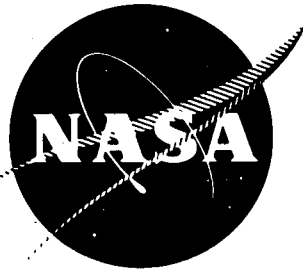


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NASA CR-135343 ✓



COMPOSITE HUB/METAL BLADE
COMPRESSOR ROTOR

by Sam Yao

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prepared for

NATIONAL AERONAUTICS AND SPACE ADMINISTRATION

NASA Lewis Research Center
Contract NAS3-18926
Tito T. Serafini, Project Manager

PLASTEC 28162

19951107 125

DTIC QUALITY INSPECTED 5

1. Report No. NASA CR-135343	2. Government Accession No.	3. Recipient's Catalog No.	
4. Title and Subtitle Composite Hub/Metal Blade Compressor Rotor		5. Report Date January 1978	6. Performing Organization Code
		8. Performing Organization Report No.	
7. Author(s) Sam Yao		10. Work Unit No.	
9. Performing Organization Name and Address Fiber Science, Inc. 245 E. 157th Street Gardena, CA 90248		11. Contract or Grant No. NAS3-18926	
		13. Type of Report and Period Covered Contractor Report	
12. Sponsoring Agency Name and Address National Aeronautics and Space Administration Washington, D.C. 20546		14. Sponsoring Agency Code	
		15. Supplementary Notes Project Manager, Tito T. Serafini, Materials and Structures Division, NASA Lewis Research Center, Cleveland, Ohio	
16. Abstract The objective of this program was to design and fabricate a low cost compressor rotor for a small jet engine. The rotor hub and blade keepers were compression molded with graphite epoxy. Each pair of metallic blades was held in the hub by a keeper. All keepers were locked in the hub with circumferential windings. Feasibility of fabrication was demonstrated in this program.			
17. Key Words (Suggested by Author(s)) Low cost compressor rotor for small jet engine Composite hub/metallic blade compressor rotor		18. Distribution Statement Unclassified-Unlimited	
19. Security Classif. (of this report) Unclassified	20. Security Classif. (of this page) Unclassified	21. No. of Pages 32	22. Price*

* For sale by the National Technical Information Service, Springfield, Virginia 22161

FOREWORD

This report represents the work accomplished by Fiber Science, Inc. during the period December 1974 to October 1975 on NASA Contract NAS3-18926, "Composite Hub/Metal Blade Compressor Rotor." The work was administered by the National Aeronautics and Space Administration, Lewis Research Center, Cleveland, Ohio with Dr. T. T. Serafini, Project Manager.

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1.0 SUMMARY

A composite-hub/sheet metal blade compressor rotor, first stage, was designed in accordance with NASA-furnished envelope dimensions. The rotor is made up of a hub, blades, blade keepers and circumferential windings. The hub is designed with twelve (12) cavities to accept 12 pairs of sheet metal blades and their keepers. The circumferential windings hold the keepers and blades to the hub. Recesses are provided on the hub and keepers to house the windings so that a smooth contour with the hub is maintained. Figure 1 shows the completed rotor.

The hub, blade keepers and the circumferential windings are all Thornel 300/epoxy and the blades are steel.

A total of two hub assemblies were fabricated and shipped to NASA for testing.

