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PRELIMINARY DESIGN AND COST STUDY OF
RECIRCULATING CHROMATE RINSE SYSTEM
FOR AIRCRAFT CORROSION CONTROL

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Naval Air Development Center

Prepared for:

Naval Air Systems Command

2 November 1972

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NAVAL AIR DEVELOPMENT CENTER

WARMINSTER, PA. 18974

REPORT NO. NADC-72183-VT

2 November 1972

PRELIMINARY DESIGN AND COST STUDY OF RECIRCULATING
CHROMATE RINSE SYSTEM FOR AIRCRAFT CORROSION CONTROL

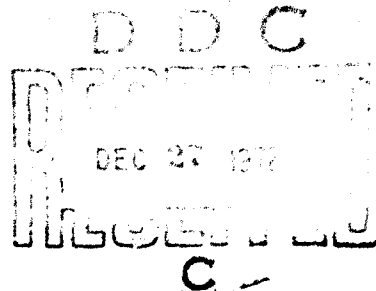
DESIGN PHASE ONE

AIRTASK NO. A3405343/200B/2F00554401

WORK UNIT 02

GSED P.O. 2-8013 of 22 SEP 71

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Security Classification

DOCUMENT CONTROL DATA - R & D

Security classification of title, body of abstract and indexing annotation must be entered when the overall report is classified

1. ORIGINATING ACTIVITY (Corporate author) NAVAL AIR DEVELOPMENT CENTER AIR VEHICLE TECHNOLOGY DEPARTMENT WARMINSTER, PA. 18974		2a. REPORT SECURITY CLASSIFICATION UNCLASSIFIED	
3. REPORT TITLE PRELIMINARY DESIGN AND COST STUDY OF RECIRCULATING CHROMATE RINSE SYSTEM FOR AIRCRAFT CORROSION CONTROL		2b. GROUP	
4. DESCRIPTIVE NOTES (Type of report and inclusive dates) DESIGN PHASE ONE			
5. AUTHOR(S) (First name, middle initial, last name) K. G. CLARK , W. C. HALLOW			
6. REPORT DATE 2 November 1972		7a. TOTAL NO OF PAGES 15	7b. NO OF FIGS 2
8a. CONTRACT OR GRANT NO		9a. ORIGINATOR'S REPORT NUMBER(S) NADC-72183-VT	
b. PROJECT NO AIRTASK A3405343/2C0B/2F00554401 Work Unit No. 02 GSED P.O. 2-8013 of 22 Sep 71		9b. OTHER REPORT NUMBER(S) (Any other numbers that may be assigned this report)	
10. DISTRIBUTION STATEMENT Approved for public release; distribution unlimited.			
11. ABSTRACT		12. FUNDING NUMBERS NAVAL AIR SYSTEMS COMMAND DEPARTMENT OF THE NAVY WASHINGTON, D. C. 20360	
13. SUMMARY A preliminary design and cost study was made for a recirculating chromate rinse system.			

DD FORM 1473

(PAGE 1)

UNCLASSIFIED

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Security Classification

Security Classification

DD FORM 1473 (BACK)
(PAGE 2)

Security Classification



DEPARTMENT OF THE NAVY
NAVAL AIR DEVELOPMENT CENTER
WARMINSTER, PA. 18974

Air Vehicle Technology Department

REPORT NO. NADC-72183-VT

2 November 1972

PRELIMINARY DESIGN AND COST STUDY OF RECIRCULATING CHROMATE
RINSE SYSTEM FOR AIRCRAFT CORROSION CONTROL

DESIGN PHASE ONE
AIRTASK NO. A3405343/200B/2F00554401
WORK UNIT 02
GSED P.O. 2-8013 of 22 SEP 71

A preliminary design and cost study was made for a recirculating chromate rinse system.

