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United States Patent [19] DeLay

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[54] **COMPOSITE TANK**

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[51] Int. Cl.⁷ **B65D 7/00**

[52] U.S. Cl. **220/62.17; 589/590**

[58] Field of Search **220/62.15, 62.19, 220/62.17, 62.22, 581, 586, 588, 589, 590**

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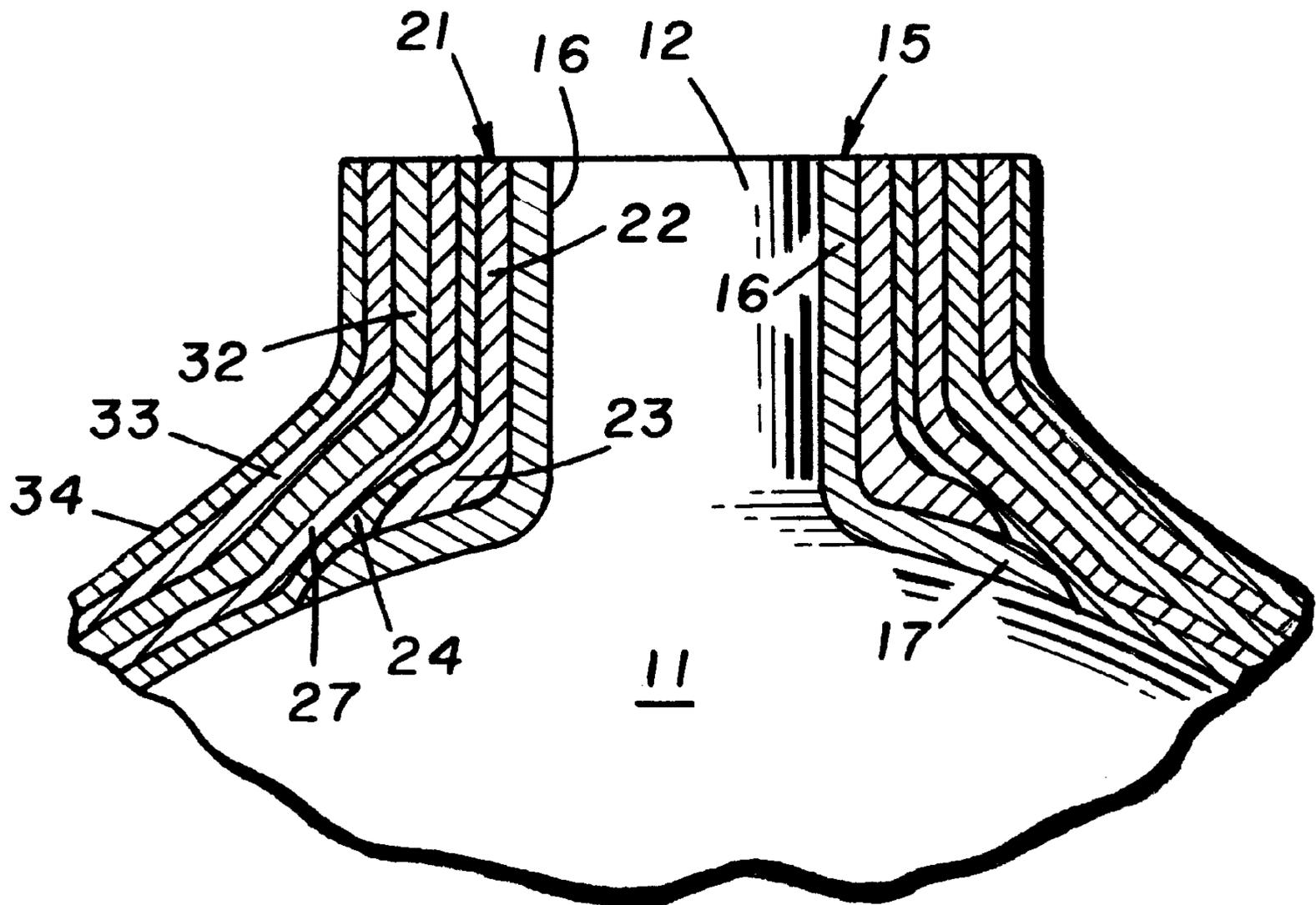
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[57] **ABSTRACT**