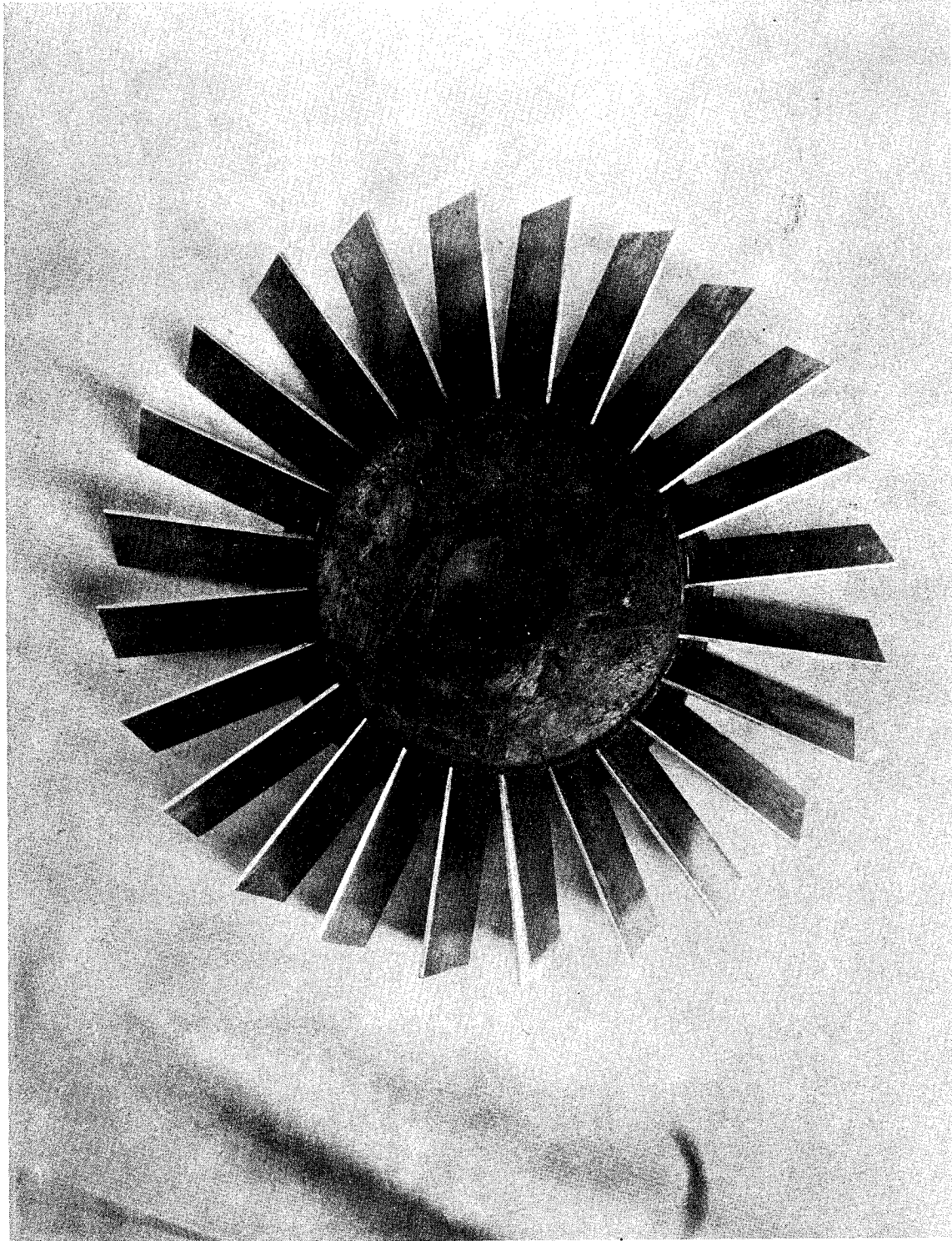


Figure 1. Composite-Hub Sheet Metal
Blade Compressor Rotor

2.0 INTRODUCTION

One of the major deterrents to small jet engines is the high cost of the compressor rotor. Fiber Science, Inc. conceived a design concept which combines sheet metal blades with a compression molded composite hub that offers low cost potential. The objective of this program was to demonstrate this design concept with the fabrication of two rotors.

This report contains a description, drawings and photographs of the composite hub/metal blade compressor rotor and the tooling used in its fabrication.

3.0 CONFIGURATION

The configuration of the composite-hub/sheet metal blade compressor rotor is shown on the following drawings:

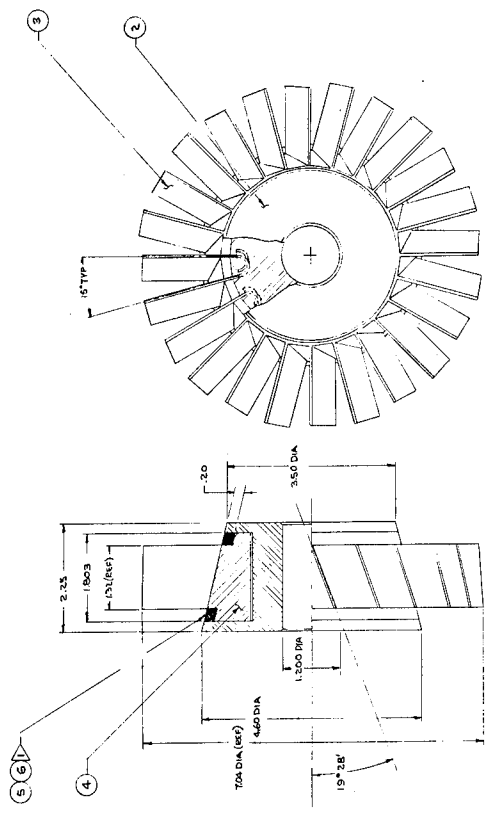
Drawing

609-001	Compressor Rotor Assembly Composite Hub/Metal Blade
609-002	Hub
609-003	Keeper Blade
CD659688	Sheet Metal Blade Pair (Flat)

The hub, blade keepers and the circumferential windings are all made of Thornel 300 graphite (product of Union Carbide Corporation) and APCO 2447/APCO 2345 resin (product of Applied Plastics Company). The fiber volume ratio is 50 percent.

The blades are sheet metal and were NASA-furnished for this program.

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-ASSEMBLY-

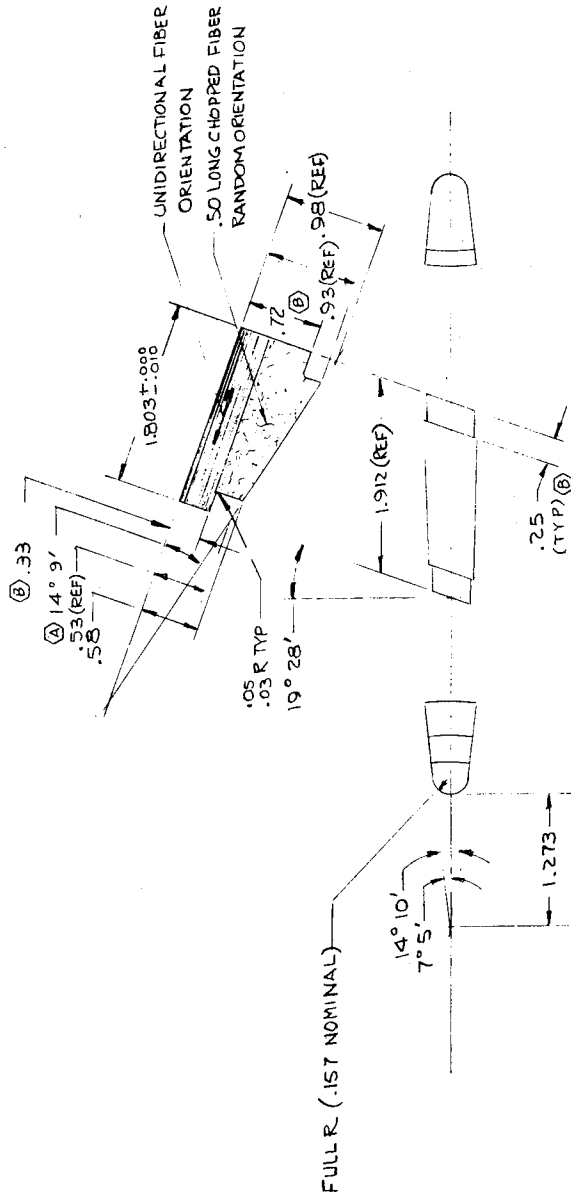
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 NOTES:

