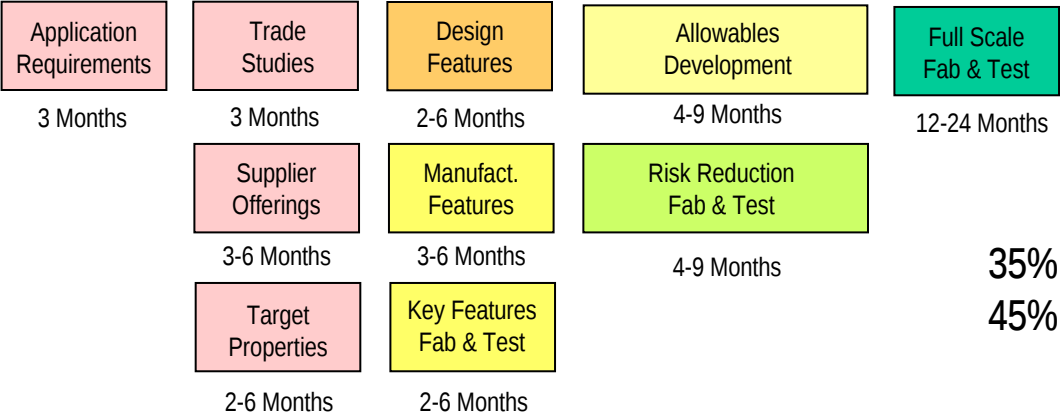
The AIM Process Uses IPT

Lessons Learned to Drive Rapid Insertion

Conventional Building Block Approach to Certification



The AIM Focused Approach to Certification



35% Reduction in Total Time to Certification
45% Reduction in Time to Risk Reduction

AIM Methodology: Criteria for Success

1. Architecture

- Open/controlled (secure/open)
- Platform independent (Intranet vs. Internet)

2. Capabilities – at least 4 capabilities/modules

- Properties – time dependent properties
- Durability/Lifing
- Processing/Manufacturing/Producibility
- Cost

AIM Methodology: Criteria for Success

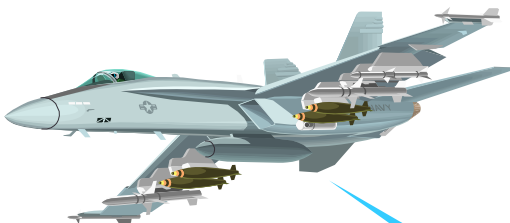
3. Features/Outputs

- Demonstrate that the methodology reproduces the DKB
- Demonstrate that “a rogue” process spec will result in a flag by the system
- Demonstrate that a rogue “geometry” results in an “un-producible” flag
- Demonstrate the ability of the system to direct experiment – to direct an experiment to determine a “benchmarking” parameter, or a basic physical quantity. (validation/calibration)

DESIGN TEAM'S NEEDS

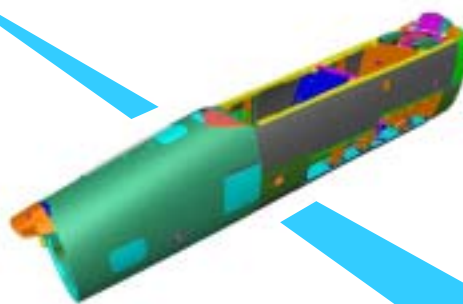
Requirements Flow-Down

Program/Product Level



- Performance
- Life Cycle Cost
- Development and Delivery Schedules
- Risk Posture

Component Level



- Weight, Smoothness, etc.
- Service Environment
- Unique Functionality
- Unit Cost Targets
- Production Concept
- O&S Concepts

Part Level



- Strength and Stiffness
- Temperature
- Geometry Assurance
- Fab and Assembly Concepts
- Damage Tolerance & Repair

Material Choice is Influenced by Higher Level Requirements (and Vice Versa)

DESIGN TEAM'S NEEDS

High Priority Requirements

Structural

- Strength and Stiffness
- Weight
- Service Environment
 - Temperature
 - Moisture
 - Acoustic
 - Chemical
- Fatigue and Corrosion Resistant

Manufacturing

- Recurring Cost, Cycle Time, and Quality
- Use Common Mfg. Equipment and Tooling
- Inspectable
- Machinable
- Automatable
- Impact on Assembly

Supportability

- O&S Cost and Readiness
- Damage Tolerance
- Inspectable on Aircraft
- Repairable
- Maintainable
 - Depaint/Repaint
 - Reseal
 - Corrosion Removal
- Logistical Impact

Material & Processes

- Feasible Processing Temperature and Pressure
- Safety/Environmental Impact
- Useful Product Forms
- Raw Material Cost
- Availability
- Consistency

Miscellaneous

- Observables
- EMI/Lightning Strike
- Supplier Base
- Applications History
- Certification Status
 - USN
 - USAF
 - FAA

Inadequate Data or Performance in Any of These Areas Will Jeopardize the Potential Application

DESIGN TEAM'S NEEDS

Data Drives Decisions

• Are Current Materials, Designs, and Methods Capable of Meeting Needs?

NO

• Are Current Materials Capable of Meeting Needs (with changes to design and/or methods)?

YES

YES

• Is Program/Customer Willing to Invest in New Materials for Performance Improvement?

NO

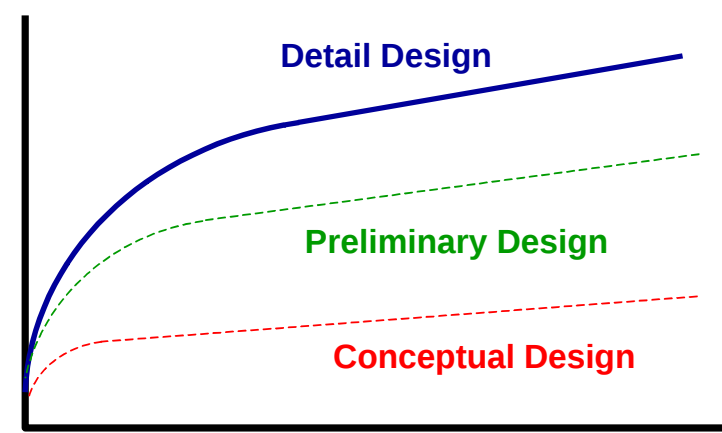
Change Design and/or Methods

YES

Pursue New Material

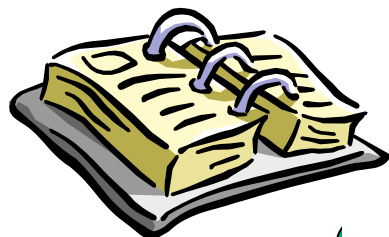
Materials Development Effort

Type and Amount of Materials Data Required

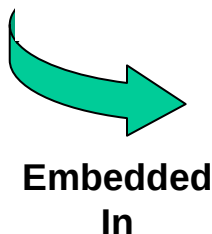


Criticality/Complexity of Application

AIM-C Will Validate the Process



**Methodology
That Links an
Accelerated
Process to the
Knowledge
Requirements**

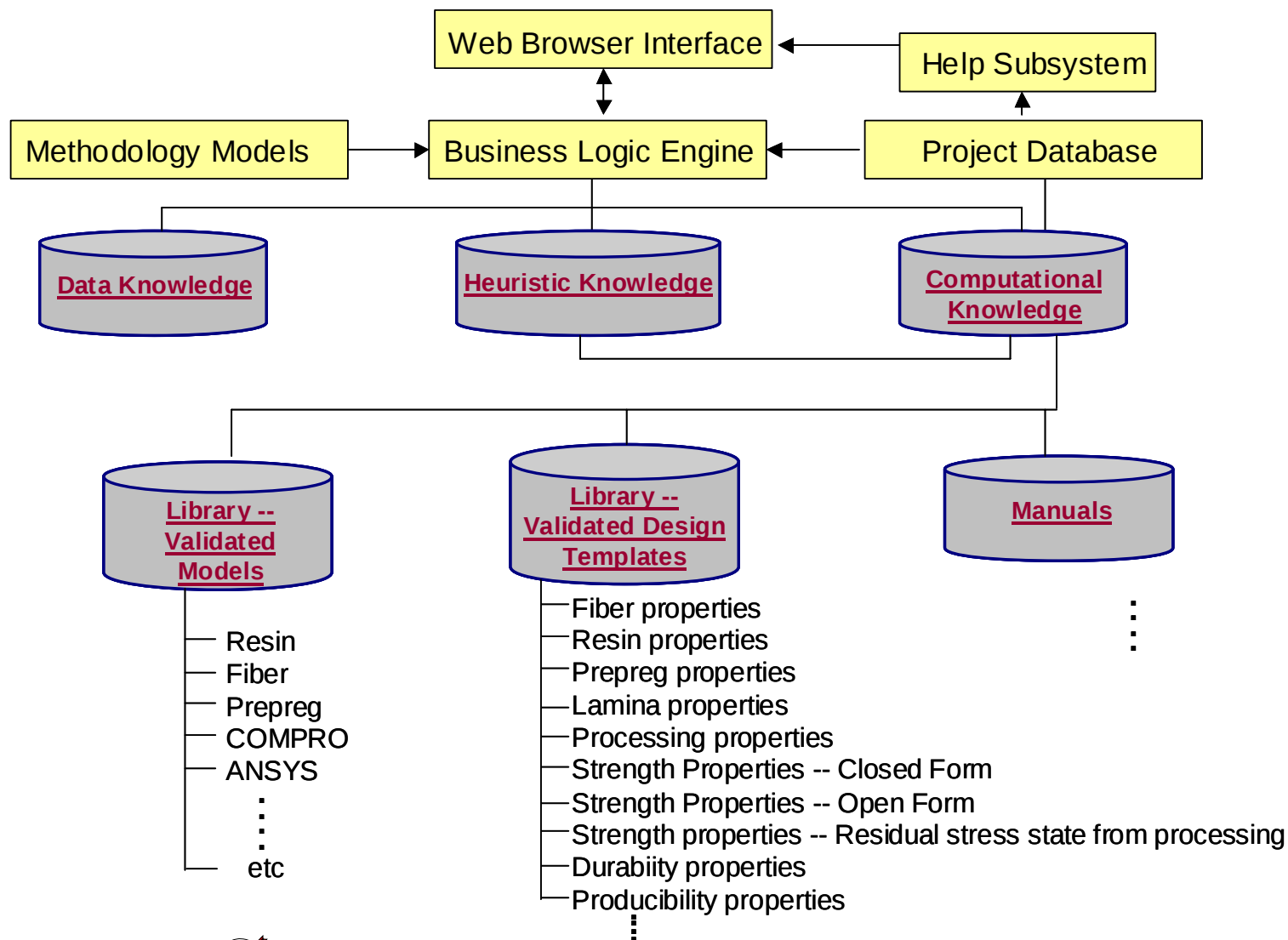


**Software
That Links the Methodology to
Knowledge, Analysis Tools,
and Test Recommendations**



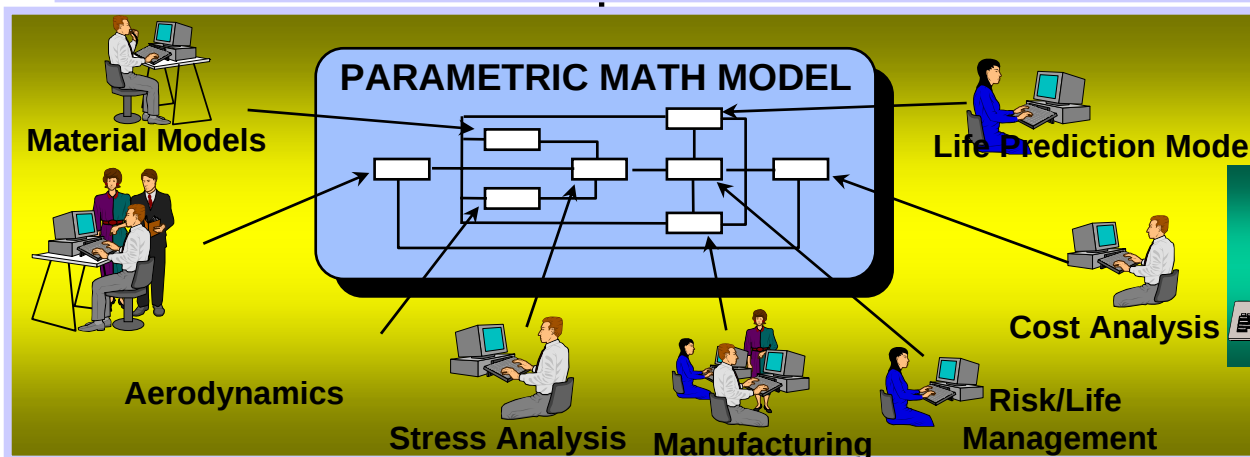
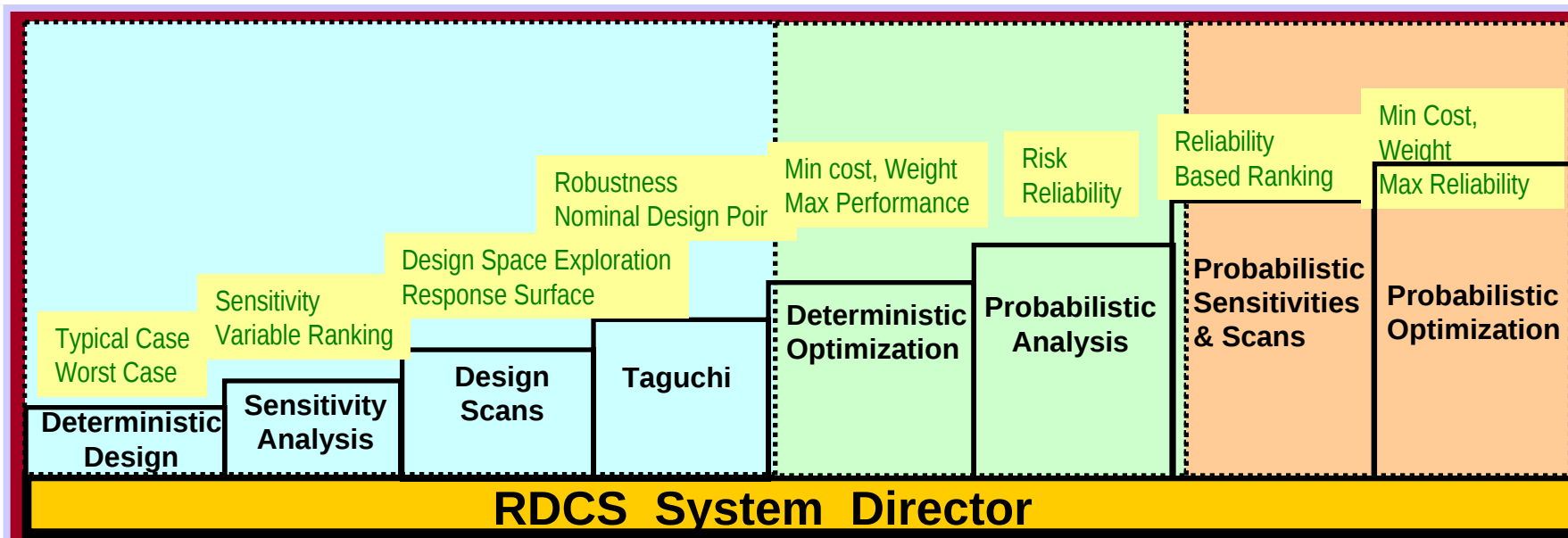
**Demonstrations
Focused on
Recreating
Existing Data,
Precluding
Persistent
Problems, and
Independent Peer
Assessment**