A composite tank for containing liquid oxygen and the method of making the same wherein a water-soluble mandrel having the desired tank configuration and a cylindrical protuberance on at least one end is fitted with an inner boss conforming to the configuration of the mandrel and an outer boss conforming to the configuration of the inner boss, the bosses each having a tubular portion for receiving the protuberance on the mandrel and a spherical portion. The mandrel and the bosses are first coated with a nickel coating. The mandrel is then wrapped with graphite fibers wetted with an epoxy resin and this resin is cured. A layer of insulating foam is then applied to the tank and cured. The insulating foam is machined to a desired configuration and a layer of aramid fibers wetted with a second epoxy resin is wrapped around the tank. The second resin is cured and the water soluble mandrel is washed from inside the tank.

4 Claims, 1 Drawing Sheet



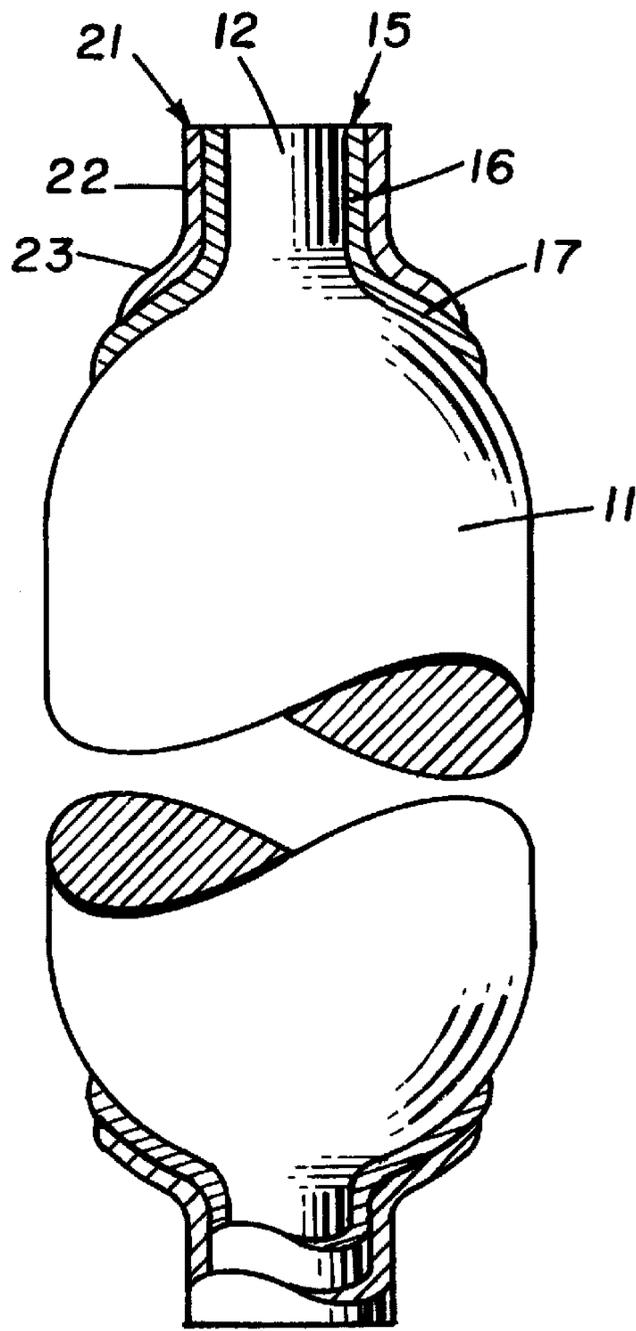


FIG. 1.