QTY REQD	QTY REQD	RESIN SYSTEM	MATERIAL	SPECIFICATION	DRG NO.
1	1	609-003	BRONLY		5
1	1	609-002	GRAPHITE		4
1	1	609-001	GRAPHITE		3
1	1	609-002	HUB		2
1	1	609-002	ASSEMBLY		1

QTY REQD	QTY REQD	RESIN SYSTEM	MATERIAL	SPECIFICATION	DRG NO.
1	1	609-003	BRONLY		5
1	1	609-002	GRAPHITE		4
1	1	609-001	GRAPHITE		3
1	1	609-002	HUB		2
1	1	609-002	ASSEMBLY		1

Figure 10. Compressor Rotor Assembly Composite Hub/Metal Blade, Drawing No. 609-001

REV	DESCRIPTION	DATE	APPROVED
A	REDESIGNED & REDRAWN AS 14° 9' WAS 13° 45'	5-2-75	[Signature]
B	IS .33 WAS .20 TYP ADDED .72 AND (TYP)	8-18-81	[Signature]



QTY REQD		LIST OF MATERIALS		DATE
		DRAWN S. CHAO		1-10-75
		DESIGN S. YAO		1-15-75
		STRESS D. ARNOLDSON		1-15-75
		ENGR. H. BERGMAN		1-15-75
		DESIGN ACTIVITY APPD		
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DECIMAL	FINISH	TITLE		
.001	14° 9' ± 0.30°	KEEPER-BLADE		
.002	DO NOT SCALE			
FINISH	TREATMENT	CODE IDENT DWG NO.		
		B 32500 609-003		
WEIGHT	USED ON	SCALE FULL		
.032 LB	APPLICATION	RELEASE DATE 1-15-75 SHEET 1 OF 1		

Figure 11. Keeper Blade, Drawing No. 609-003

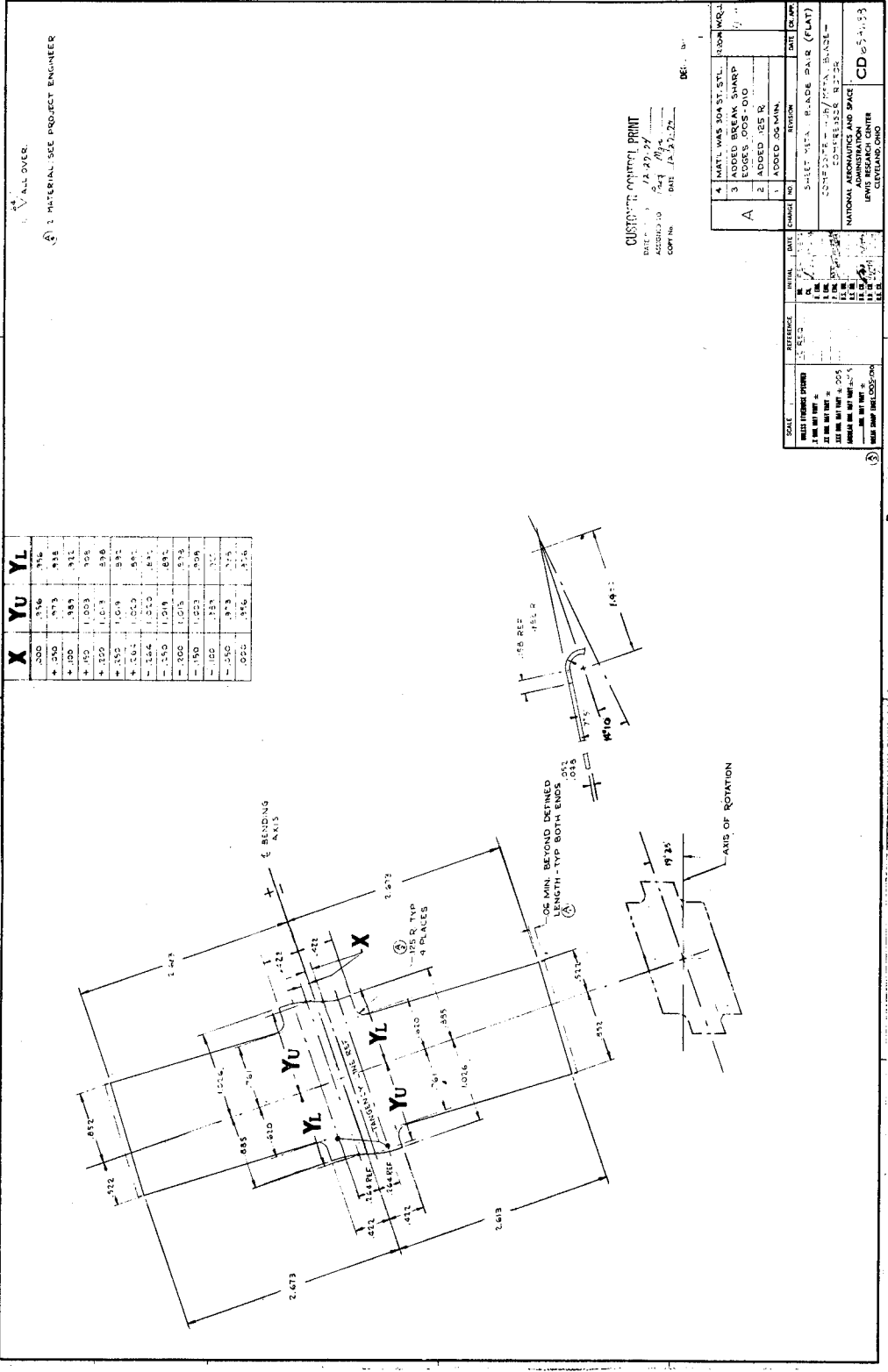


Figure 12. Composite-Hub/Metal Blade-Compressor Rotor, Drawing No. 659688

4.0 TOOLING

The tooling to fabricate the hub, blade keepers and assemble the blades and keepers (circumferential winding) are shown in the following drawings.