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EVALUATION AND DISCUSSION

INTRODUCTION

Aircraft rinse facilities are presently employed to create a short rain storm effect that removes corrosive salt deposits from aircraft operating in salt laden environments. While water rinsing has been effective in reducing corrosion, the rate of attack can be further reduced by introducing a small amount of corrosion inhibitor, such as potassium dichromate, into the rinse water. Traces of the inhibitor which form a molecular film on exposed corrodible surfaces should reduce not only surface attack but also galvanic corrosion in critical areas. A preliminary design and cost study for a recirculating chromate rinse was undertaken under AIRTASK A3405343/200B/2F00524401, Work Unit No. 2 and GSED P.O. 2-8013 (22 Sep 1971).

The initial concept for introducing a corrosion inhibitor into an aircraft rinse was to add the inhibitor directly to the rinse water system. But since chromates are toxic to aquatic life, the rinse effluent would need chromate removal treatment before being discharged to the storm sewers. Investigation of treatment plants with large capacity chromate separators showed that chemical precipitation would be the most feasible approach for removal but that operating and maintenance costs would be high. At that point it was felt that these high costs could be avoided by separating the chromate rinse from the fresh water rinse. The aircraft would be first rinsed with fresh water then at a separate site, sprayed with a chromate rinse. Following the spraying of chromate solution, the rinse would be collected and reused to reduce the cost of a large treatment plant.

A preliminary design and cost study was undertaken for a recirculating chromate rinse system.

DISCUSSION

The design of an aircraft rinse apparatus incorporating a chromate rinse system is complicated by three factors: 1) the effectiveness of potassium dichromate as a corrosion inhibitor is diminished as the salinity of the chromate rinse water increases, 2) chromates and salts dissolved in the rinse water can be separated but only slowly and expensively with reverse osmosis or ion exchange techniques, and 3) chromates are toxic to aquatic life and, therefore, cannot be discharged to the sewer system.

An aircraft rinse apparatus expanded to include chromate treatment must make use of two separate spray systems, where the first system is a fresh water rinse and the second system recirculates the chromate rinse solution. This design requires that the first fresh water rinse remove salt deposits to avoid contamination of the

chromate rinse and that a suitable length of taxiway exist between the two systems to avoid contamination of the fresh water rinse effluent with chromates.

Design considerations include:

1. A high impact spray system to deliver a large volume of water in the short rinsing cycle.
2. A recirculating chromate rinse system where suspended solids and oils are removed from the system prior to respraying.
3. A small treatment facility capable of removing chromates from the rinse prior to ultimate disposal via the sewers.
4. A highly automated system, with little maintenance or manual operation required.
5. A rinse system capable of handling a wide range of aircraft from small helicopters to large fixed wing aircraft.

Process equipment required for such a water rinse - chromate rinse apparatus would include the following (see Figures 1, 2 and 3):

1. A centrifugal pump to power each spray system, rated at 300 psi and 1000 gpm for the fresh water rinse and 300 psi and 500 gpm for the recirculating chromate rinse.
2. One centrifugal pump rated at 100 gallons per minute at 75 pounds per square inch for pumping chromate rinse water from the settling tank through a filter and into the storage tank.
3. Two vertical cylindrical 20,000 gallon tanks functioning as a settling tank to remove solid particles and a storage tank for the filtered chromate rinse.
4. One vertical cylindrical 5,000 gallon holding tank to collect rain water run-off for make-up water or disposal via the water purification unit.
5. Water purification unit capable of handling 400 gallons per hour to purify rain water contaminated with chromates prior to disposal via the sewer system.
6. One filter capable of handling 100 gallons per minute to remove suspended solids.
7. One deflector screen to knockdown chromate spray from the prop wash.

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8. 210 spray nozzles delivering 10 gallons per minute at 300 pounds per square inch to produce a dense, high impact spray.

