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CR-147909

(NASA-CR-147909) DISPOSAL OF HYPERGOLIC PROPELLANTS. PHASE 6, TASK 1: THE CRYOGENIC SCRUBBER PROTOTYPE Final Report (Florida Inst. of Tech.) 32 p HC A03/MF A01 CSCL 21D G3/28 N77-31332 Unclas 48171

DISPOSAL OF
HYPERGOLIC PROPELLANTS

Final Report
Phase VI Task 1
The Cryogenic Scrubber Prototype
August 1976

by

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prepared for
NATIONAL AERONAUTICS AND SPACE ADMINISTRATION
Kennedy Space Center
Contract NAS 10-9399



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PREFACE

This study was conducted by Florida Institute of Technology under Contract NAS 10-8399, administered by the National Aeronautics and Space Administration, John F. Kennedy Space Center, Florida. The HASA Technical Representative for the contract was Mr. Harold H. Franks, DD-MDD, and the Alternate Technical Representative was Mr. Jimmy L. Dobson, DD-MDD. Florida Institute of Technology's study manager was Dr. Thomas E. Bowman, Mechanical Engineering Department.

THE CRYOGENIC SCRUBBER PROTOTYPE (CSP)

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1. ABSTRACT

A large part of the Phase VI effort has involved evaluation of a Cryogenic Scrubber Prototype (CSP) as a means of removing both Monomethylhydrazine (MMH) and Dinitrogen Tetroxide (NTO) from vent streams. This report concerns the concept, laboratory data, design, construction, experimentation and discussion involving the CSP as well as the final recommendations concerning its use in the Shuttle Program.

2. CONCEPT

The hypergols which will be utilized in the Shuttle Program are Monomethylhydrazine (MMH) and Dinitrogen Tetroxide (NTO). These materials must be removed from GHe and GN₂ vent streams at the pad, the HMF, and the OPF in order to prevent any possible health hazards and environmental pollution. Since the freezing points of these materials are considerably higher than those of the carrier gases, it was envisioned that cooling would cause condensation of the hypergols and facilitate their subsequent removal. Liquid nitrogen (LN₂) was proposed as the coolant since it is readily available at KSC and many workers are experienced in the necessary handling procedures. Also, because of its -198°C temperature, LN₂ should theoretically be able to condense out even relatively small concentrations of hypergol contaminants and thus the effluent discharges of GHe and GN₂ should theoretically approach undetectable limits.

3. LABORATORY DATA

Liquid Nitrogen (LN_2) traps were proposed, in the summer of 1975, to remove $\text{NO}_2\text{-N}_2\text{O}_4$ from GN_2 and GHe vent streams from the pad, the HMF, and the OPF facilities which will be constructed and utilized for the Shuttle Program. To investigate the feasibility of such systems, a laboratory model was constructed as shown in Figure 1. GHe was passed through latex rubber tubing, through a flow meter, and into a 3-necked, 500 ml. round bottom flask containing one drop (0.05 ml.) N_2O_4 at room temperature 23-25°C. From one of the necks, the NO_2 containing He stream was passed through an LN_2 trap and finally passed through rubber tubing into a water trap containing sulfanilic acid and N-(1-naphthyl)-ethylenediamine to form a deep red color which was quantitated spectrophotometrically. (See Phase I-III, Final Report.)

Four complete experiments were run at different He flow rates: 30, 50, 75, and 100 cc/min. At 200 cc/min., plugging of the trap occurs. The results of these experiments are shown in Table 1. NO_2 determinations were conducted with and without the LN_2 trap inserted into the stream. The calculated surface area of those surfaces cooled by LN_2 and in contact with the NO_2 contaminated He stream is 144.6 sq. cm. When high concentrations of N_2O_4 in the 3-necked round bottom flask were used, the LN_2 trap would quickly plug with solidified N_2O_4 since most of the blue solid N_2O_4 is trapped inside the inner tube of the trap 1-2 cm. below the level of the LN_2 . Very little was dispersed beyond this point. (see Figure 2.)

The effluent concentration assays were made by determining the amount of NO_2 contained in the water trap (Trap No. 2, Figure 1) that accumulated over an experimentally convenient period of time.

As can be seen, use of the LN_2 trap resulted in a drastic reduction of the NO_2 in the effluent He stream. Extrapolations to field conditions could not be made because the flow rates in this experiment were too low. However, LN_2 cooling at this point seemed to be an attractive method for removing NO_2 from the He vent streams. Although further experiments conducted with equipment designed to accommodate higher flow rates were deemed necessary before a final experimental judgement could be made.

On a theoretical basis, there are two very significant advantages of cryogenic trapping as compared to conventional scrubbing systems.

1. Cryogenic trapping avoids the problems associated with attempting to dissolve NO_2 in water while at the same time generating insoluble NO . This is the real limiting problem with conventional water scrubbers.
2. The vapor pressure of dissolved NO_2 inhibiting absorption of fresh NO_2 (Raoult's law) would not be applicable in the cryogenic system. This consideration would be even more important in the case of MMH vapor disposal.