AIM-C Software Architecture



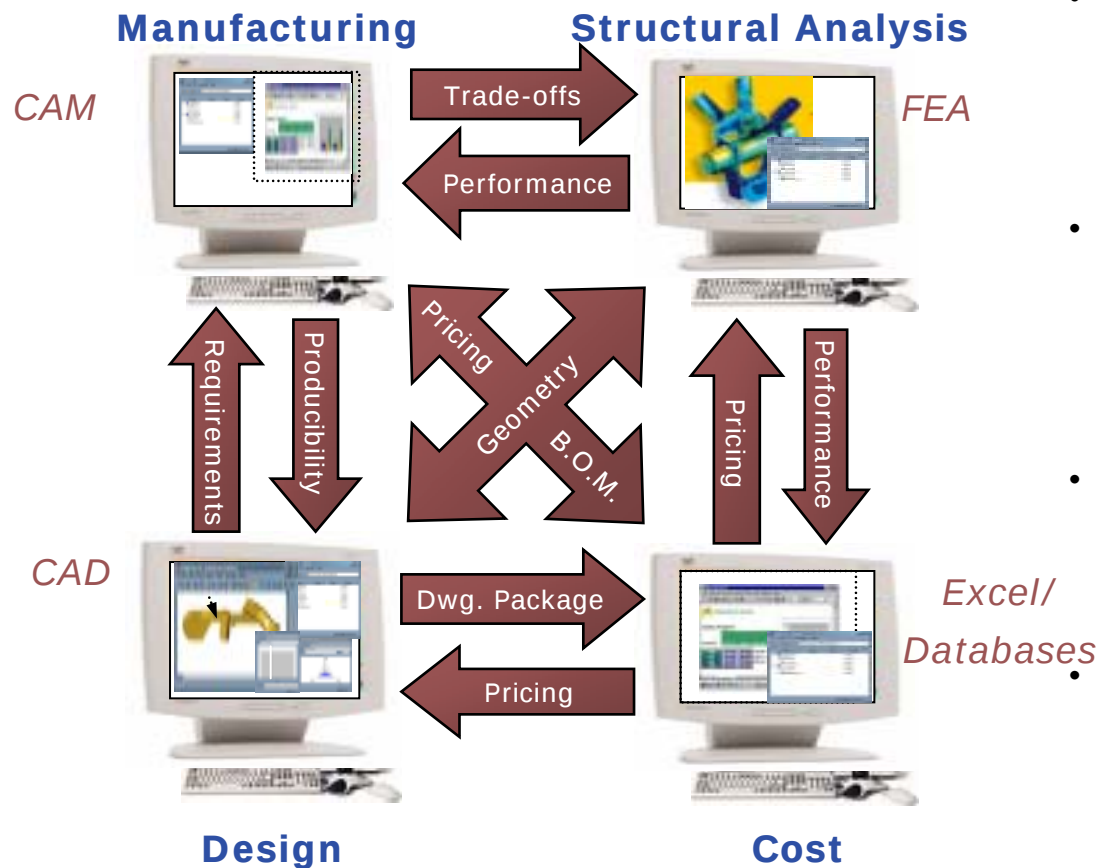


Robust Design Computational System



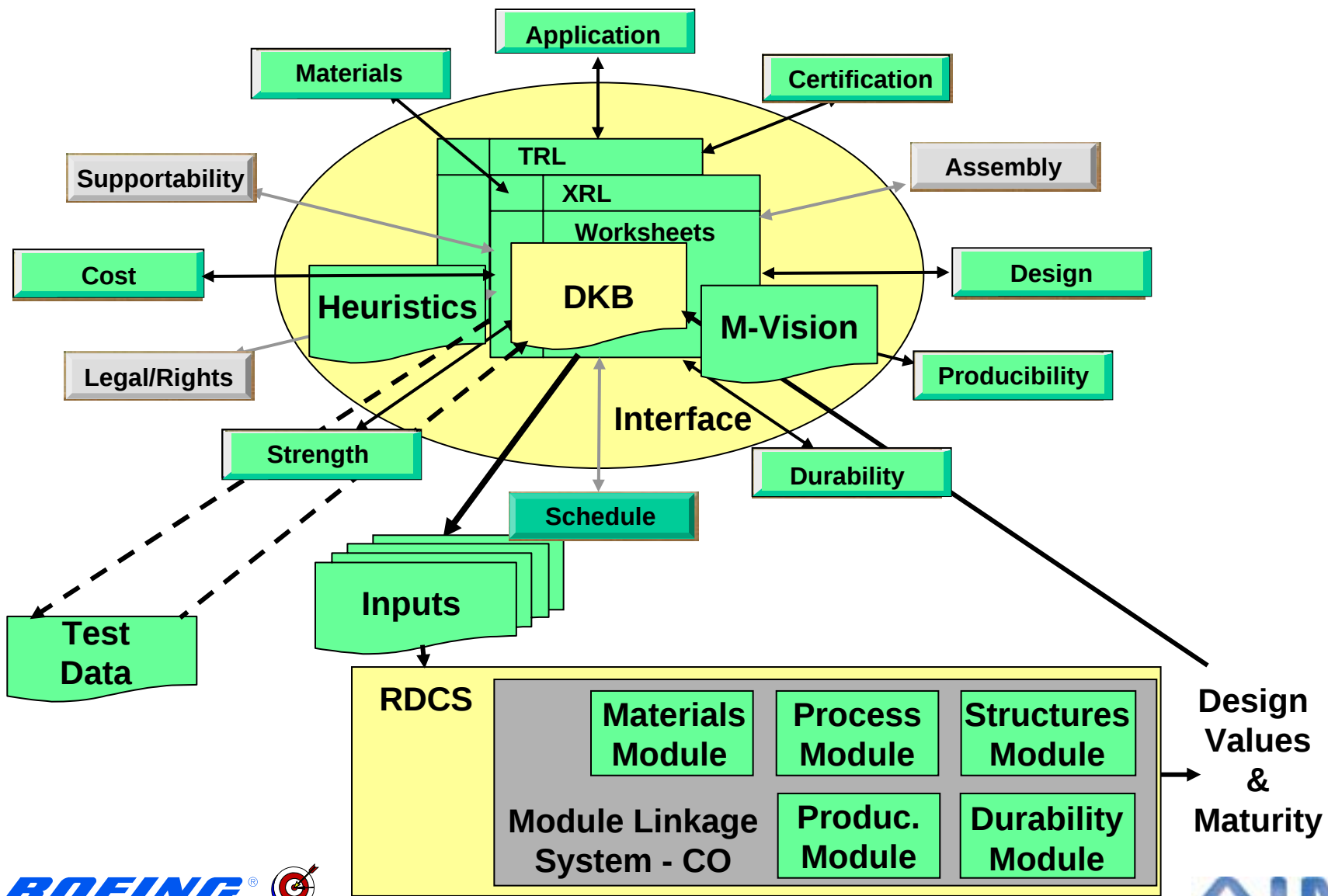
The Oculus Integration System

CO™: A Plug & Play Modeling Environment

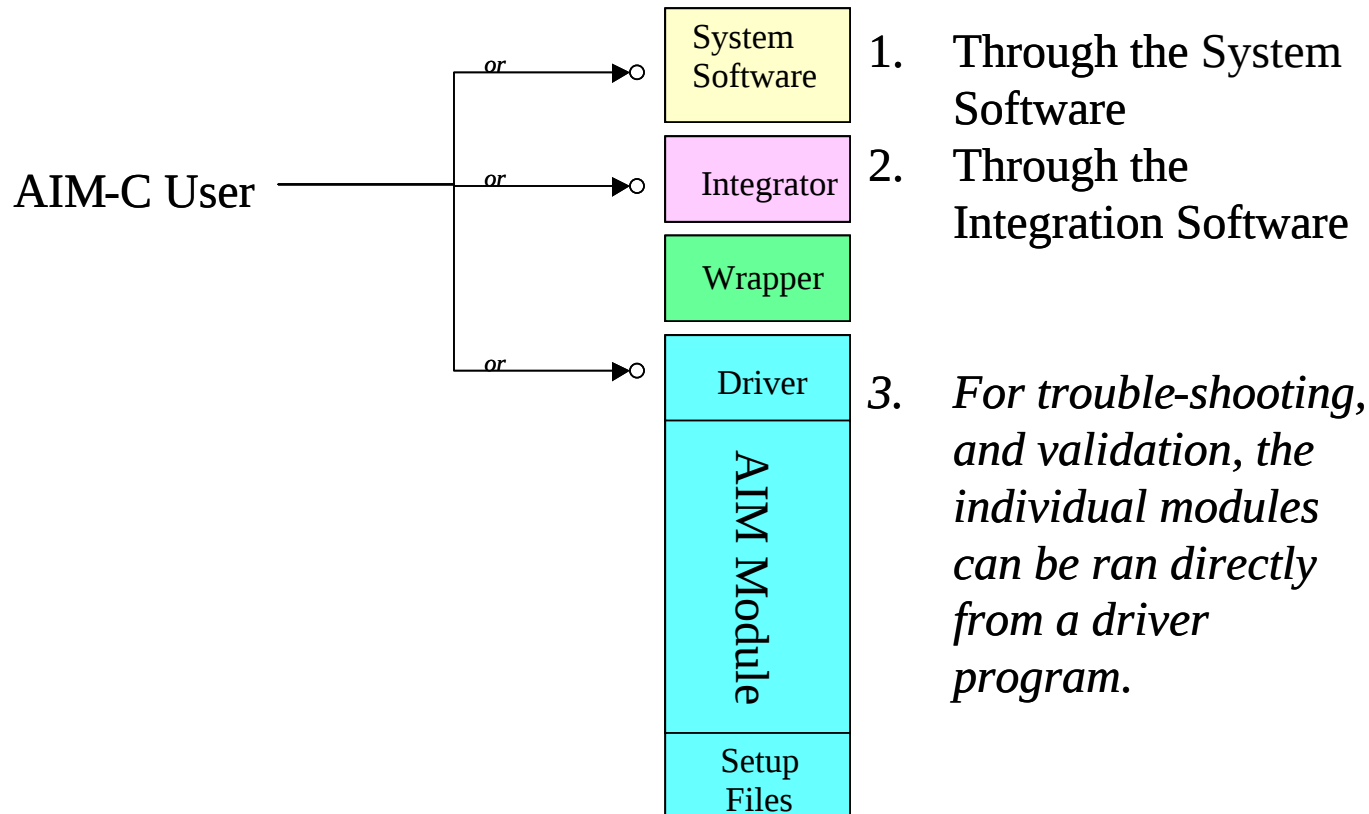


- **Integrates Data and Software Applications on-the-fly**
 - Drag & Drop, Plug & Play
 - Simple to create, modify, manage, maintain
- **Enables Real-time data sharing between applications**
 - Secure
 - Controlled
 - Intra/Internet
- **Platform Independent**
 - Distributed
 - Neutral to Platforms and Applications
- **Increases Value of Previous Investments**
 - Software
 - Hardware
 - Networks

AIM-C System Vision



The User Is Able to Run the Module At Three Different Levels





Technical Components of AIM-C

Materials Insertion Methodology

Baseline Material and Structure

Modular Approach to Modeling

Prediction of Structural Response

Composite Mechanical Properties, including
Progressive Damage Failure, and
Durability

Distributed Object-based Modeling Environment (Oculus CO)

An *emergent* network of models (information services)

Robust Design Computational System (RDCS)

Distributed computing capability
Uncertainty and Error Propagation
Probabilistic Analysis

Materials, Processing, Producibility and Manufacturing (M&P)²

Raw material physical and mechanical properties
Residual stress state as dependent on processing
Producibility aspects of new materials and structure

Validation

Design, Certification, Implementation Considerations

Near Term or Current Capabilities

1. Processing Module

- Processing Window Studies
- Spring-In and Deformation Calculations
- Evaluation of Novel Processes (i.e. staging, VaRTM)
- Thick Laminate Structure

2. Structures Module

- Stiffener termination/pull off problem
- OHC, OHT, Un-notched Coupon Prediction
- Large Notch Type Damage Problem

3. Robust Design Computational System (RDCS)

- Already in use by Boeing Programs
- Combined Structure/Processing Effects -- Microcracking
- Sensitivity Analysis/Design Space Scans, Optimization, etc.

4. Qualification/Re-qualification of Materials

Sample Problem 1

Epoxy Cure Hardening Behavior

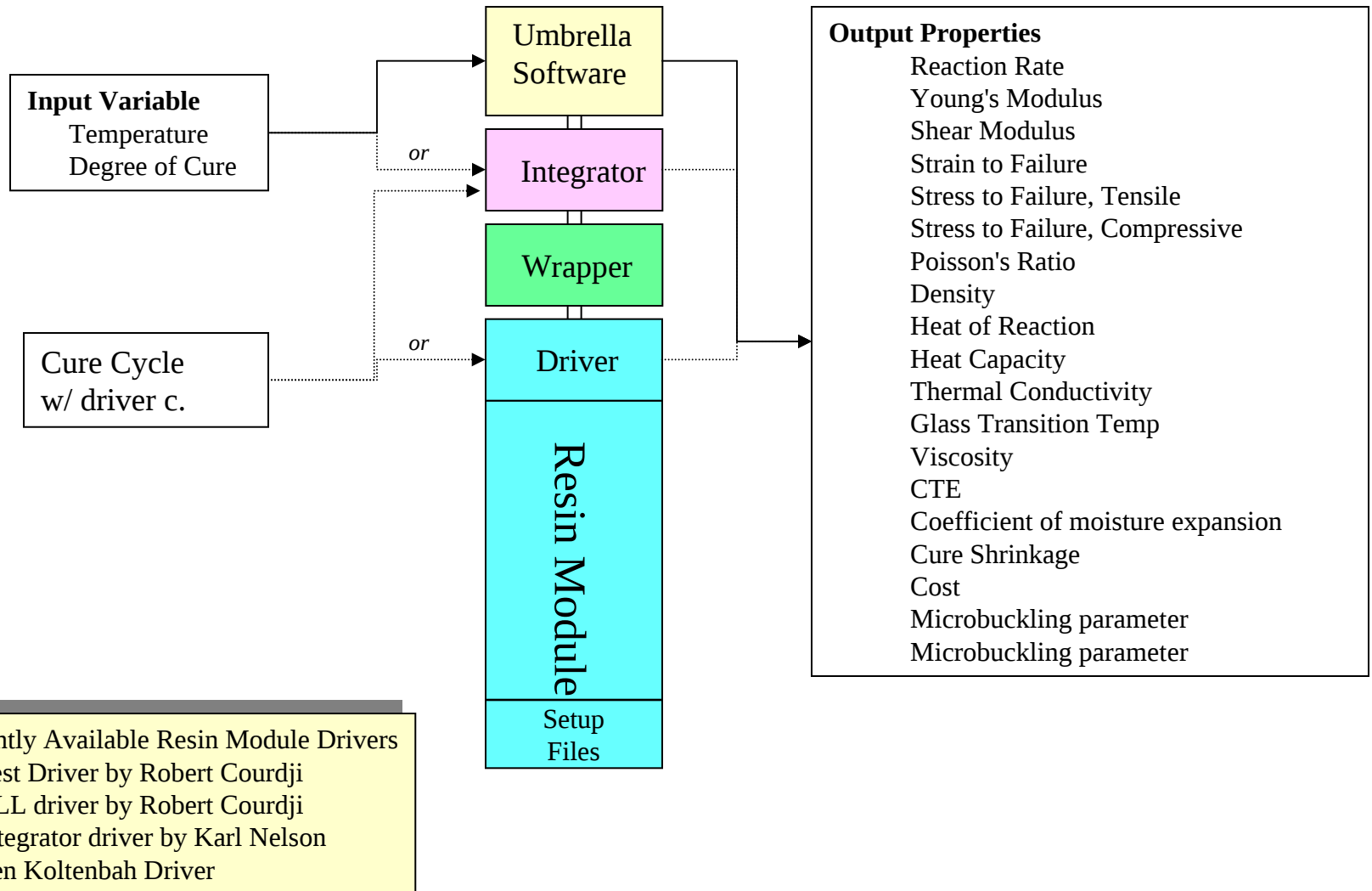
Problem Statement

- What is the cure-hardening behavior of a resin
- When does it reach minimum viscosity, gel, vitrify, and what is the glass transition temperature for a given cure cycle

