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Part III, Volume II

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VAPORIZING AND ENDOTHERMIC FUELS
FOR ADVANCED ENGINE APPLICATION

Part III. Studies of Thermal and Catalytic Reactions,
Thermal Stabilities, and Combustion Properties
of Hydrocarbon Fuels

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Shell Development Company,
A Division of Shell Oil Company

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Calculation Procedure for Mach 8 Engine

Station 1.

Use the following formulas from Ref. 12 to calculate the inlet area:

$$I_f = \frac{n_p (H_f) J}{V_1}$$

$$W_f = \frac{n_n (F_g)}{I_f}$$

$$A_1 = \frac{W_f}{(F/A)(\rho_1)(V_1)}$$

Assume: $n_p = .412$

$n_n = .95$

$H_f = 18894$ Btu/lbm fuel

At 100,000 ft and $M = 8$

$$T_1 = 420.1^\circ R$$

$$P_1 = 22.32 \text{ lb/ft}^2$$

$$\rho_1 = .000996 \text{ lbm/ft}^3$$

$$V_1 = 8050.96 \text{ ft/sec}$$

$$I_f = \frac{(.412)(18894)(778)}{(8051)}$$

$$I_f = 752.23 \text{ sec}$$

Assume: $L/D = 6$

$$L = 450,000 \text{ lb}$$

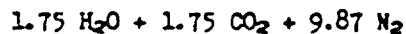
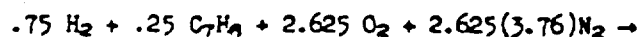
$$D = F_g = 75000 \text{ lb}$$

Therefore:

$$W_f = \frac{(.95)(75000)}{752.23}$$

$$W_f = 94.72 \text{ lbm/sec fuel}$$

To Calculate the stoichiometric fuel-air ratio (F/A) assume the fuel is MCH converted to H_2 and C_7H_8 :



The average molecular weight of the fuel: 25.25

$$F/A = \frac{(1 \text{ mole of fuel})(25.25 \text{ lbm molecular weight})}{(9.87 + 2.625 \text{ moles air})(28.95 \text{ lbm molecular weight})}$$

$$F/A = .0698$$

Assuming E.R. = 1.0

$$A_1 = \frac{94.72}{(.0698)(.000996)(5051)}$$

$$A_1 = 169.23 \text{ ft}^2$$

Station 3.

Use the Dugger Equation for the total pressure drop from Station 1 to 3:

$$\eta_d = 1 - \frac{\left(\frac{P_{t1}}{P_{t3}}\right)^{\frac{\bar{\gamma}-1}{\bar{\gamma}}} - 1}{((\bar{\gamma}-1)/2)M_1^2}$$

Assume: $\eta_d = .959$

$$\bar{\gamma} = 1.4$$

then

$$\frac{\bar{\gamma}-1}{\bar{\gamma}} = \frac{1.4-1}{1.4} = .286$$

$$\frac{(P_{t1}/P_{t3})^{.286} - 1}{((1.4-1)/2)(8)^2} = 1 - .959$$

$$(P_{t1}/P_{t3})^{.286} = 1.5248$$

$$(P_{t1}/P_{t3}) = 4.36$$

From the isentropic flow tables at $M = 8$

$$P_1/P_{t1} = .000102$$

$$P_{t1} = \frac{22.32 \text{ lb/ft}^2}{(.000102)(144 \text{ in}^2/\text{ft}^2)}$$

$$P_{t1} = 1519 \text{ lb/in}^2$$

$$P_{t3} = \frac{1512 \text{ lb/in}^2}{4.30}$$

$$P_{t3} = 348 \text{ lb/in}^2$$

Assume:

$$M_3 = 2.5 \quad \text{then}$$

From the isentropic flow tables at $M = 2.5$

$$P_3/P_{t3} = .05853$$

$$P_3 = 20.4 \text{ lb/in}^2$$

Assume the enthalpy at 1 and 3 are equal:

$$h_{t1} = h_{t3} = h_3 + \frac{(M_3 49.1 \sqrt{T_3})^2}{2g_c J}$$

$$h_{t1} = 100.32 + \frac{((8)(49.1)\sqrt{420.1})^2}{(2)(32.2)(778)}$$

$$h_{t1} = 1394 \text{ Btu/lbm}$$

By trial and error

$$T_3 = 2500^\circ\text{R}$$

$$h_{t3} = 732.33 + \frac{((2.5)49.1\sqrt{2500})^2}{(2)(32.2)(778)}$$

$$h_{t3} = 1395 \quad \text{close enough}$$

$$\rho_3 = \frac{(20.4)(144)}{(53.34)(2500)}$$

$$\rho_3 = .0220 \text{ lbm/ft}^3$$

Station 5.

By an iterative procedure calculate the heat transfer from the combustion area assuming 2000°R wall temperature and thus the total temperature rise. Then using a Rayleigh line relationship the remaining conditions at Station 5 may be determined.

First calculate the flow area and heat transfer area:

$$\dot{m} = \rho_3 A_3 V_3 = \rho_1 A_1 V_1$$

$$V_3 = (2.5)(49.1)\sqrt{2500}$$

$$V_3 = 6140$$

$$A_3 = \frac{\rho_1 A_1 V_1}{\rho_3 V_3} = \frac{(.000006)(169)(8051)}{(.0220)(6140)}$$

$$A_3 = 10.0$$

$$10.0 = \pi r_1^2 - \pi r_3^2 = 169 - \pi r_3^2$$

$$r_3 = 7.11 \text{ ft}$$

Hydraulic Diameter D_h

$$D_h = \frac{4A_3}{P_w} = \frac{4(10.0)}{2\pi(7.11) + 2\pi(7.28)}$$

$$D_h = .444$$

Assume time for combustion and mixing can be accomplished in $2 \mu\text{sec} = .002 \text{ sec}$ and the average velocity in the combustor is 5000 ft/sec. The length of the combustor then is L

$$L = (.002)(5000)$$

$$L = 10 \text{ ft}$$

Forming a heat balance on the combustion area

$$(\dot{h}_p' - \dot{h}_{p0}') - (\dot{h}_R' - \dot{h}_{R0}') - \dot{q} = -\dot{h}_{RP0}$$

where: $\dot{h}_R'$ = enthalpy of the reactants

$\dot{h}_p'$ = enthalpy of the products

$\dot{h}_{RP0}$ = heat of combustion

$\dot{q}$ = heat transferred per lbm fuel

Heat of combustion calculation:

$$\dot{h}_{RP0} = \dot{m}_{C_7H_8}(\dot{h}_{RP0})_{C_7H_8} + \dot{m}_{H_2}(\dot{h}_{RP0})_{H_2}$$

$$\dot{m}_{C_7H_8} = .938 \text{ lbm } C_7H_8/\text{lbm fuel}$$

$$\dot{m}_{H_2} = .062 \text{ lbm } H_2/\text{lbm fuel}$$

$$(h_{RfO})_{C_7H_8} = -17601 \text{ Btu/lbm}$$

$$(h_{RfO})_{C_7H_8} = -51593 \text{ Btu/lbm}$$

$$h_{RfO} = (.938)(-17601) + (.062)(-51593)$$

$$h_{RfO} = -19702.5 \text{ Btu/lbm fuel}$$

The reactants:

$$h_R' - h_{RfO}' = (h' - h_o')_{air} + (h' - h_o')_{fuel}$$

$$(h' - h_o')_{air} = \frac{M_{air}}{M_{fuel}} (h_{2500} - h_{537})$$

$$= \frac{(2.625 + 9.87) 28.92}{25.25} (645.78 - 128.34)$$

$$(h' - h_o')_{air} = 7412.8 \text{ Btu/lbm fuel}$$

$$(h' - h_o')_{fuel} = C_{Pfuel}(t - t_o)$$

$$\text{Assume: } C_{Pfuel} = .766 \text{ Btu/lbm} \cdot ^\circ\text{F}$$

$$t = 900 ^\circ\text{F}$$

$$(h' - h_o')_{fuel} = (.766)(900 - 77)$$

$$(h' - h_o')_{fuel} = 631 \text{ Btu/lbm fuel}$$

$$h_R' - h_{RfO}' = 8043.8 \text{ Btu/lbm fuel}$$

The products:

Calculate enthalpy of products as function of temperature and make plot.

Constituent	n	h_{537}	h_{4000}	$n\Delta h$	h_{5000}	$n\Delta h$	h_{5360}	$n\Delta h$
CO ₂	1.75	4030	49231	79102	54000	104948	69677	114881
H ₂ O	1.75	4258	40489	63404	53327	85871	58339	94991
N ₂	9.87	3730	31329	272406	40080	358773	43436	391898
				414913		549591		601771

$$(h_P' - h_{PfO}')_t = \frac{n\Delta h}{M_t} = \frac{n\Delta h}{25.25}$$

T _{asp} , °R	(h _p ' - h _p c') _c Btu/lbm Fuel
4000	16432
5000	21766
5380	23833

} See plot on following page (Figure T2)

Estimate of Heat Transfer From the Combustor:

Procedure:

1. Assume Temperature at Station 5
2. Calculate Mach Number and pressure at Station 5 from Rayleigh line
3. Assume linear variation of pressure and temperature over length of combustor
4. Calculate density, velocity, viscosity, Reynolds Number, Nusselt Number, correction constant for high velocity heat transfer, thermal conductivity, heat transfer coefficient, adiabatic wall temperature and the final product, $hP\Delta t$, where P is the wetted perimeter, $\Delta t = t_{aw} - t_w$ and $t_w = 2000^\circ R$, and h is the local heat transfer coefficient.
5. From curve of $hP\Delta t$ vs x calculate heat transferred;

$$q = - \int_{x=0}^{x=L} hP\Delta t dx$$

6. From q and $(h' - h_0')_p$, $(h' - h_0')_R$ and h_{p0} calculate temperature at Station 5.
7. Return to 2 until temperature used to calculate values and calculated temperature are equal.

Example:

Station 3:

M = 2.5
P = 20.4
T = 2500°R
(P/P₀) = .24616
(T/T₀) = .3787

Assume T₅ = 5637.5°R

$$(T/T_0)_3 = (T/T_0)_2 T_2/T_3 = (.5787) \frac{(5637.5)}{(2500.)}$$

$$(T/T_0)_3 = .8540$$

From Rayleigh Line:

$$M_3 = 1.31$$

$$(P/P_0)_3 = .70535$$

$$P_3 = (P/P_0)_3 / (P/P_0)_2 P_2 = (.70535) / (.24616) (20.4)$$

$$P_3 = 58.45 \text{ lb/in}^2$$

x	P	T	ρ	V	μ $\times 10^{-5}$	Re $\times 10^6$	Nu_1 ($M=0$)	M	c	Nu_1	ϵ
0	20.4	2500	.022	6150	3.4	1.76	1330	2.50	.65	864.5	.048
2	28.0	3110	.024	5633	3.8	1.58	1270	2.06	.75	952.5	.056
4	35.6	3740	.026	5200	4.2	1.43	1220	1.73	.81	988.2	.062
6	43.3	4370	.027	5007	4.6	1.30	1170	1.54	.84	982.8	.0685
8	51.0	5000	.028	4872	4.9	1.24	1145	1.40	.88	1007.6	.074
10	58.45	5637.5	.028	4828	5.2	1.17	1110	1.31	.89	987.9	.079

• Extrapolated (based on air at low pressures)

x	Pr	Pr 1/3	T_{AW}/T	T_{AW}	Δt	h	$hPr\Delta t$
0	.73	.90	2.125	5312.5	3312.5	93.4	2.80×10^7
2	.75	.91	1.77	5504.7	3504.7	120.1	3.81×10^7
4	.79	.92	1.55	5797.0	3797.0	138.0	4.74×10^7
6	.90	1.0	1.47	6423.9	4423.9	151.6	6.07×10^7
8	1.00	1.0	1.39	6950.0	4950.0	167.9	7.52×10^7
10	1.00	1.0	1.34	7554.3	5554.3	175.8	8.84×10^7

In the above calculations the following expressions were used:

$$\rho = P/RT \quad \text{where } R = 53.34$$

$$V = \rho_1 V_1 / \rho = 135.2 / \rho$$

$$Re = \frac{V D_n \rho}{\mu}$$

$$Nu_1 = f(Re, Pr) \quad \text{from Kays}^{14)} \text{ expression for turbulent flow inside concentric annuli at } r_i/r_o = 1.0 \text{ (See Figure 73)}$$

$$M = V / (49.1 \sqrt{T})$$

$$C = \text{From Kays page 13.28 for affect of high velocity on Stanton No.}$$

$$M_1 = C M_{u1}$$

$$h = \frac{M_{1k}}{D_n}$$

$$T_{AW}/T = 1 + \frac{Pr^{1/3}}{2} (\gamma - 1) M^2 \quad \text{where } \gamma = 1.4$$

$$\Delta t = (T_{AW} - T_W) = (T_{AW} - 2000)$$

$$P = 2\pi r_1 + 2\pi r_0 = 90.5 \text{ ft}$$

Then: $q' = - \int_{x=0}^{x=L} (h P \Delta t)_x dx$ This expression is integrated graphically from Figure 7b

$$q' = - 5.575 \times 10^8 \text{ Btu/hr}$$

$$\dot{m}_{air} = \rho_1 A_1 V_1 = 4.879 \times 10^8 \text{ lbm/hr}$$

$$q = - \frac{5.575 \times 10^8}{4.879 \times 10^8}$$

$$q = - 1.1426 \times 10^2 \text{ Btu/lbm air}$$

$$q' = - \frac{1.1426 \times 10^2}{.0698}$$

$$q' = - 1637 \text{ Btu/lbm fuel}$$

Now to calculate the combustion temperature:

$$(h' - h_o')_p - (h' - h_o')_R - q' = - h_{RPo}$$

$$(h' - h_o')_p - 8043.8 + 1637 = - (-19708.5)$$

$$\therefore (h' - h_o)_p = 26115.3 \text{ Btu/lbm fuel}$$

From curve in Figure 7j this gives a temperature:

$$T_3 = 5800^\circ R \text{ which does not agree with assume temp, } \therefore \text{ recalculate}$$

However, by plotting the calculated temperatures vs the assumed temperatures we can find the point they are equal. In addition by plotting the heat transferred vs the assumed temperature we can obtain the actual heat transfer at the actual temperature - see curves in Figure 7j.

This yields:

$T_3 = 5791^\circ R$ $q' = 1727 \text{ Btu/lbm fuel}$
--

$$\text{Then } (T/T_0)_5 = (.3787) \frac{(5791)}{(2500)}$$

$$(T/T_0)_5 = .8774 \quad \text{from Rayleigh line we get}$$

$$M_5 = 1.265$$

$$(P/P_0)_5 = .740$$

$$P_5 = \frac{(.740)}{(.24616)} (20.4)$$

$$P_5 = 61.3 \text{ lb/in}^2$$

Station 6.

- Assume: 1. Isentropic expansion from 5 to 6.
2. $A_6 = 313.58 \text{ ft}^2$ ($D = 20 \text{ ft}$)

$$(A/A_0)_6 = (A/A_0)_5 \frac{A_5}{A_6} = \frac{(1.052)(313.58)}{10.0}$$

$$(A/A_0)_6 = 32.89$$

$$M_6 = 5.28$$

$$(P/P_0)_6 = .001538$$

$$P_6 = \frac{(.001538)(61.3)}{.377}$$

$$P_6 = .250 \text{ lb/in}^2$$

$$T_6 = \frac{(T/T_0)_6}{(T/T_0)_5} T_5$$

$$T_6 = \frac{(.15415)(5791)}{.758}$$

$$T_6 = 1177.88^\circ\text{R}$$

$$V = (5.28)(49.1)\sqrt{1177.88}$$

$$V_6 = 8897.48 \text{ ft/sec}$$

$$p_e = \frac{36.05}{(53.34)(1177.88)}$$

$$\rho_a = .000574 \text{ lbm/ft}^3$$

Calculate Thrust, Specific Impulse, and Overall Efficiency:

$$\left. \begin{aligned} \text{Thrust} = F_g &= f_e - f_1 - P_1(A_e - A_1) \\ f_e &= A_e \left(P_e + n_n \frac{\rho_a V_e^2}{g_c} \right) \\ f_1 &= A_1 \left(P_1 + \frac{\rho_1 V_1^2}{g_c} \right) \\ n_n &= .95 \end{aligned} \right\} \text{From Tuggeris}$$

$$f_1 = 169 \left(22.32 + \frac{(.000996)(8051)^2}{32.2} \right)$$

$$f_1 = 342644.1 \text{ lb}$$

$$f_e = 313.58 \left(36.05 + \frac{.95(.000574)(8897.48)^2}{32.2} \right)$$

$$f_e = 431703.9 \text{ lb}$$

$$F_g = 431703.9 - 342644.1 - 22.32(313.58 - 169.)$$

$$F_g = 85833.22 \text{ lb}$$

Specific Impulse:

$$I_f = \frac{n_n(F_g)}{W_f}$$

$$W_f = f_{o1} V_1 A_1 = (.0698)(.000996)(169.)(8051)$$

$$W_f = 94.6 \text{ lbm/sec fuel}$$

$$I_f = \frac{(.95)(85833.22)}{94.6}$$

$$I_f = 861.96 \text{ sec}$$

Overall Efficiency:

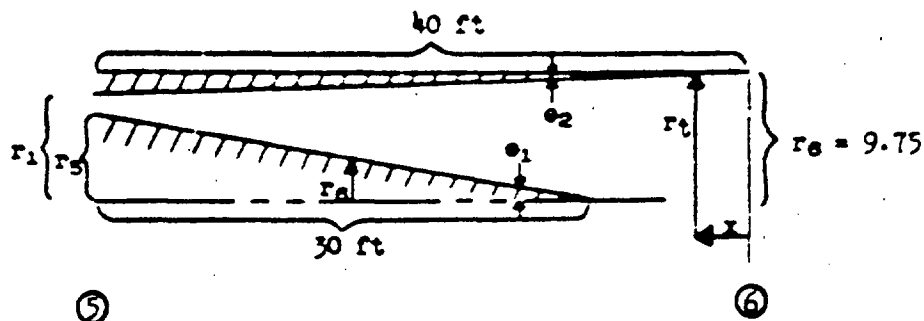
$$\eta_o = \frac{I_f V_1}{E_f + V_1^2 / 2g_c}$$

$$n_e = \frac{(861.96)(8050.96)}{(19708.5 + \frac{(8050.96)^2}{(2)(32.2)(778)}) 778}$$

$$n_e = .4247$$

Estimate of Heat Transfer From Nozzle:

Consider the nozzle below: (Note: the values below are not the final but a first estimate)



Flow Area:

$$r_2 - r_1 = 9.75 - 7.28 = 2.47$$

$$\tan e_2 = \frac{2.47}{40} = .06175 \quad \tan e_1 = \frac{7.11}{30.0} = .237$$

$$e_2 = 3\frac{1}{2}^\circ$$

$$\text{From } x = 0 \text{ to } x = 10 \quad \text{where } r_t = r_2 - x \tan e_2 = 9.75 - x (.06175)$$

$$\text{From } x = 10 \text{ to } x = 40 \quad A_x = \underbrace{\pi r_t^2}_{A_t} - \underbrace{\pi r_b^2}_{A_b} \quad r_b = (x - 10) \tan e_1 = (x - 10) .237$$

$$x' = 40 - x$$

x'	x	r_t	A_t	r_b	A_b	A_x
40	0	9.75	298.8	0	0	298.8
30	10	9.13	262.0	0	0	262.0
20	20	8.52	227.8	2.37	17.6	210.2
10	30	7.90	195.9	4.74	70.6	125.3
5	35	7.60	180.9	5.92	110.3	70.6
4	36	7.53	178.0	6.16	119.3	58.7
3	37	7.47	175.1	6.40	128.6	46.5
2	38	7.40	172.2	6.64	138.3	33.9
1	39	7.34	169.3	6.87	148.4	20.9

Assuming isentropic expansion to each point:

$$(A/A_0)_X = \frac{(A/A_0)_S A_X}{A_S} = \frac{1.1}{10.3} = .10967 A_X \quad (\text{ft}^2)$$

This yields a Mach Number from Isentropic Flow Tables.

$$T_X = \frac{(T/T_0)_X}{(T/T_0)_S} T_S = \frac{(T/T_0)_X 5465}{.726} = 7527.5 (T/T_0)_X \quad (^\circ\text{R})$$

$$P_X = \frac{(P/P_0)_X}{(P/P_0)_S} P_S = \frac{(P/P_0)_X 54}{.323} = 167 (P/P_0)_X \quad (\text{lb/in}^2)$$

$$V_X = M_X 49.1 \sqrt{T_X} \quad (\text{ft/sec})$$

$$\rho_X = \frac{P_X 144}{53.34 T_X} = 2.7 P_X / T_X \quad (\text{lbm/ft}^3)$$

x'	(A/A ₀) _X	M	(P/P ₀) _X	P _X	(T/T ₀) _X	T _X	V _X	ρ _X	μ
1	2.292	2.35	.074	12.38	.475	3525	6851	.00948	4.4 x 10 ⁻⁵
2	3.718	2.86	.034	5.68	.379	2815	7451	.00544	3.93
3	5.10	3.20	.020	3.34	.328	2430	7745	.00371	3.68
4	6.44	3.45	.014	2.34	.290	2150	7855	.00294	3.47
5	7.74	3.64	.0108	1.81	.274	2063	8118	.00236	3.40
10	13.74	4.28	.0050	.836	.220	1656	8552	.00136	3.07
20	23.05	4.90	.00213	.356	.172	1294	8654	.00074	2.75
30	28.73	5.10	.00165	.276	.160	1200	8674	.00062	2.66
40	32.89	5.28	.00154	.257	.154	1160	8831	.00060	2.62

Assume the heat transfer relation is turbulent flow flat plate.

$$Nu_X = c(.332(Pr)^{1/3}(Re_X)^{1/2}) = cNu_1$$

$$Re_X = \frac{V_X \rho}{\mu}$$

c = correction constant for high speed flow (Kays, ¹⁴ p. 13.28)

$$h = \frac{Nu_X k}{X'} \quad (\text{Btu/hr-ft}^2\text{-}^\circ\text{F})$$

x'	Re	Re ^{1/2}	Pr	Pr ^{1/3}	Nu ₁	c	Nu _X	k	h
1	1.475 x 10 ⁶	1.214 x 10 ³	.83	.94	378.9	.70	265	.065	17.2
2	2.06	1.435	.76	.91	433.5	.63	273	.058	7.9
3	2.34	1.530	.74	.90	457.2	.58	265	.054	4.8

(Continued)

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x'	R_e	$R_e^{1/2}$	Pr	$Pr^{1/3}$	Nu'	c	Nu_x	k	h
4	2.66	1.63	.73	.90	487.0	.55	268	.050	3.4
5	2.82	1.68	.73	.90	502.0	.54	271	.049	2.7
10	3.79	1.946	.71	.89	575.0	.45	259	.044	1.1
20	4.66	2.16	.70	.89	638.2	.38	243	.038	.46
30	6.06	2.46	.70	.89	726.9	.37	269	.037	.33
40	8.06	2.84	.696	.89	839.2	.36	302	.036	.27

$$T_{ax} = T_x (1 + \frac{r_c}{2} (\gamma - 1) M^2)$$

$$\gamma = 1.4$$

$$r_c = Pr^{1/3}$$

$$\Delta t = T_{AW} - T_W = (T_{AW} - 2000^\circ R)$$

$$P = 2\pi r_t + 2\pi r_b$$

x'	T_{AW}	Δt	P	$hP\Delta t$
1	7184.8	5184.8	89.3	7.96×10^6
2	6959.6	4959.6	88.2	3.46
3	6909.0	4909.0	87.1	2.05
4	6756.3	4756.3	86.0	1.39
5	6983.1	4983.1	84.9	1.14
10	7116.3	5116.3	79.4	.447
20	6886.4	4886.4	68.4	.154
30	6618.2	4618.2	57.4	.091
40	6981.0	4981.0	61.3	.082

Then:

$$q_N = \int_{x'=0}^{x'=40} (hP\Delta t)_x dx'$$

Integrating graphically from curve of x' vs $hP\Delta t$ in Figure 76 we get,

$$q_N = 47.8 \times 10^6 \text{ Btu/hr}$$

$$q_N = \frac{47.8 \times 10^6 \text{ Btu/hr}}{4.879 \times 10^6 \frac{\text{lbm air}}{\text{hr}}}$$

$$q'_N = 9.797 \text{ Btu/lbm air}$$

$$q'_N = \frac{9.797}{.0098} \text{ lbm fuel/lbm air}$$

$$q'_N = 140.4 \text{ Btu/lbm fuel}$$

$$q'_T = q'_N + q'_c$$

$$q'_T = 1867.4 \text{ Btu/lbm fuel}$$

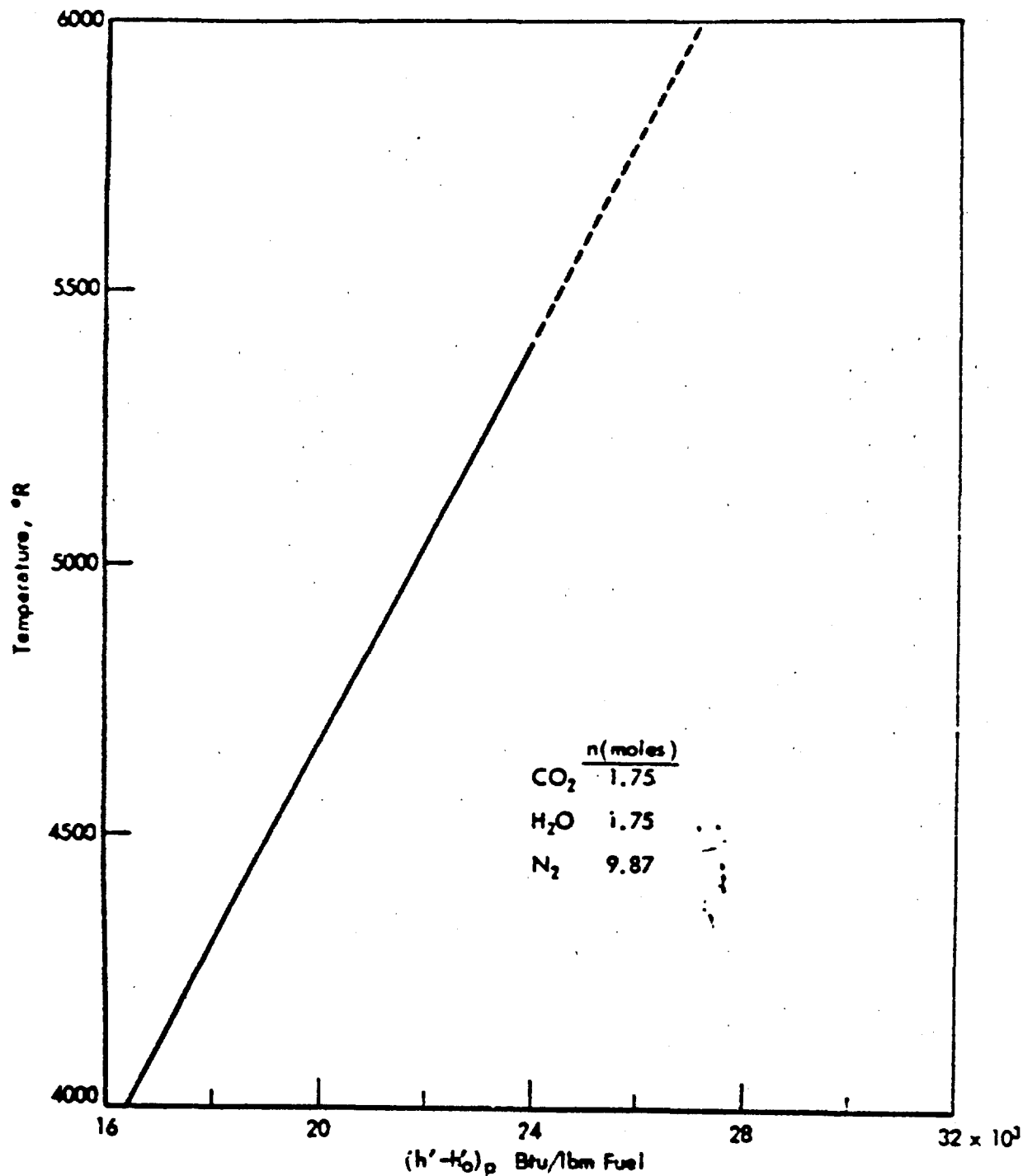


Figure 72. ENTHALPY OF PRODUCTS OF COMBUSTION

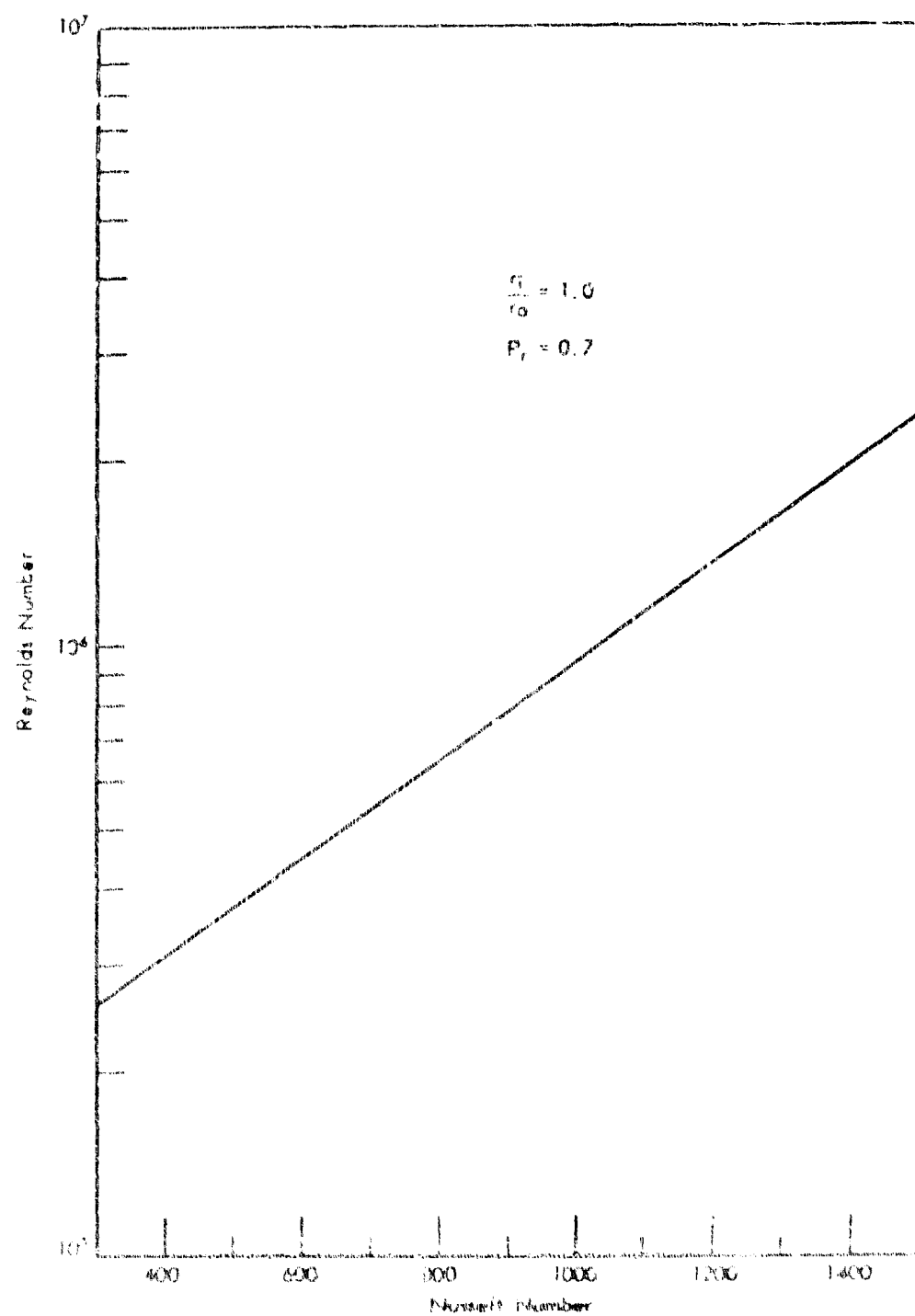


Figure 73. TURBULENT ANNULAR FLOW
From Kay, Table 7-7

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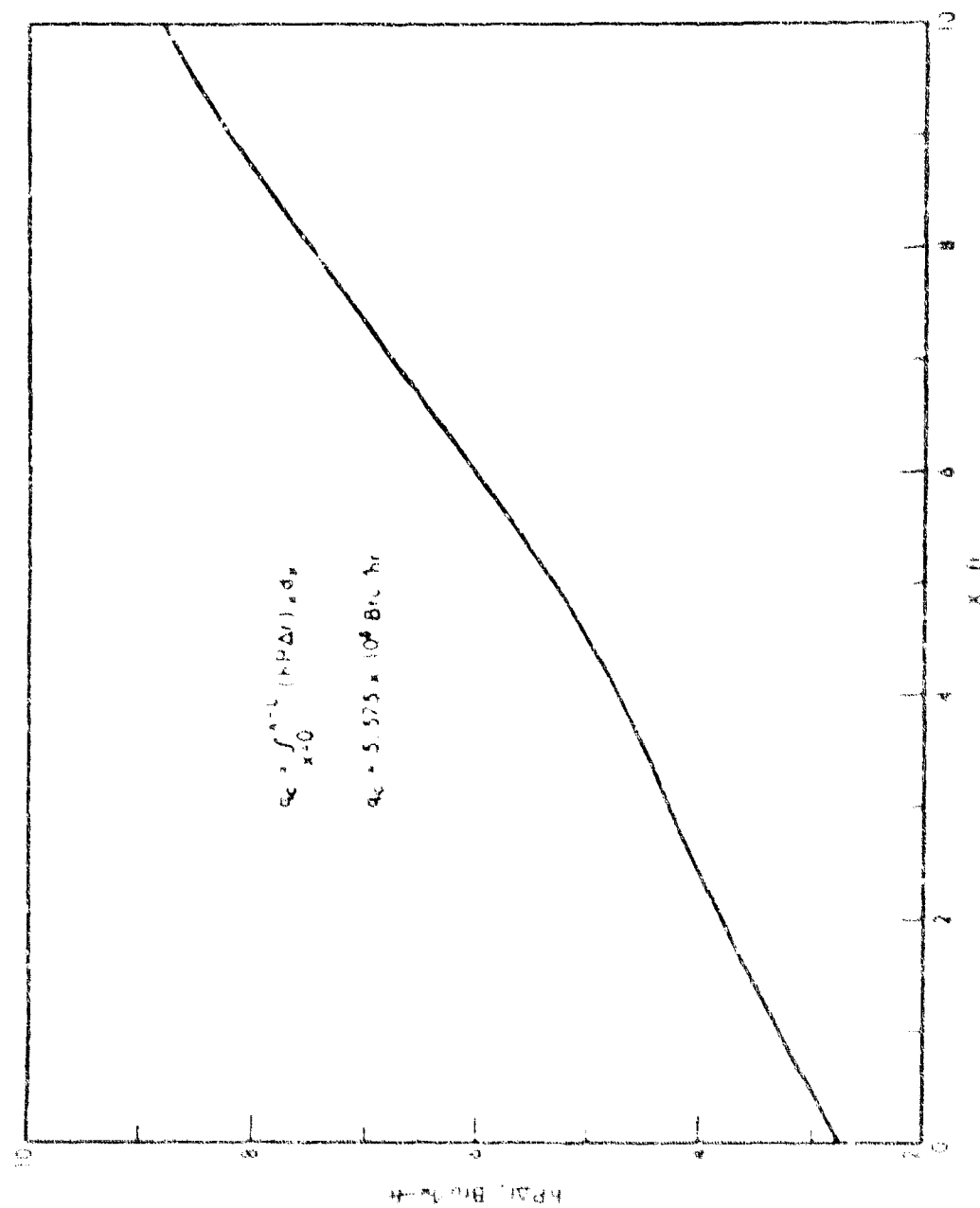