Figure 2. THE NO₂ TRAP IN LN₂

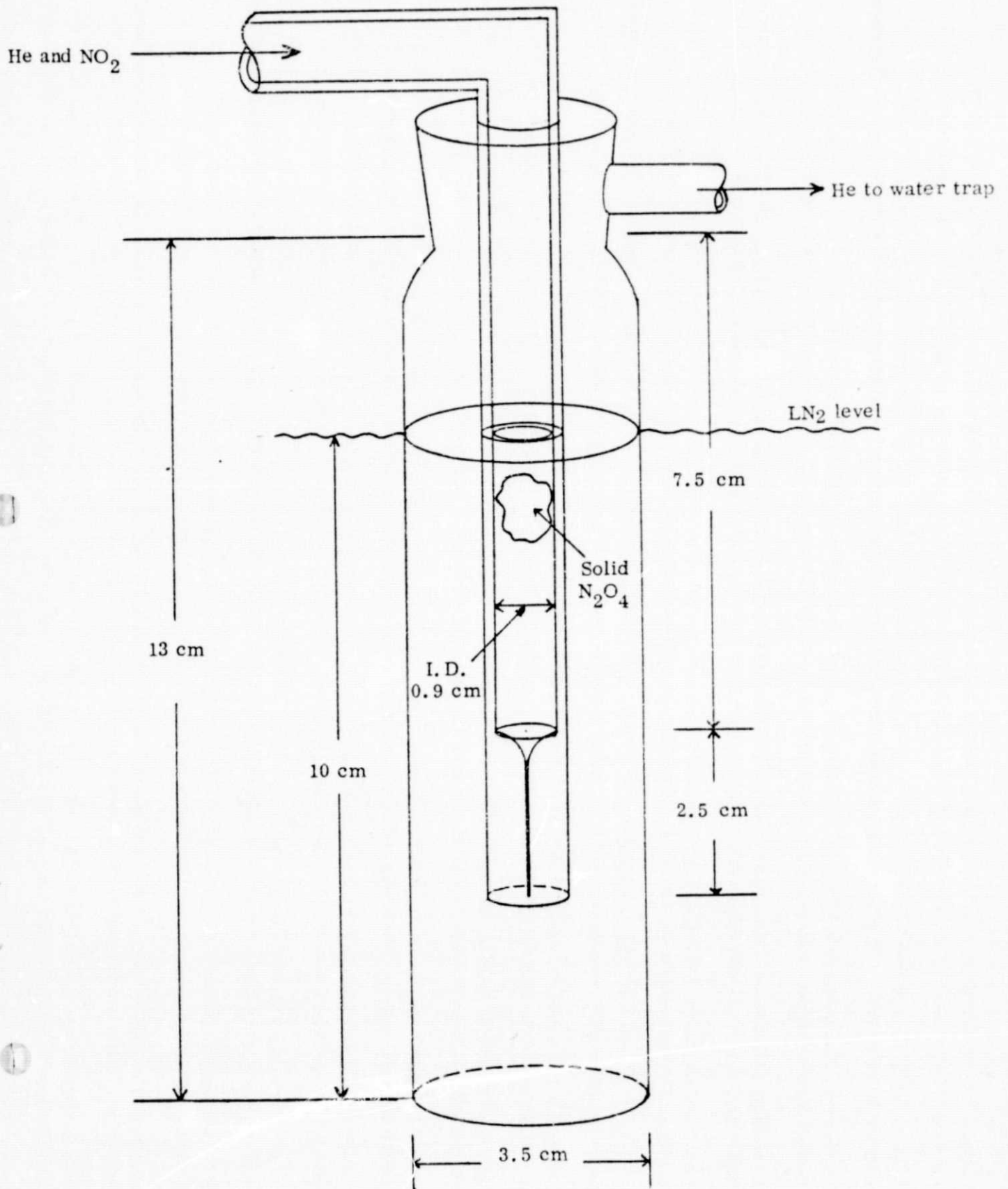


Figure 1. A LABORATORY MODEL FOR CRYOGENIC TRAPPING OF VENTED HELIUM STREAMS
CONTAINING NITROGEN DIOXIDE

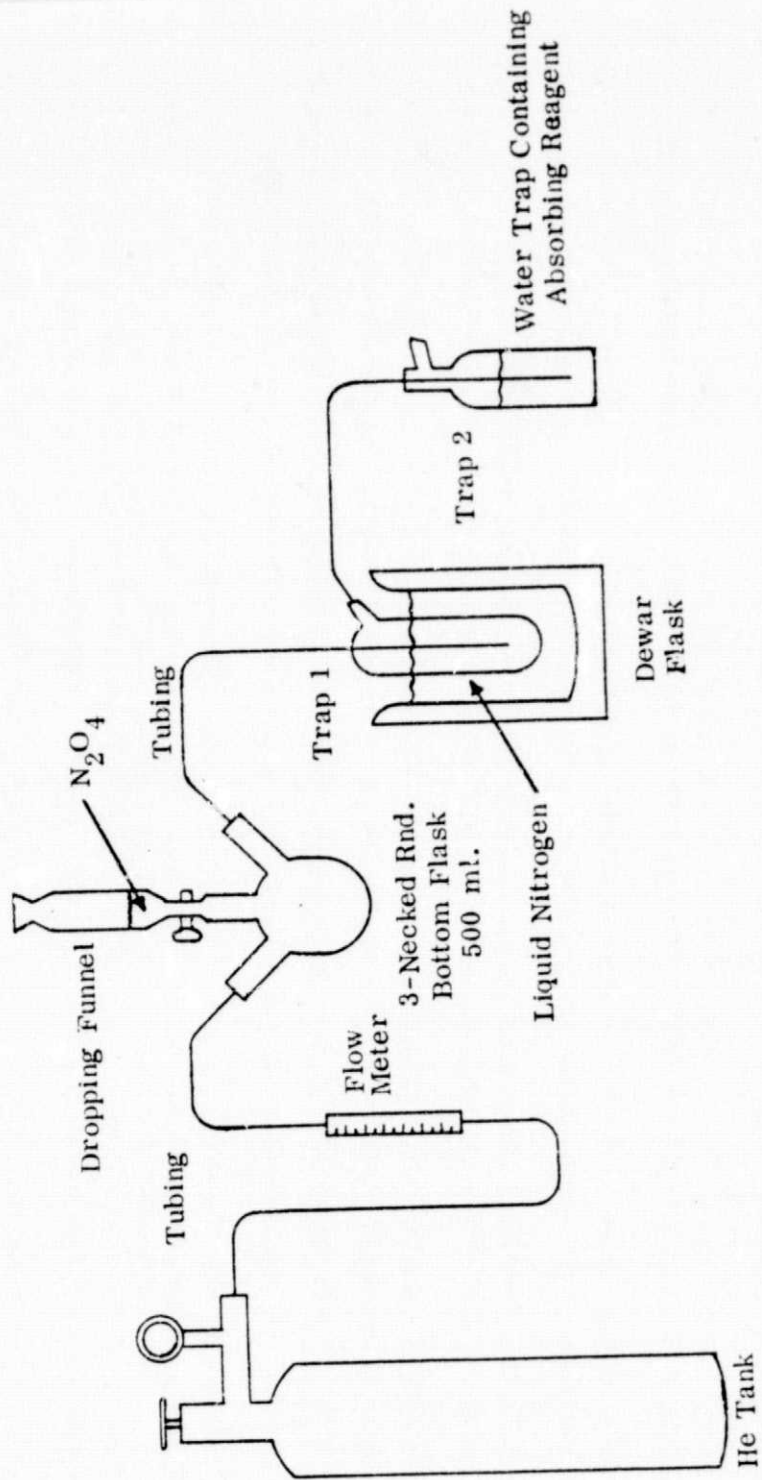


TABLE I - REMOVAL OF NO₂ FROM He VENT STREAMS

EXPERIMENT NUMBER	CONDITIONS	RATE He FLOW (cc/min., CF/min.) $\times 10^{-3}$	EFFLUENT NO ₂ CONCENTRATIONS (μ l NO ₂ /1000 cc He. gas)	TIME OF FLOW (Minutes)
1.	LN Trap	30, 1.06	26.3	33.3
	No LN ₂ Trap	30, 1.06	42,300.	33.3
2.	LN ₂ Trap	50, 1.77	61.0	20.0
	No LN ₂ Trap	50, 1.77	42,300.	20.0
3.	LN Trap	75, 2.65	2.82	13.3
	No LN ₂ Trap	75, 2.65	210,000.	13.3
4.	LN ₂ Trap	100, 3.53	1.98	10.0
	No LN ₂ Trap	100, 3.53	86,630.	10.0

4. DESIGN

In view of the apparently successful laboratory results, a Cryogenic Scrubber Prototype (CSP) was constructed. This unit was designed by E. Spearman P.E., of Canoga Park, California. The basic design of the CSP is illustrated in Figure 3. As is seen, the hypergol laden GN_2 stream enters at the top and passes over 40-1/2 inch coils containing either LN_2 or cold GN_2 . The GN_2 stream exits from the bottom through a tube passing up through the center of the coils. The surface area of the coils is 40 sq. ft. There are substantial differences between CSP design and the laboratory design described earlier. First, there is no surrounding annulus containing LN_2 on the CSP. This feature would be analagous to the LN_2 containing dewar which was used in the laboratory. Lack of this design feature allows the outside walls to remain relatively warm although the inside coils become extremely cold. Secondly, there is no substantial baffling between the inlet port and the exit port of the CSP. Thirdly, the cold surfaces in the CSP are stainless steel whereas those in the laboratory model are glass.

The CSP was designed to handle a flow rate of 20 SCFM and thus the ratio of SCFM to cold surface area is:

$$\frac{20 \text{ SCFM}}{40 \text{ sq. ft.}} = 1/2$$

The laboratory model performed satisfactorily with the following ratios of flow rate to area:

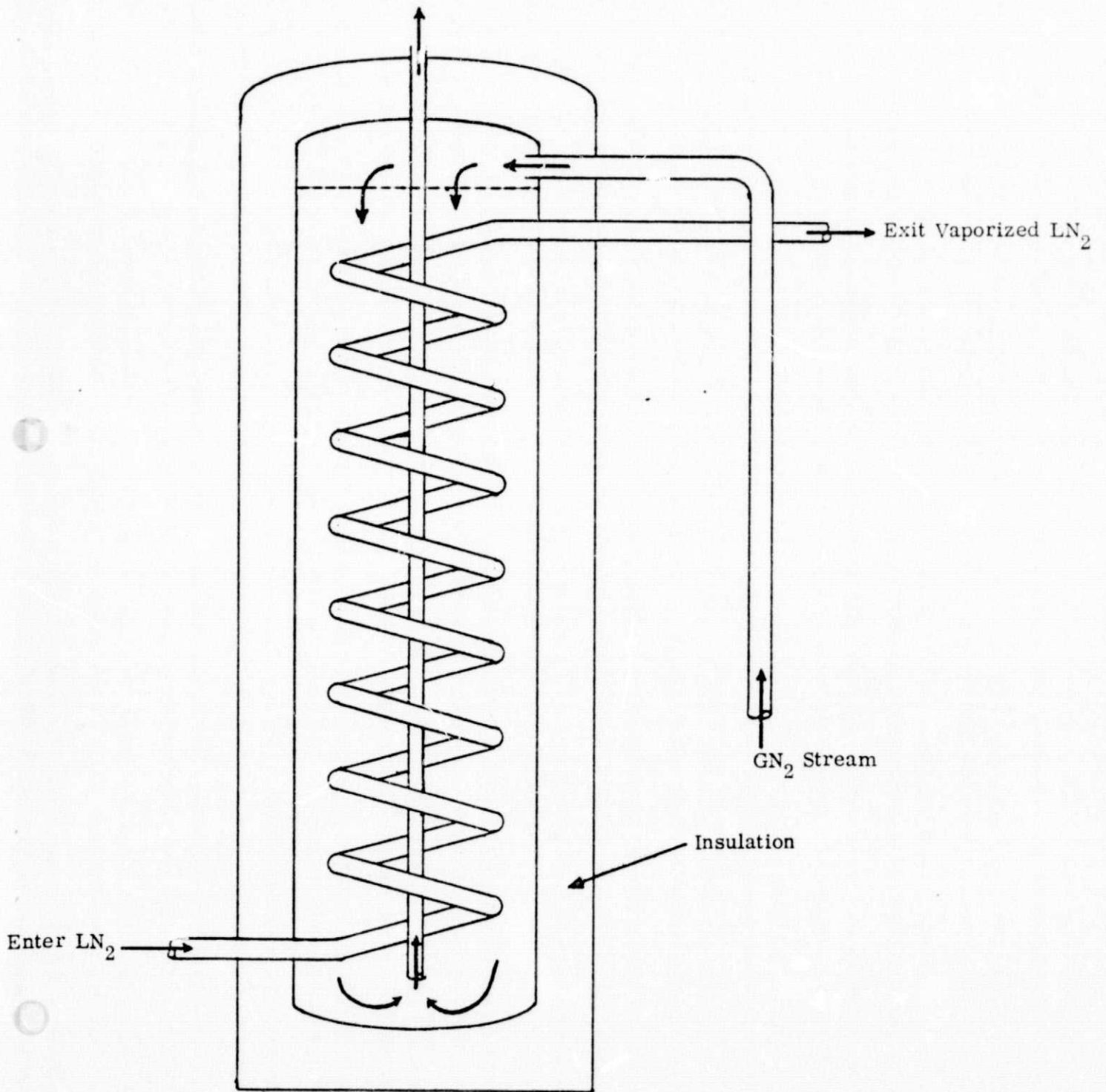
$$\frac{100 \text{ cc/min.}}{144 \text{ sq. cm.}} = \frac{1}{1.44}$$

