HEAT PIPE RADIATOR
FINAL REPORT

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GRUMMAN
HEAT PIPE RADIATOR
FINAL REPORT

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Johnson Space Center
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By
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FOREWORD

This report was prepared by Grumman Aerospace Corporation for the Johnson Space Center of the National Aeronautics and Space Administration. The work was done under Contract NAS 9-12848, with Mr. B. French serving as Technical Monitor.

The work was performed from June 1972 to September 1973 under the direction of Mr. R. Haslett as program manager and Mr. B. Swerdling and Mr. J. Alario as project engineers. A major contribution was made by Mr. R. Hembach in thermal analysis and bench testing. Contributions were also made by Mr. J. Valentine in structural design and by Mr. W. Combs in fabrication. A special tribute is paid to Dr. J. Sellers, Jr. of Tuskegee University for his help with the system test data analysis.
## CONTENTS

<table>
<thead>
<tr>
<th>Section</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 SUMMARY</td>
<td>1-1</td>
</tr>
<tr>
<td>2 INTRODUCTION</td>
<td>2-1</td>
</tr>
<tr>
<td>3 SYSTEM STUDY</td>
<td>3-1</td>
</tr>
<tr>
<td>3.1 Method of Analysis</td>
<td>3-4</td>
</tr>
<tr>
<td>3.2 Results</td>
<td>3-8</td>
</tr>
<tr>
<td>3.3 VCHP Reservoir Sizing</td>
<td>3-8</td>
</tr>
<tr>
<td>3.4 System Selection</td>
<td>3-13</td>
</tr>
<tr>
<td>3.5 System Performance</td>
<td>3-15</td>
</tr>
<tr>
<td>3.6 Feasibility Panel Selection</td>
<td>3-17</td>
</tr>
<tr>
<td>4 PANEL DESIGN DETAILS</td>
<td>4-1</td>
</tr>
<tr>
<td>4.1 Panel Feeder Heat Pipes</td>
<td>4-5</td>
</tr>
<tr>
<td>4.2 VCHP Header</td>
<td>4-8</td>
</tr>
<tr>
<td>4.3 Heat Exchanger</td>
<td>4-15</td>
</tr>
<tr>
<td>4.4 Photographs</td>
<td>4-22</td>
</tr>
<tr>
<td>5 BENCH TEST DATA</td>
<td>5-1</td>
</tr>
<tr>
<td>5.1 Feeder Heat Pipes</td>
<td>5-1</td>
</tr>
<tr>
<td>5.2 VCHP Header</td>
<td>5-5</td>
</tr>
<tr>
<td>5.3 Heat Exchanger</td>
<td>5-9</td>
</tr>
<tr>
<td>5.4 Panel Assembly</td>
<td>5-9</td>
</tr>
<tr>
<td>6 SYSTEM TEST</td>
<td>6-1</td>
</tr>
<tr>
<td>6.1 Discussion</td>
<td>6-1</td>
</tr>
<tr>
<td>6.2 Test Results</td>
<td>6-5</td>
</tr>
<tr>
<td>6.3 Conclusions</td>
<td>6-16</td>
</tr>
<tr>
<td>7 RECOMMENDATIONS</td>
<td>7-1</td>
</tr>
<tr>
<td>8 REFERENCES</td>
<td>8-1</td>
</tr>
</tbody>
</table>

### Appendixes

<table>
<thead>
<tr>
<th>Appendix</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>A RADIATOR SIZING PROGRAM LISTING</td>
<td>A-1</td>
</tr>
<tr>
<td>B SYSTEM TEST DATA</td>
<td>B-1</td>
</tr>
</tbody>
</table>
## ILLUSTRATIONS

