

G. T. SCHJELDAHL COMPANY  
Northfield, Minnesota

DEVELOPMENT OF A 425 FOOT DIAMETER  
PASSIVE COMMUNICATION SATELLITE WITH  
SELF-ERECTING PROPERTIES

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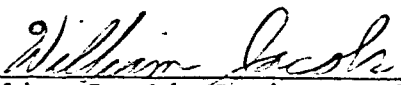
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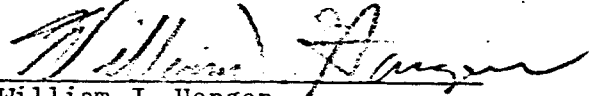
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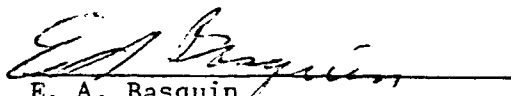
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## TABLE OF CONTENTS

|                                                                                                | <u>Page</u> |
|------------------------------------------------------------------------------------------------|-------------|
| 1.0 INTRODUCTION                                                                               | 1           |
| 2.0 SUMMARY                                                                                    | 2           |
| 3.0 DISCUSSION                                                                                 | 3           |
| 3.1 Evaluation of Dacron-Glass Combination Fabric                                              | 3           |
| 3.2 Evaluation of Sizing Agens                                                                 | 6           |
| 3.2.1 Commercially Available Sizes                                                             | 6           |
| 3.2.2 Laboratory Prepared Sizes                                                                | 10          |
| 3.3 Seam Study                                                                                 | 14          |
| 3.4 Cyclic Flexural Resistance Testing                                                         | 17          |
| 3.4.1 NASA Supplied Testing Machine                                                            | 18          |
| 3.4.2 Schopper Tester (ASTM 643-63T)                                                           | 23          |
| 3.5 Mathematical Treatment Relating Measurable Properties to Ultimate Uses of this Material    | 23          |
| 3.5.1 Comparion of Theoretical Stiffness                                                       | 23          |
| 3.5.2 Relationship of Flexural Rigidity and the Radius of Cylinder in a Space Environment      | 25          |
| 3.6 Production Runs                                                                            | 25          |
| 3.6.1 PVOH Sized Material with Vapor Deposited Aluminum                                        | 26          |
| 3.6.2 Definition of New Numbering System                                                       | 29          |
| 3.6.3 Description of Runs 132, 133, 134                                                        | 30          |
| 3.6.3.1 132                                                                                    | 30          |
| 3.6.3.2 133                                                                                    | 30          |
| 3.6.3.3 134                                                                                    | 31          |
| 3.7 Description of Controlled Atmosphere Chambers                                              | 33          |
| 4.0 FUTURE PLANS                                                                               | 37          |
| APPENDIX A Derivation of Expected Radius of Cylinder Fabricated from State-of-the-Art Material |             |

## 1.0 INTRODUCTION

The objective of this contract is to develop a material with the following properties:

1. Ability to erect without an inflation system or external aids.
2. Open mesh configuration, 90 per cent open to solar radiation.
3. Rigidity to withstand solar pressure with a safety factor of 5.0.
4. Radio frequency reflectivity (8-9 GHz) 95-98 per cent that of a similar solid surface.

This report discusses work performed during the June-August period. The information that would appear in an August monthly report is included as part of this report.

## 2.0 SUMMARY

N66-39997

A fabric was prepared from a Dacron-glass combination yarn and compared to a similarly woven sample of fiberglass. It was found that the fiberglass fabric had superior flexural rigidity and tensile strength.

A number of sizing agents were evaluated, three commercial and ten laboratory sizes. Of these supplied by Hess, Goldsmith a polyvinyl chloride size appeared the best. Of the laboratory applied size Silane A1100 had the highest tensile strength and flexural rigidity.

Of the four seam designs tested a simple overlap had the lowest resistance.

Work on the determination of the fold resistance of the material is described. The effect of folding on electrical resistance is discussed.

Several pilot production runs were made during this period, and data are presented describing the properties.

*Author*

### 3.0 DISCUSSION

#### 3.1 EVALUATION OF DACRON-GLASS COMBINATION FABRIC

A sample of a fiberglass-Dacron combination yarn was secured from Owens-Corning. This combination, GDD941(1/2) 4.4S, is a 40 denier Dacron yarn twined with ECD 900 1/0 glass yarn. To evaluate this yarn it was necessary to prepare a fabric so that a comparison to the present glass fabric could be made. A hand loom was used to make simple, basket-weave fabrics from both GDD941 4.4S and ECD 900 1/2 1.0 Z, a fiberglass yarn similar to the yarn used to weave Hess, Goldsmith Style 18539. After these fabrics were loomed and suitably sized, their tensile strength and flexural rigidity were measured.

Data presented in Tables I and II compare fabrics made of fiberglass yarn and of combination yarn. The weight increase with an alcohol size was not as high as was intended. However, this will serve as a guideline in comparing the two materials.

In a comparison of the sized fabrics the average tensile strength of the combination fabric was 66 per cent of the tensile strength of a fiberglass mesh. The rigidity of the combination fabric was approximately 52 per cent of that of the fiberglass mesh.

There appears to be no reason to carry this investigation further as there appears to be no advantage to a combination of Dacron and fiberglass.

Table I

Rigidity

| <u>Material Description</u> | <u>Rigidity (mg-cm)</u> |            |              |                |
|-----------------------------|-------------------------|------------|--------------|----------------|
|                             | <u>10°</u>              | <u>20°</u> | <u>41.5°</u> | <u>Average</u> |
| Glass                       | 354.0                   | 309.2      | 336.1        | 333.1          |
| Glass - A29                 | 460.3                   | 414.3      | 460.26       | 444.9          |
| Glass PVOH                  | 401.8                   | 426.8      | 399.1        | 409.2          |
| Glass A29, PVOH             | 462.9                   | 493.9      | 429.7        | 462.2          |
| Dacron/glass                | 180.4                   | 176.7      | 145.0        | 167.3          |
| Dacron/glass A29            | 298.4                   | 276.8      | 258.8        | 278.0          |
| Dacron/glass PVOH           | 175.2                   | 226.7      | 197.3        | 199.8          |
| Dacron/glass A29, PVOH      | 199.0                   | 203.2      | 236.9        | 213.0          |

Table II

Tensile Strength

| <u>Material</u> | <u>Starch</u> | <u>A29</u> | <u>PVOH</u> | <u>Tensile</u> | <u>Elongation</u> |
|-----------------|---------------|------------|-------------|----------------|-------------------|
| Glass           | X             |            |             | 11.5           | 4.1               |
| Glass           | X             | X          |             | 15.9           | 4.1               |
| Glass           | X             |            | X           | 15.2           | 4.7               |
| Glass           | X             | X          | X           | 16.6           | 4.3               |
| Dacron/glass    | X             |            |             | 7.9            | 4.3               |
| Dacron/glass    | X             | X          |             | 11.0           | 5.8               |
| Dacron/glass    | X             |            | X           | 8.8            | 5.0               |
| Dacron/glass    | X             | X          | X           | 11.4           | 4.83              |

### 3.2 EVALUATION OF SIZING AGENTS

#### 3.2.1 Evaluation of Commercially Available Sizings

Samples of Hess, Goldsmith Style No. 451 were received during June. Style 451 is a 36 by 18 1 pick leno weave. The machine direction threads are B 150 1/0 and the transverse threads are B 150 1/2. The design weight is 2.98 oz/yd<sup>2</sup>. Hess, Goldsmith's laboratory has applied three types of sizings to this fabric.

451-A has a polyvinyl chloride size

451-B has a neoprene size

451-C has an acrylic size

Table III shows tensile strength and elongation for each material in the machine direction. As can be seen from these data, the type of sizing has no marked effect on these properties. The initial samples were all sized at the weaver, but to determine the suitability of any of these sizes these same tests had to be run on unsized fabric. A sample of Hess, Goldsmith No. 451 was received in the latter part of August. The results of the tests on rigidity are included in Table IV. The weight of the fabrics is also shown in this table. The average weight increase of the three sizes was 8 per cent. The rigidity was measured, and these results are presented in Table IV. Hess, Goldsmith Style 451-A is the most rigid.