$$\frac{74 \text{ cc/min.}}{144 \text{ sq. cm.}} = \frac{1}{1.92}$$

$$\frac{50 \text{ cc/min.}}{144 \text{ sq. cm.}} = \frac{1}{2.88}$$

$$\frac{30 \text{ cc/min.}}{144 \text{ sq. cm.}} = \frac{1}{4.80}$$

Figure 3: Design of the CSP



Hence, it is seen that the laboratory model and the CSP have comparable ratios of flow rate to cold surface. Other calculations may be useful for design comparison. These include ratios of cold surface (in contact with LN_2) to relatively warm surfaces which are dependent on heat transfer through gases. In the laboratory model the ratio of cold surface area to warm surface area is 2.58 to 1. For the CSP the ratio is 40 sq. ft. to 37.4 sq. ft. or 1.07 to 1. Thus the laboratory ratio was approximately two and one-half times more favorable than the CSP. This situation may be one reason for the large difference in scrubbing efficiency between the laboratory model and the CSP.

Midway through the experimentation program, it was decided that filling the void volumes of the CSP might prove advantageous in increasing the efficiency of hypergol removal from the GN_2 stream. Although it was decided that stainless steel filler of some sort - nuts, bolts, fittings, etc. would be the ideal material, such material could not be found. Instead the CSP was filled to within 6" of the top with small 1" CaCO_3 stones. This design modification however, did not increase hypergol removal efficiency.

5. CONSTRUCTION

The CSP was fabricated by Cryogenic Experts Inc., CEXI of Canoga Park, California under the direction of Eugene Spearman, P.E., FIT Consultant. The basic element, a heat exchanger, was obtained from Rocketdyne and is numbered 303393.

Diagrams and photographs of the scrubber are shown in the following figures.