RESULTS OF DESIGN STUDY

The entire rinse apparatus as represented in Figures 1, 2 and 3 is comprised of two systems: 1) a fresh water rinse to remove salt deposits and 2) a recirculating rinse with dilute chromate inhibitor to deter future corrosion. While the salt laden water from the fresh water rinse is sent directly to the storm sewer as in previous designs, the chromate solution is retained, held to remove solids, filtered, and reused via a spray system similar to that of the fresh water system.

The cost of equipment, auxiliary materials, and labor for the entire apparatus, including the necessary taxiway and two pump houses totals \$322000. This figure does not account for any indirect costs (freight, insurance, construction overhead), contingency funds, or contractors fee.

The following table shows a breakdown of costs:

CHROMATE RINSE SYSTEM	MATERIAL	LABOR	TOTAL
Taxiway and drainage	48 520	36 040	84 560
Process equipment	70 080	23 975	94 055
Pump houses	<u>4 150</u>	<u>2 750</u>	<u>6 900</u>
	122 750	62 765	185 515
FRESH WATER RINSE SYSTEM	MATERIAL	LABOR	TOTAL
Taxiway and drainage	48 520	36 040	84 560
Process equipment	32 670	14 725	47 395
Pump houses	<u>2 650</u>	<u>1 750</u>	<u>4 400</u>
	83 840	52 515	136 355
TOTAL COST BOTH SYSTEMS	206 590	115 280	321 870

It is important to note that where a fresh water rinse facility and sufficient taxiway exists, a recirculating chromate rinse system can be installed for \$101,000, which includes process equipment and pump house.

CONCLUSIONS

Due in particular to the taxiway construction costs which amount to 53% of labor and material cost for the entire apparatus, this project appears more expensive than had been initially anticipated. This design, however, is superior to the initial single rinse concept due to anticipated decreased maintenance, decreased operating costs, and a more automated system design.

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RECOMMENDATIONS

It is recommended that a prototype water rinse -- chromate rinse apparatus be constructed as outlined in this preliminary report and that a monitoring project be undertaken to optimize a final design.