An experiment was designed to evaluate the feasibility of plating directly on these sizings. To determine this, samples were soaked twenty minutes in water, and the rigidity and tensile strength in the machine direction were measured, Table V shows the rigidity of No. 451-A, No. 451-B, and No. 451-C as received, after a 20-minute soak, and after drying. No. 451-A was affected least with a 60.7 per cent decrease in rigidity, whereas the rigidity of No. 451-B and No. 451-C decreased 91.2 per cent and 74.4 per cent respectively. After drying the

Table III

Tensile and Elongation of Hess, Goldsmith Styles 451-A, -B, -C

(1 inch wide samples)

|          | 451-A               |                       | 451-B               |                       | 451-C               |                       |
|----------|---------------------|-----------------------|---------------------|-----------------------|---------------------|-----------------------|
|          | <u>Tensile (lb)</u> | <u>Elongation (%)</u> | <u>Tensile (lb)</u> | <u>Elongation (%)</u> | <u>Tensile (lb)</u> | <u>Elongation (%)</u> |
| Sample 1 | 120.0               | 9.0                   | 109.0               | 7.0                   | 108.0               | 8.0                   |
| Sample 2 | 122.0               | 9.0                   | 114.0               | 7.5                   | 95.0                | 8.0                   |
| Sample 3 | 120.0               | 8.0                   | 109.0               | 9.0                   | 111.0               | 8.0                   |
| Sample 4 | 120.0               | 8.0                   | 115.0               | 8.0                   | 105.0               | 8.5                   |
| Sample 5 | <u>125.0</u>        | <u>8.0</u>            | <u>110.0</u>        | <u>8.5</u>            | <u>98.0</u>         | <u>8.5</u>            |
| Average  | 121.4               | 8.4                   | 111.4               | 8.0                   | 103.4               | 8.4                   |

Table IV

Rigidity & Length to Meet Angle

(1 inch wide samples)

|                           | 451-A                           |                     | 451-B                           |                     | 451-C                           |                     | 451 No Size                     |                     |
|---------------------------|---------------------------------|---------------------|---------------------------------|---------------------|---------------------------------|---------------------|---------------------------------|---------------------|
|                           | Length<br>to Meet<br>Angle (cm) | Rigidity<br>(mg-cm) | Length<br>to Meet<br>Angle (cm) | Rigidity<br>(mg-cm) | Length<br>to Meet<br>Angle (cm) | Rigidity<br>(mg-cm) | Length<br>to Meet<br>Angle (cm) | Rigidity<br>(mg-cm) |
| 10°                       | 9.4                             | 6,708.2             | 5.9                             | 1,645.6             | 7.2                             | 2,902.5             | 2.5                             | 112                 |
| 20°                       | 11.2                            | 5,183.6             | 7.7                             | 1,745.6             | 8.8                             | 2,677.7             | 3.8                             | 179                 |
| 41.5°                     | 10.8                            | 1,776.0             | 10.3                            | 1,557.1             | 11.9                            | 2,401.2             | 4.6                             | 123                 |
| Average                   | ---                             | 4,555.9             | ---                             | 1,650.8             | ---                             | 2,660.5             | ---                             | 138                 |
| Weight mg/cm <sup>2</sup> |                                 | 10.9                |                                 | 11.2                |                                 | 10.5                |                                 | 10.1                |

Table V

Water Sensitivity of Size as Supplied by Hess, Goldsmith

Figures in Table are Rigidities (mg-cm)

|                            | 451-A  | 451-B | 451-C |
|----------------------------|--------|-------|-------|
| As Received                |        |       |       |
| 10°                        | 6,570  | 2,450 | 2,630 |
| 20°                        | 6,350  | 1,930 | 2,310 |
| 41.5°                      | 5,400  | 1,670 | 2,210 |
| Average                    | 6,107  | 2,017 | 2,383 |
| Soaked in Water 20 Minutes |        |       |       |
| 10°                        | 2,460  | 202   | 750   |
| 20°                        | 2,480  | 156   | 540   |
| 41.5°                      | 2,260  | 177   | 540   |
| Average                    | 2,400  | 178   | 610   |
| Dried                      |        |       |       |
| 10°                        | 10,500 | 5,230 | 4,080 |
| 20°                        | 8,900  | 4,000 | 2,780 |
| 41.5°                      | 6,300  | 3,920 | 2,380 |
| Average                    | 8,567  | 4,383 | 3,080 |

soaked samples, the rigidity of all three increased to a level higher than the rigidity before soaking. This is probably due to a more complete sizing of the fiberglass during the soaking when the resins became softened by the water.

Another property that was considered important in the evaluation of the water sensitivity was the tensile strength of a sample cut on a 45-degree angle. Measurement in this direction should define the water resistance of a sizing agent as strength of yarn intersections is being tested. The results are listed below. Styles No. 451-A and No. 451-C increased in strength after a 20-minute soak, while the tensile strength of No. 451-B decreased after the soak.

Tensile Strength of Samples Cut 45 Degrees to Machine Direction

(Figures are Pounds per Inch of Width)

|                    | <u>451-A</u> | <u>451-B</u> | <u>451-C</u> |
|--------------------|--------------|--------------|--------------|
| As received        | 38           | 29           | 24           |
| After 20-min. soak | 49           | 20           | 34           |

As a result of this experiment, it appears that a polyvinyl-chloride-sized fabric can survive the stresses of copper deposition. The platability of No. 451-A has been shown to be suitable.

3.2.2 Evaluation of Laboratory Prepared Sizing

As one of the requirements of the contract is to develop a material with high rigidity, it has been found that proper choice of a sizing agent can improve the stiffness of a fabric. A study of ten sizes was made. Those investigated are listed in Table VI. In most cases, two concentrations of size solids were used. The base glass fabric used in this study was Hess, Goldsmith Style I8601. Table VII shows the flexural rigidity and tensile strength of the laboratory samples. The sizing agents in this experiment that

increased the rigidity the most were animal glue, polyvinyl alcohol, GT 201, and Silane A1100. The highest tensile strength was recorded in the Silane A1100 and GT 201 sized samples. The gain in weight with a given solids percentage was nearly the same regardless of the type size used. A five per cent solution increased the weight approximately 3 per cent while the increase with a 10 per cent solution was 6 per cent.

The sample sized with Silane A1100 showed a markedly higher tensile strength.

Table VI  
Materials Used in Sizing Study

|     | Trade Name   | Description                               | Supplier      |
|-----|--------------|-------------------------------------------|---------------|
| 1.  | TS100        | Polyvinyl acetate copolymer emulsion      | Rhom & Haas   |
| 2.  | HA16         | Acrylic copolymer emulsion                | "             |
| 3.  | ASE60        | Carboxylic terminated acrylic polymer     | "             |
| 4.  | Silane A1100 | $\gamma$ -Glycidoxypropyltrimethoxysilane | Union Carbide |
| 5.  | Selectus     | Edible gelatin                            | Swift & Co.   |
| 6.  |              | Starch                                    | Corn Products |
| 7.  |              | Dextrin                                   | Corn Products |
| 8.  | Hercules     | Animal glue                               | Swift & Co.   |
| 9.  | GT 201       | Proprietary thermosetting resin           | G.T.S. Co.    |
| 10. | 52-40        | Polyvinyl alcohol                         | E.I. du Pont  |

Table VII

| Lab. No. | Size    | Weight<br>(mg/cm <sup>2</sup> ) | Rigidity<br>(mg-cm) | Tensile Strength<br>(lb/in) |
|----------|---------|---------------------------------|---------------------|-----------------------------|
| 18601    |         | 1.82                            | 135.5               |                             |
| 301-14-1 | Glue    | 1.93                            | 1169.3              | 27.8                        |
| 301-14-2 | Glue    | 1.83                            | 848.2               | 24.3                        |
| 14-3     | Gelatin | 1.89                            | 818.7               | 19.8                        |
| 14-4     | Gelatin | 1.84                            | 939.9               | 26.6                        |
| 15-1     | TS100   | 1.91                            | 734.4               | 28.8                        |
| 15-2     | TS100   | 1.83                            | 476.3               | 19.5                        |
| 15-3     | PVOH    | 1.90                            | 1121.3              | 28.8                        |
| 15-4     | PVOH    | 1.84                            | 999.2               | 26.3                        |
| 15-5     | HA16    | 1.87                            | 515.9               | 18.7                        |
| 15-6     | HA16    | 1.77                            | 419.                | 18.6                        |
| 15-7     | Dextrin | 1.89                            | 965.2               | 26.8                        |
| 15-8     | Dextrin | 1.86                            | 706.3               | 22.1                        |
| 16-1     | GT 201  | 2.24                            | 1109.1              | 38.8                        |
| 16-2     | Starch  | 1.88                            | 894.2               | 27.5                        |
| 16-3     | Starch  | 1.78                            | 773.4               | 24.3                        |
| 16-4     | ASE60   | 1.84                            | 710.3               | 24.0                        |
| 16-5     | ASE60   | 1.78                            | 699.37              | 22.9                        |
| 16-6     | GT 201  | 2.33                            | 1137.6              | 34.6                        |