<table>
<thead>
<tr>
<th>Figure</th>
<th>Description</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>3-1</td>
<td>Series System</td>
<td>3-2</td>
</tr>
<tr>
<td>3-2</td>
<td>Parallel System</td>
<td>3-3</td>
</tr>
<tr>
<td>3-3</td>
<td>Two Series in Parallel</td>
<td>3-5</td>
</tr>
<tr>
<td>3-4</td>
<td>Three Series in Parallel</td>
<td>3-6</td>
</tr>
<tr>
<td>3-5</td>
<td>Radiator Module Thermal Model</td>
<td>3-7</td>
</tr>
<tr>
<td>3-6</td>
<td>Panel Header Vapor Temperatures</td>
<td>3-10</td>
</tr>
<tr>
<td>3-7</td>
<td>Heat Rejection per Panel</td>
<td>3-10</td>
</tr>
<tr>
<td>3-8</td>
<td>Reservoir Size vs Control Range (Based on 35°F Shutoff)</td>
<td>3-11</td>
</tr>
<tr>
<td>3-9</td>
<td>VCHP &quot;On&quot; and &quot;Off&quot; Temperatures, Series System, Ammonia Working Fluid and N₂ Gas</td>
<td>3-14</td>
</tr>
<tr>
<td>3-10</td>
<td>Series System Performance</td>
<td>3-19</td>
</tr>
<tr>
<td>3-11</td>
<td>Heat Rejected per Panel, Maximum and Minimum Loads</td>
<td>3-20</td>
</tr>
<tr>
<td>4-1</td>
<td>Panel Assembly</td>
<td>4-2</td>
</tr>
<tr>
<td>4-2</td>
<td>VCHP Header/Feeder Pipe Welded Interface</td>
<td>4-3</td>
</tr>
<tr>
<td>4-3</td>
<td>Heat Pipe Panel Fin Effectiveness</td>
<td>4-4</td>
</tr>
<tr>
<td>4-4</td>
<td>Feeder Pipe Performance</td>
<td>4-6</td>
</tr>
<tr>
<td>4-5</td>
<td>Feeder Heat Pipes</td>
<td>4-7</td>
</tr>
<tr>
<td>4-6</td>
<td>VCHP Header Heat Pipe Reference Dimensions</td>
<td>4-9</td>
</tr>
<tr>
<td>4-7</td>
<td>Header Assembly</td>
<td>4-11</td>
</tr>
<tr>
<td>4-8</td>
<td>Radiator Header Performance Without Control Gas</td>
<td>4-13</td>
</tr>
<tr>
<td>4-9</td>
<td>Header Interface Location, For Design N₂ Charge of 0.1498lb</td>
<td>4-14</td>
</tr>
<tr>
<td>4-10</td>
<td>Heat Exchanger Core</td>
<td>4-16</td>
</tr>
<tr>
<td>4-11</td>
<td>Heat Exchanger Assembly</td>
<td>4-17</td>
</tr>
<tr>
<td>4-12</td>
<td>Heat Exchanger Effectiveness</td>
<td>4-20</td>
</tr>
<tr>
<td>4-13</td>
<td>ΔT vs Q Heat Pipe Radiator Heat Exchanger</td>
<td>4-21</td>
</tr>
<tr>
<td>4-14</td>
<td>VCHP Header Assembly</td>
<td>4-23</td>
</tr>
<tr>
<td>4-15</td>
<td>VCHP Header With Feeder Pipes</td>
<td>4-24</td>
</tr>
<tr>
<td>4-16</td>
<td>Radiator Panel Components</td>
<td>4-25</td>
</tr>
<tr>
<td>4-17</td>
<td>Assembled Radiator Panel</td>
<td>4-26</td>
</tr>
<tr>
<td>Figure</td>
<td>Description</td>
<td>Page</td>
</tr>
<tr>
<td>--------</td>
<td>-----------------------------------------------------------------------------</td>
<td>-------</td>
</tr>
<tr>
<td>5-1</td>
<td>Feeder Pipe Instrumentation</td>
<td>5-2</td>
</tr>
<tr>
<td>5-2</td>
<td>Test Data, Q vs TILT</td>
<td>5-3</td>
</tr>
<tr>
<td>5-3</td>
<td>Feeder Pipe Overall Temperature Differential</td>
<td>5-4</td>
</tr>
<tr>
<td>5-4</td>
<td>VCHP Header Instrumentation</td>
<td>5-6</td>
</tr>
<tr>
<td>5-5</td>
<td>VCHP Test Data, Partial and Design Gas Charge</td>
<td>5-8</td>
</tr>
<tr>
<td>5-6</td>
<td>VCHP Header Bench Test Data</td>
<td>5-10</td>
</tr>
<tr>
<td>5-7</td>
<td>Heat Pipe Radiator Exchanger Test Data</td>
<td>5-11</td>
</tr>
<tr>
<td>5-8</td>
<td>Ambient Functional Bench Test, Heat Pipe Radiator</td>
<td>5-12</td>
</tr>
<tr>
<td>6-1</td>
<td>Panel Instrumentation</td>
<td>6-2</td>
</tr>
<tr>
<td>6-2</td>
<td>T/V Test Results, VCHP Condenser Temperatures</td>
<td>6-6</td>
</tr>
<tr>
<td>6-3</td>
<td>T/V Test Results, ΔT Header to Feeder Heat Pipes</td>
<td>6-7</td>
</tr>
<tr>
<td>6-4</td>
<td>T/V Test Results, ΔT Header to Feeder Heat Pipes</td>
<td>6-8</td>
</tr>
<tr>
<td>6-5</td>
<td>Reservoir Temperature vs Heat Gain</td>
<td>6-10</td>
</tr>
<tr>
<td>6-6</td>
<td>Heat Pipe Radiator Performance</td>
<td>6-13</td>
</tr>
<tr>
<td>6-7</td>
<td>Heat Pipe Radiator Thaw Test, VCHP Header Response</td>
<td>6-15</td>
</tr>
<tr>
<td>Table</td>
<td>Description</td>
<td>Page</td>
</tr>
<tr>
<td>-------</td>
<td>-------------</td>
<td>------</td>
</tr>
<tr>
<td>3-1</td>
<td>Radiator System Design Requirements</td>
<td>3-1</td>
</tr>
<tr>
<td>3-2</td>
<td>Summary of System Study Results for $Q_{REJ} = 15,000W @ Q_a = 60 \text{ Btu/Hr-Ft}^2$</td>
<td>3-9</td>
</tr>
<tr>
<td>3-3</td>
<td>Series System Reservoir Sizes</td>
<td>3-15</td>
</tr>
<tr>
<td>3-4</td>
<td>Modular Panel Specifications</td>
<td>3-17</td>
</tr>
<tr>
<td>4-1</td>
<td>Feeder Heat Pipe Design Details</td>
<td>4-8</td>
</tr>
<tr>
<td>4-2</td>
<td>Heat Exchanger Details</td>
<td>4-22</td>
</tr>
<tr>
<td>5-1</td>
<td>VCHP $Q_{max}$ Test Data, Reservoir Temperature $=57^\circ\text{F}$</td>
<td>5-7</td>
</tr>
<tr>
<td>6-1</td>
<td>Heat Pipe Radiator Thermocouples</td>
<td>6-3</td>
</tr>
<tr>
<td>6-2</td>
<td>Heat Pipe Radiator Thermal Vacuum Test Conditions</td>
<td>6-7</td>
</tr>
<tr>
<td>6-3</td>
<td>Summary of Results</td>
<td>6-11</td>
</tr>
</tbody>
</table>

