Report Documentation Page				Form Approved OMB No. 0704-0188		
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1. REPORT DATE <b>21 MAR 2006</b>		2. REPORT TYPE <b>Technical, Success</b>	s Stories	3. DATES COVE 09-08-2005	red 5 to 21-03-2006	
4. TITLE AND SUBTITLE	I		5a. CONTRACT NUMBER			
Increased Range /			5b. GRANT NUMBER			
	5c. PROGRAM ELEMENT NUMBER					
6. AUTHOR(S)		5d. PROJECT NUMBER <b>05-0071-09</b>				
				5e. TASK NUMBER		
				5f. WORK UNIT NUMBER		
7. PERFORMING ORGANI National Center fo Technology Way,L	,1600	8. PERFORMING ORGANIZATION REPORT NUMBER				
9. SPONSORING/MONITORING AGENCY NAME(S) AND ADDRESS(ES)				10. SPONSOR/MONITOR'S ACRONYM(S)		
	11. SPONSOR/MONITOR'S REPORT NUMBER(S)					
12. DISTRIBUTION/AVAILABILITY STATEMENT Approved for public release; distribution unlimited						
<ul> <li><sup>14. ABSTRACT</sup></li> <li>Technical Directions Inc. (TDI), Ortonville, Michigan was asked by the U.S. Army and the U.S. Air Force to improve the efficiency of their J-45 missile engine for the NLOS-LS LAM Loitering Attack Missile. The ultimate goal is to improve the overall engine efficiency by 8%, thereby reducing fuel consumption for the propulsion system, allowing for both increased vehicle payload and/or increased vehicle range. The newly designed compressor wheel requires very thin blades and a higher blade complement for optimum flow guidance with minimal flow losses. These requirements eliminate the investment casting of the compressor wheel, replacing it with the fully machined compressor wheel. The complex passages within the wheel require tolerances within .001", and blade thicknesses in the .010" range. Realizing this challenge, TDI requested the help of the National Center for Defense Manufacturing and Machining (NCDMM) to meet these heightened manufacturing goals.</li> <li>15. SUBJECT TERMS</li> <li>Success Stories; National Center for Defense Manufacturing and Machining; NCDMM; Technical Directions Inc : U.S. Army: U.S. Air Force</li> </ul>						
16 SECURITY CLASSIFIC	17 LIMITATION OF	18 NUMBER	19a NAME OF			
			ABSTRACT	OF PAGES	RESPONSIBLE PERSON	
unclassified	unclassified	unclassified				

Standard Form 298 (Rev. 8-98) Prescribed by ANSI Std Z39-18 **Increased Range / Mini-Cruise Missile** 

NCDMM Project No. 05-0071-09



## **PROBLEM / OBJECTIVE**

NATIONAL CENTER

MANUFACTURING

& MACHINING

Technical Directions Inc. (TDI), Ortonville, Michigan was asked by the U.S. Army and the U.S. Air Force to improve the efficiency of their J-45 missile engine for the NLOS-LS LAM Loitering Attack Missile. The ultimate goal is to improve the overall engine efficiency by 8%, thereby reducing fuel consumption for the propulsion system, allowing for both increased vehicle payload and/or increased vehicle range.

The current compressor wheel in the J-45 missile engine is an investment casting and purchased fully machined at \$23 per part. The new redesigned high efficiency compressor wheel will be lighter, stronger and more efficient, but will add machining costs to the overall J-45 missile engine system. The targeted cost for this new compressor wheel was established by TDI at \$100 per part.

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Realizing this challenge, TDI requested the help of the National Center for Defense Manufacturing and Machining (NCDMM) to meet these heightened manufacturing goals.



High efficiency compressor wheel design

# ACCOMPLISHMENTS / PAYOFF

### Process Improvement

The NCDMM reviewed the drawings along with solid model files and determined that due to the time constraint and part complexity, specialized programming software would be needed to produce machine code for machining the compressor wheel. The NCDMM contacted Moore Tool Co., to assist with this project. Moore Tool recommended that the firm, Concepts NREC, program the finish machining paths of the compressor wheel. CNC Software/MasterCam was utilized to program the rough machining paths.

Due to price and availability of the requested material, TDI and NCDMM decided to manufacture the test wheels from two types of aluminum material. The results would then be used to determine justification of cost.

Moore Tool machined the compressor wheels using their FSP-300X 5-axis machine utilizing high-speed 5-axis machining technology. Six (6) complete compressor wheels were sent to TDI for performance evaluations.

#### New Compressor Wheel Results

- All geometric part features were within the specified tolerances
- Machining cycle time was under 60 minutes
- The target compressor wheel cost of \$100 was achieved
- Initial overall engine efficiency improvement was measured as high as 5%

### Expected Benefits

The cooperative effort between TDI and NCDMM resulted in an increase of up to 5% in vehicle efficiency with additional efficiency gains expected with further development. The NCDMM manufacturing effort has maintained the total cost goal of \$100. This effort has brought TDI, the U.S. Army, and the U.S. Air Force closer to their overall efficiency goal and will assist TDI in future efficiency upgrade proposals.

The TDI/J-45 project has brought advanced minicruise missiles like the U.S. Army Loitering Attack Missile and the U.S. Air Force Low Cost Autonomous Attack System one step closer to supporting our nation's warfighters.

## **TIMELINE / MILESTONE**

Start Date..... August 05 Recommendations Made..... March 06

## **PROJECT FUNDING**

NCDMM funding .....\$60K

# PARTICIPANTS

Moore Tool Co.Kennametal Inc.Concepts NRECCNC Software/MasterCamTechnical Directions Inc.

For additional information concerning this project, contact the NCDMM at www.ncdmm.org