### 3.3 SEAM STUDY

Using aluminum-coated material, several seam designs were evaluated. This material was used because the conductive coating of aluminum is exposed and not masked in any way. The following designs were evaluated.

|          |                                                                                             |
|----------|---------------------------------------------------------------------------------------------|
| Design A | Standard overlapping bitape seal                                                            |
| Design B | 3/8-in overlap with 1/8-in wide strip of 0.9-mil aluminum in a bitape seal                  |
| Design C | 3/8-in overlap with 1/8-in wide strip of 1/2-oz copper foil in bitape seal                  |
| Design D | 3/8-in overlap with a bitape seal using a conductive tape (lab book sample number 105-88-1) |

Table VIII shows this as the preliminary work. The designs are compared to continuous material with respect to resistivity and tensile strength.

Sample 5 was an overlapped bitape seal using material processed in May. No resistivity measurement could be made on this seal because sample 105-113-1 has a sheath coating of RTV silicone rubber.

To determine the reproducibility of these seals, five samples of designs A, B, and D were made. Design C was not run because of its similarity to B. The material used was sample 105-119-2.

Table IX lists these results. The figures given are for the resistance of a 6-in sample divided by the length of the sample. This resistivity is false as the samples are not homogeneous, but since the same material was used in each seal a direct comparison can be made.

Table VIII

|    | Material<br>Sample | Seal Configuration | Resistivity | Tensile Strength<br>lb/in Width |
|----|--------------------|--------------------|-------------|---------------------------------|
| 1  | 105-119-1          | continuous         | 16.7        | 40                              |
| 2  | 105-119-1          | A                  | 75.0        | 18                              |
| 3  | 105-119-1          | B                  | 38.3        | 13.6                            |
| 4  | 105-119-1          | C                  | 71.7        | 15.0                            |
| 5  | 105-113-1          | A                  | ---         | 0.8                             |
| 6  | 105-119-1          | D                  | 48.2        | 10.0                            |
| 7  | 105-119-2          | continuous         | 4.7         | 32.0                            |
| 8  | 105-119-2          | D                  | 18.3        | 16.8                            |
| 9  | 105-119-2          | A                  | 8.0         | 18.8                            |
| 10 | 105-119-2          | B                  | 8.3         | 12.7                            |

Table IX

## Seam Study of Sample 105-119-2

|         | Design A    | Design B   | Design D    |
|---------|-------------|------------|-------------|
|         | 10.8        | 18.0       | 46.8        |
|         | 8.8         | 16.0       | 30.0        |
|         | 12.0        | 27.5       | 38.3        |
|         | 13.3        | 21.7       | 32.5        |
|         | <u>25.0</u> | <u>9.7</u> | <u>25.8</u> |
| Average | 13.98       | 18.58      | 34.68       |

The figures indicate that a simple overlapping seam provides the lowest resistance and therefore the best electrical contact.

### 3.4 FLEXING RESISTANCE TESTING

As this material will be used in large space structures that will need to be folded and packed in a canister, it is necessary to determine the fold resistance of the material. Fold resistance has no discrete units and there are several methods of evaluating it.

One of these is the bend radius tensile strength presently used to evaluate this material. This test determines the strength of a material as it is folded on 1/128-inch radius bend. This is described in more detail in GTS Company Q132.

Another is the folded rigidity test (Sec. 9 of Q132) which attempts to measure the stiffness remaining after the material has been creased 180 degrees while under a static load.

The above methods have been used and data generated from these tests have been presented in past reports.

Two tests that will be evaluated in the near future are described in Federal Specification CCC-T-191B. These are Method 5210, Crease Resistance of Cloth, Cold Press Method, and Method 5212, Crease Resistance of Cloth, Angle of Recovery Method. Both measure the tendency of a fabric to "set" after creasing. This is an important variable as a material would be creased severely when being packed previous to launch. Obviously, any tendency of a material to "set" would preclude its use where close tolerances of flatness or sphericity are required.

During this last quarter two tests concerned with cyclic flexing were used. Both techniques involve the flexing of a sample around a known radius bend 180 degrees and then folding it back on itself around a similar radius bend. These tests flex a loaded sample cyclically until failure occurs. The number of cycles-to-failure is recorded as a property of the material.

NASA has designed and supplied us with a testing machine which, besides

flexing the sample, has provision for a measurement of resistivity. The results of this testing are described in 3.4.1.

The paper industry uses the Schopper Tester as a standard means of determining the fold resistance of paper. The discussion of this work is in section 3.4.2.