Figure 24. COMBUSTOR HEAT FLUX DISTRIBUTION

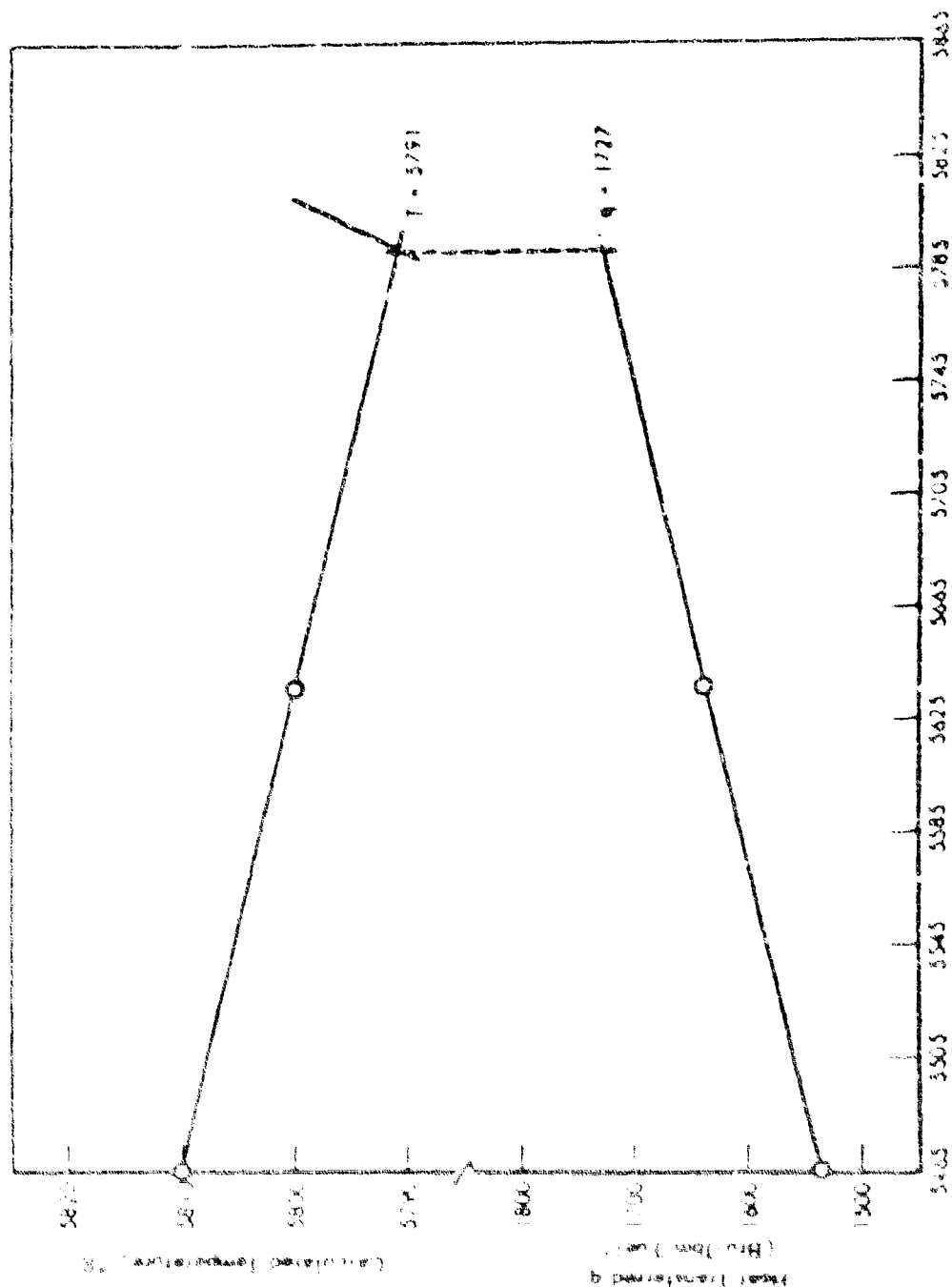


Figure 75. HEAT TRANSFER CONDITIONS

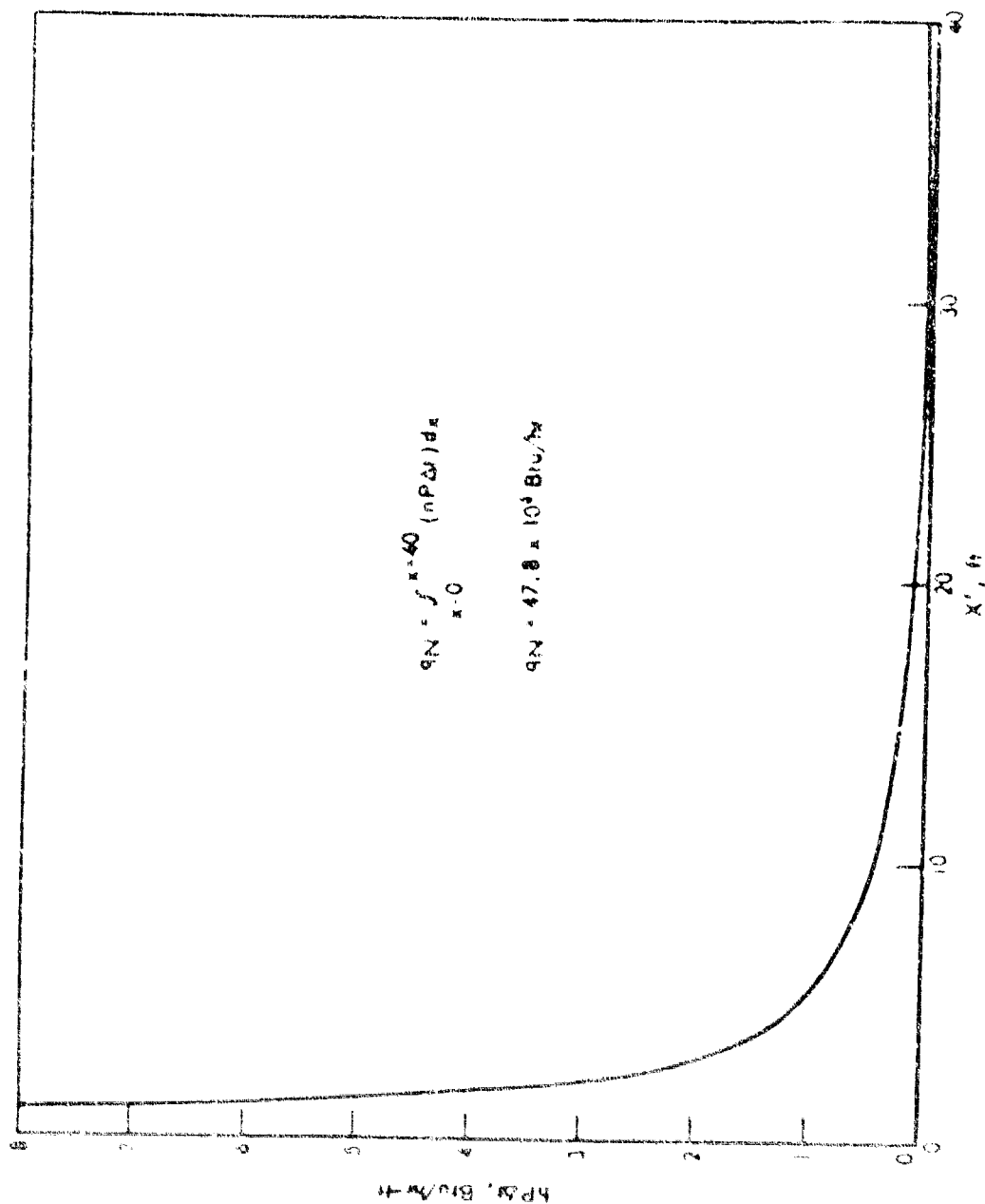


Figure 76. NOZZLE HEAT FLUX DISTRIBUTION

Table 119. DEHYDROGENATION OF MCH OVER AEROSOL-PHF-1

Pressure: 1 atm Catalyst Volume: 7 ml
Block Temperature: 842 °F Reaction Time: 30 Minutes

Run Number 11018-	35	36-1	36-2	37
LHSV	5	15	30	50
Catalyst Bed Profile, °F	752 808-06 826-24 835-33	655-60 680-75 725-25 772-66	662-777 640-759 658-741 644-734	812-38 ^{d)} 820-36 813-35 808-35
Reactor Wall Temperature, °F	824-22	74-59	730-94	
CH ₄ max	0	5	135	27 ^{d)}
Product Analysis, %				
Benzene	1.8	0.2	0.0	0.0
U ₁ ^{a)}	0.0	0.1	0.4	0.6
MCH	1.0	3.7	41.6	96.1
U ₂ ^{b)}	0.0	0.0	0.0	1.0
Toluene	97.1	96.0	58.0	1.2
U ₃ ^{c)}	0.1	0.0	0.0	1.1
MCH Conversion, %	99.0	96.3	58.4	3.9

- a) Unidentified; emerged after benzene.
b) Unidentified; emerged after MCH.
c) Unidentified; emerged after toluene.
d) Catalyst almost completely deactivated after 10 minutes.

Table 120. DEHYDROXYMATION OF MCH OVER SXILL 45

Pressure: 1 atm Catalyst Volume: 7 ml
Block Temperature: 642 °F Reaction Time: 30 Minutes
Catalyst No.: 10280-45

Run Number: 11215-	93	94-1	94-2	100-1	100-2	101
LHSV	5	15	30	50	80 ^{a)}	100 ^{a)}
Catalyst Bed Profile, °F	790-88 824-22 835-33 840-38	671-67 714-07 734-48 795-92	630-22 635-28 551-44 650-73	619 610 617 633	626-30 608 608 617	635-42 603-19 608 614
Reactor Wall Temperature, °F	850	774-70	725-20	705	698	673-91
OT max	0	0	0	0	4 ^{a)}	7 ^{a)}
Product Analysis, %						
Benzene	9.9	0.9	0.1	0.0	0.0	0.1
MCH	1.1	0.5	19.3	41.3	54.6	60.3
Toluene	89.0	98.6	80.6	58.7	45.4	39.5
MCH Conversion, %	98.9	999.5	80.7	58.8	47.7	41.8

a) Back pressure was about 15 psig during this run.

Table 121. DEACTIVATION OF MCH OVER UOP-42

Pressure: 1 atm
Block Temperature: 542°Y Reaction Time: 30 Minutes

Run Number: 11013	94-1	94-2	94
LEIV	5	15	30
Catalyst Bed Profile, °Y	770-72 799-90 815-19 831-31	709-11 626-82 716-09 739-45	752-838 540-878 671-836 682-896
Reactor Wall Temperature, °Y	815-30	775	768-858
ΔT max	4	2	168 ^{d)}
Product Analysis, %			
Benzene	3.5	0.5	0
U ₁ ^{a)}	0.0	0.0	0.3
MCH	1.3	6.1	86.7
U ₂ ^{b)}	0.0	0.0	0.5
Toluene	95.0	95.3	12.5
U ₃ ^{c)}	0.2	0.0	2.0
MCH Conversion, %	98.7	95.9	15.3

- a) Unidentified; emerged after benzene.
b) Unidentified; emerged after MCH.
c) Unidentified; emerged after toluene.
d) ΔT max = 162 after 17 minutes; catalyst completely deactivated at end of run.

Table 122. HYDROGENATION OF MCH OVER STANDARD CATALYST

Pressure: 1 atm Catalyst Volume: 7 ml
 Block Temperature: 842°F Reaction Time: 30 Minutes
 Catalyst No.: 9874-T

Run Number: 11011-	73	72-1	72-2	00
LRSP	5	15	30	50
Catalyst Bed Profile, °F	779 775 850 837-35	714-16 743 765 788-86	725-76 725-59 734-54 742-59	815-37 797-833 783-833 777-830
Reactor Wall Temperature, °F	826	792	793-97	815-34
of wall	0	2	50	52 ^{b)}
Product Analysis, %				
Benzene	1.7	0.4	0.2	0.1
MCH	1.7	19.9	62.8	93.1
Toluene	97.2	79.7	37.0	5.6
U ₁ ^{a)}	0.0	0.0	0.0	1.2
MCH Conversion, %	98.9	80.1	37.2	6.9

a) Unidentified; emerged after toluene.

b) Catalyst almost completely deactivated at end of run.

Table 123. DEHYDROGENATION OF MCH OVER SHELL 108

Pressure: 1 atm Catalyst Volume: 7 ml
Block Temperature: 842°F Reaction Time: 30 Minutes
Catalyst Number: 10280-108

Run Number: 11018-	88-1	89-1	89-2	90-1	90-2	91
LESV	5	15	30	50	80	100
Catalyst Bed Profile, °F	774-72 817-13 831 837-35	653 639 752-30 775	635-39 637 657-55 687-84	642-53 630-33 637-39 658	669-75 635-39 635-37 648	687-94 644-50 639-42 646-48
Reactor Wall Temperature, °F	826-24	761	727-25	716-18	716	723-29
OF max	0	0	4	11	6	7
Product Analysis, %						
Benzene	2.3	0.2	0.0	0.0	0.0	0.0
MCH	1.4	4.5	30.4	50.8	63.3	68.3
Toluene	96.3	94.9	69.6	49.2	35.7	31.7
MCH Conversion, %	98.6	95.1	69.6	49.3	36.3	31.9

Table 124. DEHYDROGENATION OF MCH OVER Pd-150

Pressure: 1 atm Catalyst Volume: 7 ml
 Block Temperature: 842°F Reaction Time: 30 Minutes

Run Number: 11018-	103-1	103-2	104-1	104-2	105
LHSV	5	15	30	50	80
Catalyst Bed Profile, °F	761-52 806-01 806-24 833	669-65 691-87 729-23 770-68	657-71 639-40 653-55 678-80	700-815 642-761 644-701 657-680	830-33 870-33 806-33 776-833
Reactor Wall Temperature, °F	822-20	763-61	727-29	725-88	824-35
ΔT max	0	0	14	115	-- ^{d)}
Product Analysis, %					
Benzene	1.2	0.0	0.0	0.0	0.0
U ₁ ^{a)}	0.0	0.1	0.0	0.2	0.2
MCH	1.4	2.2	27.5	56.1	96.6
U ₂ ^{b)}	0.0	0.0	0.0	0.0	0.6
Toluene	97.4	97.7	72.5	43.7	1.6
U ₃ ^{c)}	0.0	0.0	0.0	0.0	1.0
MCH Conversion, %	98.6	97.8	72.5	43.5	3.4 ^{d)}

a) Unidentified; emerged after benzene.

b) Unidentified; emerged after MCH.

c) Unidentified; emerged after Toluene.

d) Catalyst about completely deactivated at end of run.

Table 125. DEHYDROGENATION OF MCH OVER UOP-R16K

Pressure: 1 atm
 Block Temperature: 542°F
 Catalyst Volume: 7 ml
 Reaction Time: 30 minutes

Run No. 11325-	85-1	85-2	86-1	86-2	87-1	87-2
LHSV	5	15	30	50	80	100
Catalyst Bed Profile, °F	774-70 813-10 831-29 833	671 705-02 752-50 779-74	655-58 646-57 668-67 689-87	686-729 640-657 644-51 657-55	759-824 673-761 550-89 648-69 ^{a)}	824 784-822 705-761 678-720 ^{a)}
Reactor Wall Temp, °F	831	779-76	643-47	638-47	750-90	802-28
ΔT_{max} , °F	-4	-5	11	43	88 ^{a)}	31 ^{a)}
Product Analysis, %w						
Benzene	0.1	0.0	0.0	0.0	0.0	0.0
MCH	7.4	4.8	33.2	54.9	70.9	81.5
Toluene	92.4	95.2	66.8	45.1	29.0	18.0
Others ^{b)}	0.1	0.0	0.0	0.0	0.1	0.5
MCH Conversion, %w	92.6	95.2	66.8	45.1	29.1	18.5

a) Cold spot moved down the catalyst bed.

b) Emerged after MCH and after toluene.

Table 126. DEHYDROGENATION OF MCH OVER 1% Pt on Al_2O_3

Pressure: 1 atm
 Block Temperature: 542°F
 Catalyst Volume: 7 ml
 Reaction Time: 30 minutes
 Catalyst No.: 10280-44

Run No. 11325-	81-1	81-2	82-1	82-2	83-1	83-2
LHSV	5	15	30	50	80	100
Catalyst Bed Profile, °F	776-72 817 833 837	686-82 732-27 765-61 795-92	669-76 689 711-09 741-39	685-743 687-707 696-707 718-22	776-815 729-90 716-66 720-54	819-24 806-24 786-819 772-812
Reactor Wall Temp, °F	831-28	781-76	750-52	747-61	770-810	817-831
ΔT_{max} , °F	-4	-5	+7	52	61 ^{b)}	40 ^{b)}
Product Analysis, %						
Benzene	2.1	0.3	0.1	0.1	0.1	0.1
MCH	2.2	12.8	44.5	63.7	82.4	92.5
Toluene	95.7	86.9	55.2	35.8	16.7	4.9
Others ^{a)}	0.0	0.0	0.2	0.4	0.8	2.5
MCH Conversion, %	97.8	87.2	55.5	36.3	17.6	7.5
Selectivity for Toluene, %	97.9	99.7	99.4	99.4	94.5	65.3

a) Emerged after MCH and after toluene.

b) Cold spot moved down the catalyst bed.