1
2
3
4

REVISIONS		
NO.	DESCRIPTION	DATE
1		

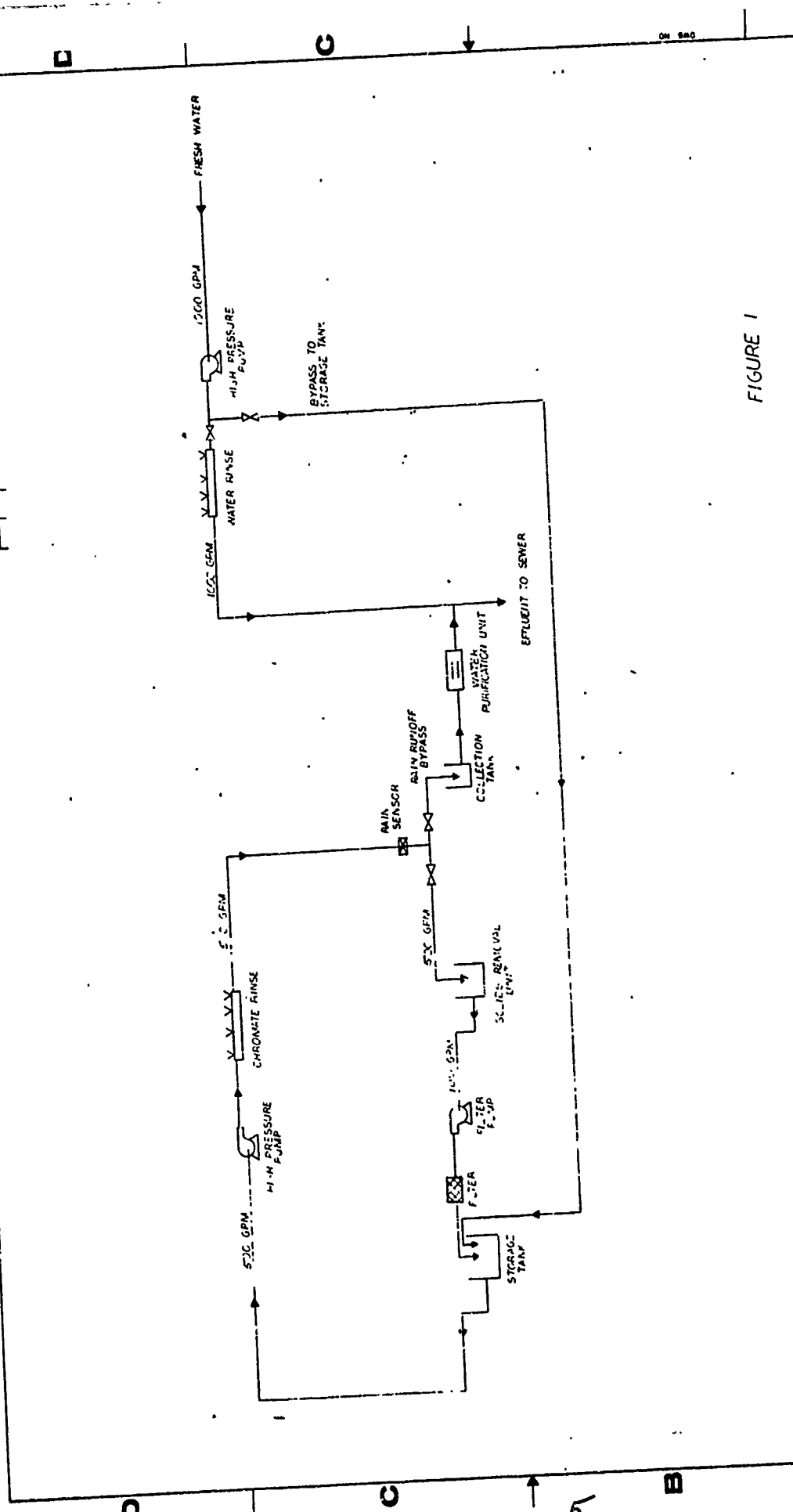
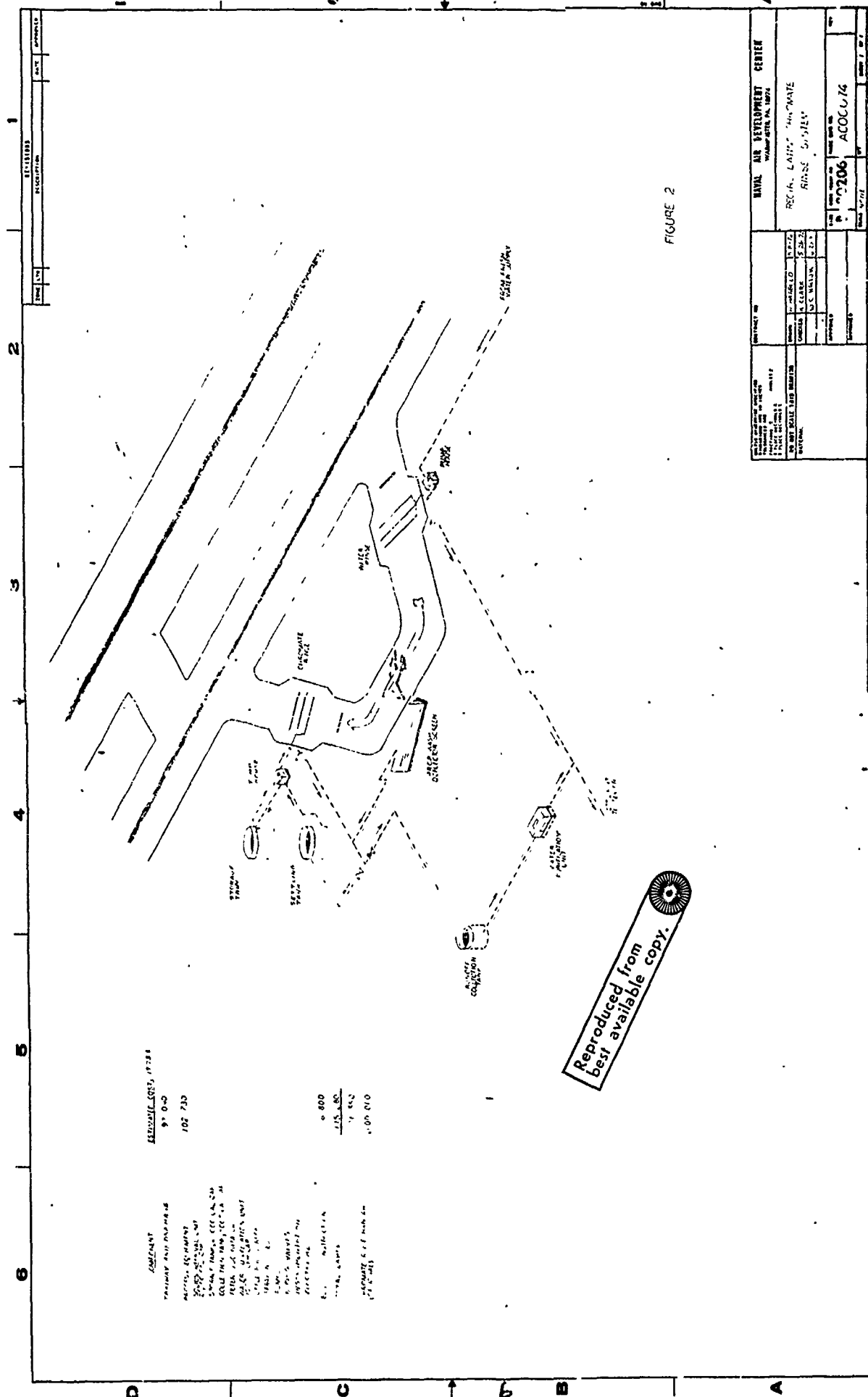