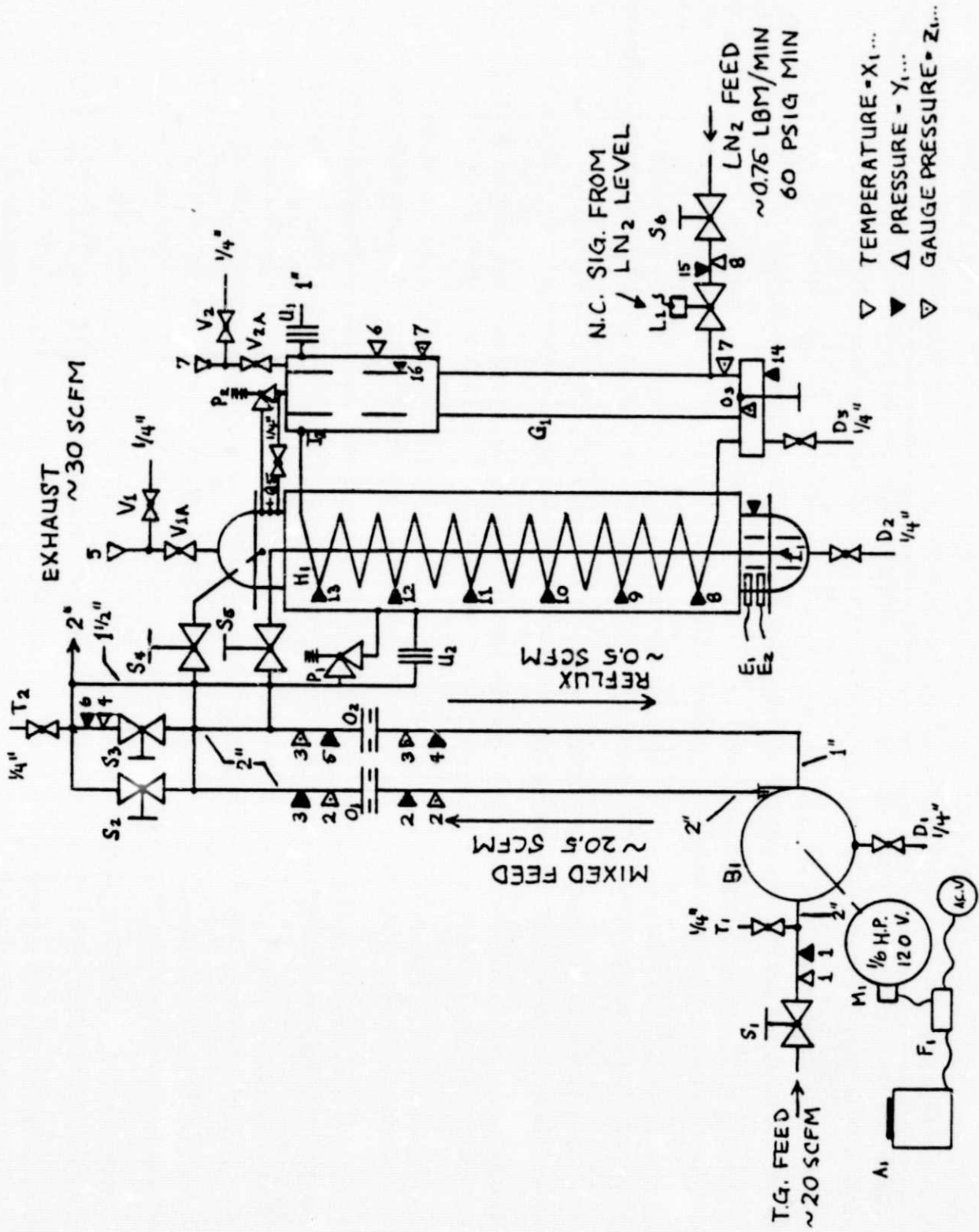


Figure 4A: FLOW DIAGRAM, CRYOGENIC SCRUBBER

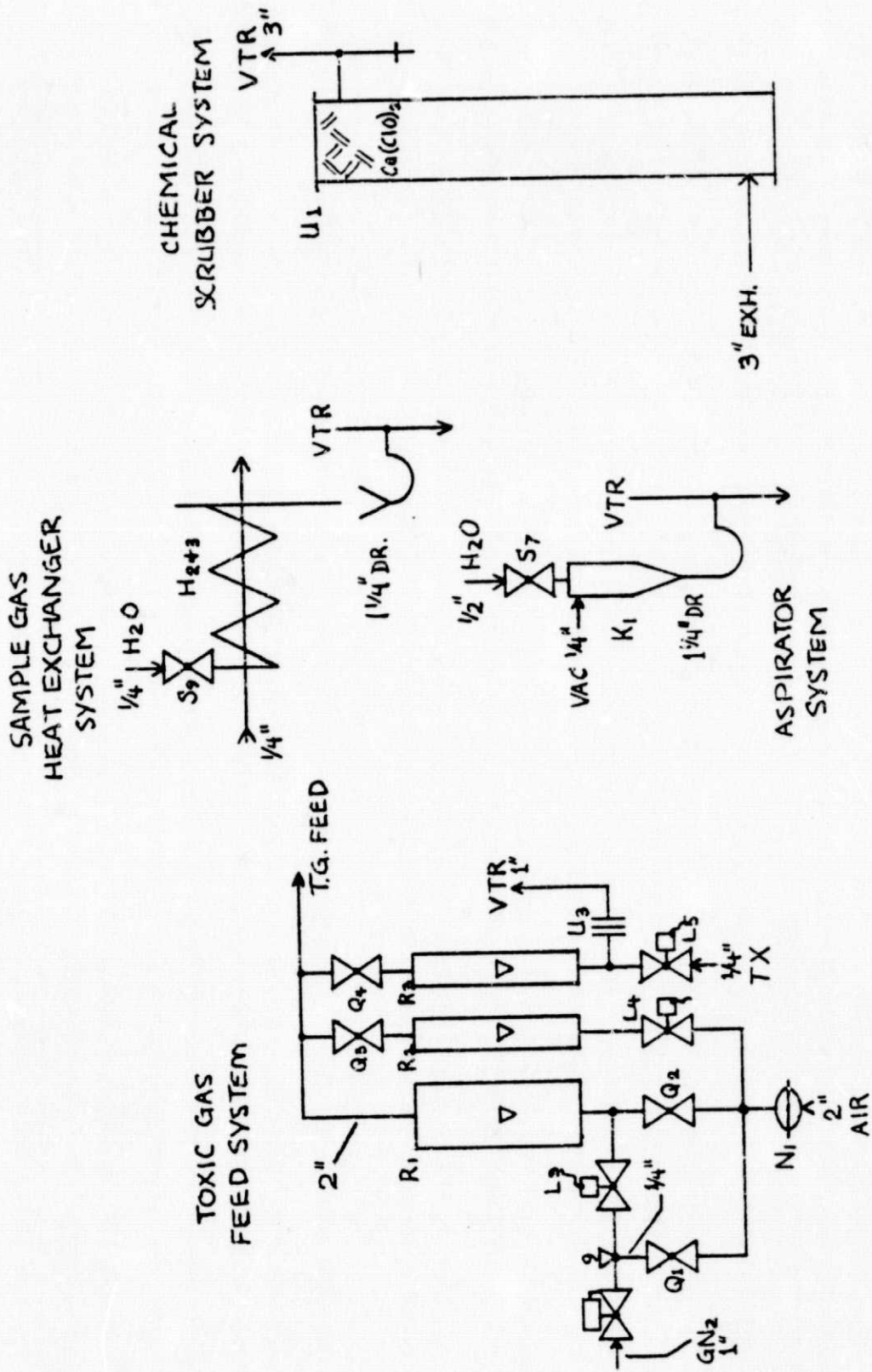


Figure 4B: FLOW DIAGRAM OF CRYOGENIC SCRUBBER ACCESSORY SYSTEMS

Figure 5a. PROTOTYPE SCRUBBER LAYOUT, FRONT VIEW (1/8 scale)
Per G. Spearman, P.E.

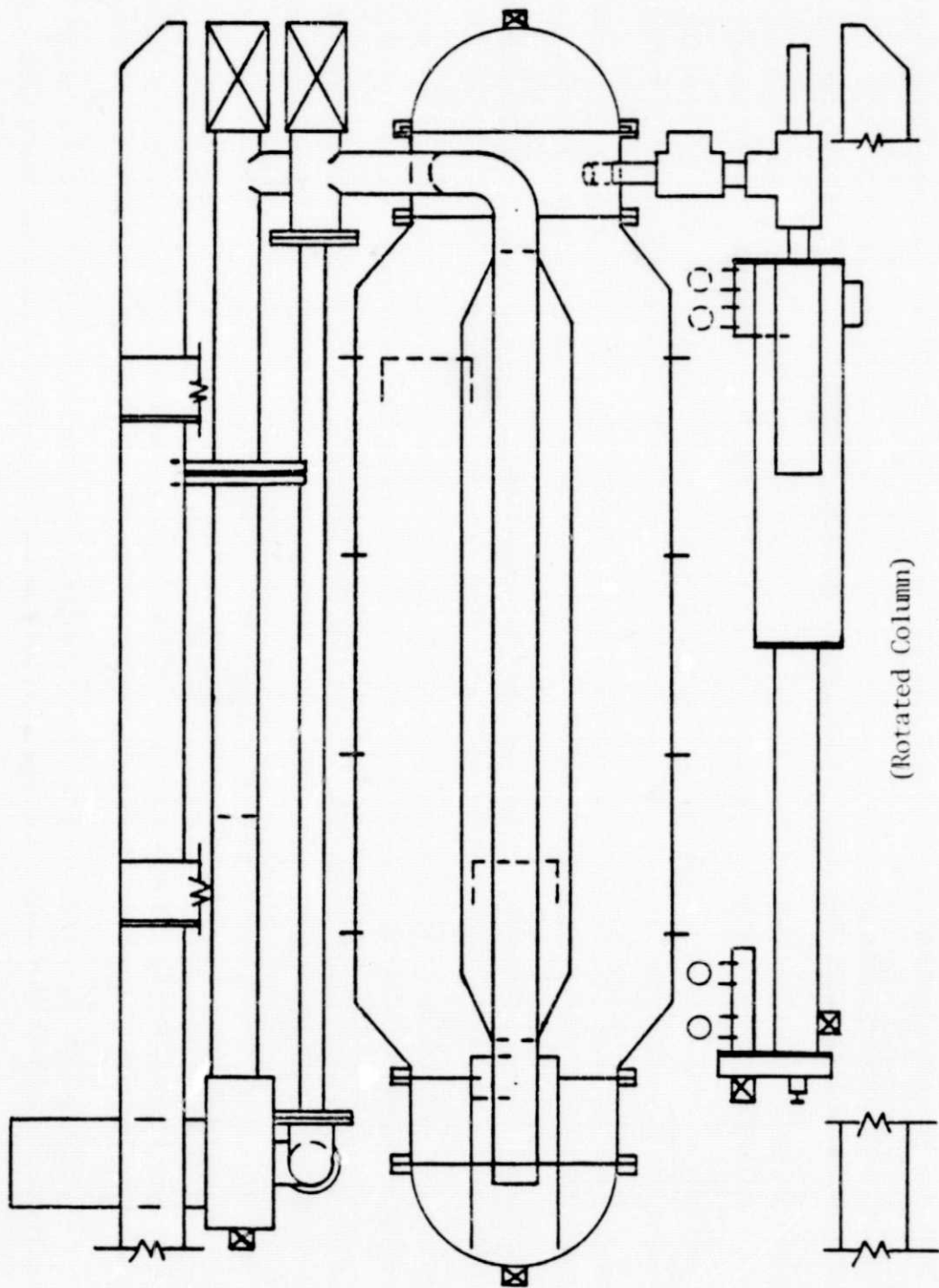
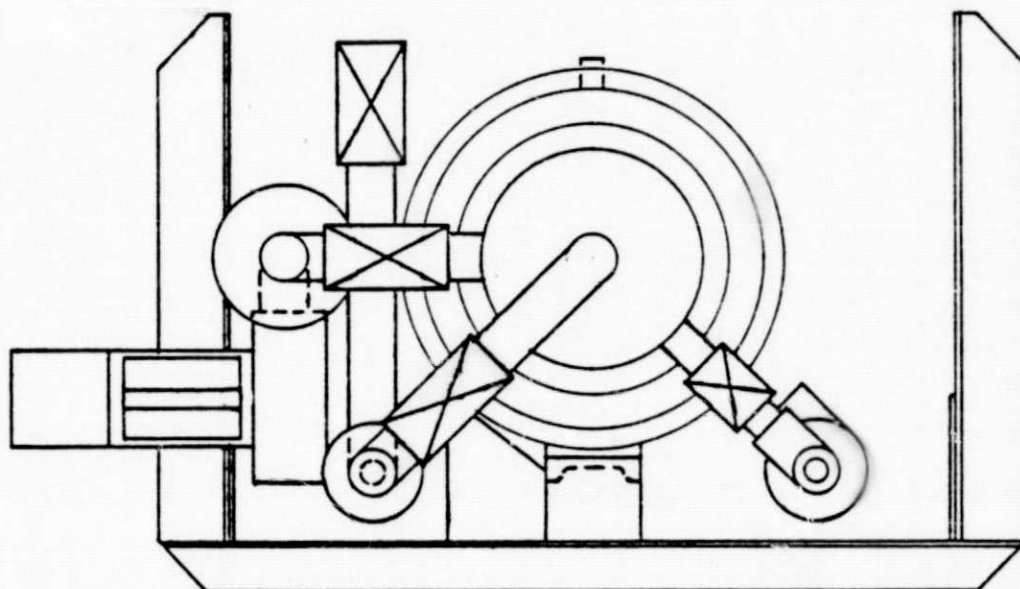


Figure 5b. PROTOTYPE SCRUBBER LAYOUT, TOP VIEW (1/8 scale)
Per G. Spearman, P.E.