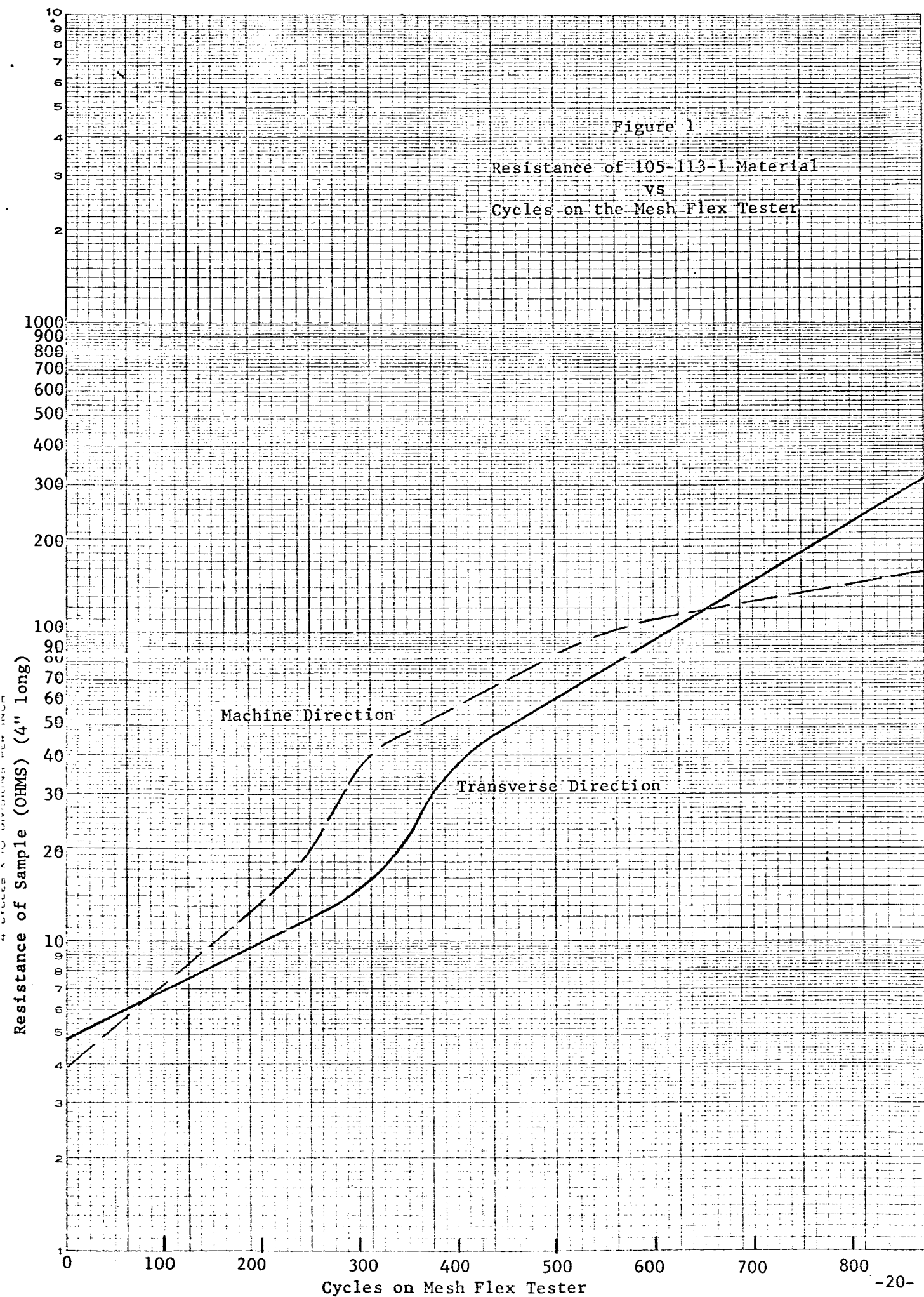
#### 3.4.1 Mesh Flex Tester

Samples of 105-113-1 material with no silicone rubber sheath coating were tested. Figure 1 compares the increase in sample resistance with the number of times folded. Each cycle on the machine is a 180 degree fold. Figure 2 covers only the first 350 cycles showing more clearly the initial increase in resistance. It is evident, from Figure 1, the resistance increases sharply in the machine direction between 200 and 300 cycles, and in the transverse direction between 300 and 400 cycles. This is the point at which there is a rapid deterioration of the plated copper. After this point, the resistance in the machine direction increases more slowly while the resistance in the transverse direction continues to increase rapidly. All samples were tested to failure except 105-113-2TD where flexing was terminated after 576,000 cycles (Table X). Figure 3 shows an enlarged view of the fiber bundles after failure.

Table X

## 105-113-1 Material - Cycles to Failure

| Sample Number                  | Cycles to Failure | Comments                                                                                                                              |
|--------------------------------|-------------------|---------------------------------------------------------------------------------------------------------------------------------------|
| 105-113-1-1MD<br>105-113-1-2MD | 8,000<br>988      | First sample tested 5 threads broke and sample pulled out of the top specimen holder. The holder was modified prior to the next test. |
| 105-113-1-3MD                  | 56,618            | Remained conductive up to 8600 cycles                                                                                                 |
| 105-113-1-4MD                  | 1,403             | Sample had been damaged prior to testing causing the pre-mature failure                                                               |
| 105-113-1-5MD                  | 71,439            | Remained conductive up to 7000 cycles                                                                                                 |
| 105-113-1-1TD                  | 517               | Sample had been damaged prior to testing causing the pre-mature failure                                                               |
| 105-113-1-2TD                  | >576,000          | Remained conductive up to 234,000 cycles                                                                                              |



NO. 340-1310 DIETZEN GRAPH PAPER  
SEMI-LOGARITHMIC  
4 CYCLES X 10 DIVISIONS PER INCH  
MADE IN U. S. A.

Figure 2  
Resistance of 105-113-1 Material  
vs  
Cycles on the Mesh Flex Tester

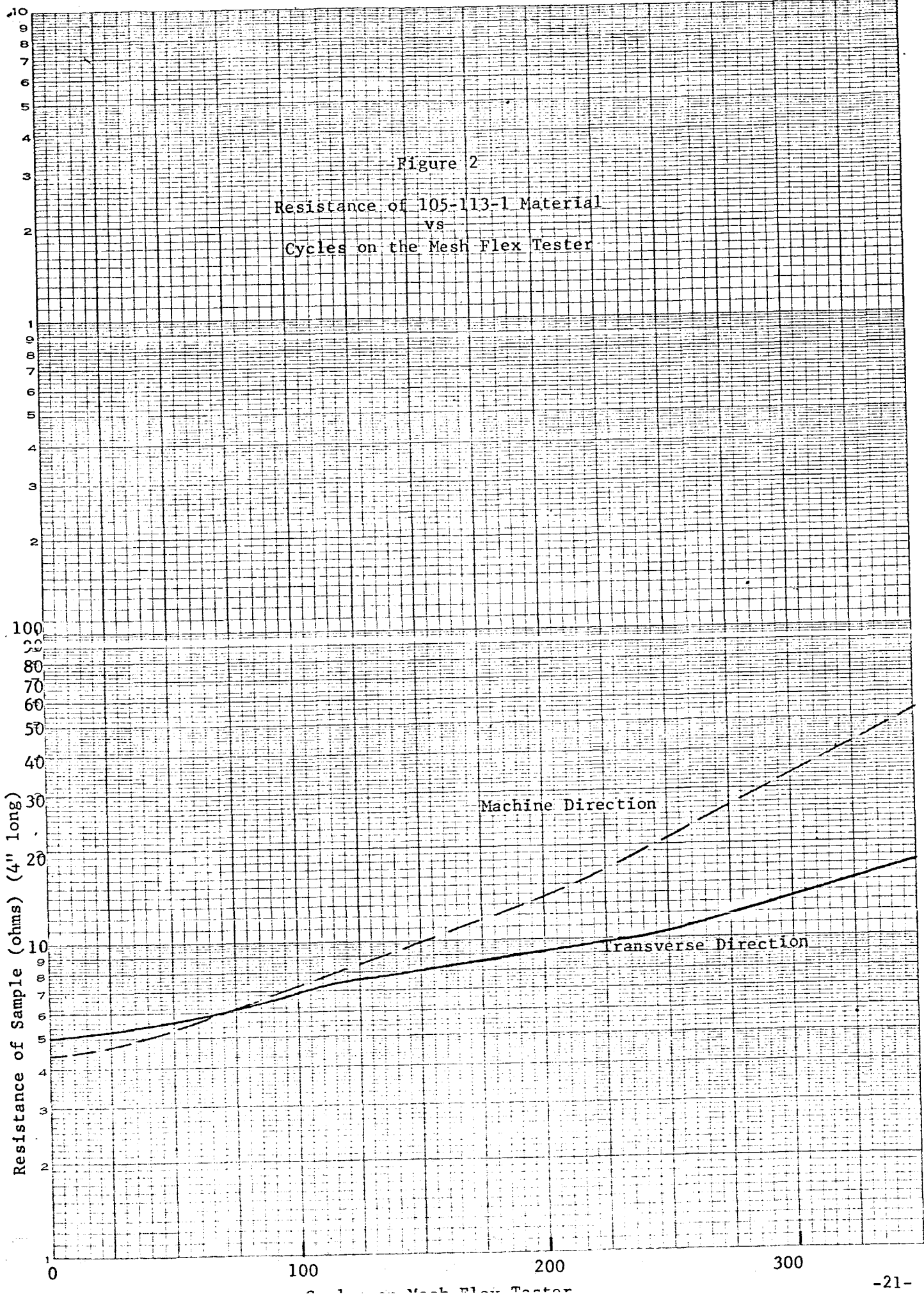




Figure 3

### 3.4.2 Schopper Tester (ASTM 643-63T)

Samples of 105-113-1 material, having no silicone rubber sheath coating, were tested on a Schopper-type folding apparatus by ASTM method D 643-63T. Table XI contains these data. More samples will be tested to evaluate this method of testing self-erecting material.