Drawing

609-101	Mold-Fan Blade Hub
609-102	Mold Keeper
609-103	Keeper Fixture
609-104	Loading Tool Mold-Fan Blade Hub

Photographs of the tooling are shown in Figures 7 through 9.

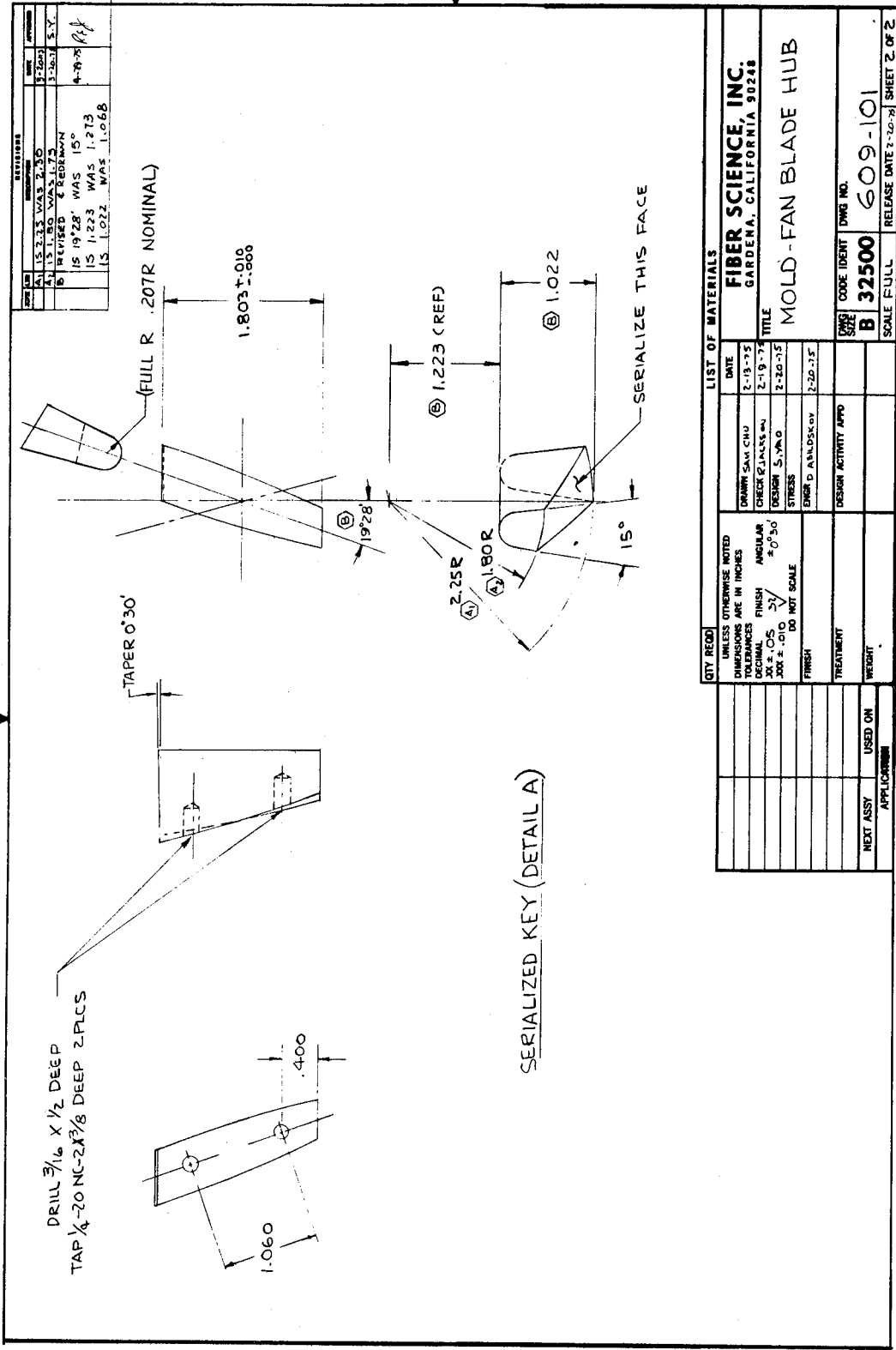


Figure 3. Mold-Fan Blade Hub, Drawing No. 609-101

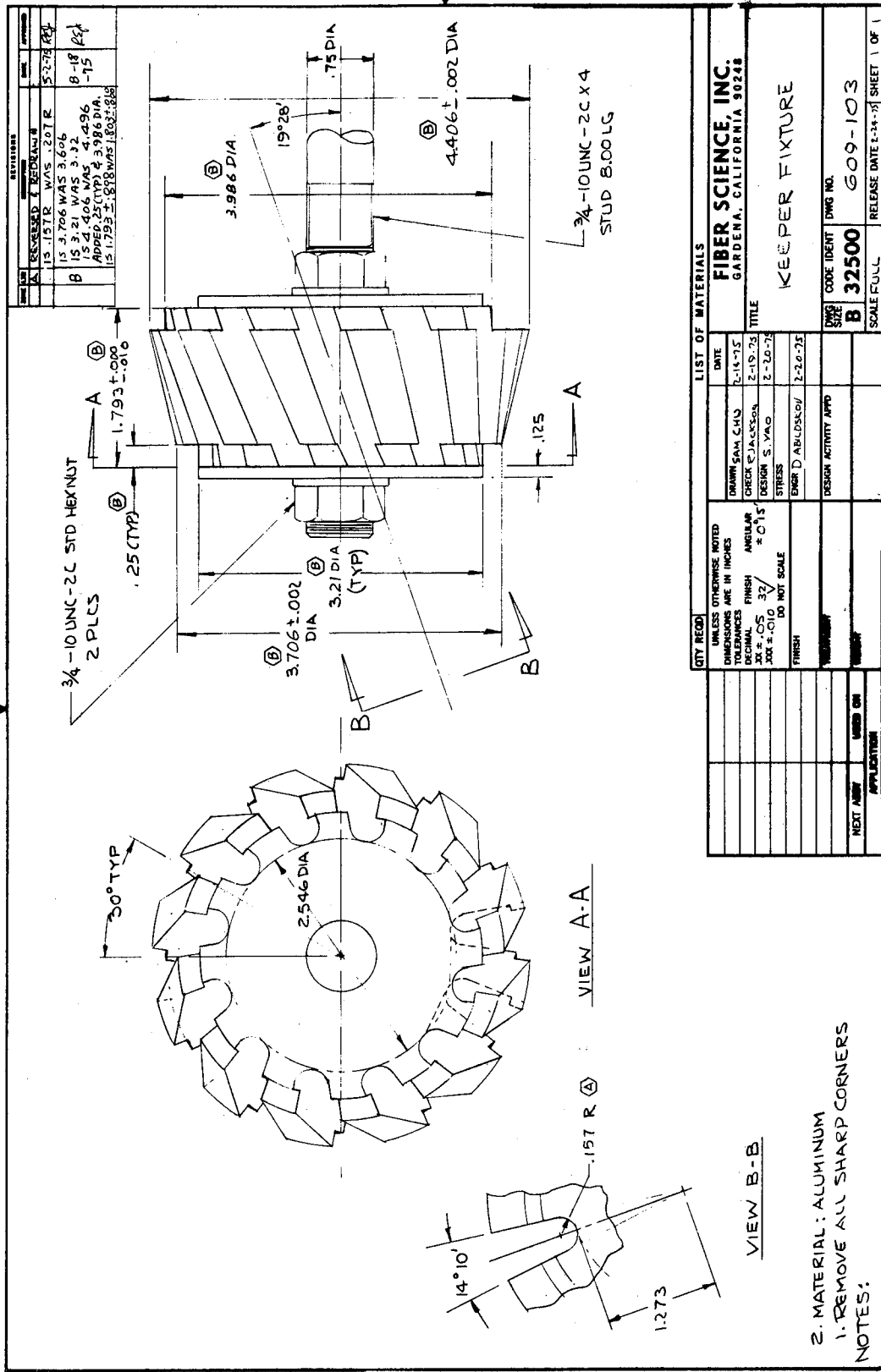


Figure 5. Keeper Fixture, Drawing No. 609-103

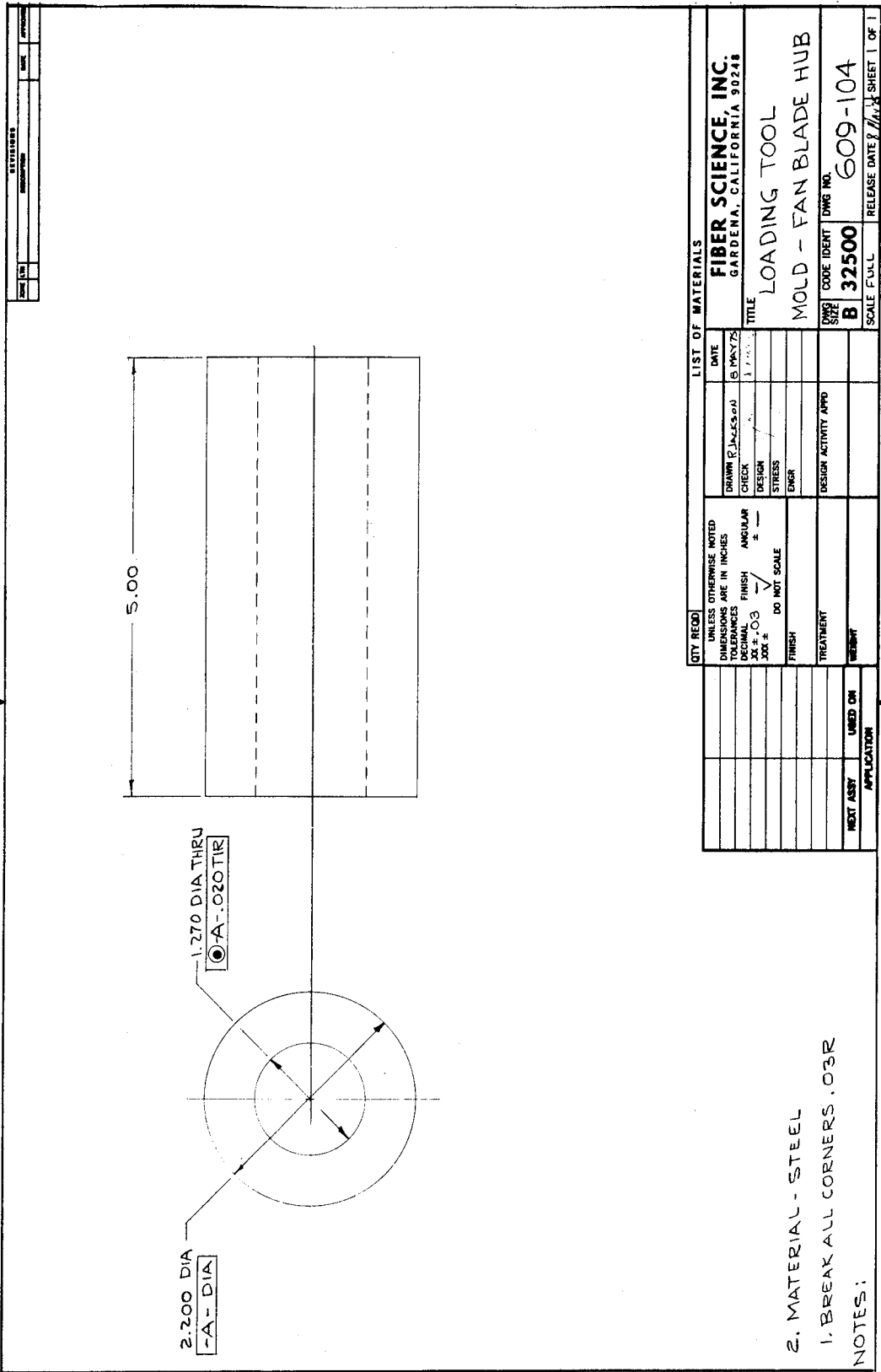


Figure 6. Loading Tool Mold-Fan Blade Hub, Drawing No. 609-104

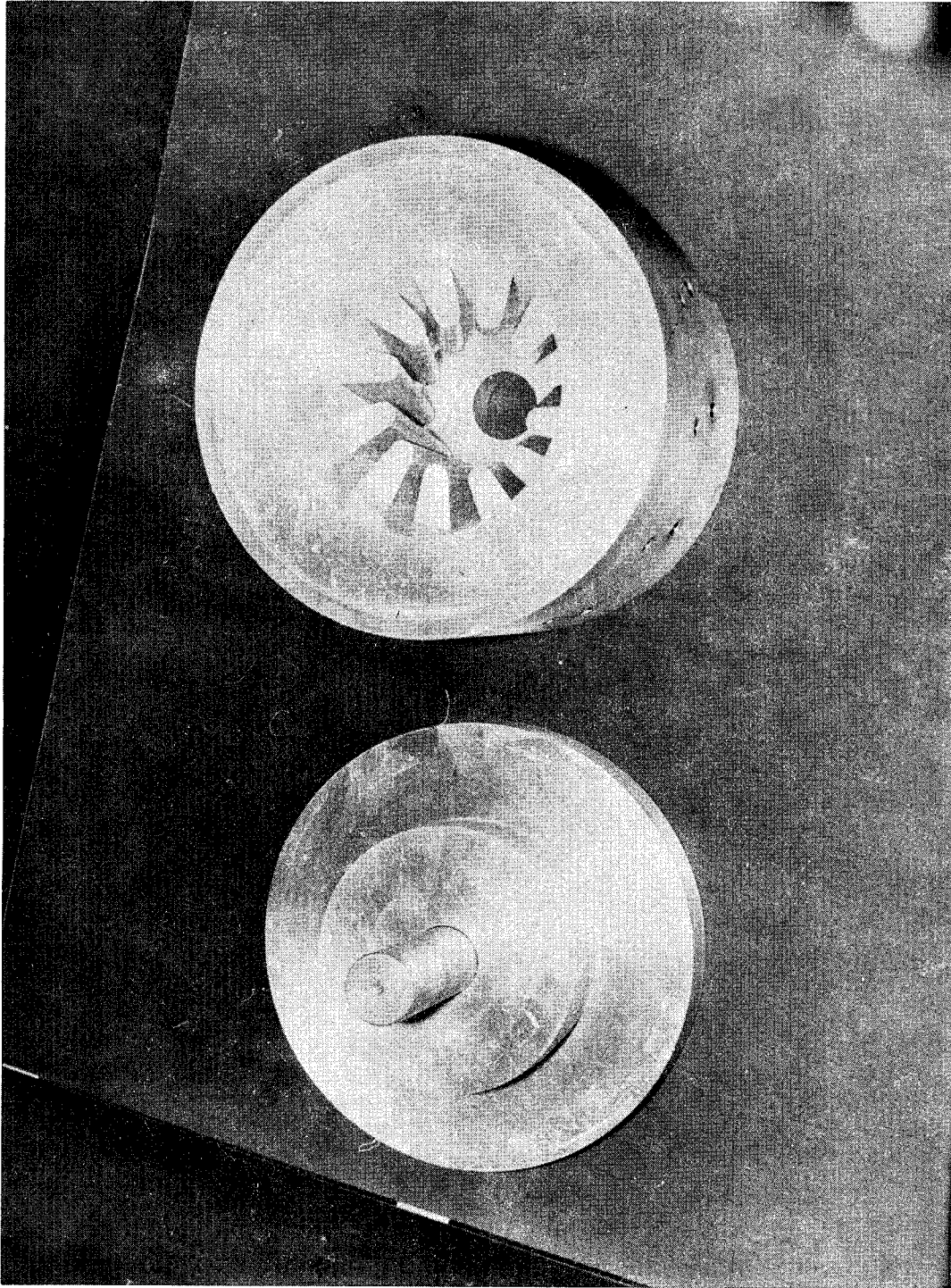


Figure 7. Mold-Fan Blade Hub

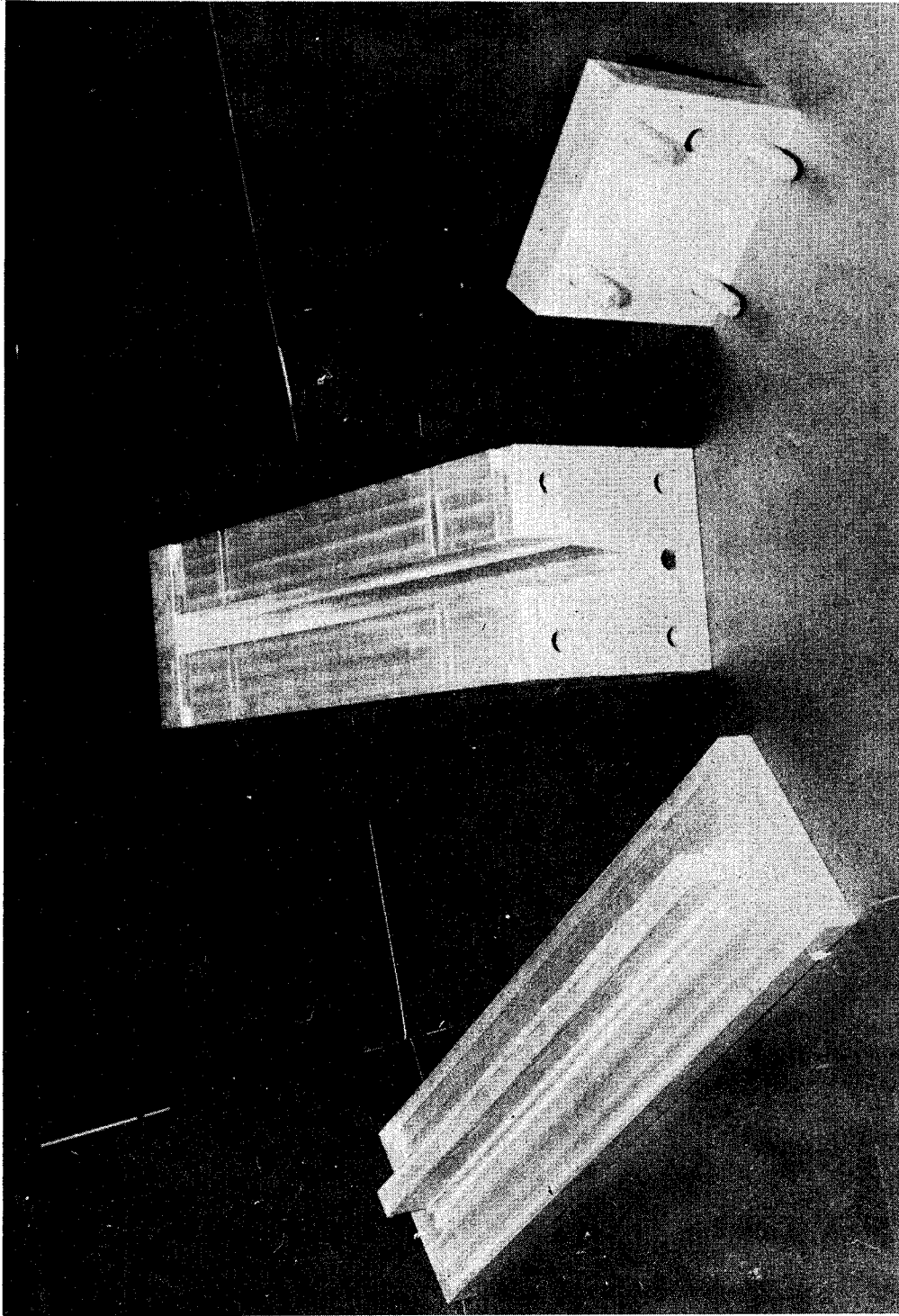


Figure 8. Mold Keeper

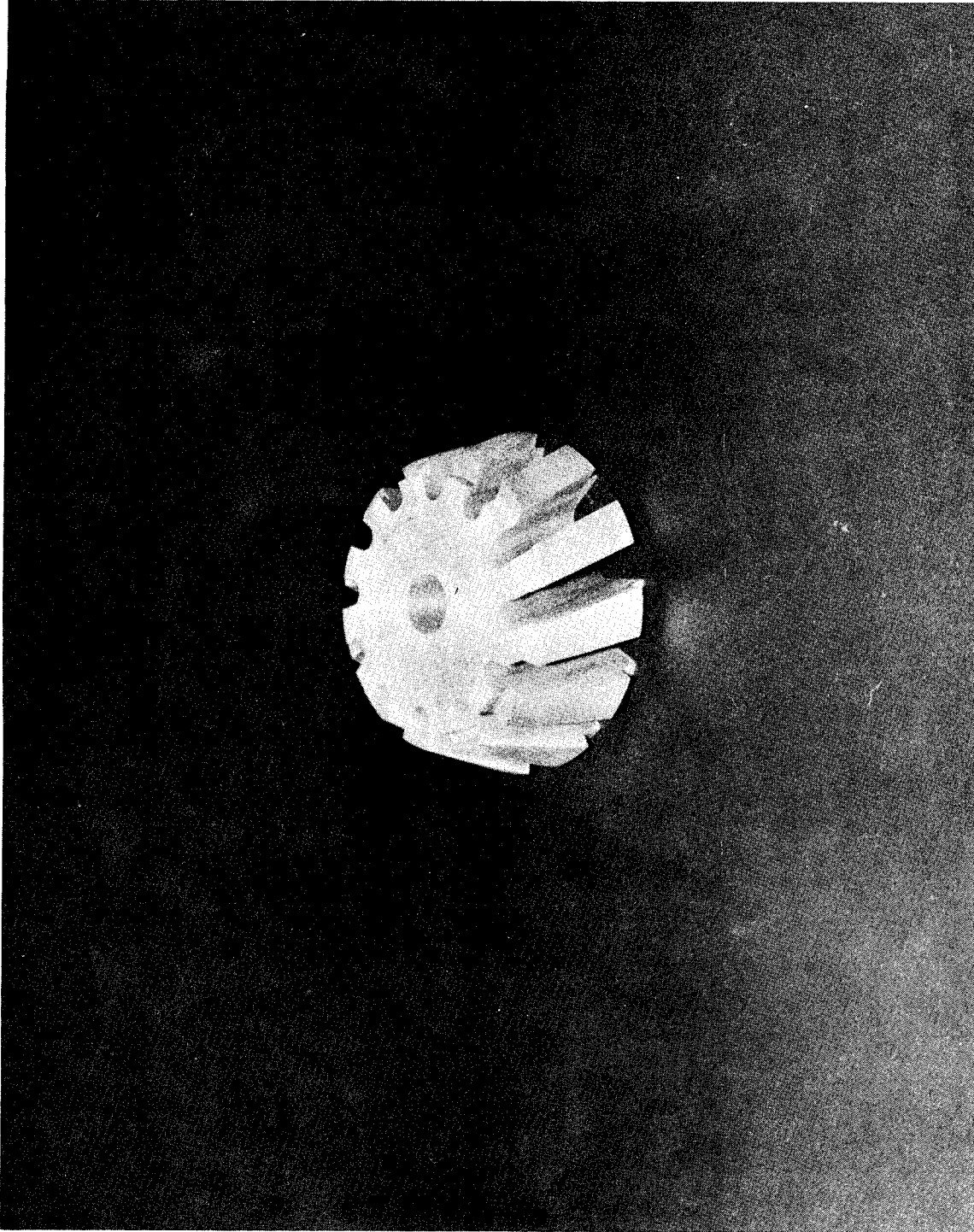


Figure 9. Keeper Fixture

5.0 FABRICATION

The hub and blade keepers were fabricated by compression molding as follows:

Hub