FIGURE 1

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ARE IN 16ths		CONTRACT NO.		NAVAL AIR DEVELOPMENT CENTER ADMINISTER, PA. 18074	
DRAWN - J. H. F.		CHECKED - J. H. F.		RE-RECULATING CHROMATE RINSE SYSTEM	
DO NOT SCALE THIS DRAWING		SCALE 1/4" = 1'-0"		SIZE C 80206	
MATERIAL		APPROVED		SCALE 1/4" = 1'-0"	
APPROVED		APPROVED		SHEET 1 OF 1	



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A P P E N D I X A

Cost Study fo · Complete Water
Rinse Chromate Rinse Apparatus

COST STUDY

I. Site Development. Taxiway and drainage system (cost information obtained from reference (b))A. Chromate Rinse System.

<u>No. of Units</u>	<u>Item</u>	<u>Material</u>	<u>Labor</u>	<u>Total</u>
4600 yd ³	Excavation, fill	5320	1150	6470
1200 yd ²	Limerock base	930	90	1020
7100 yd ²	Stabilizer base	3330	3330	6660
7100 yd ²	Flex concrete	38100	30630	68730
1200 yd ²	Asphaltic concrete	840	840	1680
		<u>\$48520</u>	<u>\$36040</u>	<u>\$84560</u>

B. Water Rinse System.

Same as above Chromate Rinse System

II. Process and Auxilliary Equipment (Cost information obtained from reference (a)).A. Chromate Rinse System.1. Process equipment.