## 3.5 MATHEMATICAL TREATMENT RELATING MEASURABLE PROPERTIES TO ULTIMATE USES OF THIS MATERIAL

### 3.5.1 Comparison of Theoretical Stiffness to Experimental Stiffness

The theoretical moment of inertia, I, was calculated for fabric using the following formula -

$$I = \frac{bd^3}{12}$$

where b is dimension in direction of axis

and d is dimension perpendicular to axis

This quantity was calculated for three fabric samples. The modulus of elasticity of glass is reported to be  $10^7$  psi. From the relationship

$$G = EI$$

where G is the flexural stiffness, a theoretical stiffness was calculated. This value, theoretical G, is compared to the experimental rigidity as determined by Q132.

| <u>Sample No.</u> | <u>Theoretical G</u> | <u>Actual G</u>   | <u>G Theoretical/G Experimental</u> |
|-------------------|----------------------|-------------------|-------------------------------------|
| 216-86-2          | $7.84 \times 10^3$   | 250               | 31.3                                |
| 105-94-3          | $12.3 \times 10^4$   | $3.2 \times 10^3$ | 38.7                                |
| 105-113-1         | $2.67 \times 10^4$   | $10^3$            | 26.7                                |

It should be noted here that the above calculations are for a flat plate with a rectangular cross section. It was also assumed that the entire

Table XI

105-113-1- Material

Schopper Folding Endurance Test

| Direction            | Sample  | Cycles to Failure        | Sample | Cycles to Failure |
|----------------------|---------|--------------------------|--------|-------------------|
| Machine Direction    | 1       | 12                       | 6      | 6                 |
|                      | 2       | 17                       | 7      | 7                 |
|                      | 3       | 17                       | 8      | 3                 |
|                      | 4       | 22                       | 9      | 13                |
|                      | 5       | 30                       | 10     | 6                 |
|                      | Average | Cycles to Failure - 13.2 |        |                   |
| Transverse Direction | 1       | 9                        | 6      | 25                |
|                      | 2       | 10                       | 7      | 3                 |
|                      | 3       | 23                       | 8      | 6                 |
|                      | 4       | 9                        | 9      | 5                 |
|                      | 5       | 10                       | 10     | 16                |
|                      | Average | Cycles to Failure - 11.6 |        |                   |

composite has a modulus of elasticity equal to that of E glass. The actual material tested is a scrim fabric with threads spaced on 0.1 inch centers. By correcting for this fact, the theoretical rigidity might be less by a factor of 20. However, for this comparison and future comparisons using the theoretical rigidity for a flat glass plate as a standard should be sufficient.

### 3.5.2 Mathematical Derivation of the Relationship Between Flexural Rigidity and Cylinder Radius

To determine the size object that can be built from self-erecting material a computer program was written. This program was derived from the equation for the bending of a flat beam. When this equation was solved, it was found that the largest diameter cylinder possible made with self-erecting material with rigidity of 1,000 mg-cm is 178 ft. A ten-fold increase in rigidity increases this diameter to 380 ft.

Further work is planned that will extend this derivation to the case of a sphere. This would investigate the interaction of a number of cylindrical bands that would be fabricated into a sphere.

Appendix A contains this derivation in detail. The computer program is included also.

### 3.6 PRODUCTION RUNS

Past efforts have shown that a sizing applied to the fiberglass fabric will markedly increase the rigidity. The most efficient size found is polyvinyl alcohol. To thoroughly examine the properties of a polyvinyl alcohol coating, it had to be applied to a fiberglass mesh. Hess, Goldsmith Style No. 18601 was used in this operation, as this was the base fabric for material processed in May. The process used was as follows:

1. A coating of polyvinyl alcohol was applied in continuous plating equipment.

2. Using vacuum chambers held at G. T. Schjeldahl under NAS5-3515 facilities contract, a conductive aluminum coating was applied.

The process used on these runs was quite different from the normal sequence which is as follows:

1. A heat treatment consisting of placing a length of fabric on an aluminum core in a 500 F oven for 60 minutes.

2. A coating of GT 201 is then applied in Section B of the plating equipment.

3. This coating is allowed to cure for 48 hours at  $100 \pm 5$  F and  $95 \pm 5$  per cent R.H.

4. The coated fabric is then copper plated electrolessly in Section A.

5. Two coats of RTV silicone rubber are applied to the copper plate; one immediately after plating, and the second after a 24-hour cure at ambient conditions.

### 3.6.1 Vapor Deposited Aluminum Coating

For the run in June, polyvinyl alcohol was chosen as the sizing agent. It was felt that for this initial work a small quantity of this solution could be obtained from any one of several suppliers. Swift and Company formula No. 2534 was used for this purpose. It was diluted with water to two solid concentrations for application to fabric style I8601. Using Section B of the continuous plater, a 6 per cent solution of polyvinyl alcohol was applied to 40 feet. Using a web speed of 6 in/min produced a residence time in the drying tunnel of 20 min. This material was assigned the laboratory sample number 105-119-1. The coating was completely dry upon emerging from the tunnel. The 6 per cent solution was then replaced with a 10 per cent solution and 15 feet more was coated. The material sized with 10 per cent solution will be referred to as sample 105-119-2. Table XII lists weights and rigidities of each material.

The fact that sample 105-119-1 is more rigid than sample 105-119-2 cannot be explained at this time and further investigation will be made. These samples were tested on different days. The size is extremely water sensitive, and varying humidity conditions undoubtedly would affect the rigidity. The higher viscosity of the 10 per cent solution could have prevented proper coating of the fiber bundles.

Approximately 11 feet of each of the materials coated above was placed in a vacuum chamber. A layer of aluminum approximately 10 microinches thick was deposited on the surface. Only one surface of one material could be "shot" at a time; thus, a total of four shots were made. Table XIII shows the rigidity, weight per unit area and tensile strength.

Table XII

|                                              | <u>105-119-1</u> | <u>105-119-2</u> |
|----------------------------------------------|------------------|------------------|
| Sizing solution solids per cent<br>by weight | 6                | 10               |
| Weight mg/cm <sup>2</sup>                    | 1.99             | 1.93             |
| Rigidity mg-cm 10° angle                     | 1980             | 1290             |
| 20° angle                                    | 1580             | 1115             |
| 41.5° angle                                  | 1250             | 848              |
| Average rigidity mg-cm                       | 1603             | 1084             |

Table XIII

| Base Material                               |                    | <u>Sample 105-119-1</u> | <u>Sample 105-119-2</u> |
|---------------------------------------------|--------------------|-------------------------|-------------------------|
| Weight                                      | mg/cm <sup>2</sup> | 1.9                     | 2.0                     |
| Rigidity                                    | (mg-cm)            | 601.6                   | 497.8                   |
| Folded Rigidity                             | (41.5°)            | 44.0                    | 43.3                    |
| Tensile Strength<br>(lbs/in)                | MD                 | 39.5                    | 32.0                    |
|                                             | TD                 | 32.0                    | 12.0                    |
|                                             | 45°                | 0.6                     | 0.4                     |
| Bend Radius<br>Tensile Strength<br>(lbs/in) | MD                 | 13.5                    | 13.3                    |
|                                             | TD                 | 0.6                     | 2.7                     |
|                                             | 45°                | 0.7                     | 3.35                    |

### 3.6.2 Description of Numbering System

A new numbering system has been developed for any materials produced in this study contract. Each material produced under this contract will be consecutively numbered. The processing of this material involves five operations: fabric procurement, pretreatment, binding, metal deposition, and sheath coating. These process steps are so numbered that if the properties of the material are desired, they can be recorded properly as to run number and process step. The process steps are defined below.

- 1. Fabric Procurement - This is simply an identification of the base fabric e.g. Hess, Goldsmith I8601
- 2. Pretreatment - Any sizing operation would be considered a pre-treatment. Any other process that a fabric is subjected to, such as heat treating, would also be described in this subheading.
- 3. Binder - This process is analogous to the sizing process described above; however, for our purposes it is advantageous to split it off as separate item. This will allow us to consider materials whose primary purpose is to tie or bind the threads together to increase the integrity of the fabric.
- 4. Metal Deposition - This, as the title implies, is the subheading that will contain the description of the process that was used to deposit a metallic coating on the self-erecting material.
- 5. Sheath Coating - This process step protects the metal deposit and as it is the final coating on the material, it becomes a major factor in the ultimate surface properties.

The incorporation of this numbering system in this contract was done for the material processed in August. Arbitrarily, the first run was numbered 132. Sample data sheets are included.

### 3.6.3 Description of Runs 132, 133 and 134

#### 3.6.3.1 Run 132

This was the first run identified with the new numbering system. The base fabric was Hess, Goldsmith style I8601. The pretreatment step consisted of the application of an aqueous solution of Silane A-1100. Data had shown that sizing with this material markedly increased the tensile strength and the rigidity. The weight increase of the dip coating was very small as the weight after this step was  $1.82 \text{ mg/cm}^2$  or virtually the same as the fabric weight as received from the weaver. Approximately 66 feet were coated in this manner.

The material was then bound with a GT 201 coating. The weight increase was approximately  $0.18 \text{ mg/cm}^2$  making a total weight at this point of  $2.0 \text{ mg/cm}^2$ . The rigidity in the machine direction was 1052 mg-cm (per ASTM D 1388). The tensile strength at this point was 40.1 lb/in. The metal deposition was done by the electroless copper plating process described in the past.

No sheath coating was applied to the material in this run as it is intended for use in the sheath coating study phase of the contract.