Table 127. DEHYDROGENATION OF MCH OVER 10860-114C CATALYST

Pressure: 1 atm
Block Temperature: 842°F
Catalyst Volume: 7 ml
Reaction Time: 30 minutes

Run No. 11325-	74-1	74-2	75-1	75-2	76-1	76-2
LHSV	5	15	30	50	80	100
Catalyst Bed Profile, °F	759-61 815 833 837-35	640-35 689-82 750-43 792-84	619 632-30 660-57 691-89	621-26 621 635 658	635-37 619-21 626 644	644-50 621-23 626 637-35
Reactor Wall Temp, °F	831	770-66	730-28	718	711	709
ΔT_{max} , °F	+2	-8	-3	+5	+2	+6
Product Analysis, %w						
Benzene	5.4	0.5	0.1	0.0	0.0	0.0
MCH	2.2	1.7	26.8	47.2	59.6	65.0
Toluene	92.4	97.8	73.1	52.8	40.4	35.0
MCH Conversion, %w	97.8	98.3	73.2	52.8	40.4	35.0

Table 126. DEHYDROGENATION OF MCH OVER 10660-1148 CATALYST

Pressure: 1 atm
 Block Temperature: 842°F
 Catalyst Volume: 7 ml
 Reaction Time: 30 minutes

Run No. 11325-	69	70-1	70-2	71	72-1	72-2
LHSV	5	15	30	50	80	100
Catalyst Bed Profile, °F	761-52 810-04 831-29 835-33	680-75 712-07 752-45 794-79	671-80 676 648-36 727-23	689-707 673-80 656-87 707	727-58 687-709 687-714 690-702	781-806 723-63 700-25 702-16
Reactor Wall Temp, °F	828-26	779-76	752	743-47	747-63	768-95
ΔT_{max} , °F	-9	-7	+9	18	41	40 ^{a)}
Product Analysis, %						
Benzene	0.8	0.2	0.1	0.1	0.1	0.1
MCH	0.8	10.8	44.3	62.2	73.3	81.3
Toluene	98.4	89.0	55.6	37.7	26.6	18.6
MCH Conversion, %	99.2	89.2	55.7	37.8	26.7	15.7

a) Cold spot moved down the catalyst bed.

Table 129. DEHYDROGENATION OF MCH OVER 10860-113A AND
HOUDRY 200 SR CATALYSTS

Pressure: 1 atm
Block Temperature: 847°F
Catalyst Volume: 7
Reaction Time: 30 minutes

Run No. 11325-	89-1	89-2	78-1	78-2	79
Catalyst	Houdry 200 SR		10860-113A		
LHSV	5	15	5	15	30
Catalyst Bed Profile, °F	758-56 801-799 826-24 833	705-833 700-831 741-830 770-828	763-58 804-797 824-12 831-28	725-68 741-50 761-58 784-779	824-37 797-833 774-826 770-817
Reactor Wall Temp, °F	826	783-838	824-21	788-97	820-837
ΔT_{max} , °F	-2	131	-7	43	b)
Product Analysis, %					
Benzene	1.4	0.2	1.7	3.2	0.1
MCH	1.7	59.3	4.8	35.0	88.3
Toluene	96.9	34.1	93.5	64.8	10.8
Others ^{a)}	0.0	6.2	0.0	0.0	0.8
MCH Conversion, %	98.3	40.6	95.2	65.0	11.7
Selectivity for Toluene, %	98.6	84.0	92.8	99.7	92.3

a) Emerged after MCH, after benzene, after toluene.

b) Catalyst bed temperature about that of reactor wall temperature.

Description of the Pulse Reactor

The pulse reactor was a 1/4-in. OD stainless steel tube (No. 304) 9-1/8 in. long and 0.028 in. wall thickness. Swagelok Tees were fastened at each end and one arm of the Tee served as an injection port. A rubber septum (GLC type) was held in place by the fitting nut and the feed was injected through this septum from a syringe. A five inch length of the reactor tube was surrounded by a secondary furnace liner and the whole was heated by an electric furnace. The secondary liner had seven radial drilled holes for thermocouples, and the holes were located as shown in Figure 79. A schematic diagram of the pulse reactor is shown in Figure 77.

All lines were 1/4-in. OD stainless steel tubing (No. 304). About 28 in. of line just prior to the reactor was wrapped with heating tape and constituted a gas preheater. About 8 in. of the preheater section was filled with quartz chips (10-20 mesh size).

In the pulse reactor system the carrier gas was metered through a rotameter (Figure 77) and passed through the preheater section and into the reactor. The exit gas passed into a manifold and then into the GLC. The purpose of the manifold was to maintain the exit gas pressure slightly greater than the gas pressure in the GLC. This was done by adjusting the pressure control valve and the vent valve. The manifold was wrapped with heating tape and was maintained at 302° to 356°F. The injection port temperature was about 450°F. The pressure control and the vent valves were needle valves (Hoke No. 1315) and the GLC valve was a lever operated valve (Hoke No. 490).

To carry out an experiment the reactor was brought to temperature and the carrier gas flow rate, reactor pressure and manifold pressure were adjusted by means of the appropriate flow control valves. Then with inert gas flowing to the GLC a pulse was injected through the lower injection port and subsequently analyzed. This gave an analysis of the starting material. A pulse was then injected in the top injection port, passed over the catalyst and analyzed.

In this system the space velocity was obtained from the inert gas flow rate. Figure 79 shows the pulse reactor system with the secondary furnace liner in place; Figure 80 shows the GLC analysis system.

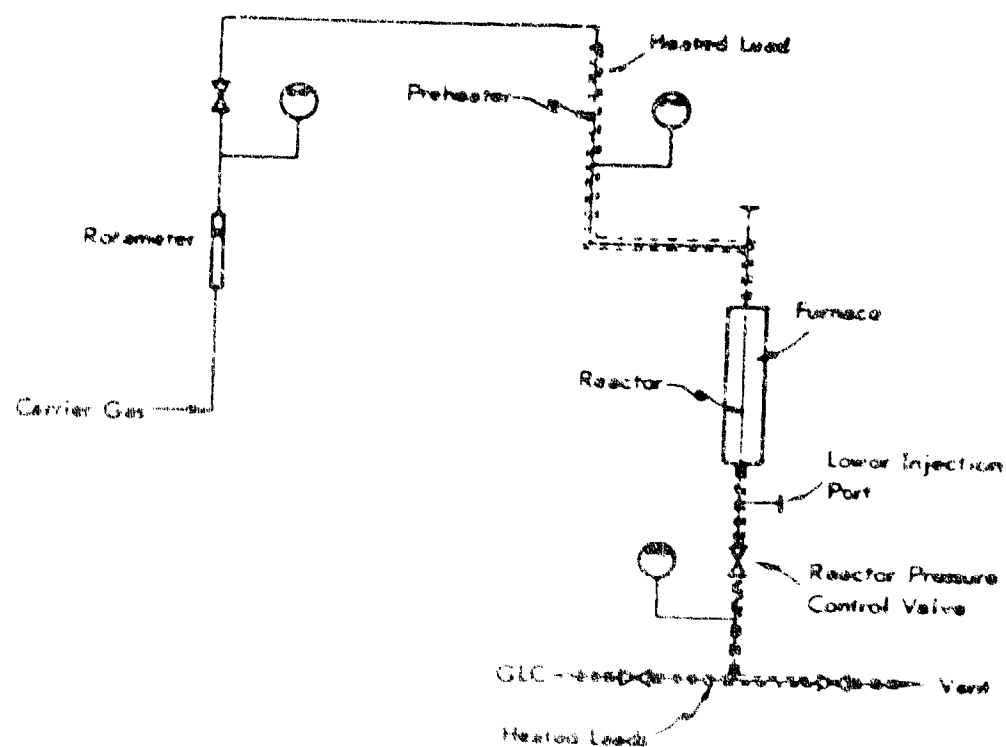


Figure 27. PULSE REACTOR SCHEMATIC

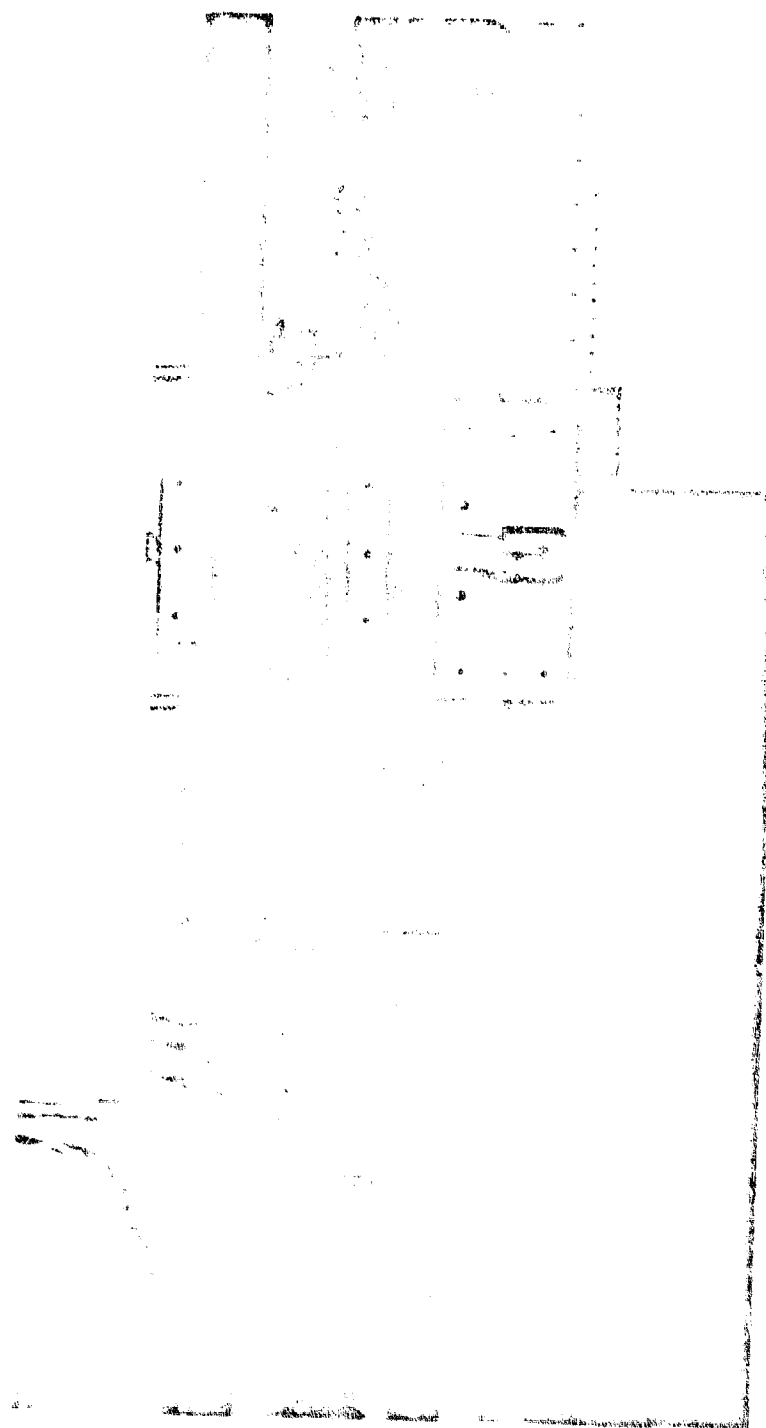


Figure 79. PULSE REACTOR SYSTEM

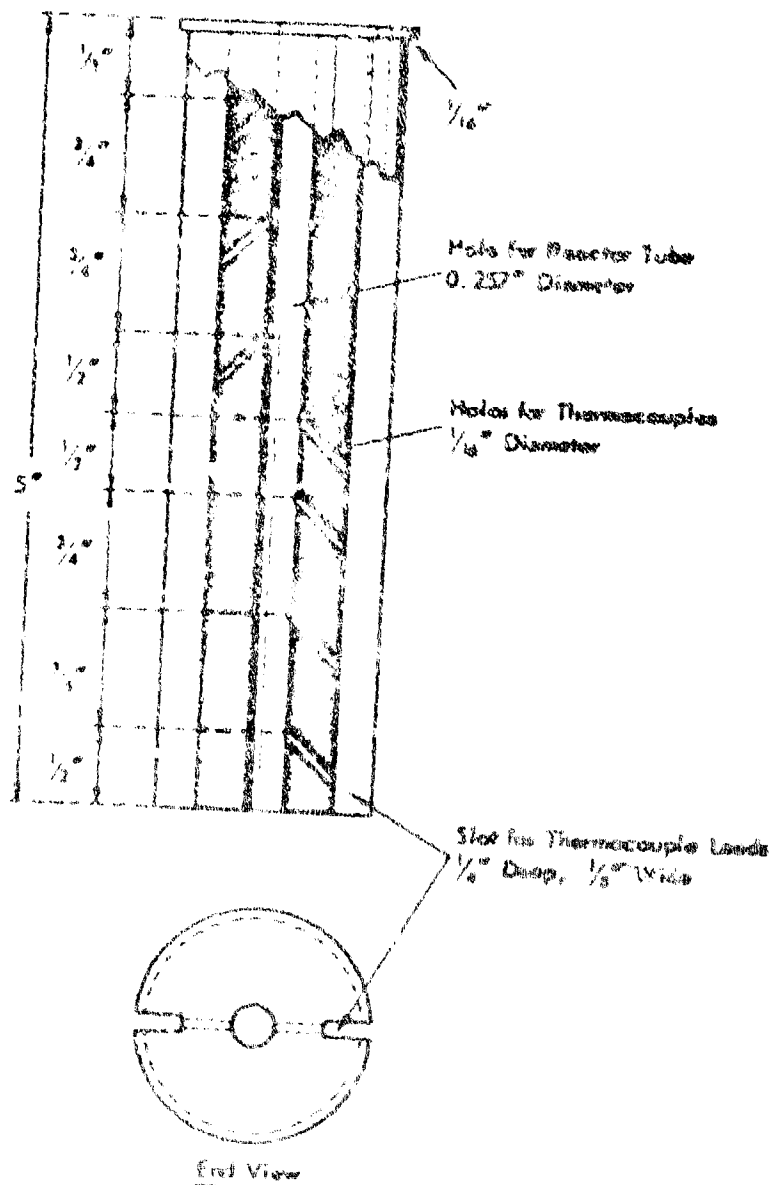


Figure 79. SECONDARY FURNACE LINER FOR PULSE REACTOR

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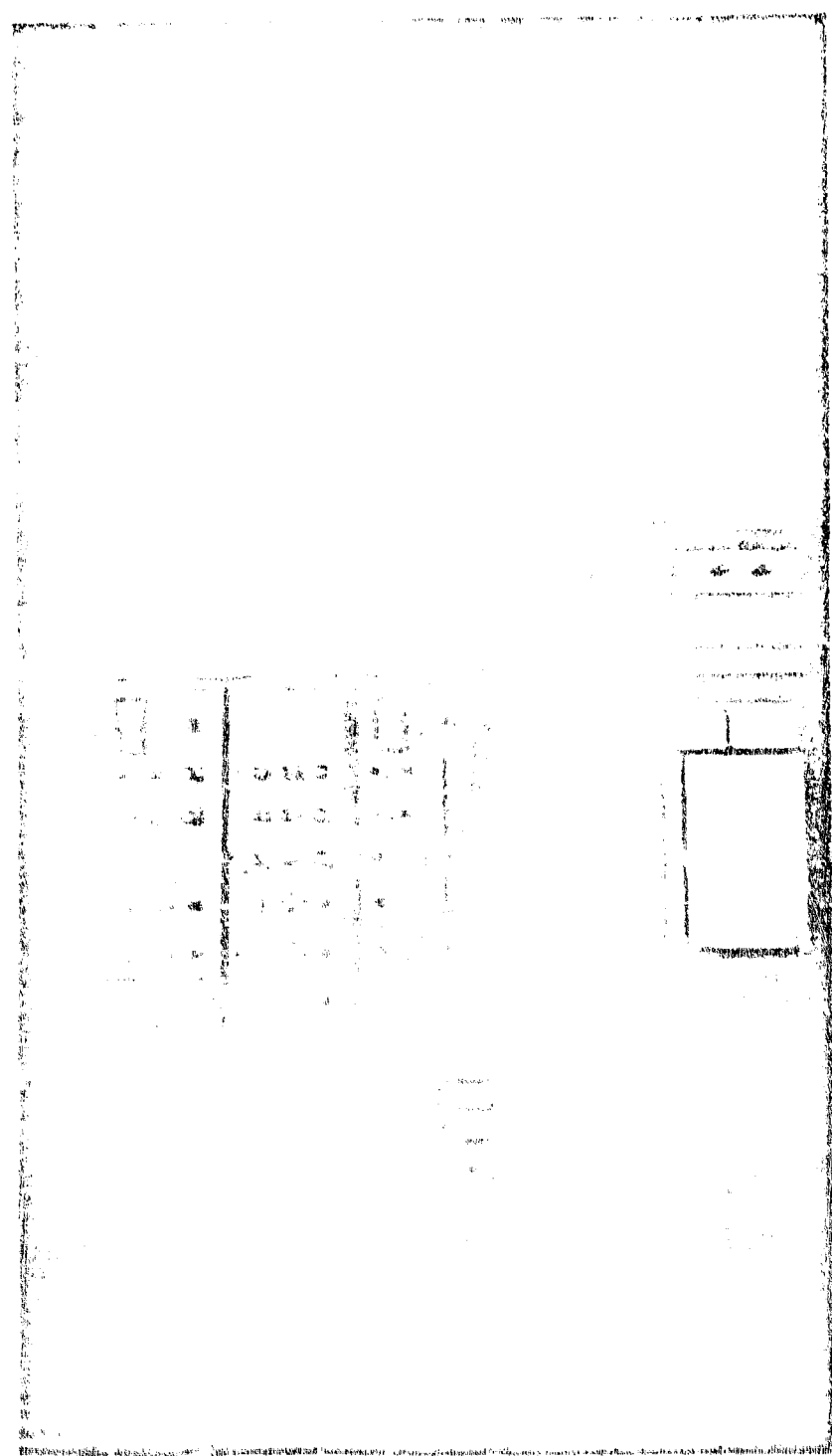


Figure 80. GIC ANALYSIS SYSTEM

Description of the 1/4-in. OD Flow Reactor

In order to test candidate fuels that are in short supply one section of our laboratory dual reactor system was modified in the following manner, so that 1/4-in. OD reactor tubes could be used.

In our laboratory reactor system the furnace is 26 in. overall length and contains four heating elements of lengths 4", 8", 8", 4" located from top to bottom in that order. The outer shell of the furnace extends one inch beyond the top and bottom of the heating elements. The furnace consists of two hinged halves and opens lengthwise. Each half contains a heavy Meehanite liner with a groove down the center to hold the reactor tube. When closed the grooves form an opening 7/8 inch in diameter.

To modify the apparatus, a secondary furnace liner was fabricated from a 7/8-in. stainless steel rod (No. 416), 13 inches long. A 0.257-in. diameter hole was drilled down the center to accommodate a 1/4-in. OD reactor tube. Seven holes were drilled radially from the outside to the center hole in which thermocouples were cemented. The thermocouples were 1-1/2 inches apart and the top couple was 1-1/2 inches from the top of the liner. The thermocouples were situated so that they just touched the reactor wall. This secondary liner was placed in the Meehanite liners at the very bottom of the furnace and extended one inch below the bottom heating element. Figure 81 shows the construction of the secondary liner and its position in the furnace.