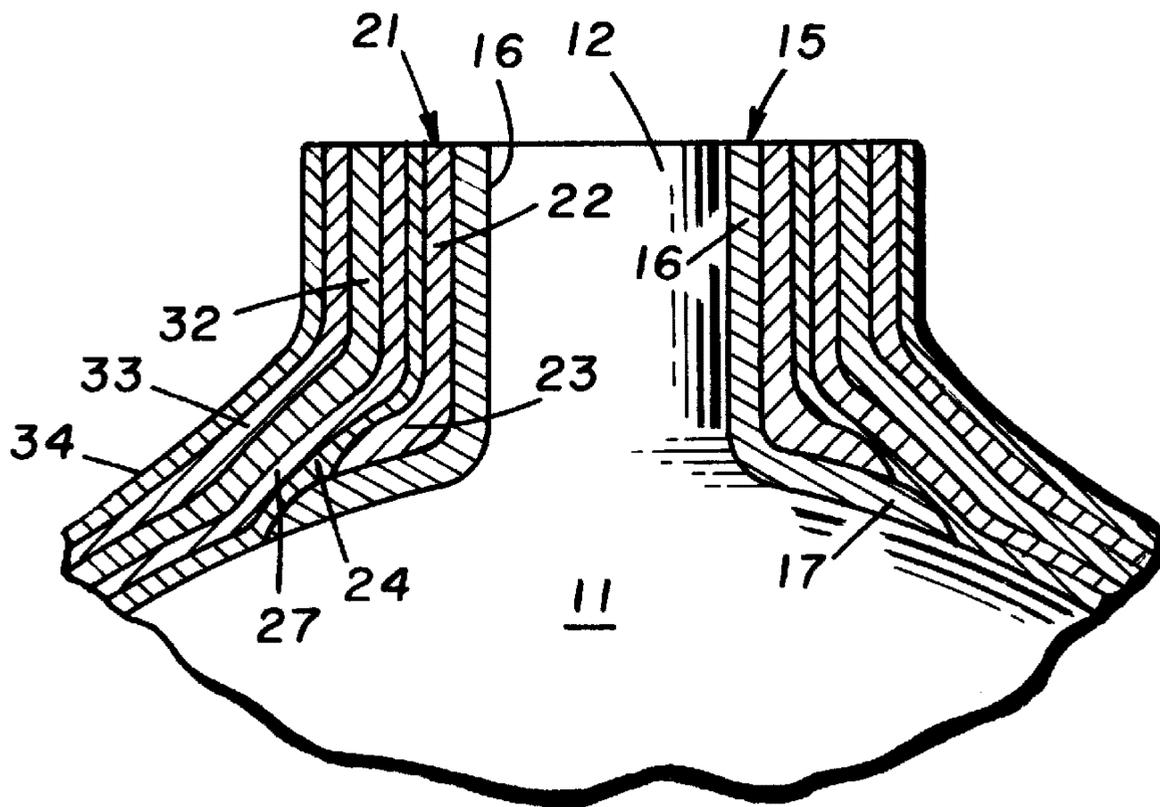


FIG. 2.

COMPOSITE TANK**ORIGIN OF THE INVENTION**

This invention was made by an employee of the United States Government and may be manufactured or used by or for the Government for Governmental purposes without the payment of royalties thereon or therefor.

BACKGROUND OF INVENTION

1. Field of the Invention

This invention relates to composite tanks.

2. Prior Art

It is known to make tanks from composite materials for various purposes. There has been considerable prior art in general for double-walled tanks for puncture resistant underground storage of environmentally hazardous chemicals, for example. There is a need for tanks and pressure vessels for the containment of fuels for aerospace and military applications. The new launch vehicles for NASA and DOD require extremely light weight hardware that is compatible with the containment of cryogenic liquid fuels and oxidizers. Long term deep space missions have even more critical and stringent storage requirements.