A ₁	Transformer, Variable Superior, Series 21	0-140 VAC, 4.5A., 1- ϕ , 60n, 16 lbs. open type
B ₁	Blower, Mill type, 1/3 HP, Cadillac, Model F-10	95 CFM 18"WC.120V.3A, 60n, 12 lbs., plus modif.
C ₁	Control Valve (if required)	
D ₁	Drain Valve 1/4" NPT Mark Whitey IGM 4 316 SS Toggle	
D ₂	Drain Valve 1/4" NPT Mark Whitey IGM4 316 SS Toggle	
D ₃	Drain Valve 1/4" NPT Mrk Whitey I GM 4 316 SS Toggle	
E ₁ & E ₂	Cartridge Heater 375W Chromolox	120 Vac, 3.1A., 1- ϕ , 1000 ^o F. 347 St. St1.
F ₁	Fusetron Dual Element & Base Buxx T-4	250 Vac., 4A., 1- ϕ
G ₁	LN ₂ Column - see detail Fab. by CFX1	
H ₁	LN ₂ Heat Exchanger - Rocketdyne H-1 GG/LOX	
H ₂	Sample Gas Heat Exchanger 1/4" 321 SS Tube in H ₂ O shell	
H ₃	Sample Gas Heat Exchanger 1/4" 321 SS Tube in H ₂ O shell	
I ₁	Inertial Separator - see detail - Fab. by CFX1	
I ₂	Inertial Separator - see Detail - Fab, bt CFX1	
J ₁	EXH. Gas Scrubber - see Detail - Fab. by FIT	
K ₁	Test Gas Aspirator - from FIT	
L ₁	LN ₂ Sol. Valve 1/4" NPT, 120 Vac. N.C. Atromatic, 316 SS, BDGS3008G Cr=0.72	
L ₂	GN ₂ Sol. Valve 1/2" NPT, 120 Vac. N.C. Atromatic, Bronze, AAD 3200 Cr = 0.72	
L ₃	GN ₂ Sol. Valve 1/8" NPT, 120 Va. N.C. Atromatic 316 SS, SBTD 1002, CR=.093	
L ₄	Toxic Gas Sol. Valve 1/8" NPT Atromatic 316 SS, GBTD 1002, CR=.093	

M₁ Blower Motor (see B₁ above)
 N₁ Air Filter 3/8" SAE Flare 0.3u D.O.P.
 MSA 78606 with 95302 Element
 O₁ Mixed Feed Flow Orifice 3/4" Bno.45
 316 SS x 0.50" Plate - CEX1
 O₂ Reflux Flow Orifice 1/8" Bno.15
 316 SS x 0.50 Plate - CDX1
 O₃ LN₂ RGSTR. FLOW Orifice - 5/32" DIA
 See detail - Fab by CEX1
 P₁ Back Pressure Relief Valve 3/4" x 1" NPT,F.
 Sage Model 433413 50 PSIG Back Pressure, 0.015⁻²/_{IN}
 P₂ Pressure Safety Relief Valve 3/4" x 1" NPT, F.
 Sage Model 433413 30 PSIG Back Pressure, 0.015⁻²/_{IN}
 Q₁ GN₂ Trim Control Valve 1/2"
 Q₂ Air Trim Control Valve 1/2"
 Q₃ GN₂ Mixing Flow Valve 1/4" - 316 SS
 Q₄ Toxic Gas Mixing Flow Valve 1/4" - 316 SS
 Q₅ GN₂ Reflux Flow Valve 1/4" AN C_v=0.019.
 NUPRO SS-4BMW
 R₁ Make VP Gas Flow Meter, 2" - 44SCFM @ 9" W.C.
 Fischer & Porter 10 A 3500 Brass Low△P.
 R₂ Diluent Gas Flow Meter, 1.3 to 23,000 cc/min.set
 Century Triflat, Fischer & Porter # 80A451
 R₃ Toxic Gas Flow Meter, 1.3 to 23,000 cc/min. set
 Century Triflat, Fischer & Porter #80A451
 S₁ Toxic Gas Feed Throttle Valve 2" - 316 SS
 S₂ Heat Exchanger Bypass Valve 2" - 316 SS
 S₃ Exhaust Gas Blocking Valve 2" - 316 SS
 S₄ Heat Exch. Isolation Supply Valve 2" - 316 SS
 S₅ Heat Exch. Isolation Exh. Valve 2" - 316 SS

T ₁	Toxic Gas Feed Sample Valve ½" NPT Mark Whitey IGM4 316 SS Toggle	
T ₂	Toxic Gas Exh. Sample Valve ½" NPT Mark Whitey IGM4 316 SS Toggle	
U ₁	Rupture Disk 1" Aluminum - BS&B BV1" 60 PSIG Ambient	
U ₂	Rupture Disk 1½" TFE/Halon - BS&B DV 1½" 40 PSIG Ambient	
U ₃	Rupture Disk 1" TFE/Halon, BS & B DV 1" 50 PSIG Ambient	
V ₁	Vent Valve ½" N.P.T., Mark Nupro 316-4P-4M	C _v =0.043, 1/16" Port
V ₂	Vent Valve ½" N.P.T., Mark Nupro 316-4P-4M	C _v =0.043, 1/16" Port
V ₃	Vent Valve ½" N.P.T., Mark Nupro 316-4P-4M	C _v =0.043, 1/16" Port

SEALANT - Silastic - Gen. Elec. \$108

INSULATION - Polyurethane "INSTAFQAM" - ½ Cu. Ft. Spray Cans

BIGHAM INSULATION (Bob Bryant) (305) 522-2887
P.O. Box 22146
Fort Lauderdale, Florida 33315

TEMPERATURE PROBES (D = Probe immersion, inches)

- X₁ - Toxic gas feed, $\pm 50^{\circ}\text{C}$ Base, 1" D, Model 78 H 09, CAL A-C (TYP) with $\frac{1}{4}$ " NPT. Comp. fitting (TYP).
- X₂ - Mixed Feed, -200°C Base, 1" D.
- X₃ - Mixed Feed, $\pm 50^{\circ}\text{C}$ Base, 1" D.
- X₄ - Reflux, -200°C Base, $\frac{1}{2}$ " D.
- X₅ - Reflux, $\pm 50^{\circ}\text{C}$ Base, $\frac{1}{2}$ " D.
- X₆ - EXN.1, -200°C Base, 1" D.
- X₇ - Exch. Sump, -200°C , 3" D.
- X₈ - Exch. Coil, -200°C , Base, $2\frac{1}{2}$ " D (200 r @ 0°C)
- X₉ - " " " " " "
- X₁₀ - " " " " " "
- X₁₁ - " " " " " "
- X₁₂ - " " " " " "
- X₁₃ - " " " " " "
- X₁₄ - LN₂ sump, -200°C Base, $\frac{1}{2}$ " D.
- X₁₅ - LN₂ Feed, -200°C Base, $\frac{1}{2}$ " D (may use T.C.)
- X₁₆ - GN₂ Exh., -200°C Base, 3" D.

CEXI - F.I.T. FURNISH

Rosemount series 78, Platinum resistance, 316 SS Capsule sensor, Comp. Loop lead wires with Model 442 A Alpha line temperature transmitter: RTD to 4-20 mA outputs.

13 x MTRS - 442 A RG A 200C M200 NIN

x x MTRS - 442 A RG A 200C M50 NIN

DELTA PRESSURE PROBES (D = Nom. mid range, inch)

$\frac{1}{2}$ - Mixed Feed Flow - Model 1151 DP 3 A 22 5 M (TYP) with 2- $\frac{1}{4}$ " NPT 2 1/8" D.C. (TYP)

D = 2 $\frac{1}{2}$ " @ AMB. Temp.

B ~ 0.45 on 2" DIA. (O₁)

1/3 - Reflux Flow

D = 2 $\frac{1}{2}$ " @ AMB. Temp.

B ~ 0.15 on 1" DIAM. (O₂)

1/7 - LN₂ Level - Model 1151 DP 3 A 22 LM with 2- $\frac{1}{4}$ " NPT 2 1/8" D.C.

D = 15" @ LN₂ Temp. Orifice DM 3/32" (O₃)

(Furnish ADV. Sol. Valve sig.)

3 - Rosemount Model 1151DP Alphal line pressure XMIDS.