1. The hub mold (609-101) was coated with Ram 225 mold release (product of Ram Chemical Company) and baked for 60 minutes at 200°F.
2. The keys were assembled (bolted) in place and the mold made ready for loading.
3. Chopped (.50 inch long) Thornel 300 graphite fibers and APCO 2447/APCO 2345 (7.5 PHR) resin were mixed in a 50% fiber volume ratio (39.31% resin by weight).
4. A portion of the graphite fiber/epoxy resin mixture was loaded into the mold using the loading tooling 609-104 to compact the mixture beneath and between the keys in the lower portion of the mold.
5. The remaining quantity of graphite/epoxy was loaded into the mold and the mold closed. Pressure was applied by a press to close the mold.
6. While under pressure the resin was cured four hours at 130°F plus two hours at 250°F.
7. The part was slowly cooled to room temperature and removed from the mold. Keys were unbolted from the mold and removed from the mold with the part. The keys were then removed individually from the molded hub.

Blade Keepers

1. The blade keeper mold 609-102 was coated with Ram 225 mold release and baked 60 minutes at 200°F.
2. Unidirectional Thornel 300 graphite impregnated with APCO 2447/APCO 2345 (7.5 PHR) 50% fiber volume were laid into the bottom of the mold and the remaining portion filled with the same material except the

2. (Continued)

fibers were chopped into a .50 inch long lengths.

3. The mold was closed and pressure applied by a press and cured four hours at 130°F plus two hours at 250°F.
4. The part was slowly cooled to room temperature and removed from the mold.