The reactor was a stainless steel tube (No. 304) 30 inches long, 1/4-inch OD with 0.035" wall thickness. Reaction was carried out in the lower part of the tube and the top part served as a feed preheater. The reactor was furnace-heated and a 13" long secondary furnace liner surrounded the reactor tube at the reaction zone. Figure 81 shows the secondary furnace liner and its position in the furnace.

The reactor wall temperature was measured at seven points along the tube. The points were 1-1/2 inches apart and the top point was one inch below the top of the secondary liner (Figure 81). The temperature of the reactor wall varied down the tube and Figure 82 shows the temperature variation for a furnace block temperature of 1202°F.

The maximum reaction rate will occur in the region of maximum temperature. Presumably the rate in that portion of the tube whose temperature was 18°F (10°C) or more below the maximum temperature, did not contribute appreciably to the overall rate. Thus the "effective" volume of the tube was that portion of the tube whose temperature was within 18°F of the maximum wall temperature, and whose volume was determined from a plot such as Figure 82. The "effective" reactor temperature was taken as 9°F below the maximum temperature.

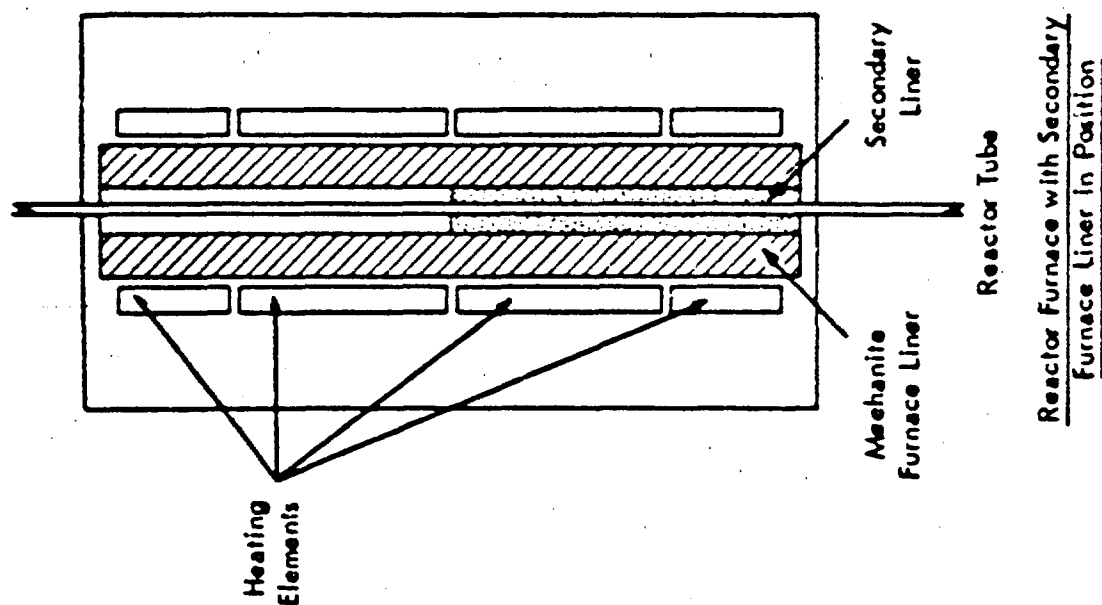
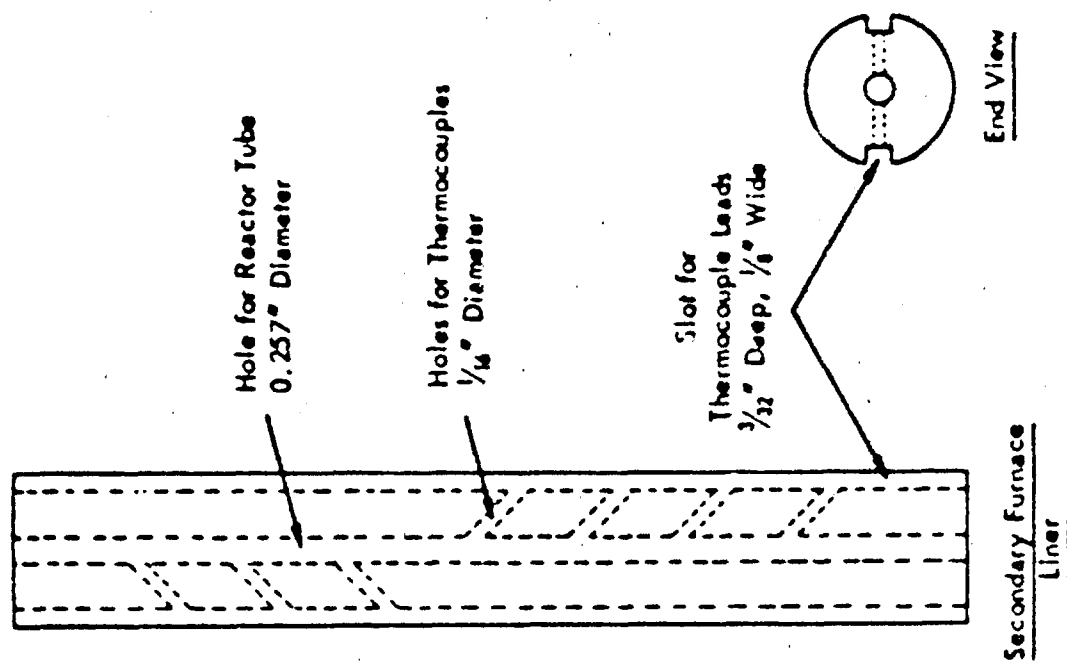


Figure 81. SECONDARY FURNACE LINER FOR 1/4" OD REACTOR TUBE

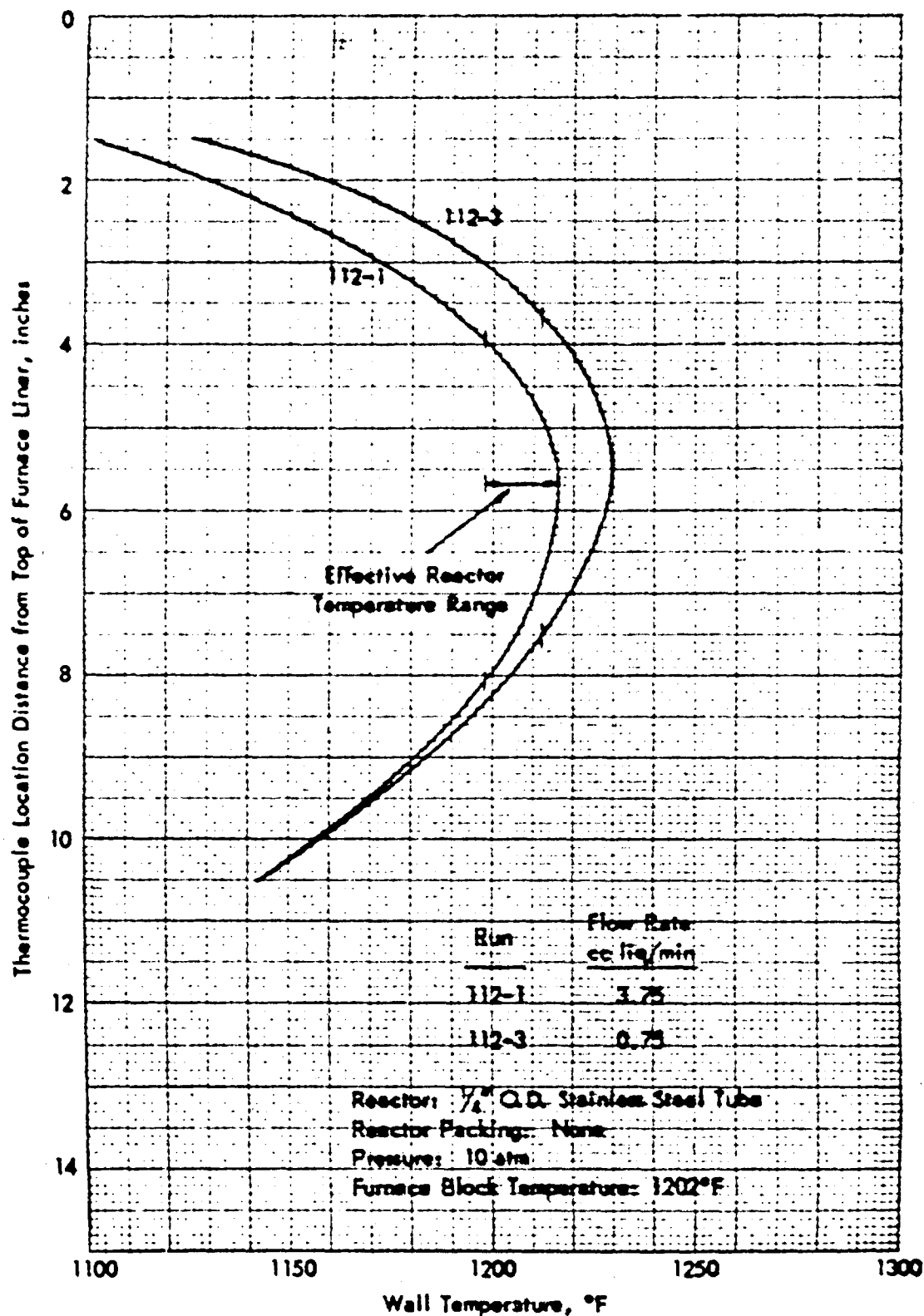


Figure 82. REACTOR TEMPERATURE PROFILE

Micro Catalyst Test Reactor Data

The micro catalyst test reactor (MUCR) and the operational techniques used for screening candidate catalysts have been described in the Appendix of the last Annual Report.¹⁶⁾ No further changes have been made. Catalysts are tested with MCH at LHSV 100 and 662, 752 and 842°F, at 10 atm pressure without added hydrogen. Figures 87 through 89, of reference 18 show the apparatus in detail, except for the changes noted in reference 16. It has been found that more consistent results are obtained if a fresh loading of the reference catalyst 9874-139 is made each week as a base point for calibration, rather than using the same reference catalyst tube over and over again, since the activity gradually declines. Also prepared catalysts have been rescreened to 10-20 mesh to remove fines after impregnation and drying of the supports, and this gives more reproducible results.

Table 150. MEH DEHYDROGENATION WITH VARIOUS CATALYSTS IN MICR: RANS 677-813

Period: June-August 1968
 Condition: 10 atm pressure; catalysts reduced in H_2 for 20 minutes at $T_{96}^{\circ}F$; GLC samples normally taken at 3-, 8-, and 13-minute operation at each block temperature.
 Catalyst Volume: 0.9 ml catalyst diluted with 1.1 ml quartz chips; LHSV 100 (catalyst and quartz particles 10-20 mesh unless otherwise noted).

Run No.	Temperature, $^{\circ}C$	Catalyst		Gas Composition, %		
		Description	Weight	H_2	CH_4	C_2H_6
678	120	15 Pt/100 20 mesh quartz (net)	0.907	100, 15, 20	95, 97, 98	70, 70, 70
679	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
680	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
681	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
682	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
683	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
684	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
685	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
686	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
687	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
688	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
689	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
690	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
691	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
692	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
693	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
694	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
695	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
696	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
697	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
698	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
699	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
700	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
701	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
702	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
703	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
704	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
705	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
706	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
707	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
708	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
709	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
710	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
711	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
712	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65
713	120	15 Pt/100 20 mesh quartz (net)	0.907	95, 15	95, 97, 98	65, 65

(Continued)

~~TOP SECRET (Soviet)~~ FOR INFORMATION ONLY: NO DISSEMINATION

Date				Description				Amount			
1917	1	Jan	1	1917	1	Jan	1	1917	1	Jan	1
1917	2	Jan	2	1917	2	Jan	2	1917	2	Jan	2
1917	3	Jan	3	1917	3	Jan	3	1917	3	Jan	3
1917	4	Jan	4	1917	4	Jan	4	1917	4	Jan	4
1917	5	Jan	5	1917	5	Jan	5	1917	5	Jan	5
1917	6	Jan	6	1917	6	Jan	6	1917	6	Jan	6
1917	7	Jan	7	1917	7	Jan	7	1917	7	Jan	7
1917	8	Jan	8	1917	8	Jan	8	1917	8	Jan	8
1917	9	Jan	9	1917	9	Jan	9	1917	9	Jan	9
1917	10	Jan	10	1917	10	Jan	10	1917	10	Jan	10
1917	11	Jan	11	1917	11	Jan	11	1917	11	Jan	11
1917	12	Jan	12	1917	12	Jan	12	1917	12	Jan	12
1917	13	Jan	13	1917	13	Jan	13	1917	13	Jan	13
1917	14	Jan	14	1917	14	Jan	14	1917	14	Jan	14
1917	15	Jan	15	1917	15	Jan	15	1917	15	Jan	15
1917	16	Jan	16	1917	16	Jan	16	1917	16	Jan	16
1917	17	Jan	17	1917	17	Jan	17	1917	17	Jan	17
1917	18	Jan	18	1917	18	Jan	18	1917	18	Jan	18
1917	19	Jan	19	1917	19	Jan	19	1917	19	Jan	19
1917	20	Jan	20	1917	20	Jan	20	1917	20	Jan	20
1917	21	Jan	21	1917	21	Jan	21	1917	21	Jan	21
1917	22	Jan	22	1917	22	Jan	22	1917	22	Jan	22
1917	23	Jan	23	1917	23	Jan	23	1917	23	Jan	23
1917	24	Jan	24	1917	24	Jan	24	1917	24	Jan	24
1917	25	Jan	25	1917	25	Jan	25	1917	25	Jan	25
1917	26	Jan	26	1917	26	Jan	26	1917	26	Jan	26
1917	27	Jan	27	1917	27	Jan	27	1917	27	Jan	27
1917	28	Jan	28	1917	28	Jan	28	1917	28	Jan	28
1917	29	Jan	29	1917	29	Jan	29	1917	29	Jan	29
1917	30	Jan	30	1917	30	Jan	30	1917	30	Jan	30
1917	31	Jan	31	1917	31	Jan	31	1917	31	Jan	31

Table 1-9 (Cont'd). THE REPRODUCTION TIME DEPENDENT PARAMETERS
IN YEARS: 1950-1959

Year	Population	Birth Rate	Death Rate	Net Growth Rate
1950	1,000,000	2.5	1.5	1.0
1951	1,010,000	2.5	1.5	1.0
1952	1,020,000	2.5	1.5	1.0
1953	1,030,000	2.5	1.5	1.0
1954	1,040,000	2.5	1.5	1.0
1955	1,050,000	2.5	1.5	1.0
1956	1,060,000	2.5	1.5	1.0
1957	1,070,000	2.5	1.5	1.0
1958	1,080,000	2.5	1.5	1.0
1959	1,090,000	2.5	1.5	1.0
1960	1,100,000	2.5	1.5	1.0
1961	1,110,000	2.5	1.5	1.0
1962	1,120,000	2.5	1.5	1.0
1963	1,130,000	2.5	1.5	1.0
1964	1,140,000	2.5	1.5	1.0
1965	1,150,000	2.5	1.5	1.0
1966	1,160,000	2.5	1.5	1.0
1967	1,170,000	2.5	1.5	1.0
1968	1,180,000	2.5	1.5	1.0
1969	1,190,000	2.5	1.5	1.0
1970	1,200,000	2.5	1.5	1.0
1971	1,210,000	2.5	1.5	1.0
1972	1,220,000	2.5	1.5	1.0
1973	1,230,000	2.5	1.5	1.0
1974	1,240,000	2.5	1.5	1.0
1975	1,250,000	2.5	1.5	1.0
1976	1,260,000	2.5	1.5	1.0
1977	1,270,000	2.5	1.5	1.0
1978	1,280,000	2.5	1.5	1.0
1979	1,290,000	2.5	1.5	1.0
1980	1,300,000	2.5	1.5	1.0
1981	1,310,000	2.5	1.5	1.0
1982	1,320,000	2.5	1.5	1.0
1983	1,330,000	2.5	1.5	1.0
1984	1,340,000	2.5	1.5	1.0
1985	1,350,000	2.5	1.5	1.0
1986	1,360,000	2.5	1.5	1.0
1987	1,370,000	2.5	1.5	1.0
1988	1,380,000	2.5	1.5	1.0
1989	1,390,000	2.5	1.5	1.0
1990	1,400,000	2.5	1.5	1.0

Notes: 1. The population figures are based on the 1950 census and are assumed to be constant throughout the period. 2. The birth rate is assumed to be constant at 2.5 per 1,000. 3. The death rate is assumed to be constant at 1.5 per 1,000. 4. The net growth rate is calculated as the difference between the birth rate and the death rate.