Simulate the cure behavior of the resin

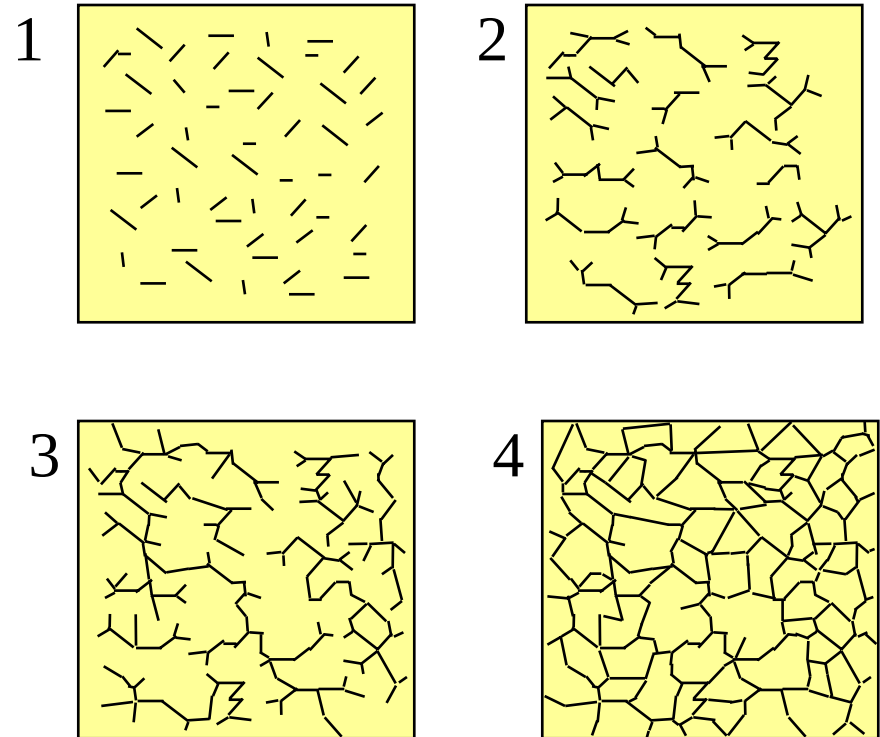
Architecture

Resin Module



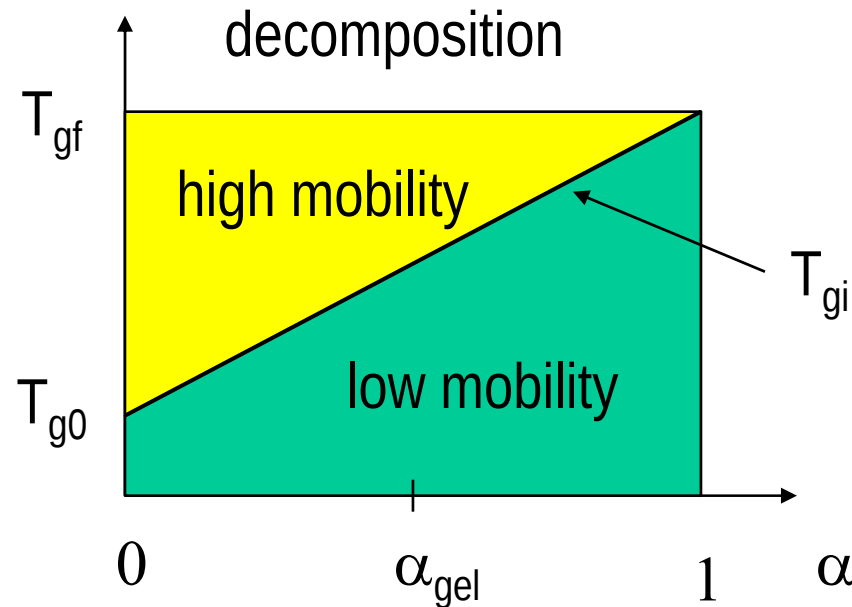
Curing of a High Performance Epoxy

- **Constituents**
 - Prepolymer
 - Curing agent
 - Catalysts
- **Important events**
 - Gelation
 - Onset of 3D network
 - Vitrification
 - Glassy behavior



Vitrification

- $T_g = T_g(\alpha)$
- $T < T_g(\alpha) \Rightarrow$ large reduction of resin free volume



State Variables in Processing

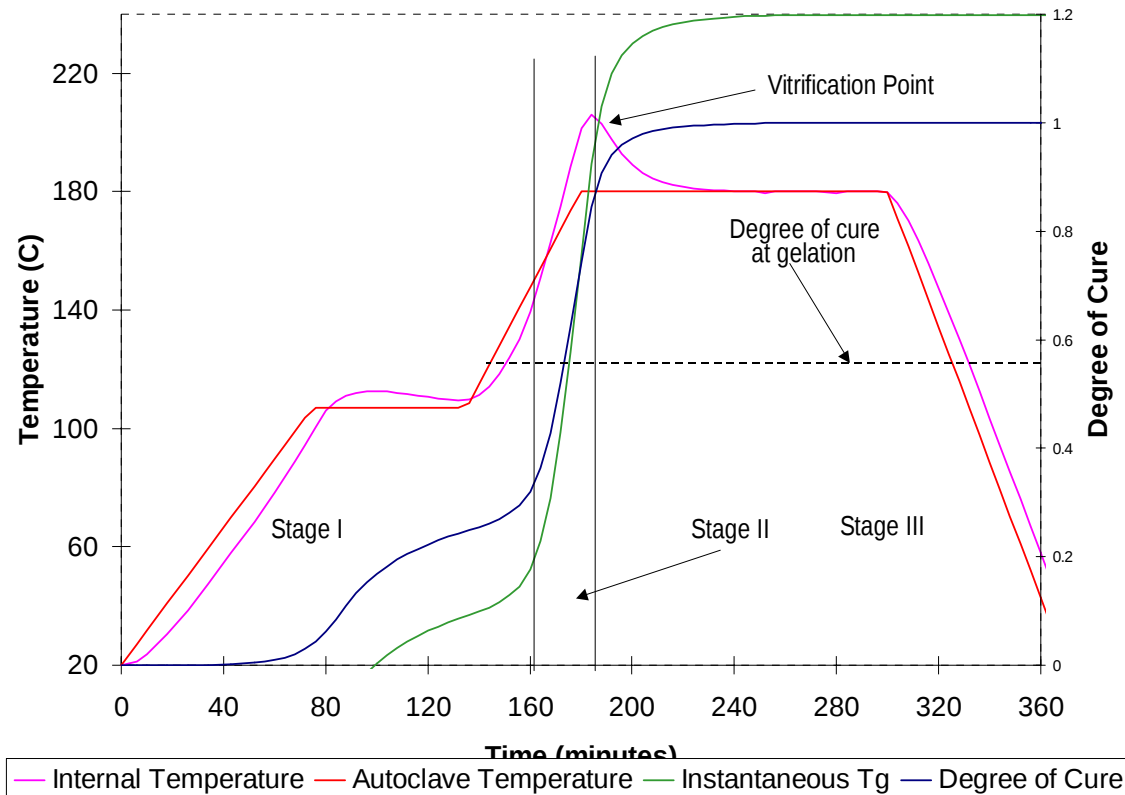
- α : degree of cure
- T: temperature
- All properties dependent on α and T:
 - Mechanical (α, T)
 - viscosity, modulus
 - Physical (α, T)
 - thermal expansion, cure shrinkage
 - Thermal (α, T)
 - thermal conductivity, specific heat

Viscosity and Modulus Development

Stage I: Viscous behavior, $\alpha < \alpha_g$, $T > T_g$

Stage II: Visco-elastic behavior, $\alpha > \alpha_g$, $T > T_g$

Stage III: Elastic behavior, $\alpha > \alpha_g$, $T < T_g$





Resin Module Simple Demonstration

Ran in Isolation of Other Modules

Output to Text File to Excel

```
CureCycle.DAT - Notepad
File Edit Format Help

:Cure Cycle Set Up File For Testing the Resin Module
:English units version

Note: the semicolon ";" in the first column identifies
      the beginning of a comment. All other lines are data.

:Version
:"01/30/02kmn"

:The number of ramp - hold segments
3

: starting degree of cure and temperature (c)
0.010, 22.0

:Segment No. 1
:Ramp Rate (C/min), Target Temp (c), and Hold time (min)
1.0, 122.0, 1.0

:Segment No. 2
:Ramp Rate (C/min), Target Temp (c), and Hold time (min)
1.0, 179.5, 360.0

:Segment No. 3
:-2.0, 22.0, 1.0

:End of File
```

```
Resin_977_Ver-25Nov-2001.dat - Notepad
File Edit Format Help

//Defining the unique ID for the file but need to find a way to verify its
uniqueness
//For now it is omitted until we can find a way.
//ResinMatConstFileID = -maybe a path to a local file?
// file name or full path on MS windows (UNIX can use relative path)

Createdby = Karl Nelson, Boeing Phantom Works
Modifiedby = Pete George, Boeing
Date = Feb 25, 2002
Version = Beta 1.5
//The above info is not used by the resin module, and will be added in the future.

// the userInputFile may be omitted by default the Request units are SI and the
DistributionLocation is 0.3 of Type Default
userInputFile = Resin_977_Ver_25Nov-2001_user_input.txt

//-----
// Density
StartProperty = ResinDensity

ModelID = Constant
ModelID = 1
DefaultValue = 1.290E+03 //mean

//The units line may be omitted by default no units are used
DefaultUnits = kg/m^3 //SI=kg/m^3 OR Imperial = lb/ft^3

//The Default distribution model is the distribution to be used when a user wants
to use the distribution of the actual
// property. The other way (Local Distribution Model) is for the user to use a
distribution for each of the material constants that
// make up the material property. If no Distribution Model is given (Default
and/or Local), a Normal distribution will be used with
// a std dev of 0.0
Default Distribution Model = Normal

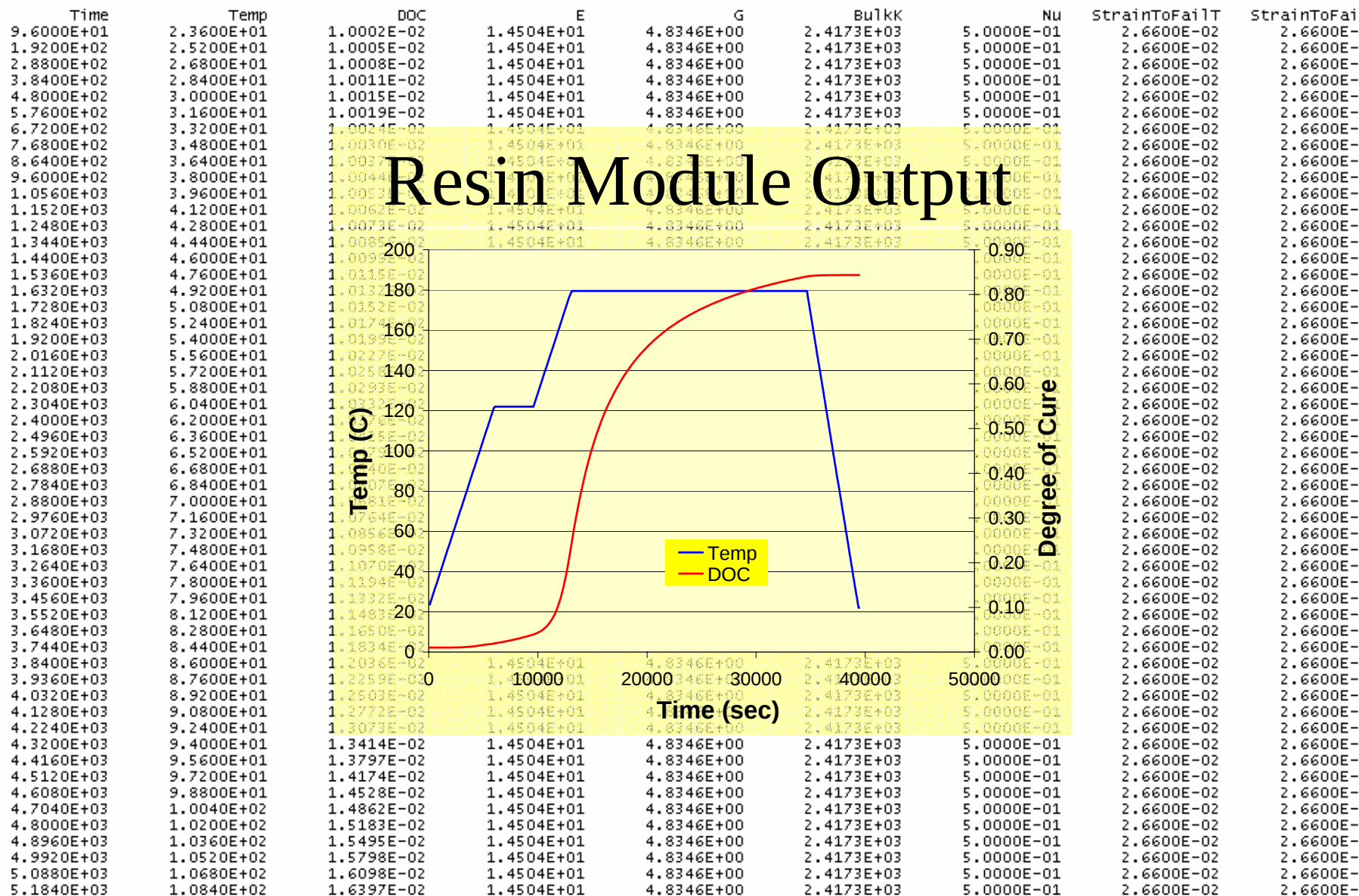
//Std dev
Default Distribution Model Const = 0.005 // g/cm^3 same units as the
DefaultUnits if not defined
Default Distribution Model Const units = g/cm^3

//Note! you can have more than one line of validation comments
ValidationComments = values from Pete e-mail oct 12 2001

//data section
ConstID = 1.290E+03 //NomResinDensity at DOC=1.0
//The units line may be omitted by default none units are used
```

Execute Resin Module

977-3 Property Values
ResinMainVKMN by Karl M. Nelson Jan. 30, 2002
Boeing Accelerated Insertion of Materials - Composites