SUMMARY OF THE INVENTION

A composite tank for containing liquid oxygen and the method of making the same wherein a water-soluble mandrel having the desired tank configuration and a cylindrical protuberance on at least one end is fitted with an inner boss conforming to the configuration of the mandrel and an outer boss conforming to the configuration of the inner boss, the bosses each having a tubular portion for receiving the protuberance on the mandrel and a spherical portion. The mandrel and the bosses are first coated with a nickel coating. The mandrel is then wrapped with graphite fibers wetted with an epoxy resin and this resin is cured. A layer of insulating foam is then applied to the tank and cured. The insulating foam is machined to a desired configuration and a layer of aramid fibers wetted with a second epoxy resin is wrapped around the tank. The second resin is cured and the water soluble mandrel is washed from inside the tank.

DESCRIPTION OF THE DRAWINGS

FIG. 1 is a side view of the mandrel on which the composite tank is to be formed showing the inner and outer bosses at the ends of the mandrel.

FIG. 2 is a greatly enlarged fragmentary view showing the structure making up the composite tank.

DETAILED DESCRIPTION OF THE INVENTION

Referring now in detail to the drawings there is shown in FIG. 1 a mandrel **11** having a desired tank configuration and a pair of cylindrical protuberances **12** extending from each end. Positioned on each protuberance **12** is an inner boss **15** which is made up of a tubular portion **16** and a spherical portion **17**. The tubular portion **16** snugly fits the protuberance **12** while the spherical portion conforms to the configuration of the end of the mandrel **11**. The inner bosses **15** are made of a nickel plated metal, preferably aluminum.

Positioned on the inner bosses **15** are a pair of outer bosses **21** made up of graphite fibers embedded in a cured epoxy resin matrix. The outer bosses have tubular portions **22** secured to spherical portions **23**. The tubular portions fit snugly on the tubular portions **16** of the inner bosses **15** and the spherical portions **23** conform to the outer surfaces of the spherical portions **17** of the inner bosses **15**.

After the inner and outer bosses **15** and **21**, respectively, are in place the mandrel and the bosses are coated with a nickel coating **24**. This coating, shown in FIG. 2, may be applied by an electroforming process or by a vacuum plasma spraying process. The diameters of the spherical portions **17** of the inner bosses **15** are greater than the diameters of the spherical portions **23** of the outer bosses. This is to insure that when the nickel coating is applied it will cover the exposed portion of the spherical portions **17** of the inner bosses **15** to completely seal the graphite outer bosses **21** in a nickel coating.

After the nickel coating has been applied to the mandrel and the bosses, the mandrel **11** is wrapped with a tow of graphite fibers wetted with an epoxy resin and the epoxy resin is cured to form a first layer **27** of graphite fibers embedded in a cured resin matrix. A layer **32** of an insulating foam is then sprayed onto the tank and, after curing, is machined to the desired configuration. Preferably, the foam is a polyurethane foam.

A tow of aramid fibers wetted with an epoxy resin is then wrapped over the insulating foam and the resin is then cured to provide a layer **33** of aramid fibers embedded in a cured epoxy resin matrix. If desired, a thin coating **34** of rubber may be sprayed over the aramid fiber layer. The water-soluble mandrel **11** is then washed out of the tank to leave a very strong tank. The bosses at each end provide for access to the interior of the tank.

What is claimed is:

1. A composite tank for holding liquid oxygen, comprising
 - a. nickel liner;
 - b. a layer of carbon fibers wrapped around the nickel liner in a cured matrix of an epoxy resin;
 - c. a layer of foam insulation surrounding the graphite fiber layer;
 - d. a layer of an aramid fiber wrapped around the foam insulation, said aramid fiber being in a cured matrix of an epoxy resin, said tank having at least one boss on the periphery thereof, said boss being made up of an inner boss of a metal plated with nickel and an outer boss of graphite fibers in a cured epoxy resin, said nickel liner covering the bosses.
2. The tank of claim 1 wherein the bosses are each made up of a tubular portion secured to a spherical portion having a diameter, the diameter of the spherical portion of the inner boss being greater than the diameter of the spherical portion of the outer boss.
3. The tank of claim 2 wherein the boss is on an end of the tank.
4. The tank of claim 3 wherein the inner boss is nickel plated aluminum.

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