Table 111. MCM DEMONSTRATION WITH VARIOUS CATALYSTS IN MCM

Period: September-November 1968
 Conditions: 10 atm pressure; catalysts reduced in H_2 for 20 minutes at 750°F; and samples normally taken at 5, 8, and 15 minute operation at each block temperature.
 Catalyst Volume: 0.9 ml catalyst diluted with 1.1 ml quartz chips; 100/100 (catalyst and quartz 10-20 mesh unless otherwise noted)

Run	Catalyst	Temp (°F)	Conversion (%)			
			5 min	8 min	15 min	Avg
1	100/100	750	10	15	20	15
2	100/100	750	12	18	22	17
3	100/100	750	14	20	24	19
4	100/100	750	16	22	26	21
5	100/100	750	18	24	28	23
6	100/100	750	20	26	30	25
7	100/100	750	22	28	32	27
8	100/100	750	24	30	34	29
9	100/100	750	26	32	36	31
10	100/100	750	28	34	38	33
11	100/100	750	30	36	40	35
12	100/100	750	32	38	42	37
13	100/100	750	34	40	44	39
14	100/100	750	36	42	46	41
15	100/100	750	38	44	48	43
16	100/100	750	40	46	50	45
17	100/100	750	42	48	52	47
18	100/100	750	44	50	54	49
19	100/100	750	46	52	56	51
20	100/100	750	48	54	58	53
21	100/100	750	50	56	60	55
22	100/100	750	52	58	62	57
23	100/100	750	54	60	64	59
24	100/100	750	56	62	66	61
25	100/100	750	58	64	68	63
26	100/100	750	60	66	70	65
27	100/100	750	62	68	72	67
28	100/100	750	64	70	74	69
29	100/100	750	66	72	76	71
30	100/100	750	68	74	78	73
31	100/100	750	70	76	80	75
32	100/100	750	72	78	82	77
33	100/100	750	74	80	84	79
34	100/100	750	76	82	86	81
35	100/100	750	78	84	88	83
36	100/100	750	80	86	90	85
37	100/100	750	82	88	92	87
38	100/100	750	84	90	94	89
39	100/100	750	86	92	96	91
40	100/100	750	88	94	98	93
41	100/100	750	90	96	100	95
42	100/100	750	92	98	100	97
43	100/100	750	94	100	100	99
44	100/100	750	96	100	100	100
45	100/100	750	98	100	100	100
46	100/100	750	100	100	100	100
47	100/100	750	100	100	100	100
48	100/100	750	100	100	100	100
49	100/100	750	100	100	100	100
50	100/100	750	100	100	100	100
51	100/100	750	100	100	100	100
52	100/100	750	100	100	100	100
53	100/100	750	100	100	100	100
54	100/100	750	100	100	100	100
55	100/100	750	100	100	100	100
56	100/100	750	100	100	100	100
57	100/100	750	100	100	100	100
58	100/100	750	100	100	100	100
59	100/100	750	100	100	100	100
60	100/100	750	100	100	100	100
61	100/100	750	100	100	100	100
62	100/100	750	100	100	100	100
63	100/100	750	100	100	100	100
64	100/100	750	100	100	100	100
65	100/100	750	100	100	100	100
66	100/100	750	100	100	100	100
67	100/100	750	100	100	100	100
68	100/100	750	100	100	100	100
69	100/100	750	100	100	100	100
70	100/100	750	100	100	100	100
71	100/100	750	100	100	100	100
72	100/100	750	100	100	100	100
73	100/100	750	100	100	100	100
74	100/100	750	100	100	100	100
75	100/100	750	100	100	100	100
76	100/100	750	100	100	100	100
77	100/100	750	100	100	100	100
78	100/100	750	100	100	100	100
79	100/100	750	100	100	100	100
80	100/100	750	100	100	100	100
81	100/100	750	100	100	100	100
82	100/100	750	100	100	100	100
83	100/100	750	100	100	100	100
84	100/100	750	100	100	100	100
85	100/100	750	100	100	100	100
86	100/100	750	100	100	100	100
87	100/100	750	100	100	100	100
88	100/100	750	100	100	100	100
89	100/100	750	100	100	100	100
90	100/100	750	100	100	100	100
91	100/100	750	100	100	100	100
92	100/100	750	100	100	100	100
93	100/100	750	100	100	100	100
94	100/100	750	100	100	100	100
95	100/100	750	100	100	100	100
96	100/100	750	100	100	100	100
97	100/100	750	100	100	100	100
98	100/100	750	100	100	100	100
99	100/100	750	100	100	100	100
100	100/100	750	100	100	100	100

1. Catalysts were reduced in H_2 for 20 minutes at 750°F.
 2. Samples were normally taken at 5, 8, and 15 minute operation at each block temperature.
 3. Catalyst and quartz 10-20 mesh unless otherwise noted.

Table III. MCH DEMETHYLOXIMATION WITH VARIOUS CATALYSTS IN MCHTP: H₂O 1:1

Period: March-August, 1969
 Conditions: 10 atm pressure; catalysts reduced in hydrogen at 726°F, GLC samples taken normally at 3-, 8- and 13-minute operation at each temperature
 Volume: 0.9 ml catalyst diluted with 1.1 ml quartz chips (10-20 mesh). LHSV 100 with MCH

Run No.	Catalyst Number	Description	5 MCH Conversion, %			
			3 min	8 min	13 min	18 min
105	1050-001	15 Pt/50 Rhodium type 1 support 100 type 1 support on No. 212 (1 type 212 Rhodium)	0.272	21, 20, 20	50, 48, 47	50, 48, 48
107	1050-002	15 Pt/50 Rhodium type 1 support 100 type 1 support on No. 212 (1 type 212 Rhodium)	0.272	20, 20, 20	50, 51, 49	50, 51, 51
108	1050-01	1.05 metal type 1 support	0.284	0, 0	0, 0	3, 3, 3
109	1050-01A	1.05 metal type 1 support	0.278	0, 0	0	0, 3, 3
110	1050-01B	Platinum, 2, 3.00 type 1 support	0.726	29, 28, 28	48, 45, 48	49, 41, 51
111	1050-01C	Platinum, 2, 3.00 type 1 support	0.725	28, 28, 28	51, 51, 51	50, 51, 51
112	1050-01D	Platinum, 2, 3.00 type 1 support	0.725	28, 28, 28	51, 51, 51	50, 50, 50
113	1050-01E	Platinum, 2, 3.00 type 1 support	0.726	25, 24, 23	50, 47, 46	50, 50, 50
114	1050-01F	Platinum, 2, 3.00 type 1 support	0.724	0	0, 0, 0	3, 12, 3
115	1050-01G	Platinum, 2, 3.00 type 1 support	0.726	28, 28, 28	51, 52, 52	51, 51, 51
116	1050-01H	Platinum, 2, 3.00 type 1 support	0.725	14, 17, 17	51, 51, 51	51, 51, 51
117	1050-01I	15 Pt/50 Rhodium type 1 support	0.272	21, 21, 21	47, 46, 46	50, 50, 50
118	1050-01J	Platinum, 2, 3.00 type 1 support	0.726	11, 11, 11	29, 28, 28	51, 51, 51
119	1050-01K	Platinum, 2, 3.00 type 1 support	0.726	29, 28, 28	52, 50, 48	51, 51, 51
120	1050-01L	Platinum, 2, 3.00 type 1 support	0.725	21, 21	0, 0, 0	10, 0, 0
121	1050-01M	Platinum, 2, 3.00 type 1 support	0.813	33, 31, 31	50, 49, 49	50, 49, 49
122	1050-01N	Platinum, 2, 3.00 type 1 support	0.724	28, 28, 28	50, 48, 48	50, 48, 48
123	1050-01O	Platinum, 2, 3.00 type 1 support	0.725	28, 28, 28	50, 48, 48	50, 48, 48
124	1050-01P	Platinum, 2, 3.00 type 1 support	0.724	28, 28, 28	50, 48, 48	50, 48, 48
125	1050-01Q	Platinum, 2, 3.00 type 1 support	0.724	14, 13, 11	43, 43, 43	44, 44, 44
126	1050-01R	Platinum, 2, 3.00 type 1 support	0.724	28, 21, 19	48, 47, 46	51, 51, 51
127	1050-01S	Platinum, 2, 3.00 type 1 support	0.724	0, 0, 0	79, 77, 75	77, 77, 77
128	1050-01T	15 Pt/50 Rhodium type 1 support	0.271	19, 21, 21	47, 47, 46	50, 50, 50
129	1050-01U	15 Pt/50 Rhodium type 1 support	0.272	15, 14, 13	43, 43, 42	51, 51, 51
130	1050-01V	15 Pt/50 Rhodium type 1 support	0.272	20, 20, 20	48, 47, 46	50, 50, 50
131	1050-01W	Platinum, 2, 3.00 type 1 support	0.723	0, 0, 0	0, 0, 0	10, 11, 11
132	1050-01X	Platinum, 2, 3.00 type 1 support	0.722	28, 28, 28	51, 51, 51	50, 51, 51
133	1050-01Y	15 Pt/50 Rhodium type 1 support	0.272	28, 28, 28	51, 51, 51	50, 51, 51
134	1050-01Z	15 Pt/50 Rhodium type 1 support	0.271	28, 28, 28	51, 48, 48	51, 51, 51
135	1050-02A	Platinum, 2, 3.00 type 1 support	0.729	29, 27, 26	51, 51, 51	51, 51, 51
136	1050-02B	Platinum, 2, 3.00 type 1 support	0.726	120, 11, 28	50, 52, 52	50, 51, 50
137	1050-02C	Platinum, 2, 3.00 type 1 support	0.718	35, 30, 28	50, 50, 51	50, 50, 50
138	1050-02D	Platinum, 2, 3.00 type 1 support	0.726	19, 20, 19	51, 48, 46	50, 50, 50
139	1050-02E	Platinum, 2, 3.00 type 1 support	0.648	27, 24, 24	47, 46, 46	47, 47, 47
140	1050-02F	15 Pt/50 Rhodium type 1 support 100 type 1 support on No. 212 (1 type 212 Rhodium)	0.280	20, 20, 20	50, 49, 48	50, 51, 51
141	1050-02G	15 Pt/50 Rhodium type 1 support 100 type 1 support on No. 212 (1 type 212 Rhodium)	0.280	20, 21, 20	50, 50, 49	50, 50, 50
142	1050-02H	15 Pt/50 Rhodium type 1 support 100 type 1 support on No. 212 (1 type 212 Rhodium)	0.247	20, 21, 20	50, 51, 49	51, 51, 51
143	1050-02I	15 Pt/50 Rhodium type 1 support 100 type 1 support on No. 212 (1 type 212 Rhodium)	0.246	21, 21, 21	51, 48, 47	50, 51, 51
144	1050-02J	15 Pt/50 Rhodium type 1 support	0.232	21, 21, 21	46, 45, 46	49, 51, 49

(Continued)

Table 132 (Cont'd-1). NCH DEHYDROGENATION WITH VARIOUS CATALYSTS IN MECE: RUNS 906-1000

No.	Date	Description	Amount			
			Debit	Credit	Balance	Check
1	1900-01-01	Balance				
2	1900-01-05	1000.00	1000.00			
3	1900-01-10	500.00		500.00		
4	1900-01-15	250.00	250.00			
5	1900-01-20	750.00		750.00		
6	1900-01-25	100.00	100.00			
7	1900-01-30	300.00		300.00		
8	1900-02-05	150.00	150.00			
9	1900-02-10	400.00		400.00		
10	1900-02-15	200.00	200.00			
11	1900-02-20	600.00		600.00		
12	1900-02-25	100.00	100.00			
13	1900-03-01	350.00		350.00		
14	1900-03-05	180.00	180.00			
15	1900-03-10	520.00		520.00		
16	1900-03-15	220.00	220.00			
17	1900-03-20	700.00		700.00		
18	1900-03-25	120.00	120.00			
19	1900-04-01	450.00		450.00		
20	1900-04-05	280.00	280.00			
21	1900-04-10	650.00		650.00		
22	1900-04-15	110.00	110.00			
23	1900-04-20	380.00		380.00		
24	1900-04-25	190.00	190.00			
25	1900-05-01	580.00		580.00		
26	1900-05-05	240.00	240.00			
27	1900-05-10	720.00		720.00		
28	1900-05-15	130.00	130.00			
29	1900-05-20	420.00		420.00		
30	1900-05-25	210.00	210.00			
31	1900-06-01	620.00		620.00		
32	1900-06-05	100.00	100.00			
33	1900-06-10	360.00		360.00		
34	1900-06-15	170.00	170.00			
35	1900-06-20	550.00		550.00		
36	1900-06-25	260.00	260.00			
37	1900-07-01	740.00		740.00		
38	1900-07-05	140.00	140.00			
39	1900-07-10	410.00		410.00		
40	1900-07-15	230.00	230.00			
41	1900-07-20	610.00		610.00		
42	1900-07-25	110.00	110.00			
43	1900-08-01	390.00		390.00		
44	1900-08-05	200.00	200.00			
45	1900-08-10	690.00		690.00		
46	1900-08-15	120.00	120.00			
47	1900-08-20	430.00		430.00		
48	1900-08-25	220.00	220.00			
49	1900-09-01	630.00		630.00		
50	1900-09-05	100.00	100.00			
51	1900-09-10	370.00		370.00		
52	1900-09-15	180.00	180.00			
53	1900-09-20	560.00		560.00		
54	1900-09-25	270.00	270.00			
55	1900-10-01	750.00		750.00		
56	1900-10-05	150.00	150.00			
57	1900-10-10	440.00		440.00		
58	1900-10-15					

(b) (5) DPP, (b) (5) ACP

Table 111 (Cont'd-3). MCH DEHYDROGENATION WITH VARIOUS
CATALYSTS IN MCH: PUMP 400-1000

Run No.	Catalyst Number	Description	5-HR Conversion, %			
			70°F	80°F	90°F	100°F
1070	1080-109	15 Pt/200 0-6 type Al ₂ O ₃ (ref.)	0.434	27. 24. 25	50. 46. 48	79. 77. 71
1080	1080-109	15 Pt/type 1 support	0.497	25. 24. 26	49. 47. 48	73. 73. 70
1091	1080-109	15 Pt/200 0-6 type Al ₂ O ₃ (ref.)	0.433	27. 25. 26	51. 47. 46	73. 71. 70
1092	1080-109	25 Pt/100 type 1 support 100 type 1 support 200 type 6 binder	0.382	24. 23. 25	38. 30. 30	62. 51. 50
1093	1080-109	25 Pt/100 type 1 support 100 type 1 support 200 type 6 binder	0.438	24. 24. 26	38. 36. 33	65. 60. 58
1094	1080-109	25 Pt/100 type 1 support 100 type 1 support 200 type 6 binder	0.480	25. 24. 27	46. 37. 36	64. 59. 56
1095	1080-109	15 Pt/100 type 1 support 100 type 1 support 200 type 6 binder	0.465	24. 24. 26	51. 38. 38	72. 58. 59
1096	1080-109	15 Pt/200 0-6 type Al ₂ O ₃ (ref.)	0.432	27. 26. 25	51. 48. 46	73. 73. 71
1097	1080-109	100 Pt/100 type 1 support (ref.) 100 type 1 support 200 type 6 binder Tube No. 26		25. (25). 23	39. 36. 37	70. 68. 69
1098		Same tube No. 26 filled with 200 Pt/100 0-6 binder	0.433			
1099	1080-1113	15 Pt/100 type 1 support 100 type 1 support 200 type 6 binder	0.508	25. 25. 23	55. 51. 51	80. 81. 82
1100	1080-1113	25 Pt/100 type 1 support 100 type 1 support 200 type 6 binder	0.548	29. 27. 27	46. 36. 36	62. 63. 59
1101	1080-1112	25 Pt/100 type 1 support 100 type 1 support 200 type 6 binder	0.465	27. 25. 21	49. 47. 48	70. 65. 74
1102	1080-1112	25 Pt/100 type 1 support 100 type 1 support 200 type 6 binder	0.470	26. 26. 19	55. 37. 33	60. 63. 63
1103	1080-1112	15 Pt/100 type 1 support 100 type 1 support 200 type 6 binder	0.538	34. 30. 29	58. 35. 35	64. 61. 60
1104	1080-1110	25 Pt/100 type 1 support 100 type 1 support 200 type 6 binder	0.584	29. 26. 27	46. 35. 35	63. 63. 60
1105	1080-1110	15 Pt/100 type 1 support 100 type 1 support 200 type 6 binder	0.585	26. 26. 27	37. 34. 36	61. 62. 60
1106	1080-1111	25 Pt/100 type 1 support 100 type 1 support 200 type 6 binder	0.588	25. 24. 26	50. 30. 30	73. 65. 68
1107	1080-7	Tube No. 26 coated with: 5.00 Pt/100 type 1 support 100 type 1 support 200 5.0g		25. 23. 28	39. 36. 37	70. 68. 68
1108	1080-7	Tube No. 26 coated with: 5.00 Pt/100 type 1 support 100 type 1 support 200 5.0g		17. 26. 24	39. 39. 38	60. 61. 61
1109	1080-7	Tube No. 26 coated with: 5.00 Pt/100 type 1 support 100 type 1 support 200 5.0g After exp. 1097 Catalyst chamber filled with usual charge of reference catalyst	0.438	25. 25. 26	63. 60. 60	88. 76. 82
1110	1080-109	15 Pt/200 0-6 type Al ₂ O ₃ (ref.)	0.432	27. 26. 26	49. 47. 46	73. 71. 70
1111	1080-1114	15 Pt/100 type 1 support	0.751	24. 26. 28	27. 33. 33	68. 66. 66
1112	1080-1114	15 Pt/100 type 1 support	0.460	27. 27. 25	46. 44. 46	60. 63. 63

- Bracketed numbers 5 indicate, unbracketed numbers 5 conversion of MCH to toluene and benzene.
- Heated in air at 1100°F before reduction in H₂.
- Support with 5.00 metal dried at 700°F before impregnation with the usual metal.
- Support with 5.00 metal, dried at 1200°F in air.
- 100% H₂.
- 100% H₂ reduced from the support.
- Different heteropoly acid than used for comparable catalysts.
- Heated in air at 1200°F.
- Compared with No. 70 only.
- Heated in air at 1200°F.
- Heated in air at 1200°F.
- Heated with ethylene diamine.
- Heated metal, neutralized.
- Heated in air at 1200°F.
- Name of Run No. 730 (Table 1).
- Same as Run No. 730.
- Same as Run No. 730.
- Same as Run No. 730.
- Four separate impregnations, first three thermal decomposition at 700°F, after each impregnation.

Measurement of Deposits on Coker Tubes With Nuclear Radiation^{a)}

Presented here is a summary to date of the results and thoughts that have gone into the application of nuclear radiation as a tool for the evaluation of coker tube deposits. Covered are the general principles, electron scattering theory, preliminary experiments, trial apparatus and results, and proposed permanent instrument design. Electron backscatter appears to be the most promising approach and is the method of primary concern in the work presented here.

Thin Film Measurement With Nuclear Radiation General Principles

Thin film measurement with nuclear radiation can be accomplished either by transmission or scatter of the radiation. The problem is to select the best type and energy of radiation and guidelines to such selection that are available.^{56/57)} The deposits of interest have a surface density in the neighborhood of 10^{-5} g/cm² equivalent to an air path of only .01 cm. This implies an arrangement based on scattering rather than absorption and the probable need of vacuum operation. Possible types of radiation applicable in the present case are summarized in the table below.