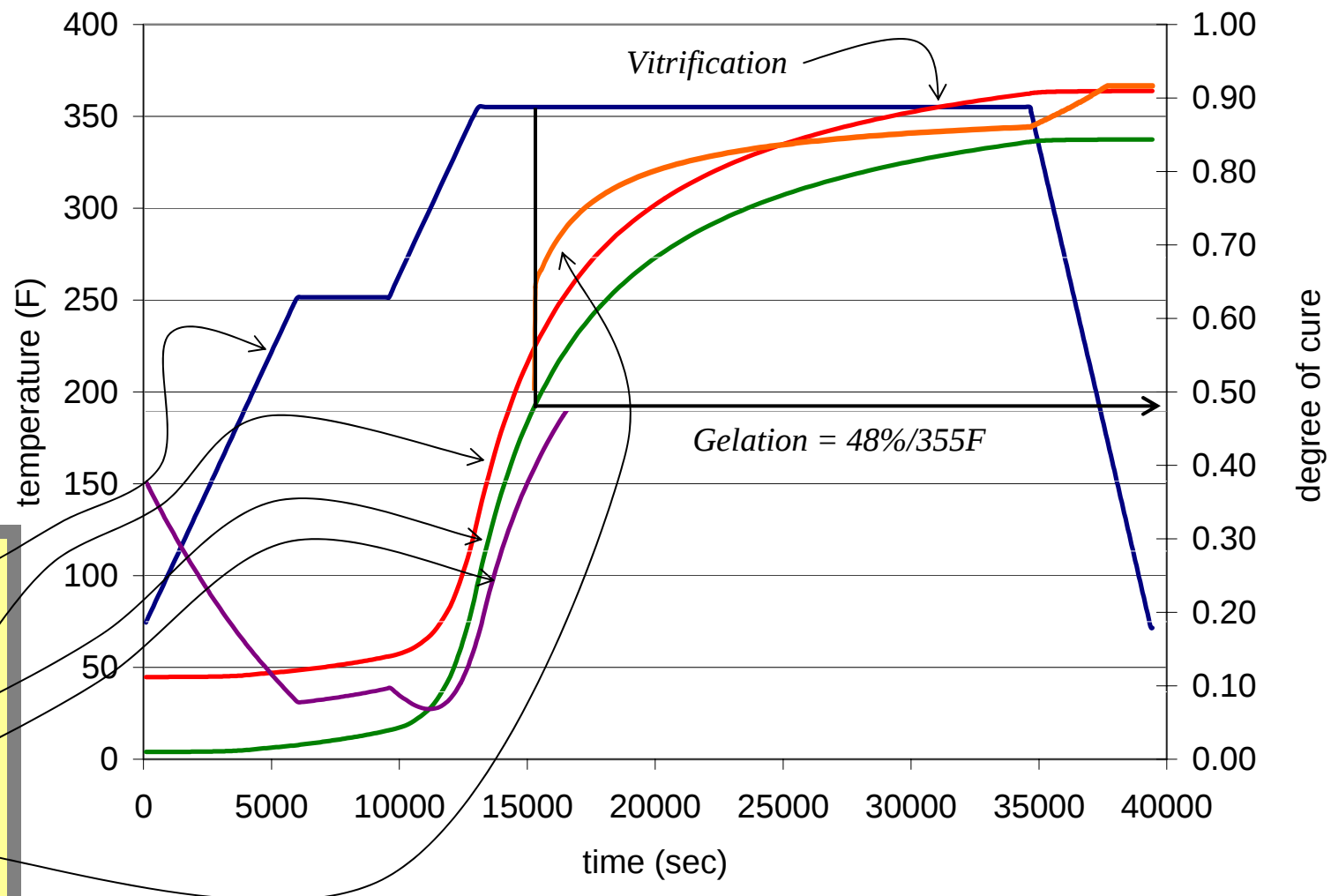


Resin Module Output

Gelation Occurs at the Cure Temperature

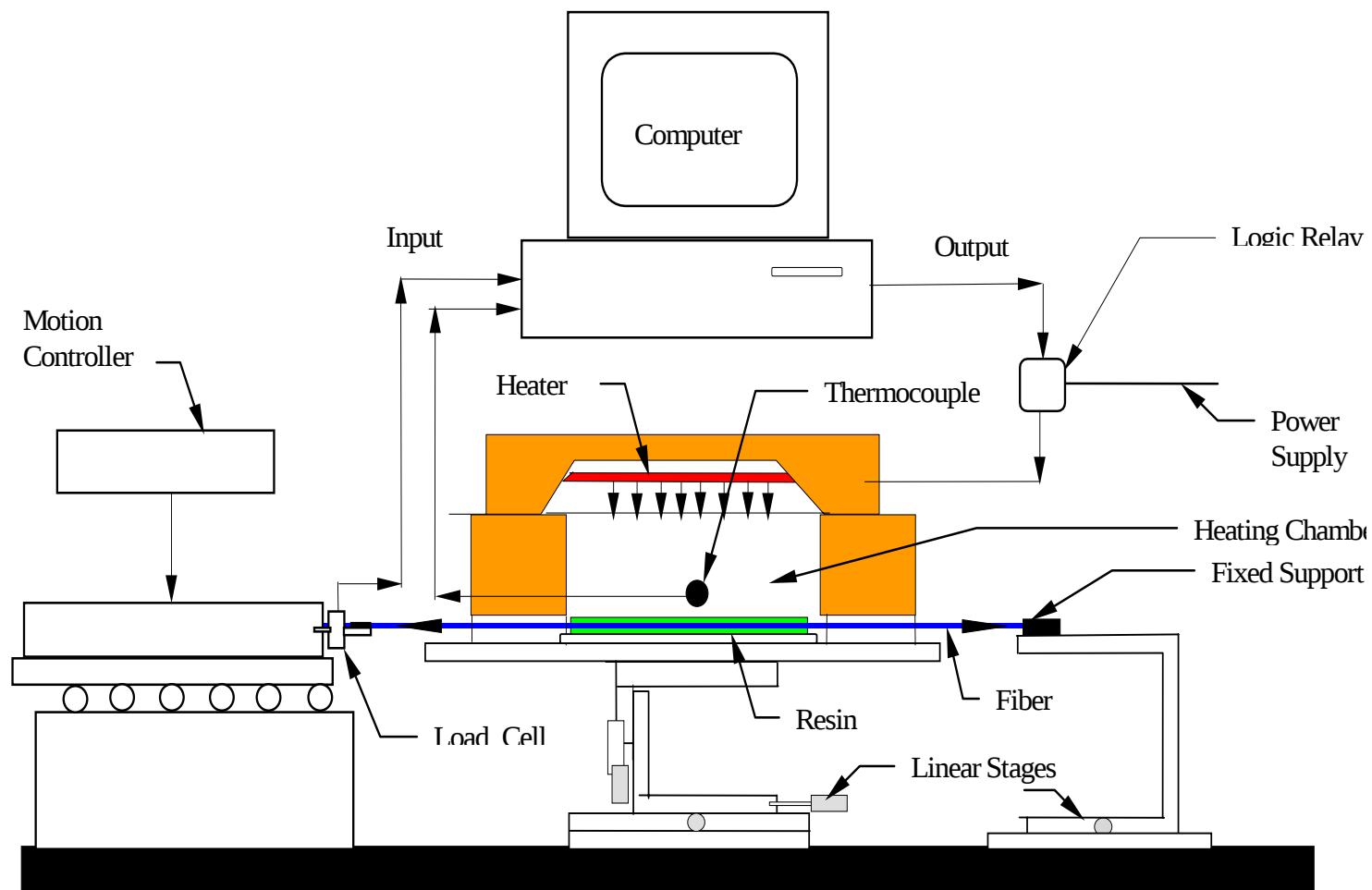
Vitrification Occurs At End of Cure Cycle, Prior to Cooling

- Resin Temperature (F)
- Instantaneous Glass Transition (F)
- Degree of Cure
- Resin Viscosity (Relative Scale)
- Resin Modulus (Relative Scale)

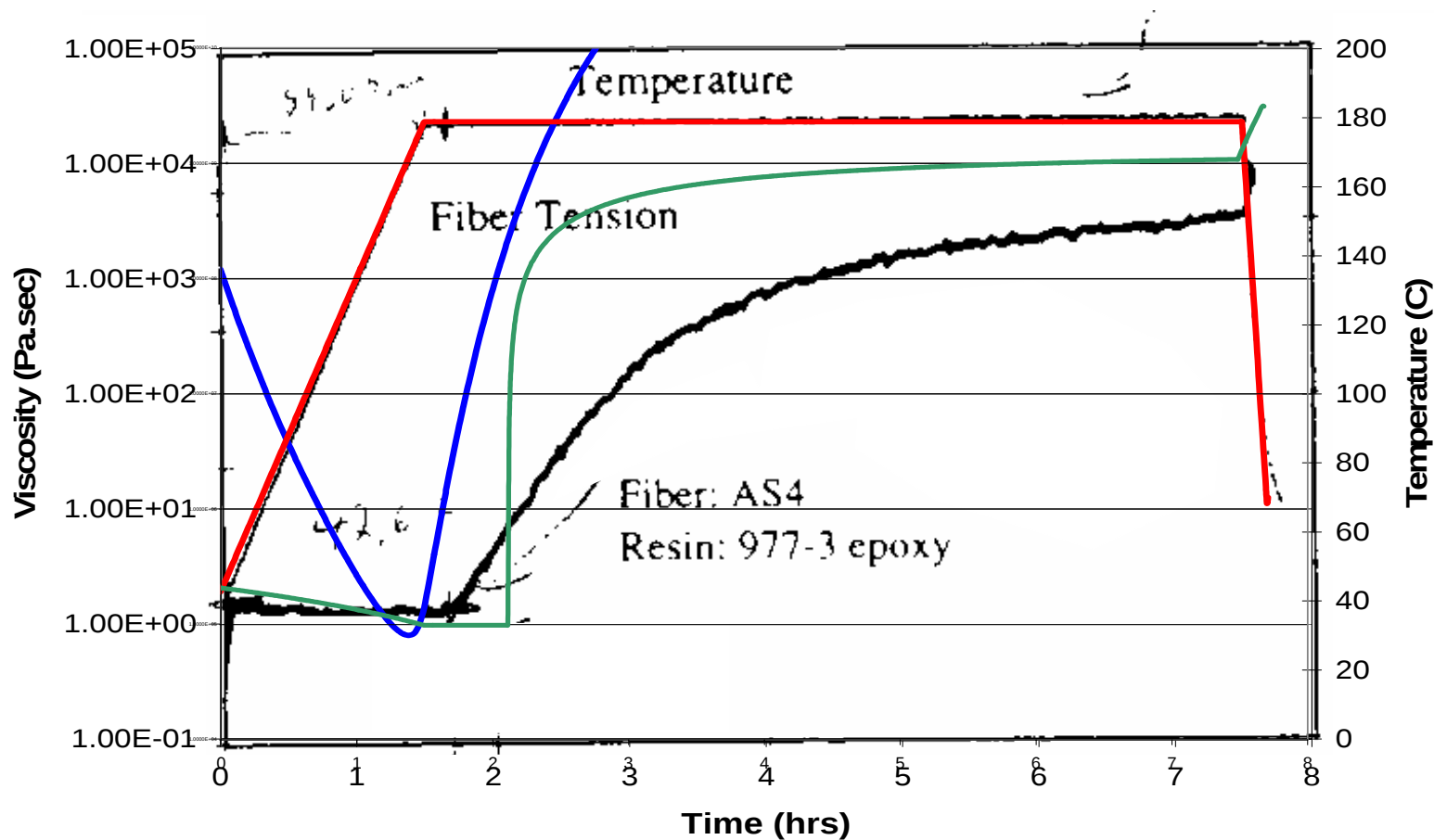


Schematic of CIST Apparatus (cure-induced stress test)

University of Tennessee, Madu Madukar

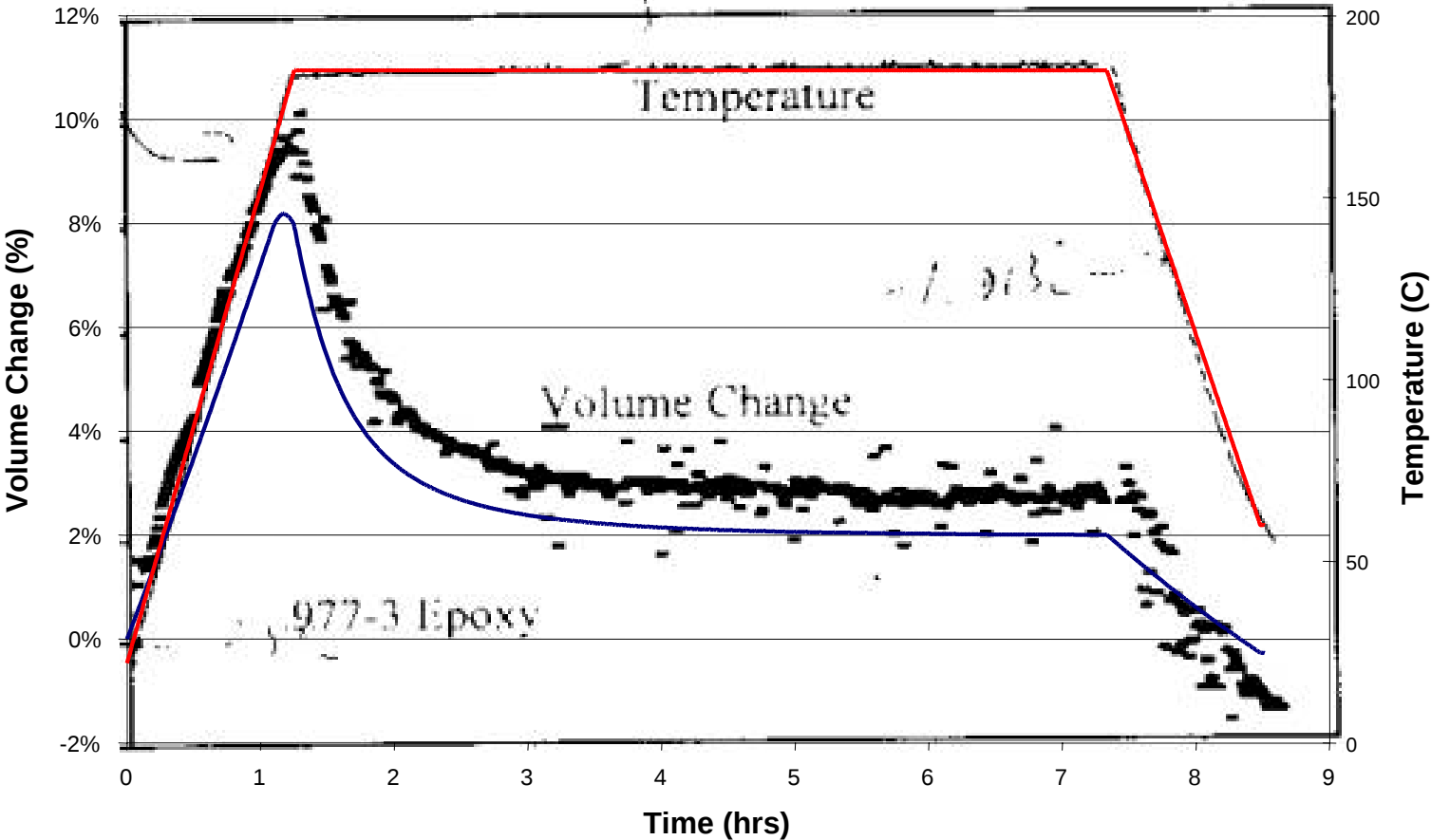


Gel Point is Consistent Although Magnitude Needs Study



Data From Genidy, Madhukar, and Russell, Journal of Composite Materials, Vol. 34, No. 22/2000

Cure Shrinkage Effect is Consistent with Published Work



Data From Genidy, Madhukar, and Russell, *Journal of Composite Materials*, Vol. 34, No. 22/2000