GAGE PRESSURE PROBES (D = Nom mid range, as noted)

Z₁ - Toxic Gas Feed $\frac{1}{4}$ " NPT, 0-10" V.W.C. Vert. Manometer, DWYER \$104.

Z₄ - Exhaust Gas $\frac{1}{4}$ " NPT. 0-7" P.W.C. included Manometer, Dwyer \$26.

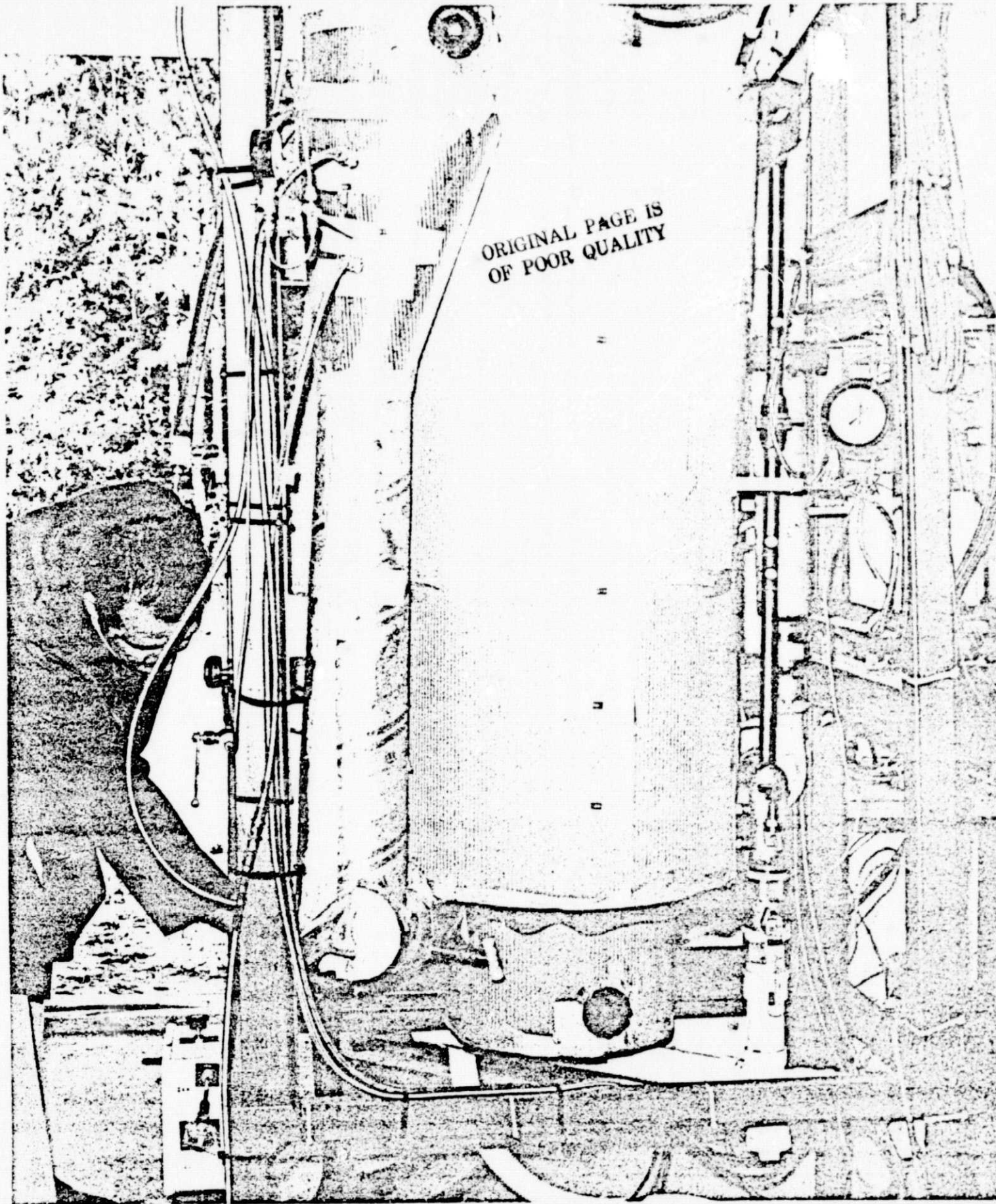
Z₅, 7 & 8 - HT. XCH'R $\frac{1}{4}$ " NPT 0-60 PSIG 3 $\frac{1}{2}$ " Bourdon Gage w/Diaph.

Z₆ - GN₂ col. Model 1144 G 0120 A 22 LM with 1- $\frac{1}{4}$ " NPT.

D = 15 PSIG @ LN₂ Temp.

1 - Rosemount Model 1144 G Alpha line Pressure XMIR.

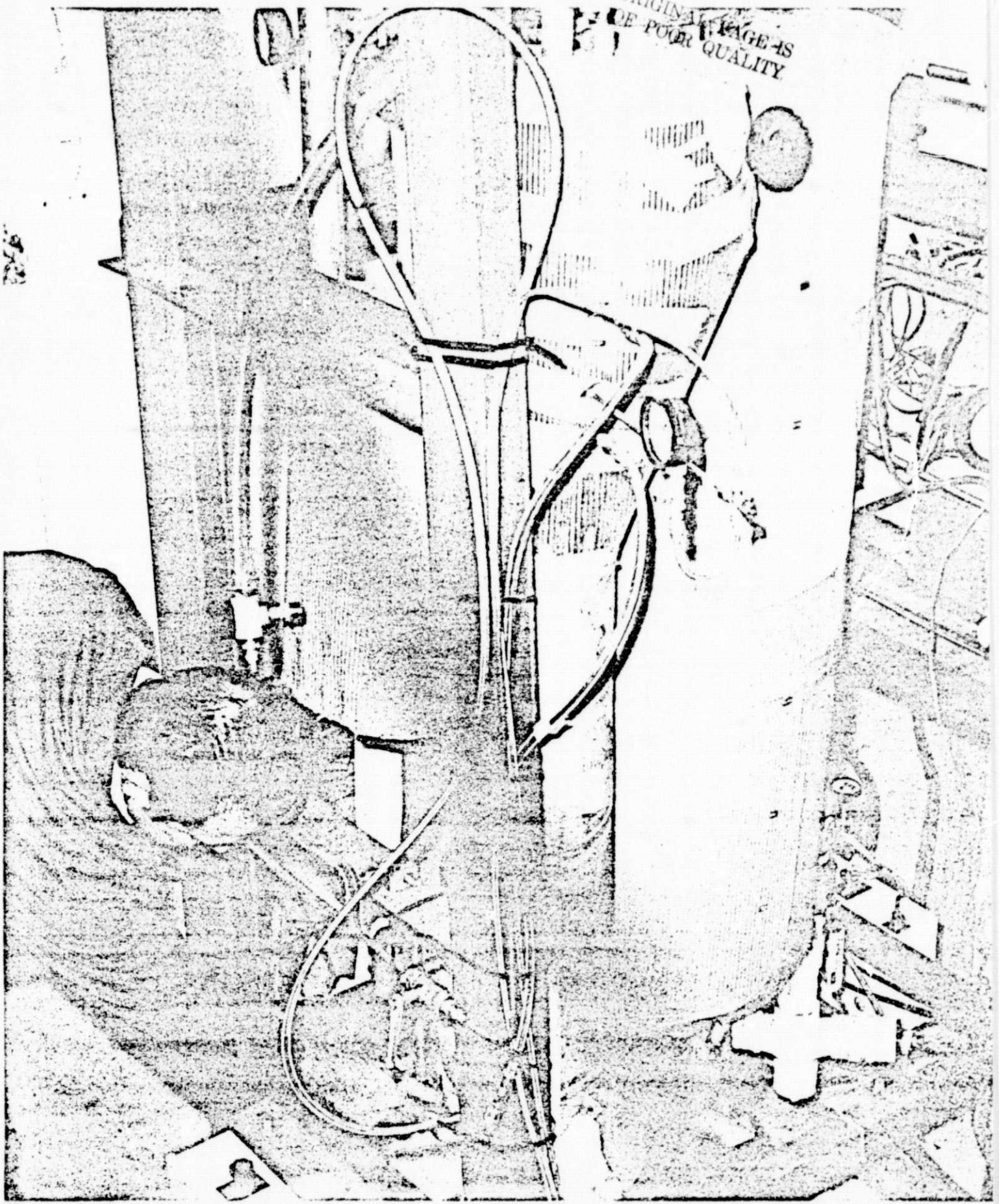
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OPENING THE LN₂ VALVE ON THE CSP