vi
GLOSSARY

Symbols

A  area
C_p  specific heat
D  diameter
D_h  hydraulic diameter
G  mass flow per unit area
g  gravitational acceleration
g_c  gravitational constant
h  convective film coefficient
M  mass flow rate
N_2  nitrogen gas
NH_3  ammonia
P  pressure
ΔP  pressure drop
Q  heat flux
T  temperature
U  overall heat transfer coefficient
V  volume
W  mass flow rate
ε  surface emittance
λ  latent heat
μ  absolute viscosity
ρ  density
σ  surface tension; Stefan-Boltzmann Constant
η  effectiveness
Subscripts

a absorbed

c condenser; core

e evaporator

f fin

g inert gas

H header

i inside surface

M mean

R reservoir

REJ rejected

V vapor

X heat exchanger
A 15,000 watt spacecraft waste heat rejection system utilizing heat pipe radiator panels has been investigated. Of the several concepts initially identified, a series system was selected for more in-depth analysis. As a demonstration of system feasibility, a nominal 500 watt radiator panel has been designed, built and tested. The panel, which is a module of the 15,000 watt system, consists of a variable conductance heat pipe (VCHP) header, and six isothermalizer heat pipes attached to a radiating fin. The thermal load to the VCHP is supplied by a Freon-21 liquid loop via an integral heat exchanger.

This report describes the results of the system studies, details the radiator design, and presents the test results for both the heat pipe components and the assembled radiator panel. These results support the feasibility of using heat pipes in a spacecraft waste heat rejection system.
The heat pipe is an extremely efficient thermal control device that can transfer heat with very little temperature drop. This is accomplished by the evaporation, vapor transport, condensation and return by capillary action of a working fluid within a sealed container. In addition to superior thermal performance, heat pipes have no moving parts, require no electrical power, do not generate noise or vibration, and can be made self-regulating. These features make heat pipes attractive for the long-life, high reliability thermal control applications frequently needed for spacecraft.

Recent engineering applications of heat pipe technology have developed hardware that represents significant advances in the thermal control field (Ref. 1, 2, 3). Experiments have also been flown that demonstrate the ability of the heat pipe to operate predictably in space (Ref. 4, 5). The fact that the heat transport capacities of these devices have now been extended to the kilowatt range (Ref. 6) make their application to large scale thermal conditioning systems a real possibility. Recent studies that evaluated heat pipe applications for Space Station (Ref. 7), and Space Shuttle (Ref. 8) indicated that heat pipes as fin isothermalizers coupled to a variable conductance heat pipe (VCHP) as a temperature controller are viable candidates for spaceborne heat rejection systems.

When the heat pipe radiator and the conventional parallel-tube, fluid-loop radiator (Ref. 9, 10, 11), are compared for the same heat rejection capacity, it is found that the fluid radiator has a smaller area but the heat-pipe radiator requires no electrical power, has no parts that can wear out, and does not generate noise or vibration; these advantages become more important as mission time increases. Consequently, as a first step towards realizing the benefits of heat pipe technology in a large scale heat rejection system, a program was initiated by the Johnson Space Center to evaluate the feasibility of a self-regulating heat pipe space radiator.

The objective of the program was basically threefold, namely: (a) investigate a 15,000 watt spacecraft waste heat rejection system using heat pipes; (b) analytically design the heat-pipe radiator systems, and (c) fabricate and test a typical component module of the system.
Section 3

SYSTEM STUDY

The performance requirements used for the heat pipe radiator system tradeoff studies given in Table 3-1 are those of the Shuttle vehicle at the time this program was initiated. The basic heat pipe system was ground-ruled to be a modular system consisting of multiple 4 X 8 ft panels. Each panel, or module, has a variable conductance heat pipe (VCHP) header and six fixed conductance feeder heat pipes spaced on 8-in. centers. A fin effectiveness of .90 and a surface emittance of .90 are assumed. The thermal load is supplied by a Freon-21 liquid loop through a heat exchanger attached to the evaporator section of the VCHP header.

Table 3-1 - Radiator System Design Requirements

<table>
<thead>
<tr>
<th></th>
<th>Maximum</th>
<th>Minimum</th>
</tr>
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<tbody>
<tr>
<td>Net heat rejection, watts</td>
<td>15,000 (51,225 Btu/hr)</td>
<td>300 (1020 Btu/hr)</td>
</tr>
<tr>
<td>Absorbed flux, watts/m²</td>
<td>190 (60 Btu/hr-ft²)</td>
<td>79 (25 Btu/hr-ft²)</td>
</tr>
<tr>
<td>Freon-21 inlet temp., °K</td>
<td>338.7 (150°F)</td>
<td>278.7 (42°F)</td>
</tr>
<tr>
<td>Freon-21 outlet temp., °K</td>
<td>278.7 (42°F)</td>
<td>277.5 (40°F)</td>
</tr>
<tr>
<td>Flow rate, kg/S</td>
<td>.234 (1850 lb/hr)</td>
<td>.234 (1850 lb/hr)</td>
</tr>
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</table>

The three types of systems that were investigated, series, parallel and series/parallel, are described below.