Sample Problem 2

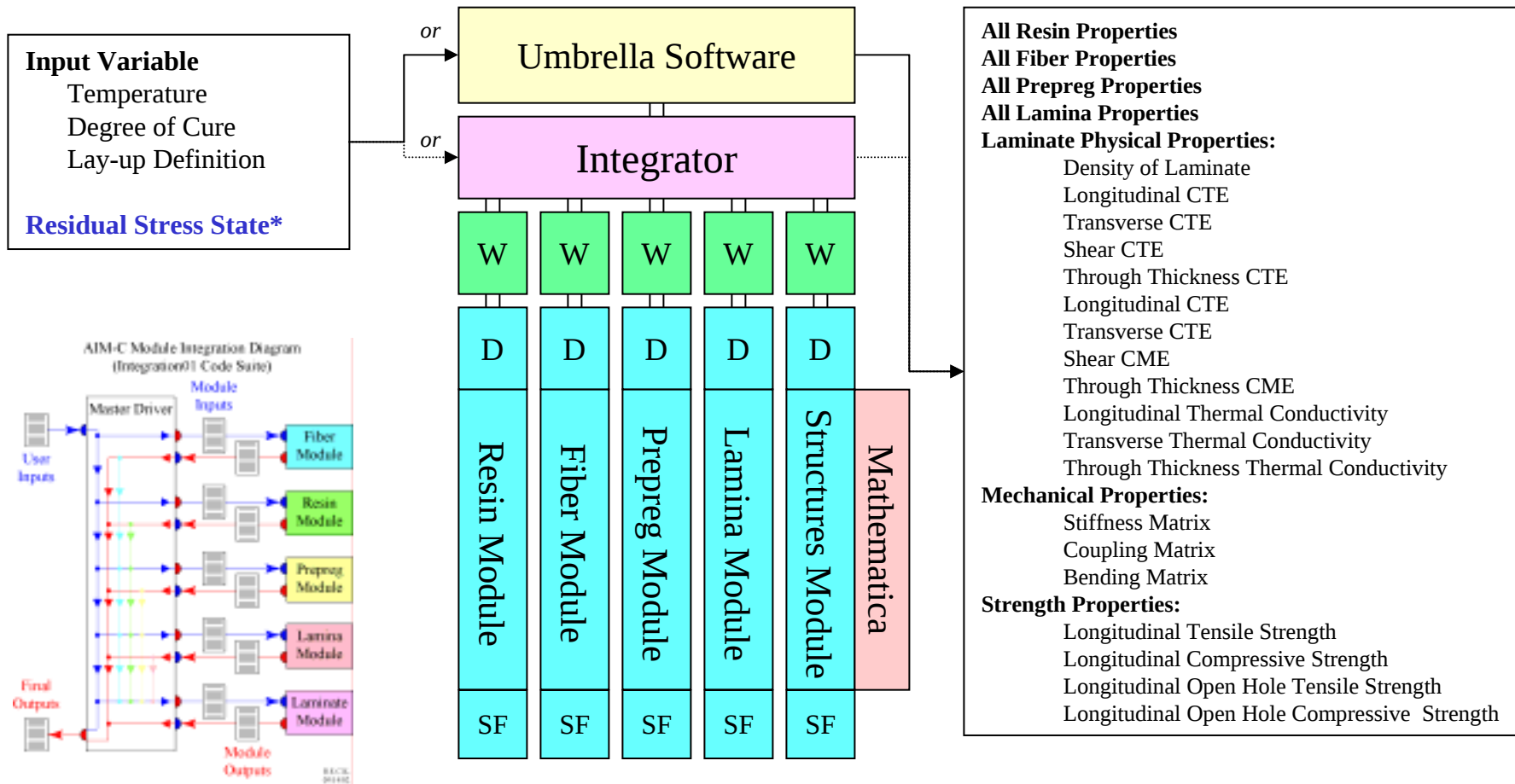
Zero CTE Structure

Problem Statement

- Zero CTE composites are often used in applications needing thermally stable structure.
- A zero CTE laminate is produced by using low or negative CTE carbon fiber laminates.

Determine a layup (fiber angle stacking sequence) that would give you a zero CTE laminate.

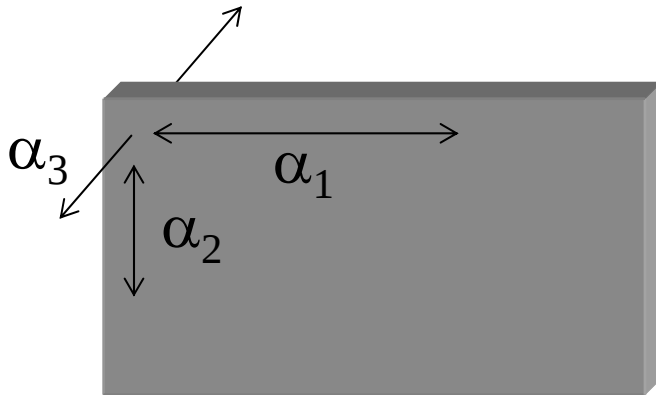
System Architecture



Assume an Eight-Ply Laminate

Made of 0's, and +/- θ Angles

Built Symmetrically



Ply Number	Layup 1 [+ θ , - θ]s	Layup 2 [+ θ , - θ , 0, + θ , - θ]s	Layup 3 [+ θ , 0, - θ , 0, + θ , 0, - θ]s	Layup 4 [0, 0, + θ , 0, 0, - θ , 0, 0]s
1	+ θ	+ θ	+ θ	0
2	- θ	- θ	0	0
3	+ θ	0	- θ	+ θ
4	- θ	+ θ	0	0
5	+ θ	- θ	+ θ	0
6	- θ	0	0	- θ
7	+ θ	+ θ	- θ	0
8	- θ	- θ	0	0

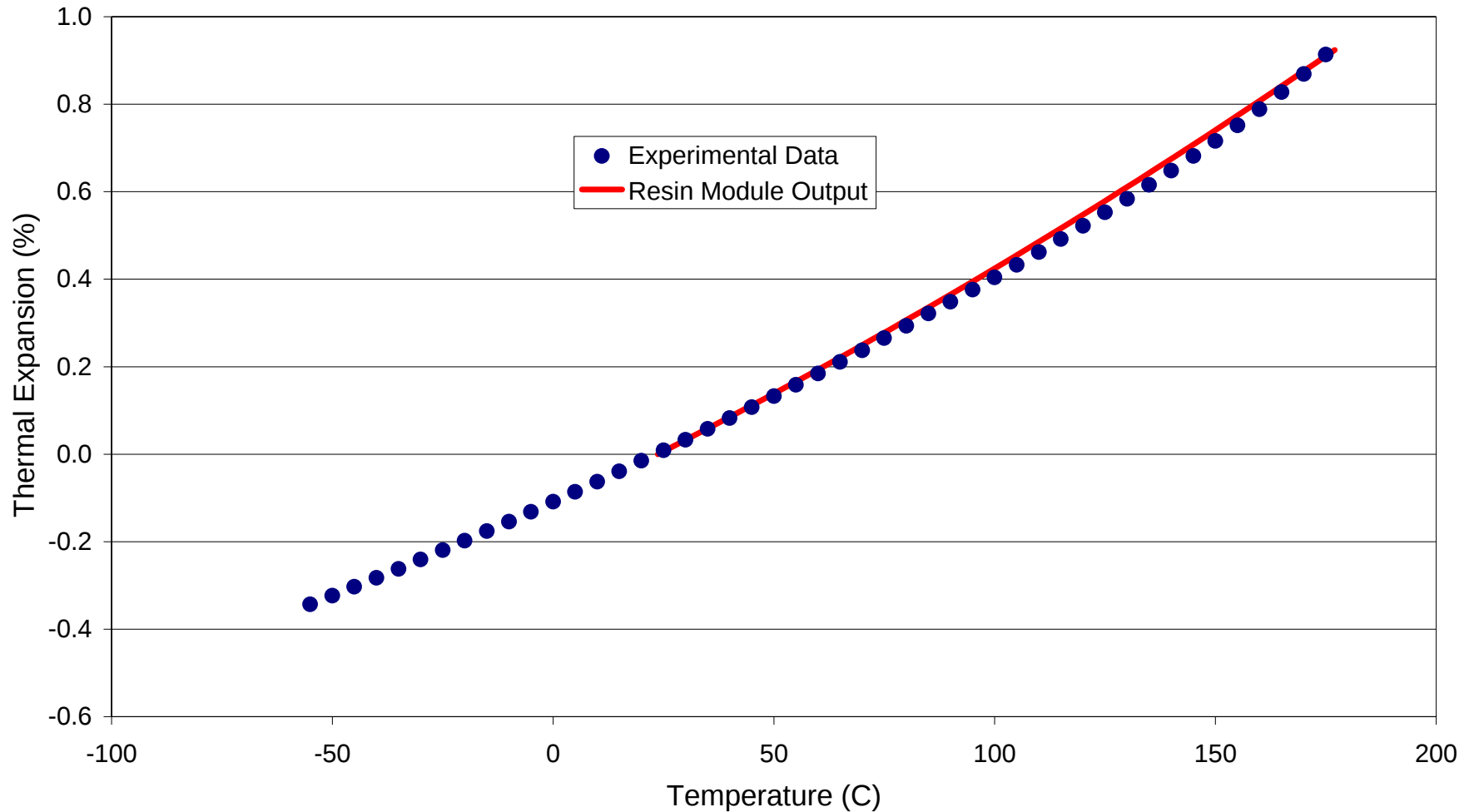
sym

θ was varied from -10° to $+90^\circ$ in steps of 5° .

Resin Module Captures Resin CTE

Property from fully cured neat resin

Behavior Dependant on Temperature and Degree of Cure



Fiber Module Captures Fiber CTE

Behavior Dependant on Temperature and Degree of Cure

$$\alpha_1 = -2.22\text{E-}7 \quad \text{Axial}$$

$$\alpha_2 = 1.118\text{E-}5 \quad \text{Transverse}$$

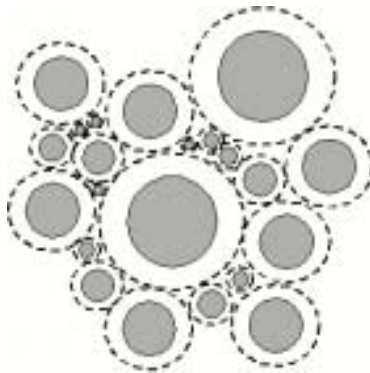
Fiber
Module
Text
Output

```
FIBMOD_SETUP.out - Notepad
File Edit Format Help
Fiber Property = Value Units
Fi_E_1 = 2.7700000027E+11 Pa
Fi_E_2 = 1.7200000208E+10 Pa
Fi_G_12 = 1.8600000000E+10 Pa
Fi_G_23 = 4.8300000000E+09 Pa
Fi_nu_12 = 2.0000000000E-01 unitless
Fi_nu_23 = 2.5000000000E-01 unitless
Fi_snf_1 = 1.8180000035E-02 unitless
Fi_Ssf_1 = 4.9500000110E+09 Pa
Fi_rho = 1.7810000004E+00 g/cc
Fi_Cp = 9.3022617815E+02 J/Kg.K
Fi_k_1 = 5.2813479194E+00 W/m.K
Fi_k_2 = 1.2195054698E+00 W/m.K
Fi_alpha_1 = -2.2200000000E-07 1/K
Fi_alpha_2 = 0.0000000000E+00 *no input data*
Fi_yield = 4.4596000030E-01 g/m
Fi_dia = 5.0000000000E-09 m
Fi_Count = 1.2000000000E+01 K
Fi_Eb_2 = 0.0000000000E+00 *no input data*
Fi_ScC_1 = 3.3230000000E+09 *no input data*
Fi_Cost = 5.0000000000E+01 $/lb
Fi_Ssf_2 = 1.1000000000E+08 Pa
Fi_Ssf_12 = 1.1700000000E+08 Pa
Fi_Ssf_23 = 8.2700000000E+07 Pa
```

Lamina and Laminate Modules

Effects of Resin Fiber and Prepreg Properties

- Composite Cylinders Assemblage used for lamina thermoelastic property prediction.
- Laminated plate theory for $[(0/90)_s]_s$ laminate level properties.
- Laminate analyses conducted using closed-form solution for stresses near an open hole.
- Various Failure Criteria (Max Strain, Hashin Interaction and PASS) can be compared.

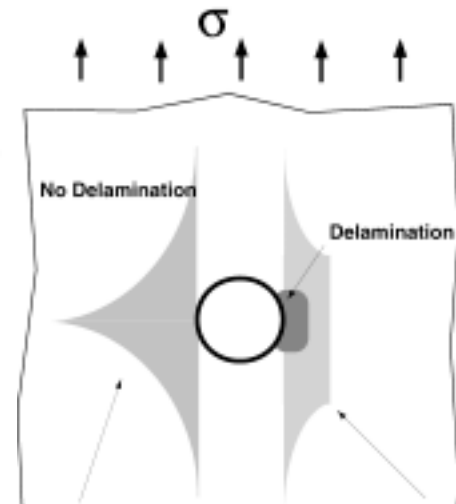
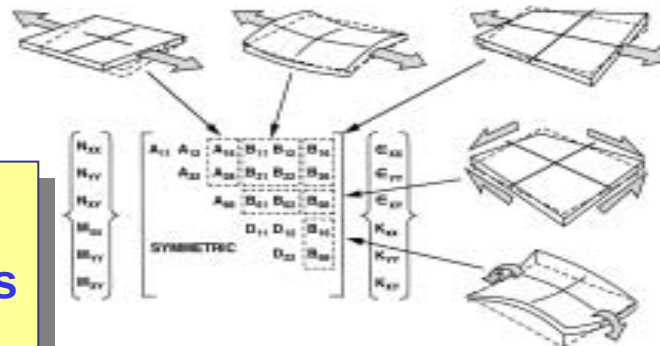


Models for Continuous Fiber Composites

Composite Cylinders Assemblage (CCA)
Generalized Self-Consistent Method (GSCM)

Models for Effective Continuum Properties

Classical Lamination Theory (CLT)



Models for Predicting Structural Response

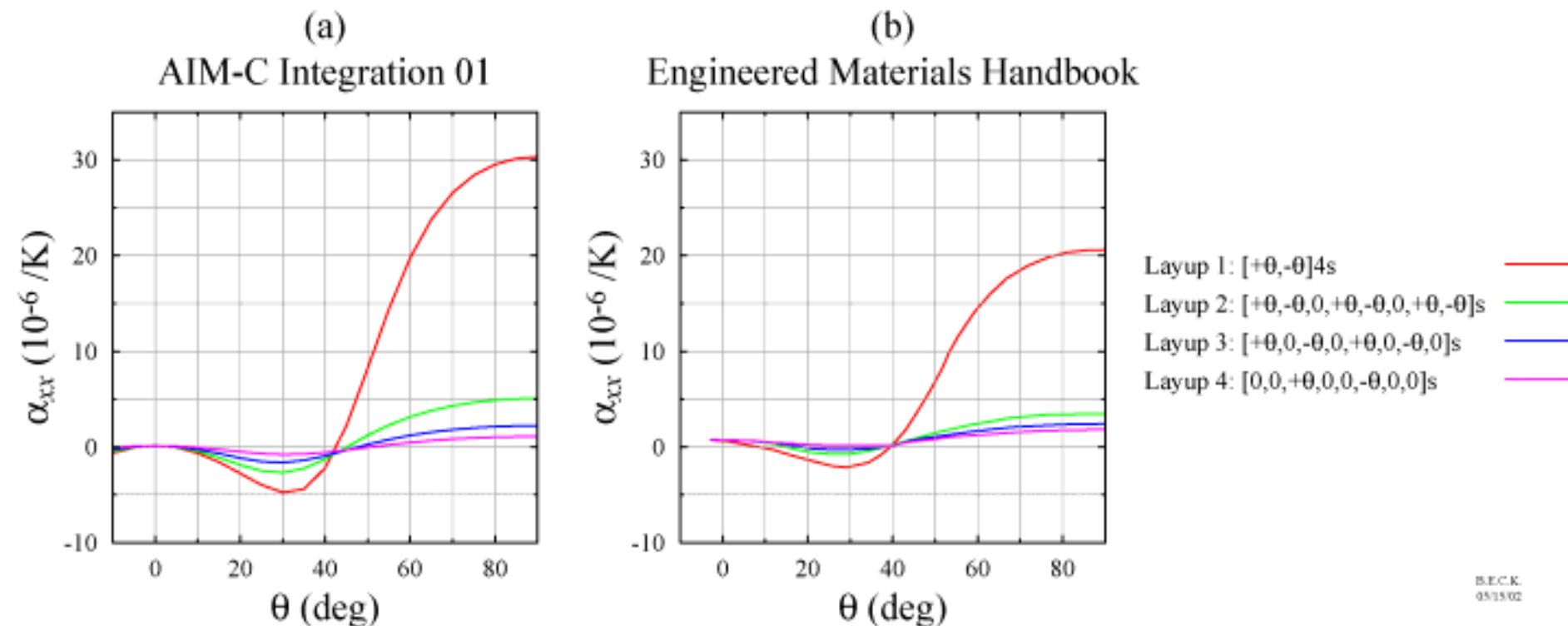
Level 1 : Parametric Analyses; elastic laminate with approximations

Results of Analysis

Two Solutions, at ~ 0 -deg, and ~ 43 -deg

The difference in solutions is due to resin and fiber type

Layup 4 with $\theta = 49$ -deg gives a “robust” solution



(b) ref. Principe, F. S., Manib, M.M., and Linsenmann, D. R., *Design Requirements*, pp 181 – 184, in *Engineered Materials Handbook, Volume 1, 1987 Composites*, ASM International.