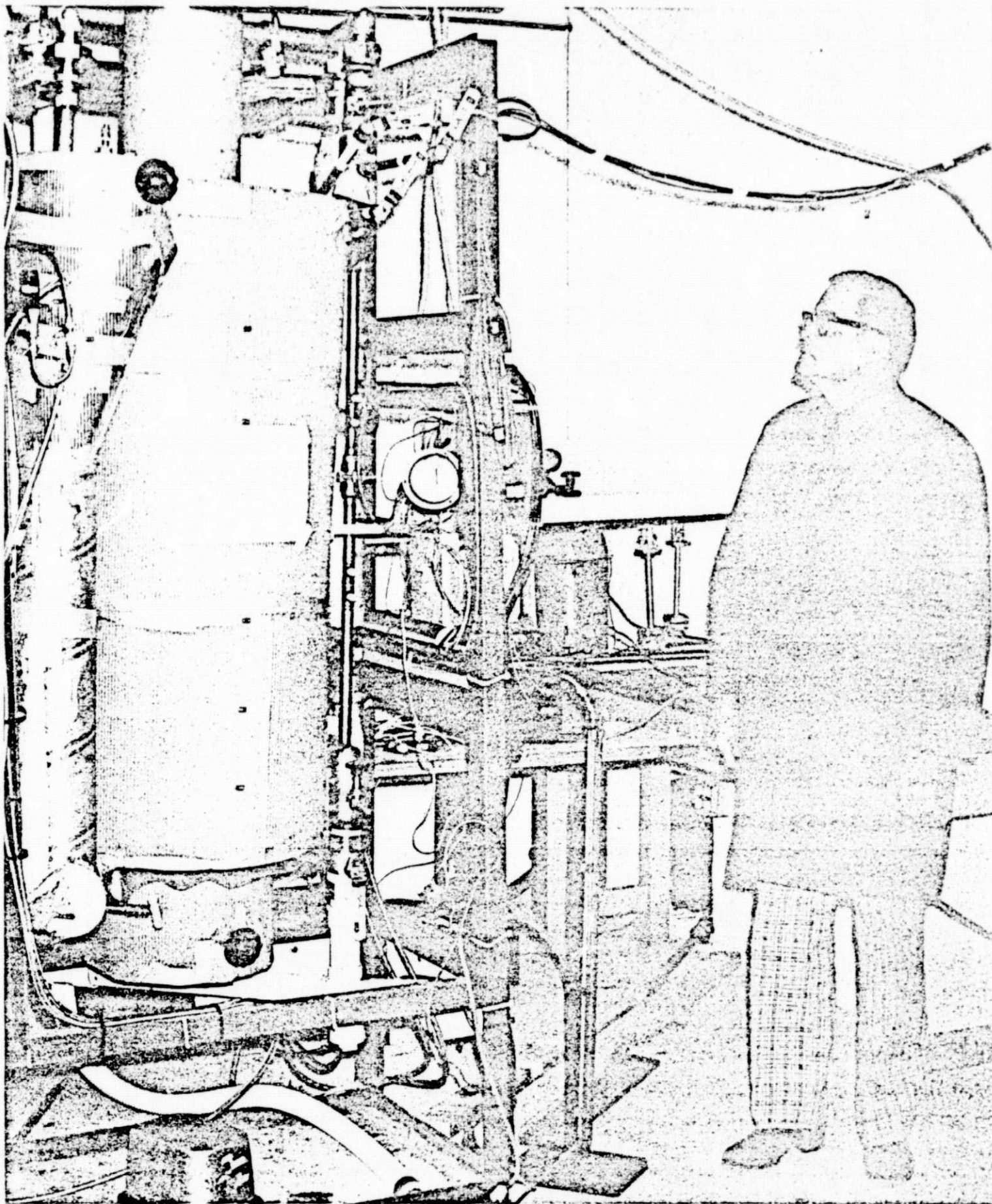
Figure 6

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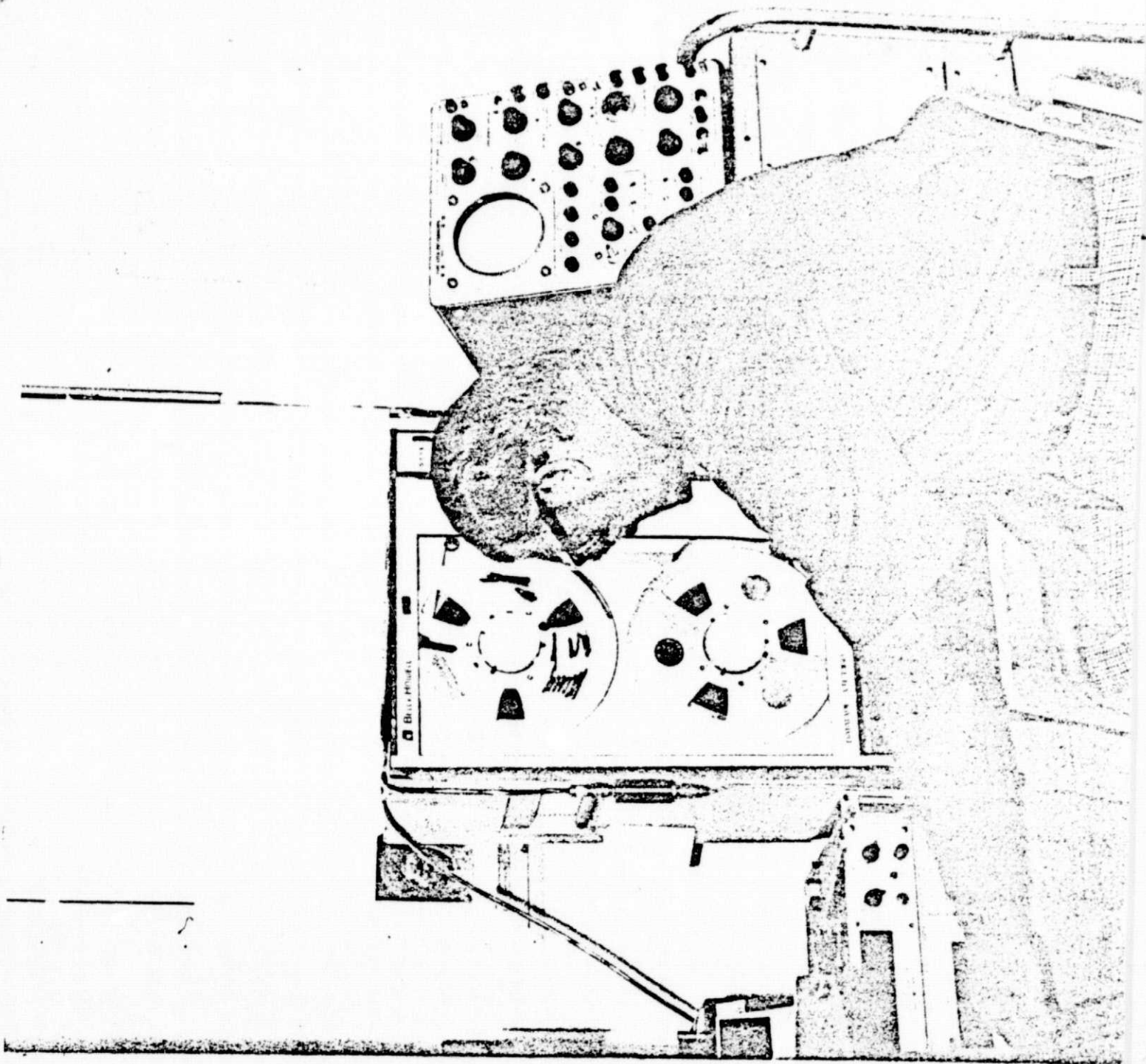
LOOKING DOWN ON THE CSP

Figure 7



THE CSP JUST PRIOR TO OPERATION
Figure 8

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THE TAPE RECORDER FOR THE CSP

Figure 9

6. EXPERIMENTATION

The ability of the CSP to condense atmospheric water from air was the first project undertaken (Experiments 1-2-10-76 to 1-2-19-76) (see Table 2). The blower was used to force air through the CSP which was cooled to about -150°C . The theoretical total amount of moisture condensed was determined from the dew point and the SCF of air put through the system. The actual amount of water condensed was measured by heating the CSP, opening the drain valve D_2 , and measuring the amount of water released. The per cent efficiency is determined by the following simple formula:

$$\frac{\text{Trapped and measured } H_2O \times 100}{\text{Theoretical total amount } H_2O \text{ entering CSP}} = \text{Efficiency } (\%)$$

As is seen, the results are erratic and the efficiencies are poor. They range from 21 to 71% with an average of 55%.