#### 3.6.3.2 Run 133

This run also used Hess, Goldsmith style I8601 as the base fabric. The pretreatment consisted of a heat treatment (500 F for 30 min.). As in the past there was a weight loss during this process. For this particular run a production oven was used. The material processed in April, 105-113-1, was processed in a similar manner. Table XIV compares the weight loss and

associated rigidity increase of this material and No. 133.

Table XIV

Comparison of Weight and Rigidity Through Process

|                  | 105-113-1                   |                       | Run 133                     |                       |
|------------------|-----------------------------|-----------------------|-----------------------------|-----------------------|
|                  | <u>Wt Mg/Cm<sup>2</sup></u> | <u>Rigidity Mg-Cm</u> | <u>Wt Mg/Cm<sup>2</sup></u> | <u>Rigidity Mg-Cm</u> |
| Heat Treatment   | 1.77                        | 297                   | 1.78                        | 57                    |
| Binding          | 2.03                        | 931                   | 2.15                        | 657                   |
| Metal Deposition | 2.17                        | 850                   | 2.25                        | 646                   |

The binding operation and metal deposition was done in the same manner as Run 132. Again, as in the case of 132 material, no attempt was made to apply the sheath coating. The material was sealed in a nitrogen-filled Scotchpak bag.

3.6.3.3 Run 134

This material run again used Hess, Goldsmith style I8601 fiberglass fabric, but there was no pretreatment step. The binder was GT 201 as in the case of 132 and 133. The copper was deposited in the same plating run as 132 and 133.

Table XV

Comparison of Tensile Strength

|           | MD<br>(lb/in) | TD<br>(lb/in) | 45° Angle<br>(lb/in) |
|-----------|---------------|---------------|----------------------|
| 105-113-1 | 27.6          | 19.8          | .68                  |
| 132       | 26.6          | 25.8          | .95                  |
| 133       | 23.5          | 16.8          | .66                  |
| 134       | 28.9          | 25.4          | 1.2                  |

Table XVI

Flexural Rigidity of Runs 132, 133, & 134

|       | Machine<br>Direction<br>Mg-Cm | Transverse<br>Direction<br>Mg-Cm | 45° Angle<br>Mg-Cm | Weight<br>Mg/Cm <sup>2</sup> |
|-------|-------------------------------|----------------------------------|--------------------|------------------------------|
| 132-4 | 916.4                         | 592.2                            | 175.2              | 2.1                          |
| 133-4 | 646.9                         | 450.4                            | 152.3              | 2.25                         |
| 134-4 | 848.0                         | 595.6                            | 228.9              | 2.11                         |

### 3.7 CONTROLLED ATMOSPHERE CHAMBERS

To evaluate the use of sheath layers on self-erecting material, the last three runs were not coated but placed in bags containing a nitrogen atmosphere. Four controlled atmosphere chambers were built. With these chambers it will be possible to expose ten, one-inch wide samples to the same conditions. The resistance of 12-inch long samples can be periodically checked with as little error as possible. The first set of samples will evaluate the following:

- A. 105-123-1            vapor-deposited aluminum
- B. 105-113-1            copper-plated (no coating)
- C. 132-4                described in this report
- D. 133-4                described in this report
- E. 134-4                described in this report

The first test series will subject the samples to four different atmospheres.

- Chamber No. 1            air 0 per cent relative humidity
- Chamber No. 2            air 100 per cent relative humidity
- Chamber No. 3            100 per cent oxygen atmosphere
- Chamber No. 4            100 per cent nitrogen atmosphere

Two samples each of the above described materials will be placed in each chamber. These will be exposed to these conditions for 30 days or until there is a significant change.

The samples will be connected to leads by means of a conductive epoxy adhesive, E-solder No. 3021. To prevent contamination, the holes where the leads come out of the chamber will be sealed with a paraffin modified with E 1 Vax 150, an ethylene-vinyl acetate copolymer.

Once the effect of the above conditions is established on these materials, the study of protective coatings or sheath layer can begin.

Material No.

Lab No. \_\_\_\_\_

## Metal Deposition

Date \_\_\_\_\_ Amount Processed \_\_\_\_\_ ft

Type                      Electroless Plating (Use "Plating Log" Below)

Vapor Deposition (Use "Remarks")

Other (Use "Remarks")

Remarks -

Type of Metal \_\_\_\_\_

Thickness \_\_\_\_\_ Angstroms

No. of Shots

### Plating Log:

Machine Speed\_\_\_\_\_ fpm

[illegible]

Chemical  
Consumption:

Sensitizer

Activator

Cu400A

Cu400B

NaOH

(Record Time  
& Amt.)

## Deionized Water Tanks

Start .

End

Material No. \_\_\_\_\_

Lab. Number \_\_\_\_\_

Pretreatment & Binder In Process Sheet

Pretreatment                      Date \_\_\_\_\_ Amount Processed \_\_\_\_\_ ft

Fabric \_\_\_\_\_

Description of Pretreatment -

Remarks -

Sample Taken \_\_\_\_\_

Binder                              Date \_\_\_\_\_ Amount Processed \_\_\_\_\_

Description of Binding Operation (type, solids, machine speed, drying) -

Remarks -

Sample Taken \_\_\_\_\_

## Summary Sheet for Material \_\_\_\_\_

## Material Inventory

| Date | Amount | Article Used For |
|------|--------|------------------|
|      |        |                  |
|      |        |                  |
|      |        |                  |
|      |        |                  |
|      |        |                  |

Date Completed \_\_\_\_\_ Description \_\_\_\_\_

- 1) Fabric Description \_\_\_\_\_
- 2) Pretreatment \_\_\_\_\_
- 3) Binding \_\_\_\_\_
- 4) Metal Deposition \_\_\_\_\_
- 5) Sheath Coating \_\_\_\_\_

## Test Results:

| Process Step            | 1 | 2 | 3 | 4 | 5 |
|-------------------------|---|---|---|---|---|
| A. Tensile 1b per inch  |   |   |   |   |   |
| MD (5)                  |   |   |   |   |   |
| TD (5)                  |   |   |   |   |   |
| 45° (5)                 |   |   |   |   |   |
| B. Rigidity 41.5° mg-cm |   |   |   |   |   |
| MD (5)                  |   |   |   |   |   |
| TD (5)                  |   |   |   |   |   |
| 45° (5)                 |   |   |   |   |   |
| C. Conductance          |   |   |   |   |   |
| MD                      |   |   |   |   |   |
| TD                      |   |   |   |   |   |
| D. Weight mg/sq. cm.    |   |   |   |   |   |
| E. Folded Rigidity      |   |   |   |   |   |
| F. Cyclic Flex Test     |   |   |   |   |   |

#### 4.0 FUTURE PLANS

Tests will be started in the controlled atmosphere chambers. Means of determining conductivity will be investigated.

The fold resistant tests will be continued.

## APPENDIX A

### TECHNICAL DISCUSSION

It is desired to know how large a self-erecting sphere can be before solar pressure prevents its proper deployment. This question will be answered only indirectly here. Instead, a self-erecting cylinder will be considered. If a cylinder can have a certain maximum radius before trouble sets in, then it is thought wise not to plan spheres of this radius or larger.