Sample Problem 3

Cure of Thick Laminates
Cure Cycle Development

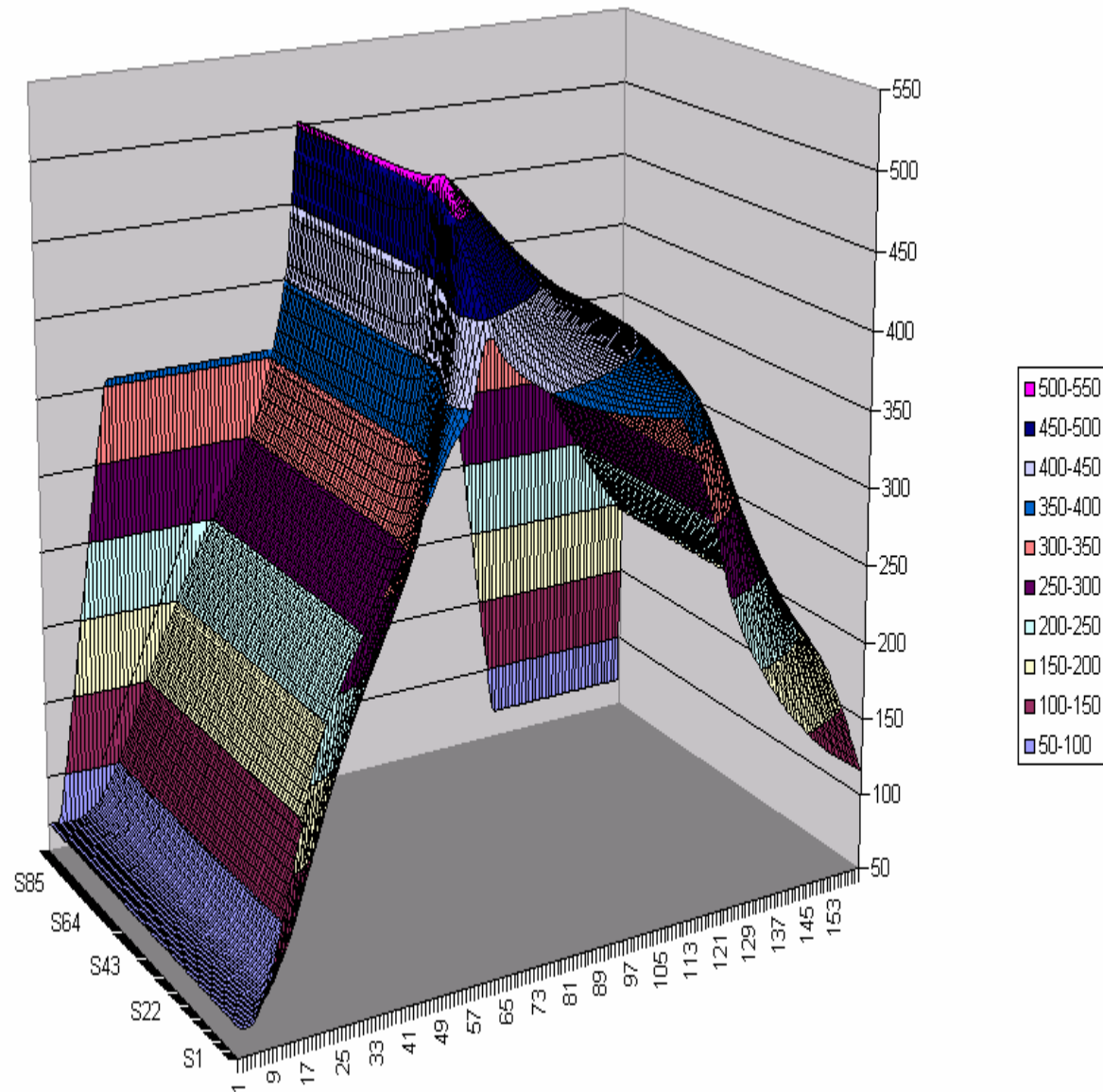
Problem Statement

- The heat of reaction during cure can create extremely high temperatures, especially in thick laminates.
- Autoclaves heat transfer characteristics vary greatly, compounding the problem.

Develop a robust cure cycle for a thick laminate, given inherent variability due to heat transfer.

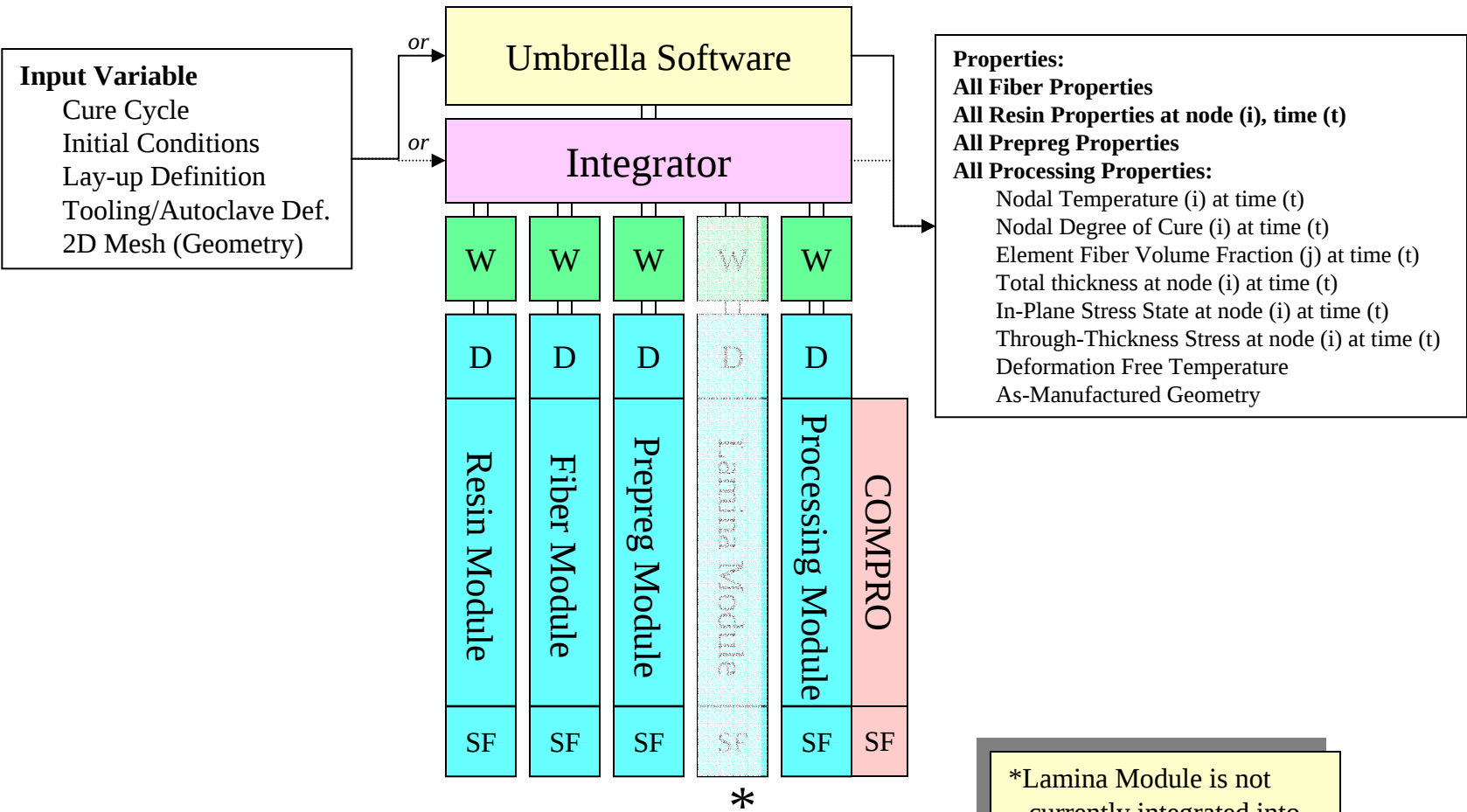
Example of Problem

977-3/IM7 - 5-inches thick



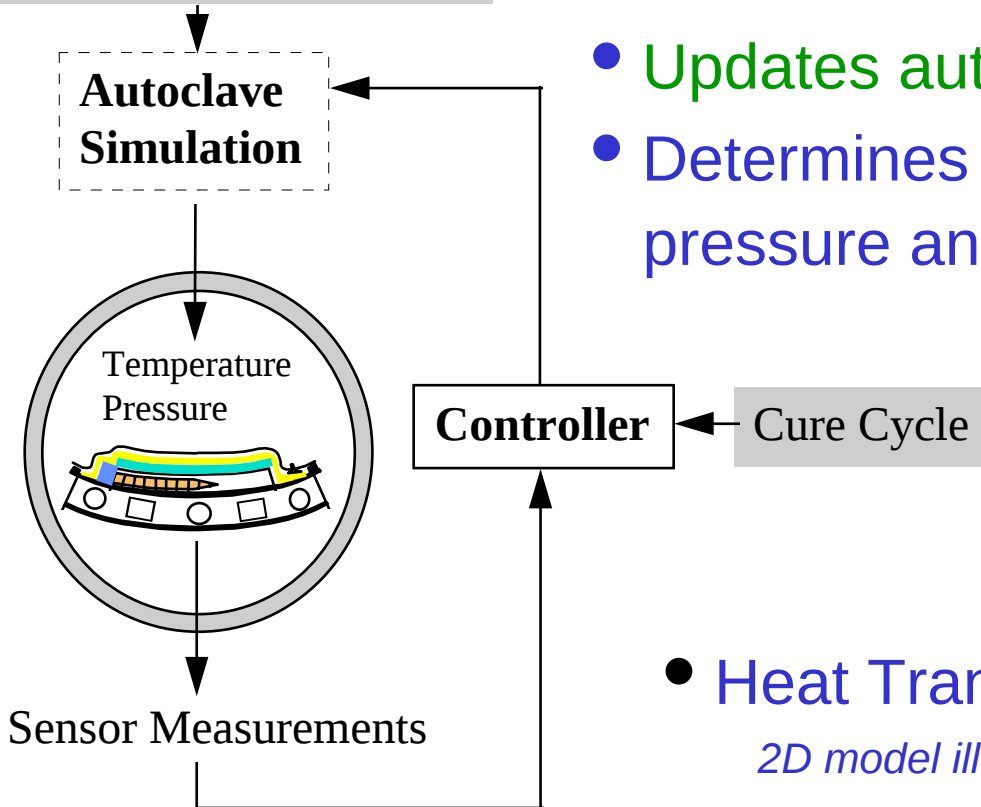
System Architecture

Processing Properties



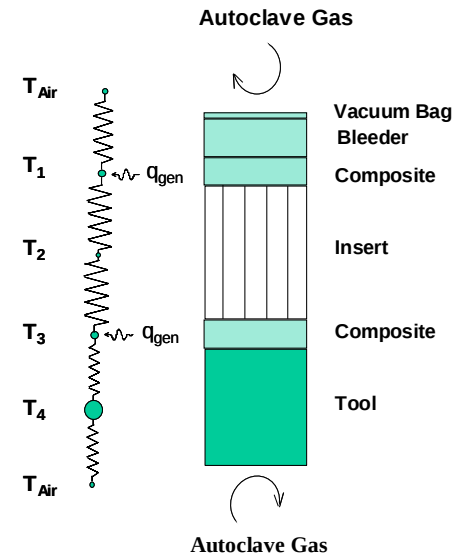
Model of the Autoclave

Autoclave Characteristics



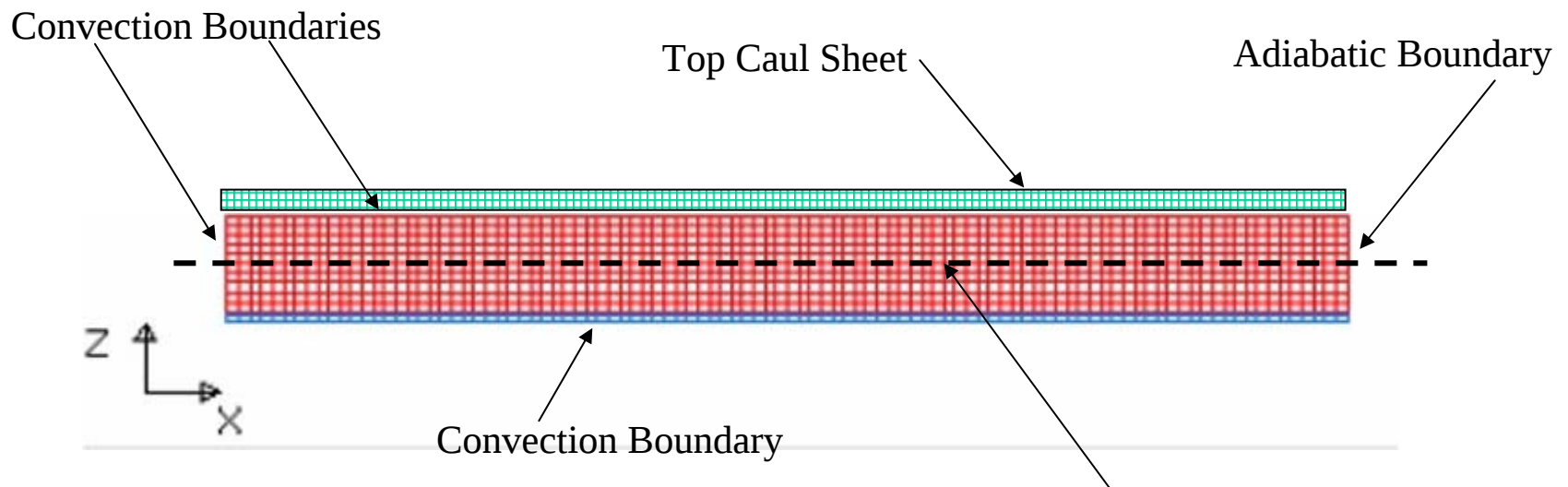
- Reads data from “virtual sensors”
- Updates autoclave controller set points
- Determines autoclave temperature, pressure and bag pressure