- Series - All of the required panels are sequentially arranged so that the coolant flows from the outlet of one heat exchanger to the inlet of the next. The major feature is that each successive panel operates at a lower temperature than the previous one. This results in a variation in the heat rejected by each panel; the panel nearest the inlet handles the most load and that nearest the outlet handles the least. See Figure 3-1.

- Parallel - The coolant enters all of the panels simultaneously, at the same temperature. The inlet temperature of each panel is the same and the outlet temperature of each panel is the same; the total system heat load is equally distributed between all panels. See Figure 3-2.
Figure 3-1 Series System

MAX LOAD - MAX ENVIRONMENT

- TOTAL AREA = 830 FT²
- $\epsilon = 0.90$
- $\eta = 0.90$
- $Q_a = 60$ BTU

$T_{OUT} = 39.6^\circ F$

$T_R = 35.5^\circ F$

$T_O = 142^\circ F$

$T = 150^\circ F$

$W = 1850$ LB/HR

LOAD $= 51,000$ BTU/HR
Figure 3-2 Parallel System
Series/Parallel - A combination of the series and parallel systems where the required number of panels is divided into two or more parallel runs of series panels. See Figures 3-3 and 3-4.

System temperatures for the maximum design load condition are also indicated in Figures 3-1 through 3-4.

3.1 METHOD OF ANALYSIS

Each system was evaluated in an essentially identical manner using an existing computer program. The program assumes a flat radiator with an unrestricted view of space. (A segment of the model is shown in Figure 3-5.) Heat is transferred from the Freon loop via the integral heat exchanger, to the evaporator section of the VCHP header, and then through the condenser section of the header to the attached evaporators of the feeder heat pipes. Finally the condenser sections of the feeder pipes distribute the heat to the radiator fin. The following equations describe the analytical model for a single radiator panel.

Net Heat Rejection

\[ Q_{REJ} = \eta \left[ \epsilon A \sigma T_{Root}^4 - Q_a \right] \]  

(3-1)

Heat Exchanger Outlet Temperature

\[ T_{out} = T_{in} - \frac{Q_{REJ}}{W C_p} \]  

(3-2)

Fluid Mean Temperature

\[ T_M = \frac{T_{in} - T_{out}}{T_{in} - T_{out}} \]  

(3-3)

VCHP Header Vapor Temperature

\[ T_V = T_M - \frac{Q_{REJ}}{COND1} \]  

(3-4)

Panel Root Temperature

\[ T_{Root} = T_V - \frac{Q_{REJ}}{COND2} \]  

(3-5)
MAX LOAD ~ MAX ENVIRONMENT

- TOTAL AREA = 896 FT^2
- ε = .90
- η = .90
- Q_a = 60 BTU / HR-FT^2

Figure 3-3 Two Series in Parallel
Figure 3-4  Three Series In Parallel
Figure 3-5  Radiator Module Thermal Model
Equations (3-1) through (3-5) can be combined after defining

\[ R^1 = \left( \varepsilon A \sigma T_{\text{Root}}^4 - Q_a \right) \]

to give

\[ T_{\text{in}} - T_{\text{Root}} + \left[ \frac{\eta}{W_{Cp}} \frac{\text{COND1}}{W_{Cp}} \left( 1 - e^{-\frac{\text{COND1}}{W_{Cp}}} \right) - \frac{\eta}{\text{COND2}} \right] R^1 = 0 \quad (3-6) \]

Since \( R^1 \) is a function of \( T_{\text{Root}} \), equation (3-6) can be solved numerically for \( T_{\text{Root}} \). Then, once \( T_{\text{Root}} \) is known, \( Q_{\text{REJ}} \) and \( T_{\text{out}} \) may be found. To analyze a radiator system containing a number of panels in series, \( T_{\text{out}} \) of the first panel would be \( T_{\text{in}} \) of the second panel, etc. Equation (3-6) was programmed and solved by Newton's method; the listing of the computer program is contained in Appendix A.

3.2 RESULTS

Using the above equations, the total radiator area and number of panels required for the maximum load, maximum environment condition was determined. The results are summarized in Table 3-2.

The parallel system requires 150 \( m^2 \) (1632 ft\(^2\)) of radiator area while the all series systems requires 77 \( m^2 \) (830 ft\(^2\)). The combined series/parallel approach requires areas between these two extremes. The smaller area for the series case is a direct result of the higher header vapor temperatures attainable as compared to the parallel case. Typically, the header vapor temperature of a panel is slightly lower than the heat exchanger outlet temperature. Thus, for the series case this allows a higher average radiating temperature resulting in greater thermal efficiency. For example, as shown in Table 3-2 the parallel panel maximum temperature is 275\(^{\circ}\)K (38\(^{\circ}\)F) vs the series maximum of 326\(^{\circ}\)K (127\(^{\circ}\)F). This effective radiating temperature phenomenon is characteristic of heat pipe systems and is summarized in Figure 3-6, which shows the header vapor temperature for each panel in each of the four systems shown in the table. The associated heat rejection for each panel is shown in the curves of Figure 3-7. These two figures emphasize that the first few panels in the series systems are very effective (by a factor of two or three) while the last panel is no worse than the best parallel panel.