Sunlight impinges on a fully erected cylinder from the right. It is assumed that a constant fraction,  $f$ , of the sunlight which hits any portion of the cylinder boundary for the first time is completely absorbed (the mesh fibers are assumed black here). The remaining light  $(1-f)$  goes on across the cylinder. When it traverses the cylinder boundary for the second time, a fraction  $f$  is again absorbed. The force, then, exerted by sunlight on the right-hand half of the cylinder per unit length is:

$$\frac{S_c f(2r)}{c}$$

Here  $S$  is the solar constant, and  $c$  the speed of light. The force exerted by sunlight on the left-hand side of the cylinder per unit length is:

$$\frac{S_c (1-f)f(2r)}{c}$$

If the mass per unit length of the cylinder is  $m$ , then the acceleration of the cylinder to the left is given by:

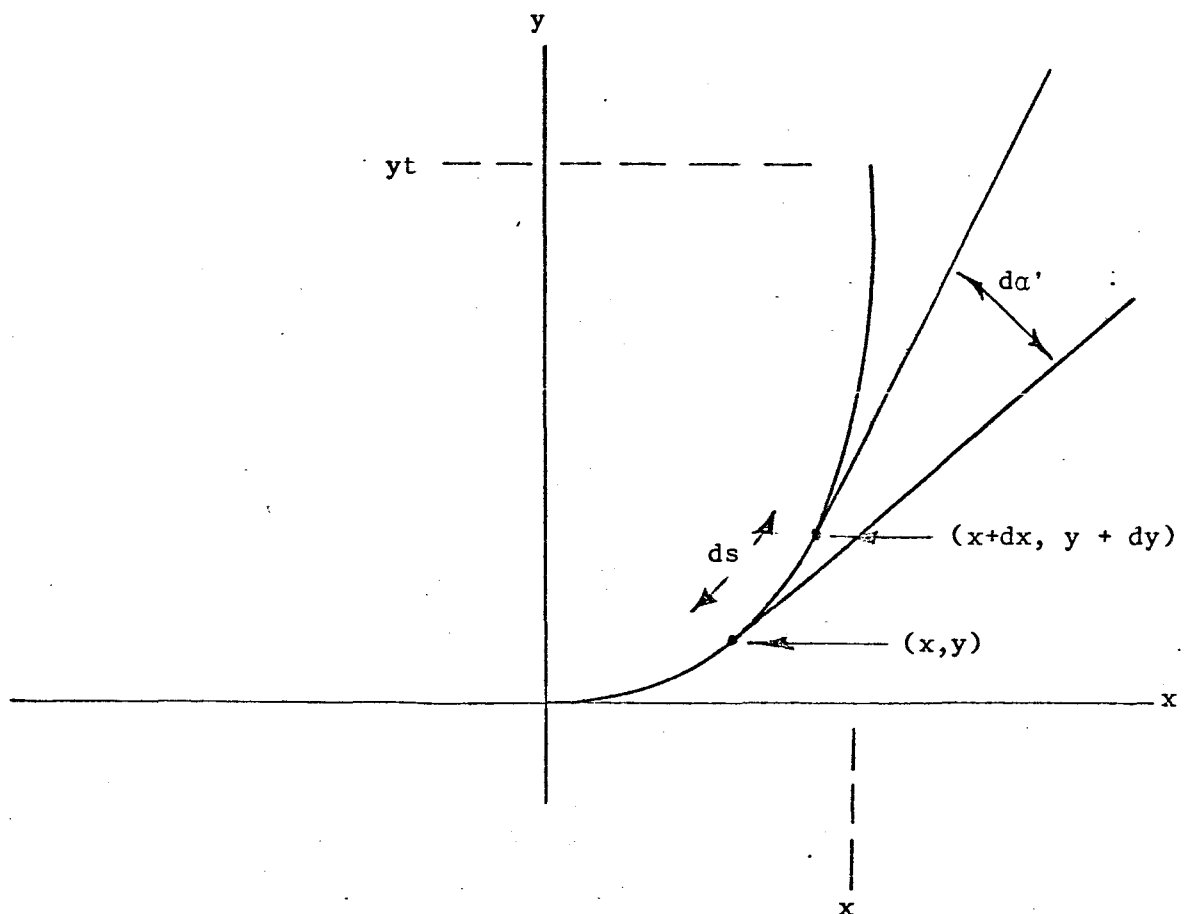
$$\frac{S_c f(2r) + S_c (1-f)f(2r)}{cm}$$

The force exerted on the right-hand half of the cylinder is greater than that exerted on the left-hand half. Consequently, the cylinder should flatten some-

what, the width of the figure now being smaller than its height. The cylinder flattens until stresses set up in the self-erecting material make all portions of the cylinder accelerate at the same rate.

It is arbitrarily assumed here that trouble in deployment can be expected if the radius of the fully erected cylinder, say in the absence of sunlight, is just large enough so that in the presence of sunlight the right and left extremities of the figure are regions of zero curvature. A cylinder of any larger radius would exhibit a dog-bone appearance.

Now the cylinder is accelerating to the left so one should have the x-y coordinate system also accelerating to the left at the same rate, and then perform the analysis in this accelerating system. Here we approximate this procedure by assuming that another sun produces light which shines on the cylinder from the left. The acceleration of the cylinder is now zero. Consider that "quarter" of the distorted cylinder which lies at the lower right hand, as illustrated below.



The moment equation is:

$$EI \frac{d\alpha'}{ds} = \frac{Sf^2(yt-y)^2}{2c}$$

Here E is Young's Modulus of the material and I its moment of inertia.

Rewrite the equation as:

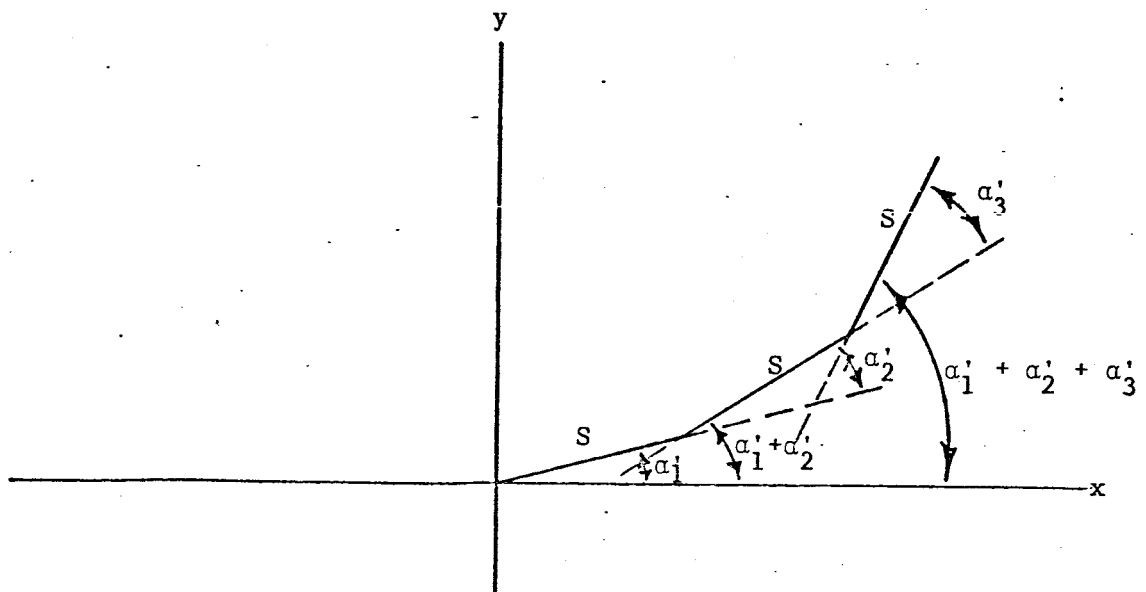
$$d\alpha' = ds \frac{Sf^2(yt-y)^2}{2EIc}$$

Define a new constant C by:

$$C = \frac{Sf^2}{2EIc}$$

Replace ds by S and replace  $d\alpha'$  by  $\alpha'_n$  where  $n=1,2,3,\dots,F-1,F$ . Note that the length, Z, of the illustrated band is FS and that the radius R of the undistorted cylinder which gave rise to this distorted band is given by  $4Z/\alpha_n$ .

A computer program (see last pages) was written which gives  $(x,yt)$ , Z, and R as a function of C. The basic fact which simplifies the computation is illustrated in the figure below:



Note that:

$$y_1 = S \sin (\alpha'_1 + \alpha'_2)$$

$$y_2 = y_1 + S \sin (\alpha'_1 + \alpha'_2)$$

$$y_3 = y_2 + S \sin (\alpha'_1 + \alpha'_2 + \alpha'_3)$$

etc.

And that

$$x_1 = S \cos \alpha'_1$$

$$x_2 = x_1 + S \cos (\alpha'_1 + \alpha'_2)$$

$$x_3 = x_2 + S \cos (\alpha'_1 + \alpha'_2 + \alpha'_3)$$

etc.

The computation must stop when  $n$  becomes just large enough, say  $N$ , to make

$$\sum_{m=1}^N \alpha'_m = \pi/2$$

Since the expression for  $\alpha'_n$  involves  $y_t$  and since  $y_t$  can only be known after the problem is solved the program initially requires the insertion of a large  $y_t$  as a starter which the program then adjusts as it proceeds so that it eventually converges to the correct value. The program prints out the correct value of  $y_t$  and the associated  $x$ .