5. The part was cut into lengths approximately 1.8 inches long and 12 sections were secured with a banding clamp to the keeper fixture 609-103.
6. The keepers were machined on their outside surface while supported in the keeper fixture. The blades and blade keepers were coated in their attachment areas with resin (APCO 2347/APCO 2345) and assembled to the hub and secured by overwinding the keeper edges with Thornel 300 impregnated with APCO 2447/APCO 2345 (7.5 PHR). Following winding the assembly was cured four hours at 130°F plus two hours at 250°F plus two hours at 400°F. The rotor assembly was slowly cooled to room temperature, cleaned up and shipped.

6.0 RESULTS

A total of two composite hub/metal blade compressor rotor assemblies were fabricated and shipped to NASA. The rotors demonstrated the feasibility of fabricating low cost rotors by this process. However, precise blade alignment was difficult to achieve with the tooling use.

7.0 CONCLUSIONS

It is concluded that composite hub/metal blade compressor rotor assemblies are practical to fabricate. The tooling used was adequate except the slots in the hub cannot be relied upon to give precise alignment of the metal blades. The alignment problem of the blades can be eliminated by changing the blade base configuration from a curve to a flat surface. This flat surface would provide positive alignment and eliminate the rotation problem of the blades during assembly.

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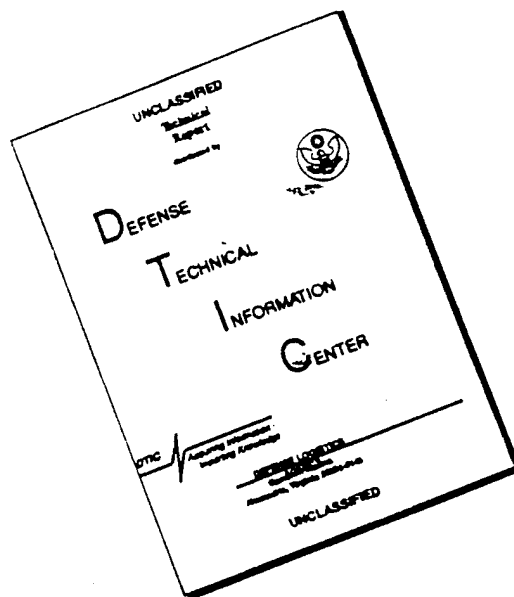
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