- Heat Transfer
2D model illustrated in 1-D



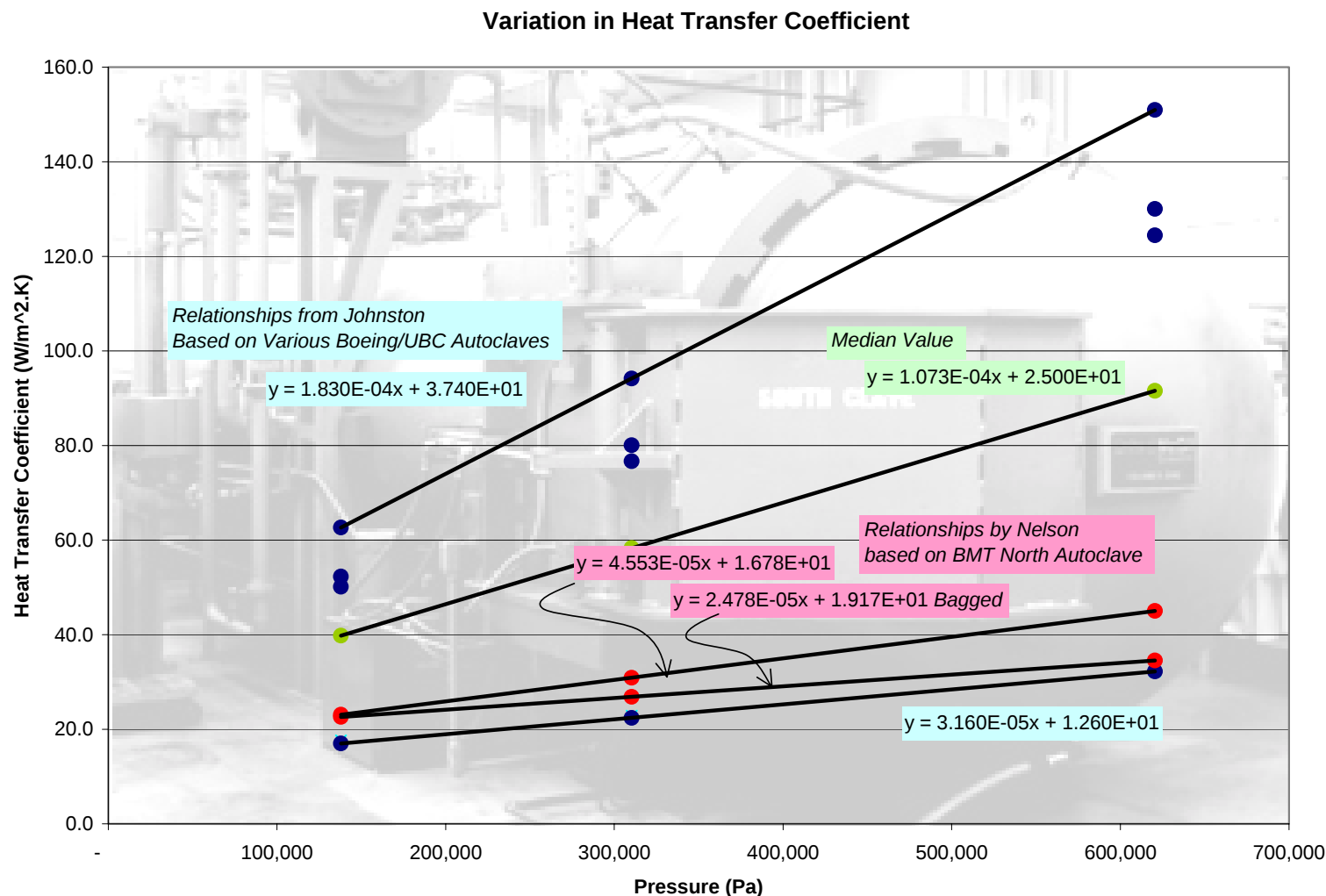
AIM Processing Module

5" thick part on 0.5" thick Invar tool

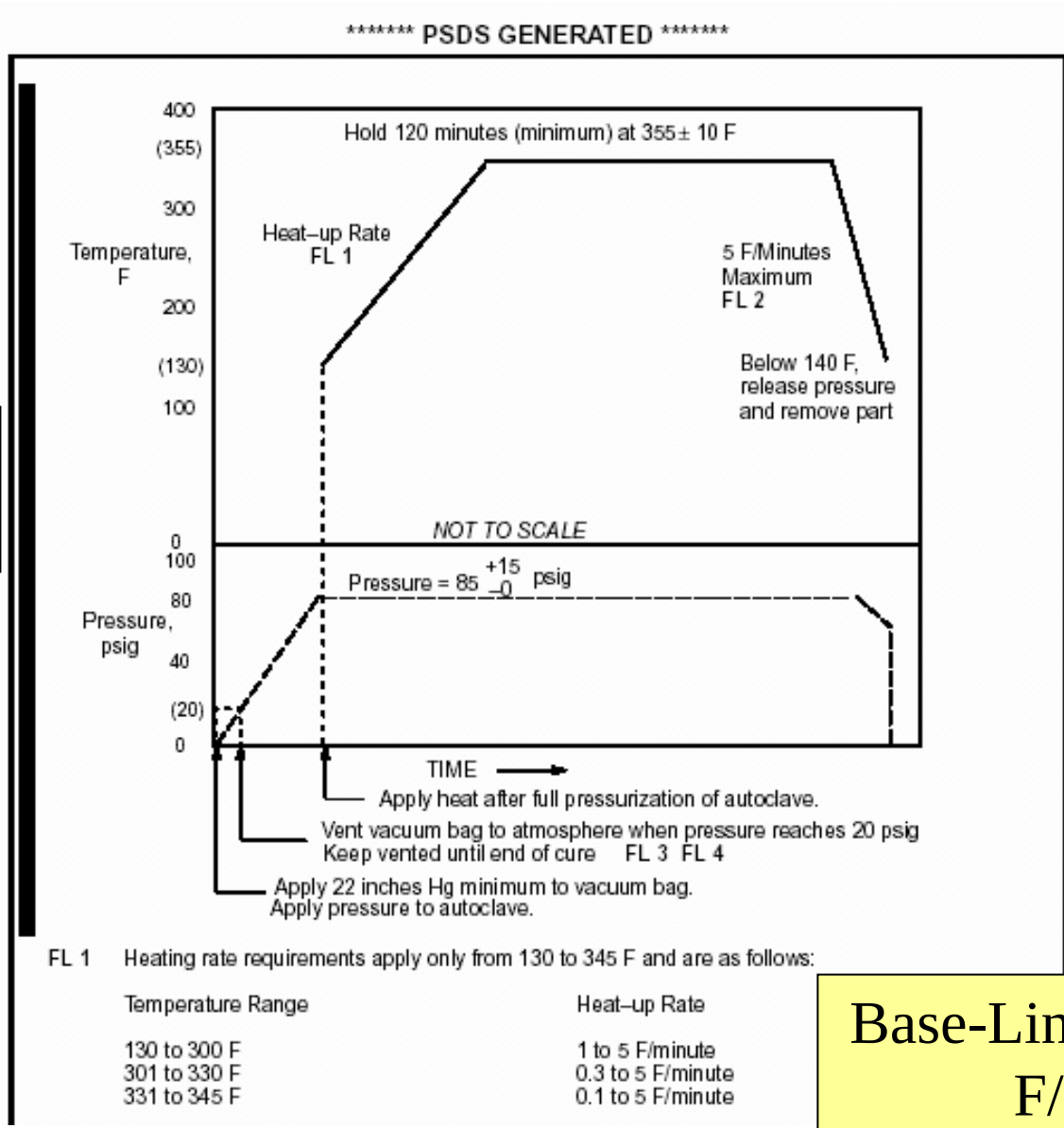


- Look at part temperature with respect to time and position along center line

Heat Transfer Variability



Process Specification



Base-Line 4.25 deg F/min

Setting up and Solving a Problem

Benchmark

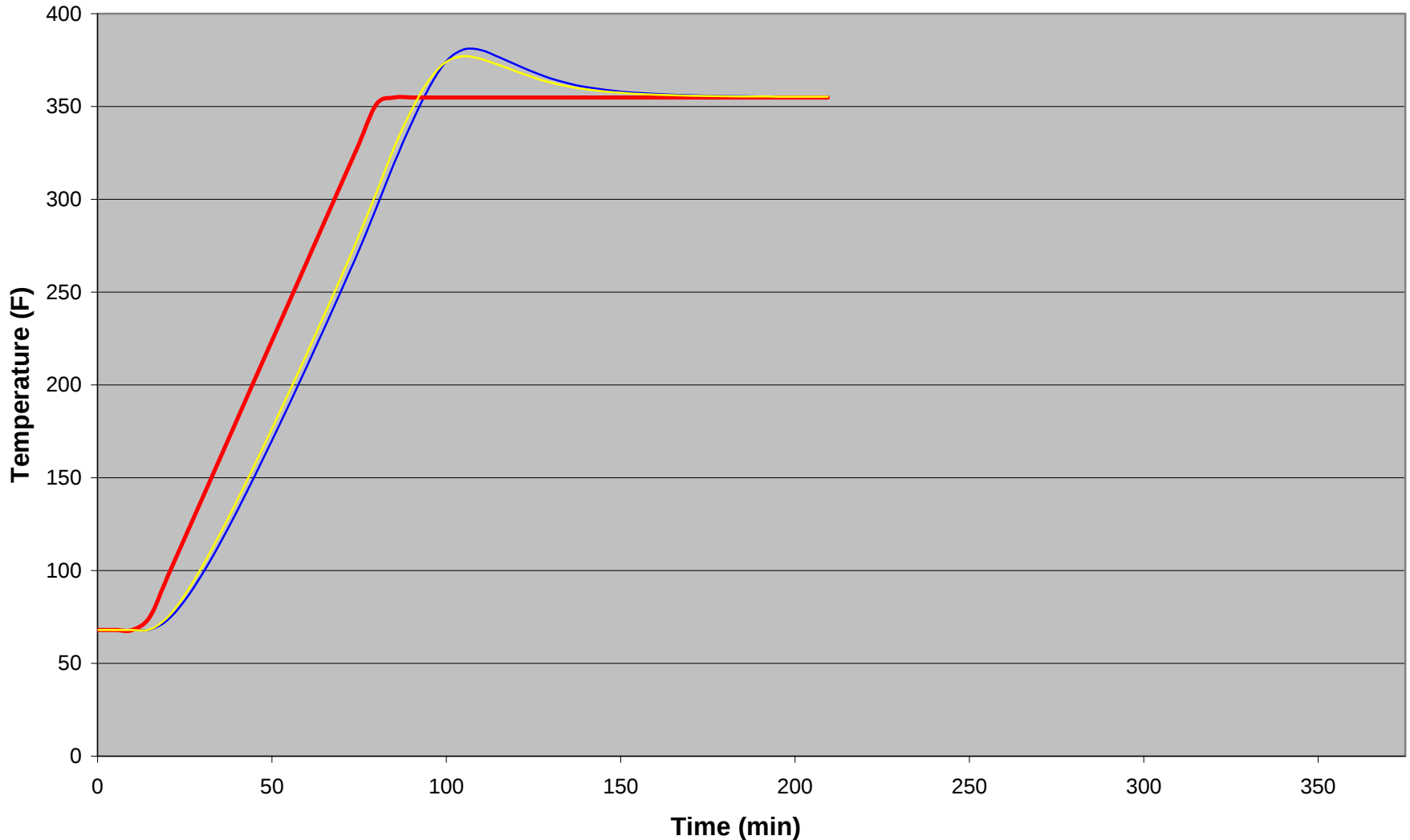
Advanced User (*Karl Nelson*)

Reviewing Specifications and Background Info	2-hrs
Defining Geometry	1-hr
Trouble Shooting	2-hrs
Running Simulations and Reviewing Results	5-hrs
Review Final Results with Customer	1/2-hr
Total Time	10 1/2-hrs



Cure of 0.88-inch Thick Laminate

Simulation of Typical Cure Cycle



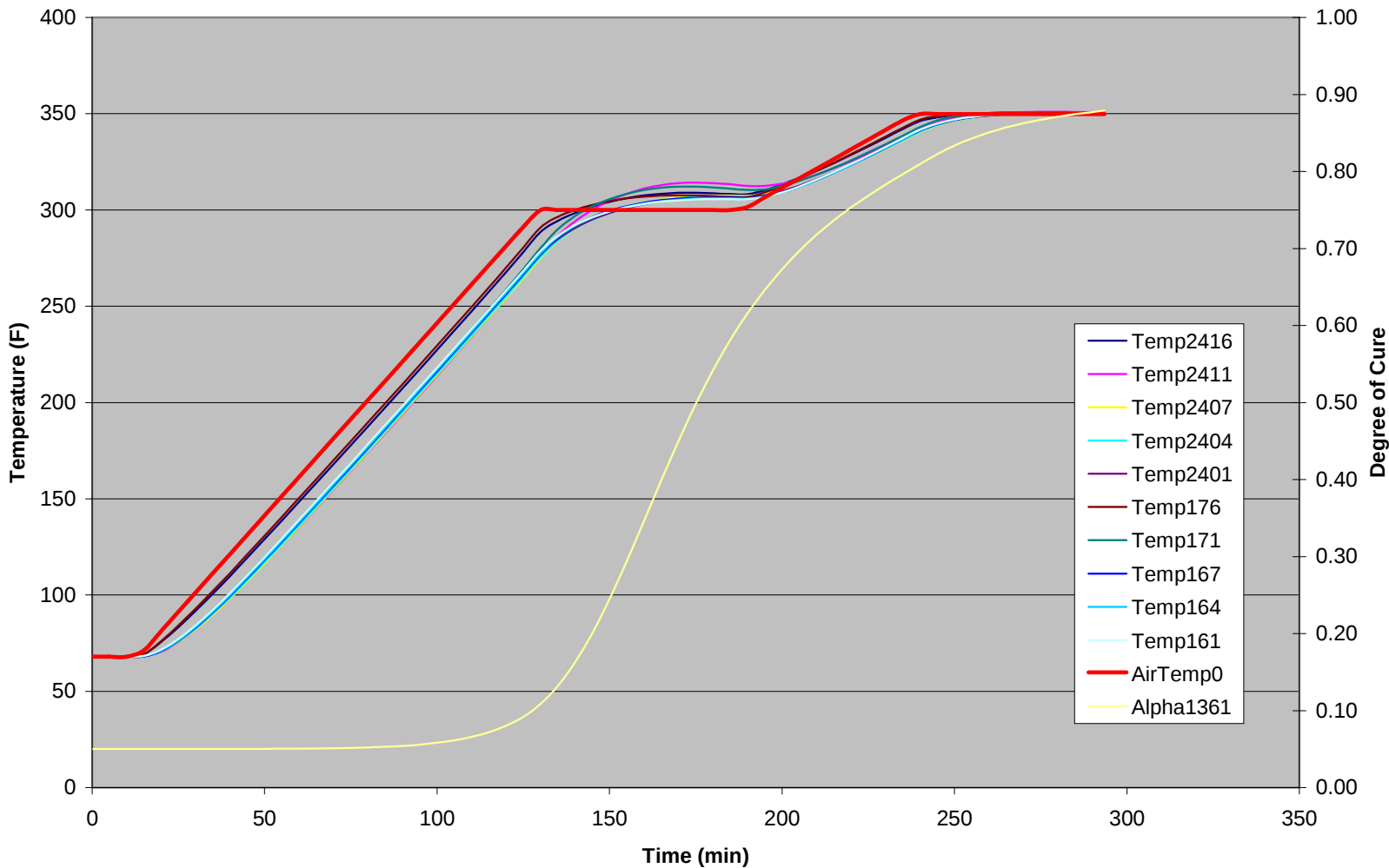
Engineering Recommendation

Based on Processing Module (COMPRO) Results

1. Heat at a maximum heating rate (based on air thermocouple) of 2F/min up to a 300 +/- 10F hold.
2. Hold at 300 +/- 10F for a minimum of 60-minutes.
3. Heat at a maximum heating rate of 1F/min to a target of 350F (350+15/-5)
4. Hold base on the lagging part thermocouple for 120-min (as prescribed in processing specification).
5. Complete the cycle as put forth in processing specification.