3.3 VCHP RESERVOIR SIZING

With the radiator system configuration established, the VCHP reservoir can be defined. The reservoir size is a function of the desired control band established by the radiator requirement and the temperature of the reservoir. The size can be determined by calculating the gas inventory at the hot (full open) and cold case (full close) operating conditions.
Table 3-2 - Summary of System Results for $Q_{REJ} = 15,000 \text{ W @ } Q_a = 60 \text{ Btu/HR-Ft}^2$

<table>
<thead>
<tr>
<th>System</th>
<th>Branch Flow Rate, W</th>
<th>Total Area</th>
<th>Max $T_{Root}$</th>
<th>Header</th>
<th>$T_V$</th>
<th>Panel Temp. Range</th>
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</thead>
<tbody>
<tr>
<td></td>
<td>lb/hr</td>
<td>Kg/S</td>
<td>ft$^2$</td>
<td>m$^2$</td>
<td>$^\circ$F</td>
<td>$^\circ$K</td>
</tr>
<tr>
<td>Parallel</td>
<td>36.4</td>
<td>0.0046</td>
<td>1632</td>
<td>150</td>
<td>37.9</td>
<td>276</td>
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<tr>
<td>Series</td>
<td>1850</td>
<td>0.234</td>
<td>830</td>
<td>77</td>
<td>127</td>
<td>326</td>
</tr>
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<td>2 Series/Parallel</td>
<td>925</td>
<td>0.117</td>
<td>896</td>
<td>81.3</td>
<td>119.6</td>
<td>322</td>
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<tr>
<td>3 Series/Parallel</td>
<td>616</td>
<td>0.0075</td>
<td>960</td>
<td>87.3</td>
<td>113.8</td>
<td>319</td>
</tr>
</tbody>
</table>
Figure 3-6  Panel Header Vapor Temperatures
\( Q_L = 15000 \text{W} \)
\( Q_A = 60 \text{ BTU/HR-FT}^2 \)
\( F-21 \text{ SYSTEM FLOW RATE} = 1850 \text{ LB/HR} \)
\( T_{IN} = 150^\circ \text{F, T_OUT} = 40 \pm 2^\circ \text{F} \)
\( \epsilon = .90 \)
\( \eta = .90 \)

Figure 3-7 Heat Rejection Per Panel
Consider the simplified VCHP shown below which consists of ammonia as the working fluid and N₂ inert gas. During the cold or full close case, the gas fills the condenser with the interface located at the end of the evaporator. From the gas laws:

\[(mR)_G = \frac{P_G V_G}{T_G} \quad (3-7)\]

where

\[P_G = (P_{NH_3})_{\text{Cold}} - (P_{NH_3})_{\text{Res}} \quad (3-8)\]

\[V_G = V_C + V_R \quad (3-9)\]

and

\[T_G = (T_R)_{\text{Cold}} \quad (3-10)\]

During the hot or full open case, the gas interface is located at the end of the condenser with all of the gas in the reservoir and:

\[P_G = (P_{NH_3})_{\text{Hot}} - (P_{NH_3})_{\text{Res}} \quad (3-11)\]

\[V_G = V_R \quad (3-12)\]

and

\[T_G = (T_R)_{\text{Hot}} \quad (3-13)\]

Since the mass of gas mR is constant in the pipe, equations (3-8, -9, -10 and -11, -12, -13) can be substituted in equation (3-7) to give:

\[
\left(\frac{(P_{NH_3})_{\text{Cold}} - (P_{NH_3})_{\text{Res}}}{(T_R)_{\text{Cold}}}\right) \frac{(V_C + V_R)}{(T_R)_{\text{Cold}}} = \left(\frac{(P_{NH_3})_{\text{Hot}} - (P_{NH_3})_{\text{Res}}}{(T_R)_{\text{Hot}}}\right) \frac{V_R}{T_R} \quad (3-15)
\]

which can be rearranged to give:

\[
V_C = \left[\frac{(P_{NH_3})_{\text{Hot}} - (P_{NH_3})_{\text{Res}}}{(T_R)_{\text{Cold}}}\right] (T_R)_{\text{Cold}} - 1 \quad (3-15)
\]

\[
V_R = \left[\frac{(P_{NH_3})_{\text{Cold}} - (P_{NH_3})_{\text{Res}}}{(T_R)_{\text{Hot}}}\right] (T_R)_{\text{Hot}}
\]

3-12
where \( (P_{NH_3})_{Evap} \) = pipe total pressure at evaporator temperature
\( (P_{NH_3})_{Res} \) = ammonia partial pressure at reservoir temperature
\( P_G \) = inert gas pressure
\( T_R \) = reservoir temperature
\( V_C, V_R \) = condenser and reservoir vapor volumes, respectively
\( V_g \) = inert gas volume
\( m \) = moles of inert gas
\( R \) = gas constant

From equation (3-15), one can determine the VCHP reservoir size required for a given control condition. Figure 3-8 is a plot of \( V_R/V_C \) (ratio of reservoir to condenser volume) as a function of evaporator temperature control range (temperature difference between hot and cold cases). At \( T_{Hot} \) the panel is fully open and at \( T_{Cold} \) it is completely closed. Also shown is the affect of variation in reservoir temperature on reservoir size. A constant reservoir temperature results in a tighter control range for the same \( V_R/V_C \) ratio.

3.4 SYSTEM SELECTION

The heat pipe radiator system selected for detailed design was the all series system shown in Figure 3-1. Under the boundary conditions imposed, the series system required the least radiator area of the several systems studied (see Table 3-2) and required nominal VCHP reservoir sizes \(<0.1 \text{ ft}^3\). The parallel system was rejected on the grounds that the area required for maximum load, maximum environment condition was almost double that of the series system. In addition, the size of the VCHP reservoirs required for control were impractical. The series/parallel systems considered were attractive from an area standpoint, but they required reservoir sizes approximately twice as large as the straight series system and were rejected for that reason.