Table 134. METHODS OF UTILIZING NUCLEAR RADIATION

Type	Source Radiation	Detected Radiation	Operation	Remarks
1	α	α	alpha backscatter	Low scattering coefficient, requires very high intensity source.
2	α	x	x-ray fluorescence in coker tube	Possible method. Efficiency very dependent on tube metal.
3	β	β	beta backscatter	Preferred method.
4	β	x	x-ray fluorescence	Similar to method 2.
5	x	x	x-ray backscatter	Low efficiency.
6	x	x	x-ray fluorescence	Low efficiency.

The conclusion from this list is that electron scattering is preferred but other factors, not listed, also lead to the same conclusion. Should an alternative method be considered for investigation the use of fluorescence from alpha bombardment is probably the most promising. A transmission type of measurement is possible if radioactivity is introduced, by plating for example, onto the coker tube. This method, suggested by H. Siegel, is

a) Acknowledgment is made to Dr. R. Curtis of the Analytical Department for this work.

preferable from the point of view of measurement to any of those listed above, but the handling of radioactive tubes is a sufficient deterrent to exclude the method.

Electron Backscatter Theory

An approximate description of the relative backscattered electron flux to be expected from a coating of thickness x (g/cm^2) on a base of effectively infinite thickness is given by Tittle³⁸ as:

$$\frac{I}{I_0} = \frac{\beta_1}{\mu_1 + \lambda_1} \left[1 - e^{-(\mu_1 + \lambda_1)x} \right] + \frac{\beta_2}{\mu_1 + \lambda_2} e^{-(\mu_1 + \lambda_2)x} \quad (53)$$

The constants μ , λ , and β depend upon the materials involved and the maximum beta energy, subscripts 1 and 2 referring to the coating and base respectively, and 3 to properties of both. From relations given by Tittle equation (53) in the approximation of small x can be expressed as:

$$\begin{aligned} \frac{I}{I_0} = & \left(1 - e^{-Z_2/40} \right) + \frac{35x}{E^{1.16}} \left[\left(\frac{Z_1}{A_1} \right) \left(\frac{331 + Z_1}{106 + Z_1} \right) \left(1 - e^{-Z_1/40} \right) - \right. \\ & \left. \left(\frac{Z_1}{A_1} + \frac{50Z_1 + 0.31}{106 + Z_2} \right) \left(1 - e^{-Z_2/40} \right) \right] \end{aligned} \quad (54)$$

in which Z_1 and A_1 are the atomic number and atomic mass of the coating, Z_2 the atomic number of the substrate, and E is the maximum beta energy in Mev. Approximating the deposit composition by $Z_1/A_1 = 0.56$ and $Z_1 = 5.9$ on an aluminum ($Z_2 = 13$) base gives

$$\frac{I}{I_0} = 0.28 - \frac{4.4x}{E^{1.16}} \quad (55)$$

as the ratio of scattered to incident flux. The statistics of counting and the general level of instrumental variables is such that it is not practical to measure a change dI/I_0 of much less than 1%. Equation (55) then predicts a maximum energy of 1.1 Kev in order to detect a thickness change dx of 10^{-6} cm, assuming unit density for the deposit. Some idea of the range of thickness measurable with this energy is obtained by equating (55) to zero with the result $x = 3.10^{-5}$ g/cm^2 . This prediction indicates the need of a very low energy source though perhaps not as low as 1 Kev if the expected range of thickness (up to 10^{-6} cm) is to be covered. Possible sources that are available are listed in Table 135. None of these sources is as low in energy as might be desired, but the least energetic sources should provide a useable compromise since even ^{24}C is capable of showing some response to the heavier deposits.

Table 135. LOW ENERGY BETA SOURCES

Isotope	Half Life, Years	E _{max.} , Kev	Range in Air, cm
²¹⁰ Pb	21	17	0.4
³ H	12	19	0.5
⁶³ Ni	85	67	5.5
¹⁴ C	5700	155	26.0

Though not immediately apparent, equation (54) dictates that the replacement of aluminum with any metal of higher atomic number will produce an increased response to a given deposit. The method depends on the difference, primarily in atomic number, between coating and base. This difference is not large with aluminum so that a successful measurement in this case assures success with heavier metals.

Preliminary Experiments

Initial tests were aimed at answering three questions: whether operation without a vacuum was feasible, whether to minimize absorption a windowless flow counter was practical, and what magnitude of response would be observed in practice. To this end a small counter was constructed (courtesy A. Telfer) from one inch brass tubing with a wedge shaped end opening approximately one mm wide. As a source ⁶³Ni, having a reasonable penetration in air, was utilized in the form of the chloride adsorbed on a strip of filter paper mounted near the counter entrance. Tests were made using a 3/16" aluminum rod covered with various thicknesses of mylar film and mounted 1/2 cm from the counter.

This arrangement was unsatisfactory in several respects. One difficulty, not unexpected, was a large dependence of count rate upon counter gas flow rate. This could be controlled, but drift beyond this factor occurred that could not be accounted for. Stability was sufficient to show a count difference for one mil mylar film but was wholly inadequate for the detection of deposit films. In short, it was concluded that vacuum operation, which would require a thin window counter, was necessary and that a lower energy beta source was essential.

Trial Apparatus and Results

The bell jar and forepump portion of a vacuum deposition apparatus were utilized in the following measurements. Feedthroughs in the base were provided for piping the flow of counter gas, the high voltage lead to the detector, and a slide fitting to which the cocker tube could be attached. This slide fitting allowed translation and rotation of the cocker tube in front of the source and detector for scanning the deposit area.

A locally constructed thin window flow counter^{a)} was used as detector. This window is exposed via a $3/32 \times 5/8$ " slot cut in a one inch diameter faceplate. The source was mounted directly on this face about $1/4$ " from the slot. The source itself was a $1/8 \times 1/4$ " section of a neutron generator target arranged with a rather simple collimator fashioned from aluminum foil. The source-to-scatterer and scatterer-to-detector distance was 2.5 cm.

The associated electronics consisted of a Baird-Atomic Model 530 Spectrometer and Printer which provides the necessary functions of high voltage supply, pulse amplifier, discriminator, counter, and timer. Originally the high voltage was carried into the vacuum to the detector through a shielded cable, but this proved unsatisfactory. Attempts at shielding and insulating were not sufficient to eliminate corona and discharge in the vacuum with resultant spurious counting. A sufficiently hard vacuum to eliminate this problem was not practical. Instead, the high voltage lead and connection to the detector were enclosed in copper tubing and arranged to remain at atmospheric pressure.

The beta source used produces as well, some x-rays. These contribute to the scattered flux which is detected and produces a background counting rate even at atmospheric pressure. As the air pressure is reduced, a point is reached where the mean free path of the scattered electrons is sufficient for them to reach the detector and be counted. It was anticipated that a maximum count rate would be reached at some pressure and that this rate would remain constant below this pressure where essentially all electrons that could be scattered toward the detector would reach it. Instead, it was found that the count rate reached a maximum and then decreased with increasing vacuum. This maximum occurred at a pressure of approximately 25 torr while below $1/2$ torr the count rate was independent of pressure. Apparently, as the pressure is reduced there is a maximum in count rate when the coker tube, bell jar wall, and residual atmosphere all contribute to the scattering and further evacuation diminishes the air scatter more rapidly than the increased scatter from wall and coker tube. As long as the pressure remains under $1/2$ torr this presents no difficulty.

The coker tubes used in this study are of a miniature variety, the section of interest being $2-1/2$ " long and $1/8$ " diameter between end sections of $3/16$ " diameter. The deposit generally covers only a portion of the central tube section, being lightest (visually) near one shoulder, increasing in darkness toward the center of the tube and ending fairly abruptly to leave apparently bare metal beyond this point. The scattered intensity measured along such a tube is shown in Figure 83. Each point in the figure represents a 20 second count. The scatter of these points from a smooth curve is primarily due to statistical variations in counting. The rate corresponding to an uncoated tube is about 300 c/s, while on the wider tube section beyond the shoulder it is approximately 350 c/s. While the deposit in this example is a rather heavy one by visual inspection there appears to be ample sensitivity in the backscatter response. This is particularly true considering two simple improvements that could easily be introduced. The first involves better collimation of the incident beta flux to improve resolution of the

a) A. Telfer, "A Flow-Proportional Counter for Soft x-Rays", Emeryville Technical Progress Report 271-64.

Deposit profile, the present arrangement viewing about 112 cm of tube at a time. The second improvement incorporates a collimator over the detector window the purpose of which is to reduce background scatter from the bell jar. This background involves both x-ray and electron scatter and amounts to about 100 c/s in the absence of a sample tube.

Results with a group of coke tubes are given in Figure 84. Again a 20 sec count was made at each point, but with the limited number of points involved a good approximation to the profile is acquired in roughly 3 min. The two curves for each sample are scans along opposite sides of the tubes. The horizontal line to the right of each curve is an adjusted rate of 300 c/s. This adjustment was necessary because of an unexplained drift, possibly arising from the electronics, which could be corrected for each scan by returning to the starting position, but which is more difficult to correct for in going from tube to tube.

Calibration points for establishing a thickness scale were obtained using mylar film and by coating a tube with films of solution cast nitrocellulose. The mylar film (1/8 mil) is approaching infinite scattering thickness which simply means that the aluminum rod no longer contributes to the scattering. At this point the count rate has dropped from 300 to 200 c/s. Reasonably consistent results were obtained with 1, 2 and 4000A of film. Applied to the five tubes in Figure 84 this gives the following results as shown in Table 136.

$$\frac{I}{I_0} = 1 - e^{-Z_2/40} + \frac{35x}{E^{1.14}} \left[\frac{Z_1}{A_1} \left(\frac{331 + Z_1}{106 + Z_1} \right) \left(1 - e^{-Z_1/40} \right) - \left(\frac{Z_1}{A_1} + \frac{409 Z_1^{0.31}}{106 + Z_2} \right) \left(1 - e^{-Z_2/40} \right) \right]$$

For Aluminum base $Z_2 = 13$ $x = \text{film thickness, g/cm}^2$

$$\frac{I}{I_0} = 0.2775 + \frac{35x}{E^{1.14}} \left[\frac{Z_1}{A_1} \left(\frac{331 + Z_1}{106 + Z_1} \right) \left(1 - e^{-Z_1/40} \right) - \left(\frac{Z_1}{A_1} + 4.195 Z_1^{0.31} \right) (0.2775) \right]$$

Composition	Z_1	Z_1/A_1	$Z_1^{0.31}$	$1 - e^{-Z_1/40}$	I_0	% Change ^{a)}
CH = 7.74% H	5.613	.5383	1.707	.1309	1.914	-
CH ₂ = 14% H	5.23	.572	1.675	.1237	1.898	-2.0
CHO. ₂₅ = 23.5% O	6.18	.529	1.758	.1432	1.965	+1.5
CHS. ₀₅ = 11% S	6.75	.534	1.808	.1553	2.005	+3.5
CHFe. ₀₁ = 4.1% Fe	6.46	.535	1.784	.1492	1.985	+2.5
CHPb. ₀₀₁ = 1.4% Pb	6.64	.519	1.798	.1530	1.997	+3.1

a) Scaled with CH as reference.

n = st. no.

A = Avg at. wt. of coating

w = wt. fraction

E = max energy of source, MEV

$$Z_1 = Ew_1Z_1$$

$$\frac{Z_1}{A_1} = Ew_1 \frac{Z_1}{A_1}$$

Tritium = .019 (must be a very soft source)

Table 136. RESULTS ON FIVE COVER TUBES

Fuel No.	Max Count Rate Decrease	Max Film Thickness, A°	Approx Total ^{a)} Deposit, A° x cm	Visual Ratings	
				Max	Avg
1	85 c/s	5000	6000	7.0	1.3
2	70	4500	7000	6.5	1.5
3	20	1200	1500	4.0	1.6
4	50	3000	4000	6.5	1.8
5	125	8000	6000	6.5	1.0

a) Multiplication by tube circumference (1.0 cm) will give total deposit volume.

There is little agreement with the visual ratings. The scattering results are, of course, reproducible and independent of operator judgment.

The deposit composition in calculations with equation (54) was assumed to be $CH_2O_{.25}$. It can approach $CHO_{.25}$ and may contain up to 5% sulfur. Again the effects of composition changes in the deposit on the scattered intensity can be estimated at least roughly from this equation. The main effect from composition changes is in the average for Z . Starting with $CH_2O_{.25}$ and going to $CH_2O_{.25}S_{.05}$, that is, adding 8% sulfur is equivalent to a 2% change in apparent thickness. The dependence on sulfur or any other heavier element is large, as expected, but film measurement within 2% that does not depend on composition is still far superior to visual estimates.

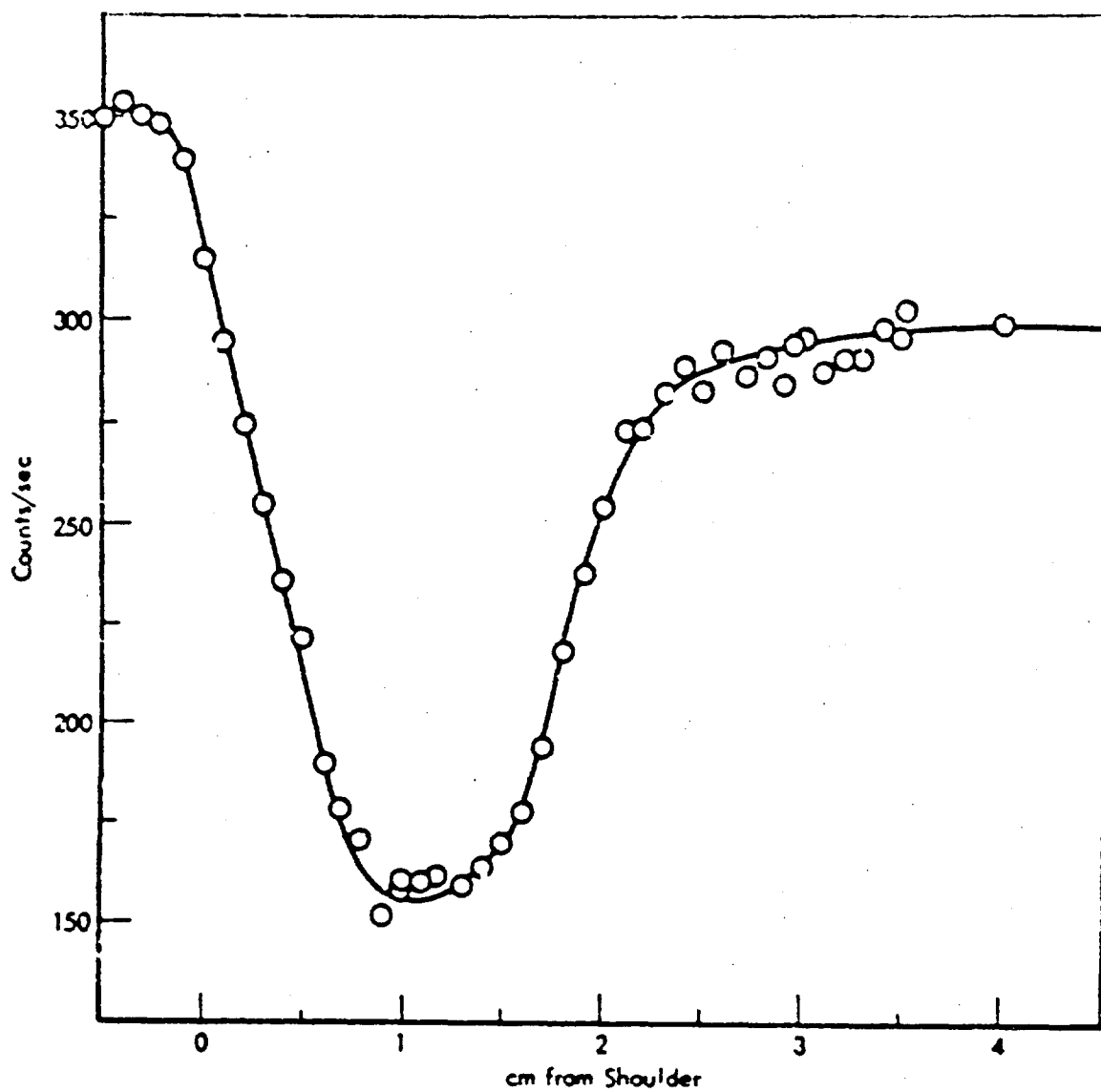


Figure 83. COKER TUBE DEPOSIT PROFILE

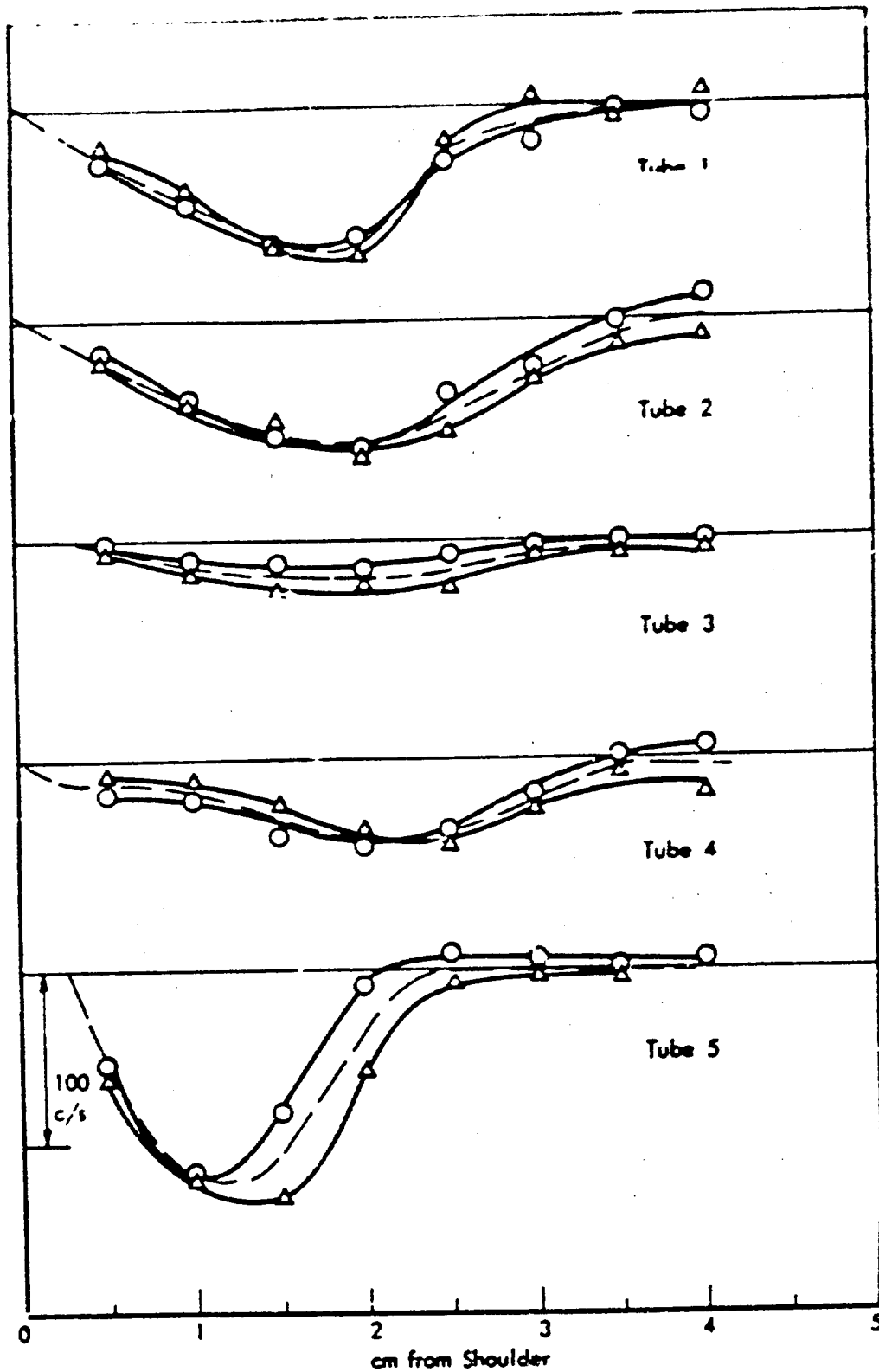


Figure 84. COMPARISON OF DEPOSIT TUBE PROFILES

Proposed Instrument Design

The results observed above demonstrate the feasibility of electron backscatter as a means of quantitative measurement of coke tube deposits. Several conveniences can, however, be incorporated in a practical instrument. These include automatic scanning and recording of the profile and a convenient vacuum assembly.