Predicted Response of 0.88-inch Thick Carbon/Epoxy Laminate

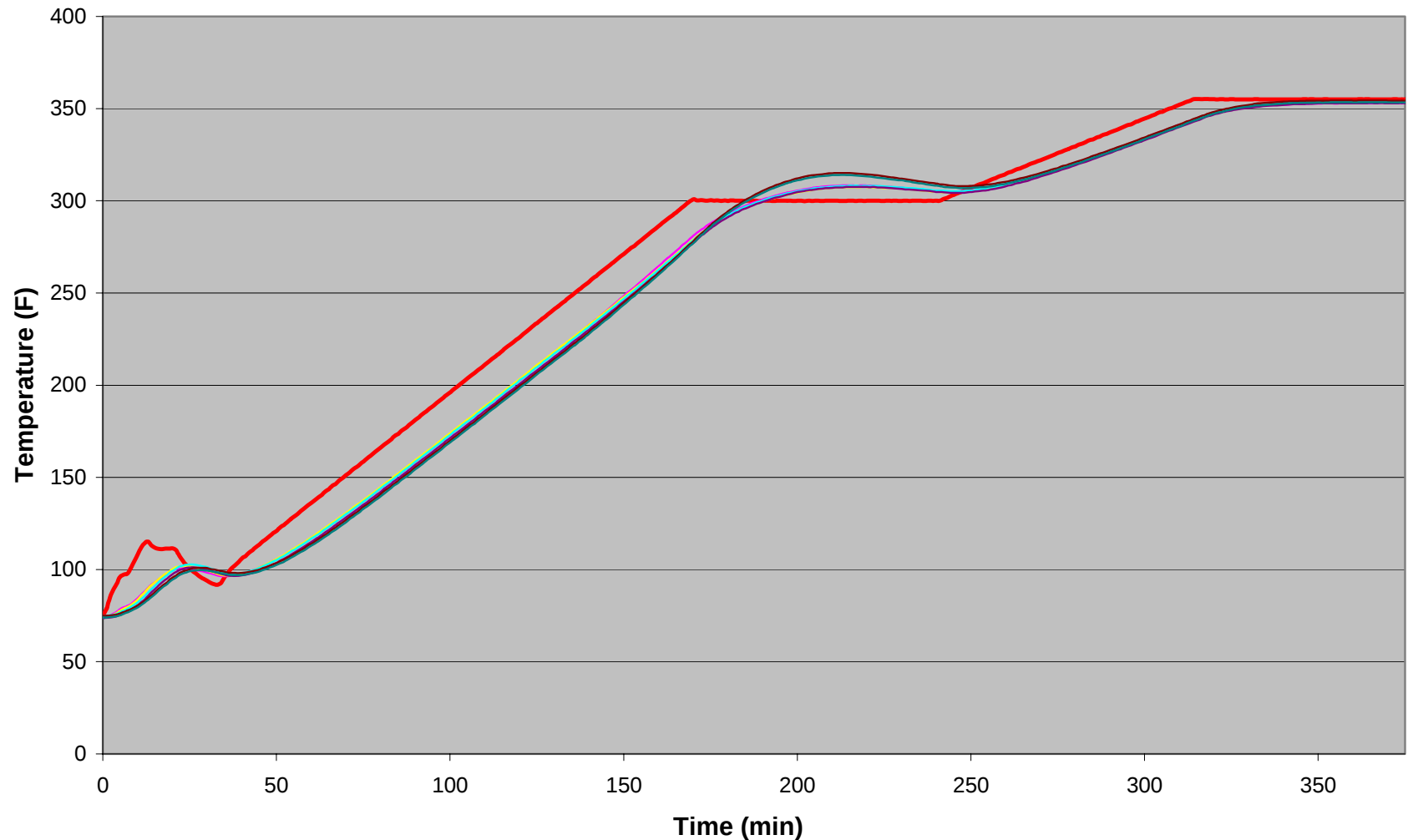


The heat transfer coefficient was unknown, so the challenge was to develop a (robust) cycle that would be work no matter what the value.





Autoclave Thermocouple Data of 0.88-in Thick Carbon/Epoxy Laminate



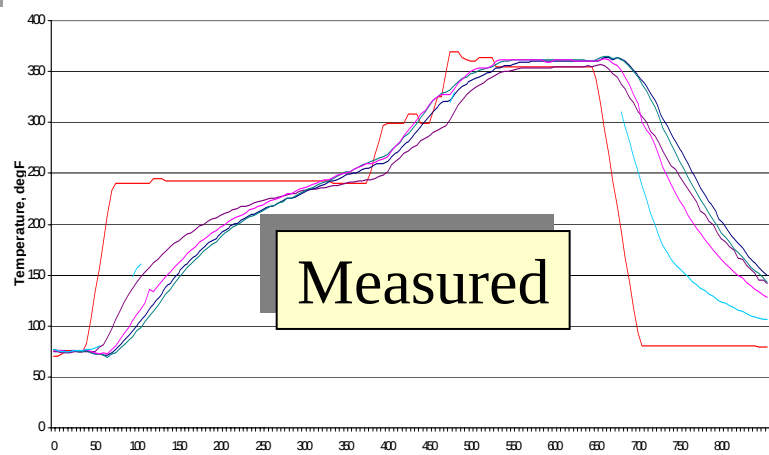
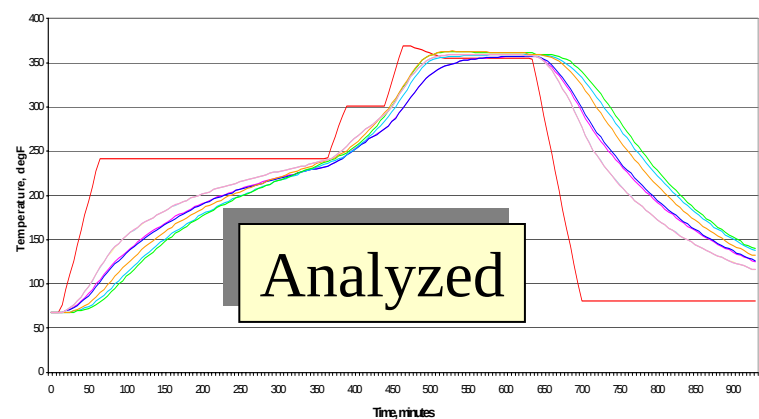
Problem Solution of John Kooch

Can We Cure a Laminate up to 5-inches?

- Process design by analysis – validate by test
- Carbon/Epoxy
- Current simulations indicate *yes*
- Test run just completed at Boeing MR&D in Auburn
 - 3.5-inch thick laminate 18-inch square.



Successful Cure of 3 ½ inch Thick Laminate
First Time - Using Analysis To Specify Cure Cycle



More Complex Problems

- How do you use the tools to design and build a complex composite structure?
- Can you accurately predict failure and the failure mode:

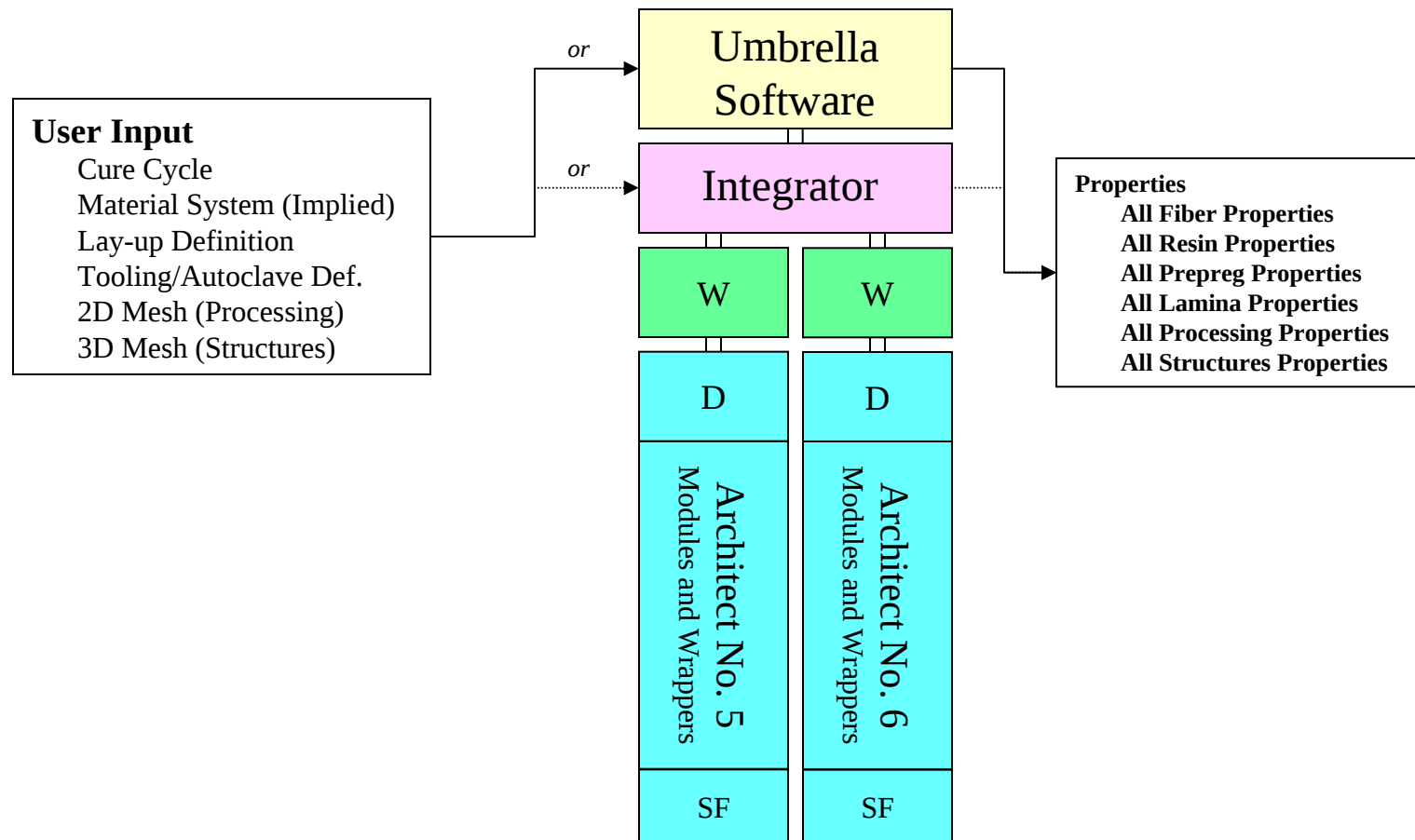
Demonstrate capability with the design of a hat-stiffened panel -- Currently being worked as our part of our validation/demonstration



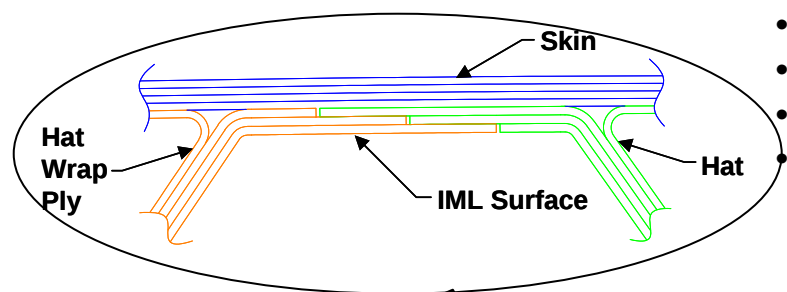
Architecture

Strength Properties

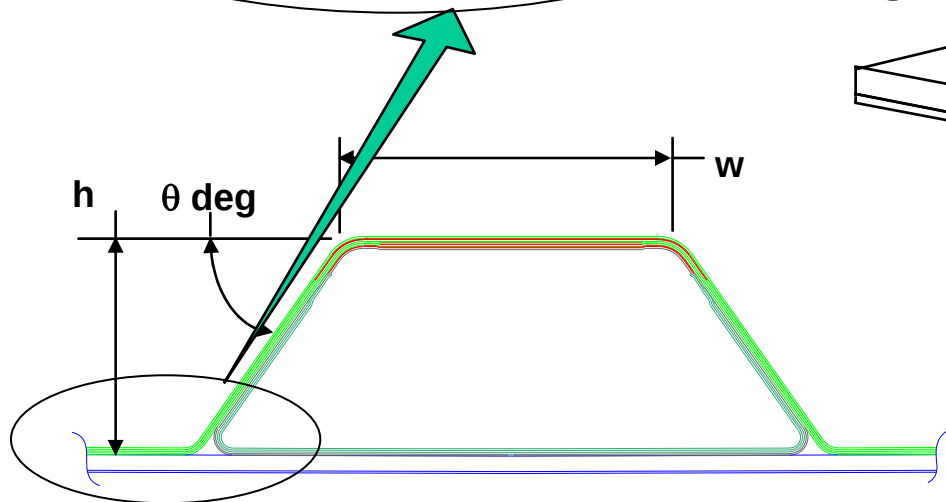
Residual Stress State from Processing Module



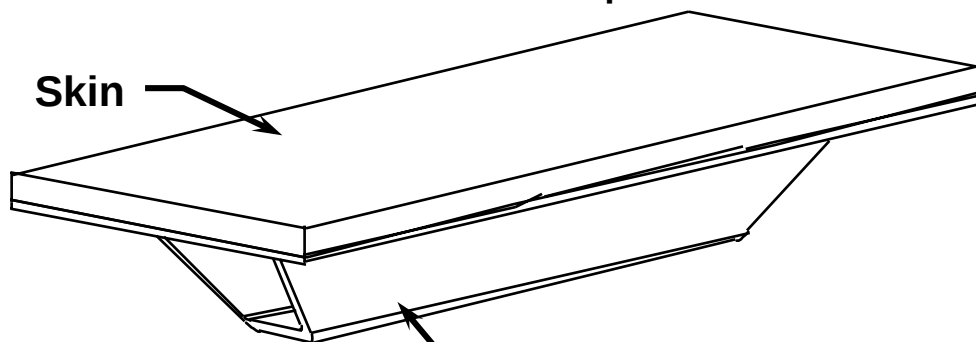
Understanding The Mechanics of a Stiffener Runout A True 3D Problem with Hundreds of Variables



- Runout Shape and Angle
- Boundary Conditions/Edge Reinforcement
- Hat Stiffness Tailoring at/near Runout
- Edge of Flange Configuration (Tapered, Square-edged)
- Presence or Absence of Internal Wrap Plies



Sect A-A



- Part Length
- Skin Thickness
- Spanwise/Chordwise ply dropoffs
- Hat Geometry (e.g., h , w , and θ)
- Layups
- Taper?

Comments and Summary

- Accelerated Insertion of Materials Can be Achieved by
 - Definition of requirements
 - Focus based on insertion needs (DKB)
 - Approach for use of existing Knowledge
 - Validated Analysis tools
 - Focused Testing
 - Feature Based Demonstration
 - Rework Avoidance
 - Knowledge management



AIM-C Alignment Tool

The Objective of the AIM-C Program is to Provide Concepts, an Approach, and Tools That Can Accelerate the Insertion of Composite Materials Into DoD Products

AIM-C Will Accomplish This Three Ways

Methodology - *We will evaluate the historical roadblocks to effective implementation of composites and offer a process or protocol to eliminate these roadblocks and a strategy to expand the use of the systems and processes developed.*

Product Development - *We will develop a software tool, resident and accessible through the Internet that will allow rapid evaluation of composite materials for various applications.*

Demonstration/Validation - *We will provide a mechanism for acceptance by primary users of the system and validation by those responsible for certification of the applications in which the new materials may be used.*