For the radiator module under study, the VCHP condenser vapor volume was approximately 28 in.\(^3\) (0.0055 m\(^3\)). A reasonable reservoir/condenser volume ratio was set at \( V_R/V_C = 7 \) which gives a \( V_R = 196 \text{ in.}^3 \) (0.04 m\(^3\)). From Figure 3-8, curve A, for a \( V_R/V_C = 7 \), the minimum control range is 25\(^\circ\)F for a varying reservoir temperature. This means a full-open panel at an evaporator temperature of 60\(^\circ\)F and a fully closed panel at 35\(^\circ\)F. For control spans less than 25\(^\circ\)F, a fixed reservoir...
Figure 3-8  Reservoir Size vs Control Range (Based on 35°F Shutoff)
temperature is required, as seen in Figure 3-8, curve B. Referring to Figure 3-2, it can be seen that the all-parallel system operating vapor temperatures will be close to 40°F. This will be the nominal value for all load conditions since the fluid outlet temperature remains fixed at 40°F; thus, a relatively tight control range is needed ($T_{\text{hot}} - T_{\text{cold}} < 5^\circ\text{F}$). Even by keeping the reservoir temperatures constant, high reservoir volumes would be required as seen in Figure 3-8. However, in the series systems reasonable reservoir sizes can be used for most of the modules since the control spans can be expanded to $20 - 30^\circ\text{F}$. Only the last few panels in the series need be restricted to tighter control ranges to insure a nominal 40°F fluid outlet. The number of different size reservoirs can be minimized by varying the inert gas pressure as required to compensate for different "on/off" operating temperatures.

3.5 SYSTEM PERFORMANCE

The system selected for detailed design consisted of 26, 1.22m (4 ft) by 2.44 m (8 ft) panels with heat exchangers connected in series. The performance analysis neglected temperature drops through the tube walls and also across thermal interfaces since these should be small. The complete 15,000 watt system was divided into three zones; namely, zones A, B, and C. Table 3-3 shows the split.

<table>
<thead>
<tr>
<th>Zone</th>
<th>Panel No's.</th>
<th>Nominal Reservoir Size, $V_R/V_C$</th>
<th>Reservoir Temperature</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>1 - 14</td>
<td>5</td>
<td>Varies with environment</td>
</tr>
<tr>
<td>B</td>
<td>15 - 21</td>
<td>4</td>
<td>Constant @ 246°C (-16°F)</td>
</tr>
<tr>
<td>C</td>
<td>22 - 26</td>
<td>7</td>
<td>Constant @ 246°C (-16°F)</td>
</tr>
</tbody>
</table>

Each VCHP header was designed to be fully operational under maximum load and environment at the temperatures shown in Figure 3-9 by the solid curve. The fully closed temperature for each header is indicated by the dashed curve in the same figure. For example, the VCHP header on panel number 14 is fully open at a temperature of 297°C (74°F) and fully closed at 280°C (44°F). To keep the reservoir sizes reasonable ($V_R/V_C \approx 7$), the reservoirs in zones B and C must be kept at a constant temperature of approximately 246°C (-16°F). The last several panels close at temperatures less than 278°C (40°F). This is because the panels in zone C have an "on/off" temperature difference of 2.8°C (5°F) with a full open temperature of 278°C (40°F). If desired, the system can be designed for an "on" temperature of 279°C (42°F) and off at 277°C (38°F) but this scheme must be fully investigated.
Figure 3-9 VCHP On and Off Temperatures, Series System, Ammonia Working Fluid and N₂ Gas
The 26-panel series system was investigated for several load conditions and environments. Figure 3-10 summarizes the data for the extreme environments. In Figure 3-10a, the system freon liquid loop outlet temperature is plotted as a function of the maximum and minimum environments. As shown, outlet temperature varies only 3.3°K (6°F) for a maximum-to-minimum load variation of 37:1. Figure 3-11 shows the heat rejection per panel for the two extreme load conditions. Under the low load condition ($T_{in} = 55\,^\circ F$), panels 1 - 10 and 16 - 23 are fully closed as expected since the VCHP header vapor temperatures are below the cutoff temperatures shown in Figure 3-9.

### 3.6 FEASIBILITY PANEL SELECTION

Panel number 14 in the series system was selected to demonstrate the operational feasibility of a VCHP radiator. The reasons for selection were: (1) it required a nominal (500 watt) load capability; (2) it had a convenient operating temperature range between $72\,^\circ F$ (full open, warm environment) and $41\,^\circ F$ (full close, cold environment); and (3) it did not require a constant temperature reservoir to hold its control span. The design specifications established for this panel are summarized in Table 3-4. The $V_R/V_C$ ratio was changed from 5 to 7 to compensate for slightly warmer reservoir temperatures than were originally estimated. This was a result of more comprehensive investigations that were done in support of the detailed design effort.