In order to check the validity of these calculations slight modifications of the above experiments were carried out (Experiments 1-2-20-76 to 1-2-24-76 and 1-3-3-76 to 1-3-5-76). A measured amount of water was converted to steam and merged with a 5-20 SCFM GN_2 stream which was supplied from a portable LN_2 tanker supplied by Union Carbide of Mims, Florida. Using this method the entering quantity of water can be measured directly. However, the efficiencies decreased even more when this method was used. They ranged from 11 to 47% with a mean of 30%. Two values of greater than 100% were discarded due to experimental error caused by failure to completely purge the CSP before initiating experiments.

Experiments 1-2-25-76 and 1-2-26-76 measured the efficiency of MMH condensation from a GN_2 stream. As can be seen from the Table, the efficiencies

ranged from 0 to 33%. The input measurement was taken just prior to entry into the scrubber system at T_1 . The output measurements were taken at a point just before exiting to the outside scrubber. P.P.M. concentrations of MMH were made using Drager tubes obtained from KSC. These results only served to substantiate the initial findings with water and thus further experimentation with MMH became unjustifiable. However, experiments using $\text{NO}_2\text{-N}_2\text{O}_4$ seemed warranted since our initial laboratory data was obtained on this material. The initial experiment (1-3-1-76) with $\text{NO}_2\text{-N}_2\text{O}_4$ is shown in Table 2. Again the results were unpromising.

The remaining experiments were conducted using N_2O_4 and are listed in the Table as Experiments 1-3-30-76 and 1-4-1-76. Both of these experiments were concerned with determining the effects of CSP temperature on the scrubbing efficiency. Again, the measurements were made using Drager tubes. As is seen, no experiments resulted in scrubbing efficiencies greater than 0. These results were clearly unpromising and experimentation on the CSP was discontinued.

The LN_2 usage for each experiment is delineated in Table 2. Each experiment required on the average 1.0 P.S.I. per hour run. A P.S.I. unit is equivalent to 2857 SCF of GN_2 , which in turn is equivalent to 100 K of LN_2 , which equals 220 lbs. Thus, scaling up the CSP for the full-size unit would require approximately 26,400 lbs. of LN_2 for one 6-hour run. This is 13.25 tons which at present prices of \$80.00/ton amounts to \$1,060. If we assume that 110 lbs. of N_2O_4 will be vented during the loading process, this means that each lb. of N_2O_4 removed from the vent stream will cost \$9.64. This is clearly unacceptable.

The calculated input concentration column in Table 2 was determined from flow rate data of the GN_2 stream and the hypergol stream. The large differences between the calculated input concentration and the experimental input concentration is due to hypergol condensation in the feed lines. This was qualitatively confirmed several times.

The following experiment was conducted in an attempt to minimize LN_2 usage. The CSP was cooled down to -190°C and a small bleed into the CSP was allowed overnight. However, the CSP did not remain cool overnight using this technique and by morning of the following day, the temperature of the CSP was ambient. Therefore, a basic design modification of the CSP appears necessary if only to control LN_2 usage.

THE CRYOGENIC SCRUBBER PROTOTYPE EXPERIMENTATION

Experiment Number	Time of Run (Hours)	CSP Fan Voltage	Flow Rate SCFM	Input Material (carrier gas)	Total Input H ₂ O (ml)	Calculated Input Concentration (ppm)	Experiment Input Concentration (ppm)
1-2-10-76	1.5	30	3*	H ₂ O, Air	63*		6,556
1-2-11-76	1.5	60	6*	H ₂ O, Air	127*		6,556
1-2-13-76	1.5	60	6*	H ₂ O, Air	205*		11,076
1-2-16-76	1.4	30-90	10-30	H ₂ O, Air			
1-2-19-76	1.1	60	6*	H ₂ O, Air	128*		9,312
1-2-20-76	4.3	60	20	H ₂ O, GN ₂	10		
1-2-23-76	3.9	60	20	H ₂ O, GN ₂	150		
1-2-24-76	3.9	60	20	H ₂ O, GN ₂	30		
1-2-25-76	3.0	40	20	MMH, GN ₂		1,776	6
						1,776	30
1-2-26-76	3.7	60	20	MMH, GN ₂		12,302	20
1-3-1-76	1.2	60	20	N ₂ O ₄ , GN ₂		1,783	60±10
						892	60±10
1-3-3-76	2.0	45	10	H ₂ O, GN ₂	8.0		
1-3-4-76	2.0	45	10	H ₂ O, GN ₂	28.0		
1-3-5-76	2.0	45	5	H ₂ O, GN ₂	35.0		
1-3-30-76	1.0	60	5	N ₂ O ₄ , GN ₂		3,600	75±10
		60	5	N ₂ O ₄ , GN ₂		3,600	75±10
		60	5	N ₂ O ₄ , GN ₂		3,600	75±10
		60	5	N ₂ O ₄ , GN ₂		3,600	75±10
		60	5	N ₂ O ₄ , GN ₂		3,600	75±10
1-1-76	1.0	60	5	N ₂ O ₄ , GN ₂		3,600	75±10
		60	5	N ₂ O ₄ , GN ₂		3,600	75±10
		60	5	N ₂ O ₄ , GN ₂		3,600	75±10
		60	5	N ₂ O ₄ , GN ₂		3,600	75±10
		60	5	N ₂ O ₄ , GN ₂		3,600	75±10

TABLE 2

continued

Experiment Number	Lowest Temperature	Effluent Concentration (ppm)	Time of Assay (Hours)	Total Amount Recovered From CSP (ml)	% Efficiency	Amount LN ₂ Used (P. S. L.)
1-2-10-76	-150			40	63*	0.5
1-2-11-76	-150			90	71*	1.3
1-2-13-76	-165			44	21*	1.3
1-2-16-76	-160					1.6
1-2-19-76	-137			80	63*	1.0
1-2-20-76	-160			10	100 ^a	2.6
1-2-23-76	-160			70	47	2.5
1-2-24-76	-155			12	40	3.0
1-2-25-76	-150	0.5	1.9		92 ^b	Gauge mal- function
		20	3.0		33	
1-2-26-76	-25	20	3.7		0	1.5
1-3-1-76	-165	60±10	0.5		0	1.75
		60±10	0.6		0	
1-3-3-76				10.0	>100 ^a	2.0
1-3-4-76				3.0	11	4.5
1-3-5-76				8.0	23	1.5
1-3-30-76	-178	75±10	0.00		0	0.5
	-168	75±10	0.25		0	
	-164	75±10	0.50		0	
	-158	75±10	0.75		0	
	-153	75±10	1.00		0	
1-4-1-76	-5	75±10	0.00		0	
	-27	75±10	0.25		0	
	-53	75±10	0.50		0	
	-77	75±10	0.75		0	
	-107	75±10	1.00		0	

* High Estimate.

^aResult due to experimental error.^bEarly in MM run.

7. DISCUSSION

As mentioned earlier in the design section of this report, there are several significant differences between the CSP and the laboratory model. Whether any of these is significant in terms of performance can only be determined by further experimentation. However, there was one phenomenon observed which is worthy of mention and may eventually lead to some concrete answers.

In the laboratory experiments, the bright blue frozen NO_2 collected in one place to such an extent that blockage became a significant problem. However, the CSP presented the opposite problem. In spite of the fact that the effluent gas from the CSP was extremely cold (-87°C), large amounts of NO_2 , MMH and H_2O would not collect inside the CSP. Also, the amounts of LN_2 used in these experiments would be prohibitive if scaled up to the amounts required in the Shuttle program. Since most of the LN_2 is utilized in the initial chilldown, and very little is used during the "scrubbing" process, any practical design using the cryogenic principle must be analogous to that shown in Figure 1. This type of design will allow the cryogenic scrubber (CS) to remain cold at all times and thus utilize a minimum of LN_2 . Using this design, once the LN_2 has been depleted to a certain level all that is required is for the vessel to be refilled. The technology of maintaining LN_2 in closed vessels with small bleeds has been well established, therefore such designs should be no real problem, particularly if the "footprint" in which the system must sit is not too restrictive.

8. FINAL RECOMMENDATIONS

The CSP did not yield any sort of results which could be called encouraging enough to yield design criteria within the currently established time frame. However, the sound theoretical concepts and the highly promising laboratory data seem to indicate that the inability of the CSP to function is related to basic design and/or materials problems. Thus, it is recommended, before any construction of a new CSP is undertaken, that basic design and materials specifications be decided upon as a consensus of experts from KSC, FIT, industry and academia in general, and that laboratory scale experiments be resumed. These experiments should be on a scale of 1/10 to 1/4 of the current CSP.