In respect to scanning it may be convenient to integrate or average readings around the tube circumference so that a one-dimensional average along the tube length is obtained. This can be achieved in either of two ways. With a point source and detector arrangement and a ratemeter output the tube can be rotated with a period less than the time constant of the ratemeter while being translated along its length. A motor driven screw motion would achieve this. The alternative is to arrange both source and cylinder in the form of rings surrounding the rod. Actually, a triangular array would provide a sufficient approximation to a continuous ring. The main cost increase would be in respect to three detectors. The source and electronics cost increase is trivial. In this way only a linear motion need be applied to the sample tube and eccentricity is averaged out.

For the vacuum assembly it may be most convenient to adapt a commercially available apparatus involving a bell jar. But a smaller volume would allow quicker pumping down and would be more compact. This could be in the form of a tube sufficiently long for sample translation and of perhaps 3" ID. An internal motor drive would move the sample placed on a suitable carriage. Source and detector would be mounted in the mid-section wall of the tube with collimation on the source and on the detector to reduce extraneous backscatter. Electrical connections would then all be at atmospheric pressure.

[illegible]

NAME: _____

[illegible]

TRIP	VAPOR PRESS.	ENTHALPY, BTU/LB	ENTHALPY, BTU/LB	ENTHALPY, BTU/LB	SPEC. HEAT AT COND. P.	DEWPOINT, F	WETBULB TEMP., F	RELATIVE HUMIDITY	WETBULB TEMP., F
-90	4.769E-03	1.627E+02	0.518E+01	-7.769E-02	2.191E-01	4.640E+01	9.199E-02	1.637E+02	1.637E+02
0	1.797E-03	1.667E+02	0.302E+01	0.670E+00	3.237E-01	9.313E+01	9.213E-02	1.697E+02	1.697E+02
10	3.669E-02	1.718E+02	1.718E+01	0.680E+00	3.195E-01	9.341E+01	9.151E-02	1.779E+02	1.779E+02
150	9.621E-02	1.837E+02	9.366E+01	1.319E+01	0.349E-01	9.434E+01	0.424E-02	2.149E+02	2.149E+02
190	2.717E-01	1.969E+02	1.896E+01	1.496E-01	0.469E-01	9.509E+01	0.262E-02	2.567E+02	2.567E+02
250	7.345E-01	1.919E+02	0.070E+01	2.643E-01	0.499E-01	9.179E+01	0.277E-02	2.711E+02	2.711E+02
300	1.073E+00	1.869E+02	1.961E+02	7.962E-01	9.349E-01	9.839E+01	0.279E-02	1.967E+02	1.967E+02
360	4.766E-00	1.313E+02	1.314E+02	3.496E+01	0.614E-01	0.000E+01	1.216E-02	0.942E+02	0.942E+02
400	1.669E+01	1.240E+02	1.677E+02	3.669E+01	0.260E-01	9.799E+01	0.873E+02	7.791E+02	7.791E+02
460	2.216E+01	1.177E+02	1.975E+02	0.402E-01	0.774E-01	0.630E+01	7.601E+02	9.421E+02	9.421E+02
500	4.090E+01	1.696E+02	2.261E+02	4.859E-01	7.237E-01	0.679E+01	6.927E+02	6.366E+02	6.366E+02
560	0.697E+01	1.011E+02	0.622E+02	9.294E-01	7.743E-01	0.364E+01	9.293E+01	7.167E+02	9.293E+01
600	1.073E+02	9.171E+01	2.993E+02	9.766E-01	0.367E-01	4.162E+01	4.896E+01	6.474E+02	6.474E+01
660	1.967E+02	6.193E+01	3.324E+02	0.116E-01	0.969E-01	3.014E+01	3.166E+01	4.297E+02	4.297E+01
700	2.175E+02	0.942E+01	3.719E+02	0.319E-01	0.979E-01	3.667E+01	4.643E+01	3.649E+02	3.649E+01
750	2.866E+02	9.436E+01	4.122E+02	0.928E-01	1.187E+02	3.162E+01	1.917E+01	3.963E+02	3.963E+01
800	3.777E+02	3.470E+01	4.909E+02	7.349E-01	1.766E+02	2.612E+01	1.366E+01	3.379E+02	3.379E+01

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姓名: 王德明 性别: 男 年龄: 45 职业: 教师 单位: 某某中学
 联系电话: 13800138000 电子邮箱: wangdeming@163.com

【参考文献】 1. 李树德, 李树德. 中国人口学. 北京: 中国人口出版社, 1998. 100-101.

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Sl. No.	Project Name	Project Type	Project Status	Project Manager	Project Start Date	Project End Date	Project Budget	Project Actual Cost	Project Variance	Project Risk	Project Impact
1	Project A	Software Development	Completed	John Doe	2020-01-01	2020-03-31	\$100,000	\$95,000	\$5,000	Low	High
2	Project B	Hardware Development	In Progress	Jane Smith	2020-04-01	2020-06-30	\$200,000	\$180,000	\$20,000	Medium	Medium
3	Project C	Cloud Migration	On Hold	Mike Johnson	2020-07-01	2020-09-30	\$150,000	\$100,000	\$50,000	High	Low
4	Project D	Mobile App Development	Completed	Sarah Lee	2020-10-01	2020-12-31	\$80,000	\$78,000	\$2,000	Low	Medium
5	Project E	Website Redesign	In Progress	David Kim	2021-01-01	2021-03-31	\$120,000	\$110,000	\$10,000	Medium	High
6	Project F	Database Optimization	Completed	Emily White	2021-04-01	2021-05-31	\$60,000	\$58,000	\$2,000	Low	Medium
7	Project G	Security Audit	On Hold	Chris Brown	2021-06-01	2021-08-31	\$90,000	\$40,000	\$50,000	High	Low
8	Project H	API Integration	In Progress	Alex Green	2021-09-01	2021-11-30	\$110,000	\$105,000	\$5,000	Medium	Medium
9	Project I	System Upgrade	Completed	Mia Black	2021-12-01	2022-01-31	\$130,000	\$125,000	\$5,000	Low	High
10	Project J	Network Expansion	In Progress	Noah Grey	2022-02-01	2022-04-30	\$160,000	\$150,000	\$10,000	Medium	Medium
11	Project K	Cloud Storage Migration	On Hold	Olivia Blue	2022-05-01	2022-07-31	\$140,000	\$80,000	\$60,000	High	Low
12	Project L	Mobile App Enhancement	Completed	Peter Red	2022-08-01	2022-09-30	\$70,000	\$68,000	\$2,000	Low	Medium
13	Project M	Website Performance Optimization	In Progress	Quinn Yellow	2022-10-01	2022-12-31	\$100,000	\$95,000	\$5,000	Medium	High
14	Project N	Database Security Audit	On Hold	Rachel Purple	2023-01-01	2023-03-31	\$80,000	\$30,000	\$50,000	High	Low
15	Project O	API Security Enhancement	In Progress	Sam Green	2023-04-01	2023-06-30	\$110,000	\$105,000	\$5,000	Medium	Medium
16	Project P	System Integration Project	Completed	Tina Blue	2023-07-01	2023-08-31	\$130,000	\$125,000	\$5,000	Low	High
17	Project Q	Network Security Upgrade	In Progress	Uma Red	2023-09-01	2023-11-30	\$160,000	\$150,000	\$10,000	Medium	Medium
18	Project R	Cloud Backup Migration	On Hold	Victor Yellow	2023-12-01	2024-01-31	\$140,000	\$80,000	\$60,000	High	Low
19	Project S	Mobile App Bug Fixes	Completed	Wendy Purple	2024-02-01	2024-03-31	\$70,000	\$68,000	\$2,000	Low	Medium
20	Project T	Website Content Management System	In Progress	Xavier Blue	2024-04-01	2024-06-30	\$100,000	\$95,000	\$5,000	Medium	High

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CONFIDENTIAL

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TABLE 1-1		TABLE 1-2	
SCHEDULE OF WORK		SCHEDULE OF WORK	
NO. OF WORKERS	NO. OF WORKERS	NO. OF WORKERS	NO. OF WORKERS
100	100	100	100
200	200	200	200
300	300	300	300
400	400	400	400
500	500	500	500
600	600	600	600
700	700	700	700
800	800	800	800
900	900	900	900
1000	1000	1000	1000

TABLE 1-3		TABLE 1-4	
SCHEDULE OF WORK		SCHEDULE OF WORK	
NO. OF WORKERS	NO. OF WORKERS	NO. OF WORKERS	NO. OF WORKERS
100	100	100	100
200	200	200	200
300	300	300	300
400	400	400	400
500	500	500	500
600	600	600	600
700	700	700	700
800	800	800	800
900	900	900	900
1000	1000	1000	1000

[illegible][illegible]

For 1999

1. The first step is to identify the problem or question that needs to be answered. This involves understanding the context and the specific requirements of the task.

U.S. AIR FORCE OFFICE OF SPECIAL INVESTIGATION

• 1994: 1st year, 1st semester

[illegible]

SECRET

Abstract

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86														

1998

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2000

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Year	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100
1990	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100

EXHIBIT (34-5)

Qualitative Analytical and Physical Property Data

Following are typical analytical data and calculated physical property information based on a variety of methods. Since only a limited number of samples of CHILLDYNE-H have been prepared, the consistency of the data from batch to batch has not been established. Also, pending larger scale preparations, we have not independently calculated the effect of temperature and pressure, outside the normal range, on various liquid and gaseous properties of interest. Instead we have applied corrections to the values calculated for CHILLDYNE itself, as given in the citation above, as deemed advisable.

The magnitudes of the correction factors involved are generally not large and we believe the data can be used without serious error. Improved information will be supplied as soon as it is available.

Table 1.1. Summary of Data

Physical and Chemical Properties of the Sample

	Typical Value	Test Method
Gravity, deg API	1.01	ASTM D-155
Specific Gravity	1.01	
Refractive Index, n_D^{20}	1.44	ASTM
Color	Water white	
Distillation temperature, °F		ASTM D-156
Initial boiling point	107	
1% Evaporated	115	
2% Evaporated	119	
5% Evaporated	122	
10% Evaporated	125	
End Point	127	
Loss, %	1.1	
Residue, %	0.9	
Sulfur, %	0.0001	ASTM D-129-47
Mercaptan sulfur, %	<0.001	ASTM D-129-47
Existent O ₂ , mg per 100 ml	1	ASTM D-129-47
Freezing point, °F	-45.0	ASTM D-156-57
Boiling point, °F	127	ASTM D-156-57
Net heat of combustion		ASTM D-156-57
Btu/lb	17,400	
Btu/gal	101,300	
Aromatic content, %	<0.1	ASTM D-129-47
Clarin content, %	1	D-129-47
Copper strip corrosion	1A	ASTM D-156-57
Viscosity, cs, at 100°F	13	ASTM D-156-57
0°F	215	
-30°F	1200	
Flash point, °F	120	ASTM D-156-57
Vapor pressure, psia at 300°F	0.5	
psia at 500°F	12	
Thermal stability, 5 hr	100%	ERC Modified
Pressure change, in. Hg	1.5	Standard Gaer
Preheater deposit rating	2-1/2	
Smoke point	0.5	D-156-57
Carbon/hydrogen ratio	9.8	Calculated
Critical temperature, °F	400	API 441.2
Critical pressure, psia	110	API 441.2
Heat of formation, Btu/lb	100	
Molecular weight	150.7	

- a) Generally fluid because of low viscosity; some samples have formed crystals at temperatures of about -30°F and below.
- b) 100% recycle color.
- c) All 100% point corrected as per API Figure M1.1.

Table 116. 114 IS PROPERTIES OF "E" ELEMENTS AT SATURATED PRESSURE

Temp. °F	Density, lb/ft ³	Viscosity, a) lb/ft-hr	Thermal conductivity, Btu/ft-hr-°F	Heat capacity, Btu/lb-°F	Enthalpy, Btu/lb	Heat of vaporization, Btu/lb	Vapor pressure, psia
-60	70.8	22000.	0.048	0.217	-14.5	151.9	0.0220
0	69.5	532.	0.036	0.257	0.0	145.5	0.0000
100	66.6	35.7	0.093	0.342	29.0	140.3	0.3011
200	63.8	8.78	0.090	0.307	64.5	135.7	0.0000
300	60.9	3.12	0.065	0.452	106.4	128.4	0.0000
400	57.8	1.41	0.079	0.507	154.4	120.4	2.97
500	54.5	0.752	0.072	0.559	207.7	111.5	11.30
600	50.9	0.432	0.064	0.606	266.0	101.3	32.9
700	46.7	0.341	0.057	0.651	328.8	88.9	76.2
800	41.7	0.238	0.048	0.702	396.3	72.9	153.0
900	34.2	0.135	0.040	0.818	470.9	46.8	278.0

a) To convert to cgs multiply by $\frac{25.8}{\text{density}}$.

Table 1. (Continued) Performance of the AFAPL-TR-07-114

Performance of the AFAPL-TR-07-114										
Year	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999
Performance of the AFAPL-TR-07-114										
1990	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1991	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1992	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1993	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1994	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1995	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1996	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1997	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1998	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1999	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
Performance of the AFAPL-TR-07-114										
1990	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1991	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1992	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1993	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1994	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1995	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1996	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1997	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1998	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1999	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
Performance of the AFAPL-TR-07-114										
1990	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1991	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1992	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1993	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1994	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1995	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1996	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1997	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1998	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0
1999	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0	100.0

a) The performance index is the ratio of the observed performance to the target performance.

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12. This extends the survey of the literature presented in reference 11.

...and the fact that the *Journal* is a journal of the American Psychological Association, the largest and most prestigious of the psychological organizations in the United States, is a source of great pride for me.

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Part III

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VARIATIONS AND ENDOTHERMIC FUELS FOR ADVANCED ENGINE APPLICATION. Part III. Studies of Thermal and Catalytic Reactions, Thermal Stabilities, and Combustion Properties of Hydrocarbon Fuels		
Final Report - June 1-30-September 1969		
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Air Force Aero Propulsion Laboratory Wright Patterson Air Force Base, Ohio		
The feasibility of utilizing hydrocarbon fuels for high speed air craft depends upon the endothermic and enthalpic capacity of the hydrocarbons, and the combustion properties of the products. At Mach 5 a supersonic combustion ram jet engine would require about 1900 Btu of cooling per pound of fuel. The enthalpic capacity of hydrocarbons can be augmented by thermal and catalytic reactions. These have been studied. The rate of thermal cracking can be accelerated by means of additives. The rate of dehydrogenation of naphthenes, a strongly endothermic reaction, can be increased by the use of improved catalysts based on platinum or similar. The stabilities of such catalysts are inversely proportional to the pore size of the support and are affected by composition. Dispersed catalysts have some advantages over bed type catalysts and some indications of possible success have been observed. About 1/3 of the 850 catalysts developed for naphthene dehydrogenation has been more active than the standard laboratory catalyst, although none is orders of magnitude better. Wall catalysts have the advantage of low pressure drop and are showing efficiency benefits also. Calculations show that diffusion limitations can be avoided if the coating thickness is no more than about 3 mils thick. Satisfactory operation with both improved bed catalysts and wall catalysts has been demonstrated in the fuel system simulator with both methylcyclohexane and Decalin. Heat transfer studies have been carried out with MCP, Decalin, HYDROLYNE-S and JP-7 fuel in small diameter test sections under heat fluxes up to 8×10^5 Btu per hour per square foot. Studies on the effect of high temperatures on the thermal stability of various fuels have been continued with emphasis on methods of measuring deposits on tube surfaces. Combustion and electron back scattering are the methods of present choice and an instrument based on the latter principle has been designed. Mathematical models are being devised to represent the various portions of an endothermic fuel system with present emphasis on the development of heat transfer correlations and a model for the dehydrogenation of Decalin. Physical properties for Decalin and JP-8 are included. Calculation of the rate of oxidation of normal octane and HYDROLYNE-M from shock tube studies indicate similar rates of reaction and temperature coefficients.		

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