<table>
<thead>
<tr>
<th>Table 3-4 Modular Panel Specifications</th>
</tr>
</thead>
<tbody>
<tr>
<td>- Panel size - nominal 1.22 m x 2.44 m (4 x 8 ft)</td>
</tr>
<tr>
<td>- 1 - VCHP header - 1.83 m (6 ft) overall length</td>
</tr>
<tr>
<td>- Reservoir size - $V_R/V_C \approx 7$</td>
</tr>
<tr>
<td>- Heat exchanger length - 0.61 m (2 ft)</td>
</tr>
<tr>
<td>- 6 - Feeder heat pipes - nominal 2.75 m (9 ft) overall length</td>
</tr>
<tr>
<td>- VCHP full-open vapor temperature - 295°K (72°F) @ 190 w/m² (60 Btu/hr-ft²)</td>
</tr>
<tr>
<td>- VCHP full close vapor temperature - 278°K (41°F) @ 79 w/m² (25 Btu/hr-ft²)</td>
</tr>
<tr>
<td>- Reservoir temperature range - 200°K to 246.5°K (-100°F to -16°F)</td>
</tr>
<tr>
<td>- Operational environment - 79 - 190 w/m² (25-60 Btu/hr-ft²)</td>
</tr>
<tr>
<td>Table 3-4 Modular Panel Specification (Cont'd)</td>
</tr>
<tr>
<td>---------------------------------------------</td>
</tr>
<tr>
<td>• Nominal panel capacity - 500 watts</td>
</tr>
<tr>
<td>• Panel emittance, $\epsilon = .9$</td>
</tr>
<tr>
<td>• Heat pipe working fluids</td>
</tr>
<tr>
<td>- VCHP header: $\text{NH}_3 + \text{N}_2$ inert gas</td>
</tr>
<tr>
<td>- Feeder pipes: $\text{NH}_3$</td>
</tr>
</tbody>
</table>
Figure 3-10 Series System Performance
Figure 3-11 Heat Rejected Per Panel, Maximum and Minimum Loads
Section 4

DESIGN DETAILS

The objective of the hardware phase of this program was to design and build a typical VCHP radiator module that would demonstrate the feasibility of the technical approach. No attempt was made to weight-optimize the design. The basic panel, shown in Figure 4-1, has the VCHP header, fluid heat exchanger, panel feeder heat pipes and radiating fin as its major components.

The overall size of the panel was set by ground rules at 4 x 8 ft. The number of feeder heat pipes for the panel was determined by the required fin effectiveness, redundancy, ease of fabrication and cost. A large number of feeder pipes would certainly result in a more efficient panel but it would also unnecessarily complicate the manufacturing and assembly. Six feeder pipes, spaced on 8-in. centers, were chosen as a reasonable compromise. If any one pipe were lost due to a puncture, the panel's fin effectiveness would be only slightly affected.

For ease of manufacturing and assembly, the basic panel is formed from six finned subassemblies joined (riveted) along their common edges to form the complete panel. Each subassembly contains the condenser section of a feeder heat pipe cradled in a centrally located semicylindrical depression running the entire length of the fin. A polyurethane bonding agent (Crest Products Co.) is used to attach each heat pipe to its fin. The temperature drop between the condenser and the fin root is kept small (less than 1° F) due to the relatively thin .010-.015-in. bondline and the large heat transfer area. The evaporator sections of the feeder heat pipes are welded to the condenser of the VCHP header to minimize the temperature gradient across the interface. (There is not enough heat transfer area available to permit the use of a mechanical type of attachment without incurring excessive temperature drops.) Figure 4-2 shows details of the welded interface.

A .020 in. thick aluminum sheet was specified for the fin material primarily because it could be more readily formed than the larger thicknesses. The fin effectiveness for the panel as a function of root temperature is shown in Figure 4-3. The curve is based upon an assumed surface emittance of .90 which was provided by 3-M White Velvet paint.
FOLDOUT FRAME

NOTES (UNLESS OTHERWISE INDICATED)
1. ALL ALL WELDING SHALL BE IN ACCORDANCE WITH MIL-W-8604, FILLER WIRE ALLOYS.
2. TYPICAL OPERATING CONDITIONS: WELDING.
3. ALL WELDING OPERATIONS WELDING FILLER WIRE ALLOYS SHALL BE IN ACCORDANCE WITH MIL-W-8604, FILLER WIRE ALLOYS.
4. FIELD WELDING PRACTICES NOT OTHERWISE INDICATED.

---

Figure 4-1 Panel Assembly
Figure 4-2 VCHP Header/Feeder Pipe Welded Interface
Figure 4-3  Heat Pipe Panel Fin Effectiveness
4.1 PANEL FEEDER HEAT PIPES

The overall dimensions of the feeder heat pipes were dictated by the fixed 4 x 8 ft panel area and the 8-in. center-to-center spacing. The condenser sections of the pipes were made equal to the panel length of 8 ft and the evaporator sections were made equal to the 8-in. spacing. This of course required the evaporator to be perpendicular to the condenser and resulted in an L-shaped configuration. An additional 2 in. were added to each pipe to accommodate the transition section (bend) between the evaporator and condenser; thus the overall length of each feeder pipe was 106 in. The pipe envelope was made from 6061 aluminum with a 0.625-in. o.d. and 0.500-in. i.d. since it was readily available and satisfied all structural and manufacturing requirements.

The feasibility panel needed a nominal 500 watt capacity at 70 - 75°F. The required capacity of each feeder pipe was therefore one-sixth of the panel capacity or approximately 85 watts. However, each feeder pipe was designed to handle at least 170 watts at an adverse tilt of 0.500 in. This was done to provide adequate margin in case the panel might be called upon to reject higher loads—as it would be if it were tested as the number 1 panel in the series system (1000 watt capacity at 135°F). Capacity at tilt was necessary to facilitate 1-g ground testing by minimizing the importance of panel alignment.