<u>No. of units</u>	<u>Item</u>	<u>Material Cost</u>
1	Pump, centrifugal, 500 gpm, 305 psi	6,870
1	Pump, centrifugal, 100 gpm, 75 psi	1,500
2	Tank, cylindrical, vertical, 20,000 gallon, carbon steel	11,250
1	Tank, cylindrical, vertical 5000 gallon, carbon steel	2,120
1	Water purification unit, 400 gph.	18,750
1	Filter assembly	3,750
1	Deflector screen	5,000
105	Spray nozzles, 10 gpm @ 300 psi	3,940
		<u>\$53,200</u>

Assume Labor cost = 30% of material cost

Materials	53,200
Labor	<u>15,960</u>
Total	<u>\$69,160</u>

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2. Instrumentation

<u>No. of Units</u>	<u>Item</u>	<u>Material</u>	<u>Labor</u>	<u>Total</u>
4	Pressure gauges	250	100	350
1	Flow meter	370	200	570
1	Timer, treadle switch	220	100	320
1	Rain Sensor	630	130	760
		<u>\$1470</u>	<u>\$530</u>	<u>\$2000</u>

3. Piping

<u>No. of Units</u>	<u>Item</u>	<u>\$/ft Installed</u>	<u>Total</u>
250 ft	10" cast iron	18.10	4525
300	8" cast iron	15.00	4500
50	6" steel	6.70	335
140	4" steel	4.00	560
240	3" steel	2.70	650
140	2" steel	1.40	200
			<u>\$10770</u>

Assuming 44% of Total Cost is Labor

Material Cost = \$6030

Labor Cost = \$4740

4. Valves

<u>No. of Units</u>	<u>Item</u>	<u>Material</u>	<u>Labor</u>	<u>Total</u>
3	8" Gate, cast iron	1970	90	2060
1	3" Globe, steel	220	10	230
3	6" Butterfly, Solenoid operated	<u>2100</u>	<u>140</u>	<u>2240</u>
		<u>\$4290</u>	<u>\$240</u>	<u>\$4530</u>

5. Fittings

<u>No. of Units</u>	<u>Item</u>	<u>Material</u>	<u>Labor</u>	<u>Total</u>
2	3" Reducers, steel	10	50	60
1	8" Reducer, cast iron	35	50	85
5	10"-90° Elbows, cast iron	840	410	1250
10	8"-90° Elbows, cast iron	560	340	900
2	6"-90° Elbows, steel	45	85	130
2	10"-Tees, cast iron	330	165	495
1	6"-Cross, steel	<u>75</u>	<u>50</u>	<u>125</u>
		<u>\$1859</u>	<u>\$1150</u>	<u>\$3045</u>

6. Electrical

<u>No. of Units</u>	<u>Item</u>	<u>Material</u>	<u>Labor</u>	<u>Total</u>
17	Light fixtures	1355	1355	2710
400 ft	Conduit	600		600
1000 ft	Cable, wire	<u>1240</u>		<u>1240</u>
		<u>\$3195</u>	<u>\$1355</u>	<u>\$4550</u>

7. Subtotals

<u>Category</u>	<u>Material</u>	<u>Labor</u>	<u>Total</u>
Process equipment	53200	15960	69160
Instrumentation	1470	530	2000
Piping	6030	4740	10770
Valves	4290	240	4530
Fittings	1895	1150	3045
Electrical	<u>3195</u>	<u>1355</u>	<u>4550</u>
	<u>\$70080</u>	<u>\$23975</u>	<u>\$94055</u>

B. Water Rinse System

1. Process equipment

<u>No. of Units</u>	<u>Item</u>	<u>Material Cost</u>
1	Pump, centrifugal, 1000 gpm, 305 psi	12100
105	Spray nozzles, 10 gpm @ 300 psi	<u>3940</u>
		<u>\$16040</u>

Assume Labor cost = 30% of material cost

Materials = 16040

Labor = 4810\$20850

2. Instrumentation

<u>No. of Units</u>	<u>Item</u>	<u>Material</u>	<u>Labor</u>	<u>Total</u>
1	Timer, treadle switch	220	100	320
2	Pressure gauges	<u>125</u>	<u>50</u>	<u>175</u>
		<u>\$345</u>	<u>\$150</u>	<u>\$495</u>