Now the material under study has an  $EI = 1000$  milligram-cm = 980 dyne-cm. The speed of light is  $3 \times 10^{10}$  cm/sec. The solar constant,  $S_c$  is  $\frac{(2.0)(4.18) \times 10^7}{60} \frac{\text{ergs}}{\text{cm}^2\text{-sec}}$

Consequently  $C$  is:

$$C = 2.42 \times 10^{-6} / \text{ft}^3$$

With this  $C$ , an  $R$  of about 89 ft was obtained,  $y_t$  being 108 ft and  $x$  about 78 ft. When the material strength  $EI$  was made ten times greater so that  $C$  was

$2.42 \times 10^{-7}/\text{ft}^3$ , the R obtained was about 190 ft, yt being about 231 ft,  
and x about 160 ft. Note that  $10^{1/3} \cong 190/89$ .

```

04000 C      DR-2 -- 0/1/66 -- GIEGLER
04001      B=1.7706
04004      IF(SENSE SWITCH 9)1,1
04004 1      READ11,C,YT,E,S,G
04010 11     FORMAT(E14.7)
04015      PRINT13,C,YT,E,S,G
04020 12     FORMAT(//2HC =E14.7/4HXT =F1.2/2HE =F1.2/2HS =F1.2/2HS =F1.2)
04024 3      A=0.0
04025      X=0.0
04026      Y=0.0
04027      E=0.0
04030 4      A=A+S*C*(YT-Y)**2
04032      E=E+1.0
04034      IF(A-B)5,5,6
04035      X=X-COS(A)
04036      Y=Y-SIN(A)
04040      GO TO 4
04041      X=S*X
04042      Y=S*Y
04043      Z=F*S
04044      R=4.0*Z/5.2032
04045      D=YT-Y
04046      IF(D-E)6,C,7
04047 7      PRINT17,YT,A,D,X
04048 17     FORMAT(//4HXT =E14.7,3X3HA =E14.7,3X3HD =E14.7,3X3HX =E14.7)
04049      PRINT27,Y,Z,R,F
04050 27     FORMAT(//4H Y =E14.7,3X3HZ =E14.7,3X3HR =E14.7,3X3HF =E14.7)
04052      YT=YT-G*D
04053      GO TO 3
04054 10     PRINT10
04054 10     FORMAT(//17HFINAL SOLUTION...)
04055      PRINT17,YT,A,D,X
04056      PRINT27,Y,Z,R,F
04057      IF(SENSE SWITCH 9)100,1
04060 100    STOP
04060      END
END OF COMPILATION 0716519430

```

C = 2.4200000E-06

YT = 150.00

E = 1.00

S = .50

G = .500

|                    |                   |                   |                   |
|--------------------|-------------------|-------------------|-------------------|
| YT = 1.5000000E+02 | A = 1.5755537E+00 | D = 1.3205721E+02 | X = 2.0945420E+01 |
| Y = 2.3842717E+01  | Z = 3.3700000E+01 | R = 2.4200000E+01 | F = 7.7200000E+01 |

|                    |                   |                   |                   |
|--------------------|-------------------|-------------------|-------------------|
| YT = 1.1300203E+02 | A = 1.5027716E+00 | D = 5.7685400E+00 | X = 6.8525115E+01 |
| Y = 1.0731525E+02  | Z = 1.3550000E+02 | R = 6.3281777E+01 | F = 2.7100000E+02 |

|                    |                   |                   |                   |
|--------------------|-------------------|-------------------|-------------------|
| YT = 1.1135376E+02 | A = 1.5755161E+00 | D = 4.1370100E+00 | X = 7.1571043E+01 |
| Y = 1.0721570E+02  | Z = 1.3700000E+02 | R = 6.7215704E+01 | F = 2.7400000E+02 |

|                    |                   |                   |                   |
|--------------------|-------------------|-------------------|-------------------|
| YT = 1.1011265E+02 | A = 1.5011945E+00 | D = 2.5335600E+00 | X = 7.3845330E+01 |
| Y = 1.0751901E+02  | Z = 1.3150000E+02 | R = 6.0171332E+01 | F = 2.7700000E+02 |

|                    |                   |                   |                   |
|--------------------|-------------------|-------------------|-------------------|
| YT = 1.0133451E+02 | A = 1.5737420E+00 | D = 2.0034700E+00 | X = 7.5361410E+01 |
| Y = 1.072412E+02   | Z = 1.3100000E+02 | R = 6.0489141E+01 | F = 2.7700000E+02 |

|                    |                   |                   |                   |
|--------------------|-------------------|-------------------|-------------------|
| YT = 1.0070035E+02 | A = 1.5033804E+00 | D = 1.0120500E+00 | X = 7.6515415E+01 |
| Y = 1.0716005E+02  | Z = 1.4000000E+02 | R = 6.1126551E+01 | F = 2.8000000E+02 |

|                    |                   |                   |                   |
|--------------------|-------------------|-------------------|-------------------|
| YT = 1.0130104E+02 | A = 1.5740005E+00 | D = 1.0930000E+00 | X = 7.7116170E+01 |
| Y = 1.0726204E+02  | Z = 1.4000000E+02 | R = 6.8126551E+01 | F = 2.8000000E+02 |

FINAL SOLUTION...

|                    |                   |                   |                   |
|--------------------|-------------------|-------------------|-------------------|
| YT = 1.0105134E+02 | A = 1.5703457E+00 | D = 6.0674000E-01 | X = 7.7720990E+01 |
| Y = 1.0744260E+02  | Z = 1.4050000E+02 | R = 6.8444061E+01 | F = 2.8100000E+02 |

C = 2.42000000E-07

VF = 400.00

E = 1.00

S = .50

G = .300

|                    |                   |                   |                   |
|--------------------|-------------------|-------------------|-------------------|
| YT = 4.0000000E+02 | A = 1.5732375E+00 | D = 3.7002322E+02 | X = 2.7267039E+01 |
| Y = 2.917674E+01   | Z = 4.5500000E+01 | R = 2.1966131E+01 | F = 5.1000000E+01 |

|                    |                   |                   |                   |
|--------------------|-------------------|-------------------|-------------------|
| YT = 2.0091304E+02 | A = 1.5717021E+00 | D = 1.0077301E+02 | X = 6.6567665E+01 |
| Y = 1.1621115E+02  | Z = 2.2050000E+02 | R = 1.4037423E+02 | F = 4.4100000E+02 |

|                    |                   |                   |                   |
|--------------------|-------------------|-------------------|-------------------|
| YT = 2.5076000E+02 | A = 1.5706753E+00 | D = 3.1679130E+01 | X = 1.2041306E+02 |
| Y = 2.231125E+02   | Z = 2.7500000E+02 | R = 1.7507002E+02 | F = 5.5000000E+02 |

|                    |                   |                   |                   |
|--------------------|-------------------|-------------------|-------------------|
| YT = 2.4515700E+02 | A = 1.5740401E+00 | D = 1.8272500E+01 | X = 1.3771251E+02 |
| Y = 2.292402E+02   | Z = 2.6500000E+02 | R = 1.6175451E+02 | F = 5.7100000E+02 |

|                    |                   |                   |                   |
|--------------------|-------------------|-------------------|-------------------|
| YT = 2.4341511E+02 | A = 1.5752133E+00 | D = 1.2536360E+01 | X = 1.4031610E+02 |
| Y = 2.307775E+02   | Z = 2.1150000E+02 | R = 1.3557422E+02 | F = 5.6500000E+02 |

|                    |                   |                   |                   |
|--------------------|-------------------|-------------------|-------------------|
| YT = 2.3055421E+02 | A = 1.5700497E+00 | D = 5.7717500E+00 | X = 1.3517735E+02 |
| Y = 2.3002425E+02  | Z = 2.9500000E+02 | R = 1.1710231E+02 | F = 5.9000000E+02 |

|                    |                   |                   |                   |
|--------------------|-------------------|-------------------|-------------------|
| YT = 2.3702260E+02 | A = 1.5743540E+00 | D = 5.6830000E+00 | X = 1.5918552E+02 |
| Y = 2.2133500E+02  | Z = 2.1000000E+02 | R = 1.0571224E+02 | F = 5.9000000E+02 |