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3. Piping

<u>No. of Units</u>	<u>Item</u>	<u>\$/ft Installed</u>	<u>Total</u>
500 ft	10" cast iron	18.10	9050
400	8" cast iron	15.00	6000
50	6" steel	6.70	335
140	4" steel	4.00	560
140	3" steel	2.70	380
140	2" steel	1.40	200
			<u>\$16525</u>

Assuming 44% of Total Cost is Labor

Material Cost = \$9255

Labor Cost = \$7270

4. Valves

<u>No. of Units</u>	<u>Item</u>	<u>Material</u>	<u>Labor</u>	<u>Total</u>
1	8" Gate, cast iron	660	30	690
2	6" Gate, steel	930	50	980
1	6" Butterfly, Solenoid operated	700	95	795
		<u>\$2290</u>	<u>\$175</u>	<u>\$2465</u>

5. Fittings

<u>No. of Units</u>	<u>Item</u>	<u>Material</u>	<u>Labor</u>	<u>Total</u>
2	3" Reducers, steel	10	50	60
1	8" Reducers, cast iron	35	50	85
5	10"-90° Elbows, cast iron	840	410	1250
2	6"-90° Elbows, steel	45	85	130
3	10"-Tees, cast iron	490	250	740
1	6"-Tees, steel	50	70	120
1	6"-Cross, steel	75	50	125
		<u>\$1545</u>	<u>\$965</u>	<u>\$2510</u>

6. Electrical

<u>No. of Units</u>	<u>Item</u>	<u>Material</u>	<u>Labor</u>	<u>Total</u>
17	Light fixtures	1355	1355	2710
400 ft	Conduit	600		600
1000 ft	Cable, wire	1240		1240
		<u>\$3195</u>	<u>\$1355</u>	<u>\$4550</u>

7. Subtotals

<u>Category</u>	<u>Materials</u>	<u>Labor</u>	<u>Total</u>
Process equipment	16040	4810	20850
Instrumentation	345	150	495
Piping	9255	7270	16525
Valves	2290	175	2465
Fittings	1545	965	2510
Electrical	3195	1355	4550
	<u>\$32670</u>	<u>\$14725</u>	<u>\$47395</u>

III. Process Buildings - Pump houses (Cost information obtained from reference (a))

A. Chromate Rinse System

	<u>Material</u>	<u>Labor</u>	<u>Total</u>
Pump house 12 ft by 20 ft	4150	2750	6900

B. Water Rinse System

Pump house 12 ft by 12 ft	<u>2650</u>	<u>1750</u>	<u>4400</u>
	<u>\$6800</u>	<u>\$4500</u>	<u>\$11300</u>

IV. Total Cost of Water Rinse and Chromate Rinse SystemsA. Chromate Rinse System

	<u>Materials</u>	<u>Labor</u>	<u>Total</u>
Site Development	48520	36040	84560
Process equipment	70080	23975	94055
Process buildings	<u>4150</u>	<u>2750</u>	<u>6900</u>
	<u>\$122750</u>	<u>\$62765</u>	<u>\$185515</u>

B. Water Rinse System

Site Development	48520	36040	84560
Process equipment	32670	14725	47395
Process buildings	<u>2650</u>	<u>1750</u>	<u>4400</u>
	<u>\$83840</u>	<u>\$52515</u>	<u>\$136355</u>

C. Total Cost

	\$206590	\$115280	\$321870
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R E F E R E N C E S

- (a) Popper, Herbert, ed., Modern Cost Engineering Techniques, McGraw-Hill, Inc., New York 1970.
- (b) Publi Works Contract N62467-69-C-0106, U.S. Naval Air Station, Jacksonville, Florida (Contract for wash and rinse racks).

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