Ammonia was selected as the working fluid due to its high figure of merit and the performance margin that it offered. A basic spiral artery wicking system was decided upon because it promised superior performance at tilt than the simpler, longitudinally grooved extrusions that were available at the time. Results of computerized parametric analyses are presented in Figure 4-4 and give predicted capacity as a function of tilt and temperature. The decrease in capacity with increasing temperature is related to the corresponding decrease in the liquid transport factor \((\sigma \rho_\lambda / \mu)\) for ammonia over the 75°F-125°F range. As shown in Figure 4-4a, the feeder pipe design has more than adequate capacity over the temperature range of interest. Figure 4-4b indicates how the pipe will perform when tilted. The high tilt capability is due to the 170 mesh overwrap of the artery and relaxes possible test constraints.

Details of the pipe and artery design are given in Figure 4-5 and summarized in Table 4-1. The pipe has only two welds and is bent on a 2.5-in. radius. A 10-in. long biased wrapped flexible section is spliced to the normal artery to permit forming the bend after the artery is inserted in the pipe.
Figure 4-4 Feeder Pipe Performance
Figure 4-5  Feeder Heat Pipes

4-7
Table 4-1 - Feeder Heat Pipe Design Details

<table>
<thead>
<tr>
<th>Details</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Evaporator</td>
<td>8.0 in.</td>
</tr>
<tr>
<td>Condenser</td>
<td>96.0 in.</td>
</tr>
<tr>
<td>Overall Length</td>
<td>106.0 in.</td>
</tr>
</tbody>
</table>

Pipe Envelope

- 6061 Aluminum tube, 0.625 in. x 0.500 in.
- 150 Circumferential grooves/in.

Artery

- OD = .310 in.
- Gap = 0.015 in.
- Tunnel diameter = 0.093 in.
- Material - 100 mesh SS/170 mesh outer wrap
- Retainer - 170 mesh, 3 webs

4.2 VCHP HEADER

The VCHP header consists of a circumferentially grooved aluminum envelope, 1.00-in. OD nominal and 97.54 in. long. The main sections of the pipe are: the heat exchanger, 29.88 in. long; two low K sections, 4.31 in., condenser, 51.69 in. and reservoir 7.25 in. Additional dimensional information is given in Figure 4-6.

The inside diameter of the pipe is 0.867 in., grooved with 208 threads/in. The artery is a tunnel design (Ref. 12) with an overall outside diameter of 0.683 in. and a tunnel diameter of 0.200 in. The tunnel wick is fabricated in 100 mesh stainless steel screening and sealed in a 170 mesh stainless steel screen outer enclosure. The artery is supported in the heat pipe with an eight-web, 170 mesh retainer system in the condenser and evaporator sections of the pipe. The retainer outside diameter is covered (or shielded) with 0.002 in. nickle foil and one layer of 100 mesh screen in order to build up a 0.010 in. thick insulating layer of NH₃ on the outside of the retainer. The shield and insulator screen are incorporated to minimize the reheat of the subcooled fluid from the condenser wall as it travels down the artery system to the evaporator section of the pipe (Ref. 13).

The artery is terminated at the end of the condenser assembly. Two 170 mesh scrolls, .080 in. in diameter provide the capillary communication paths between the condenser retainer and the reservoir which is lined with 100 mesh stainless steel
Figure 4-6  Header Heat Pipe Reference Dimensions (Inches)
screening. The condenser section envelope is grooved longitudinally with two 0.625 in. diameter slots to receive the evaporator sections of the feeder pipes as was shown in Figure 4-2. Figure 4-7 is a detailed drawing of the VCHP header assembly.

The design of the VCHP header was based on providing a maximum annulus flow area in the pipe. The annulus is defined as the area between the artery o.d. (0.683 in.) and the tunnel diameter (0.200 in). The intent of the maximum annulus design is to provide for vapor/gas bubble growth within the artery and still hold design capacity with fluid flow in the outer wraps of the artery (Ref. 13).

The theoretical performance of the above configuration (not optimized for $Q_{\text{max}}$) in the single fluid mode (no inert gas), is presented in Figure 4-8. The upper curves are the $Q_{\text{max}}$ vs tilt performance with a fully primed tunnel. The lower curve is the performance based on annulus capacity only (tunnel deprimed).

The reservoir size and inert gas charge in a passive VCHP are determined by the temperature control range requirements and the variations in the sink environments for the condenser and reservoir radiator panels. Of course, the reservoir size and inert gas charge are also a function of the vapor space volume in the condenser.

The performance requirements for the VCHP header are included in the panel specifications which were given in Table 3-4. They specify a maximum capacity of 500 watts; a full open condenser at a pipe temperature of $72^\circ F$, while in a maximum environment defined by $Q_a = 60 \text{ Btu/hr-ft}^2$, and a fully closed condenser at a pipe temperature of $41^\circ F$, while in a minimum environment of $Q_a = 25 \text{ Btu/hr-ft}^2$.

The reservoir volume and $N_2$ inert gas charge for the above conditions, as determined by the VCHP computer program, are respectively 39.73 in.$^3$ and 0.01498 lb.

To meet the volume requirement the reservoir was designed as a cylinder, 5.62 in. long, with a 3.00 in. i.d.

The predicted locations of the interface separating the $N_2$ gas and $\text{NH}_3$ in the condenser of the VCHP are plotted in Figure 4-9. The curve for maximum environment ($60 \text{ Btu/hr-ft}^2$) and the curve for minimum environment ($25 \text{ Btu/hr-ft}^2$) define the full operating range of the pipe. Thus, even though the overall operating range of the pipe is 41 - $72^\circ F$, the control span for a fixed environment (fixed reservoir and full off condenser temperature) is approximately 7$^\circ F$. 

4-10
Figure 4-8 Radiator Header Performance Without Control Gas
Figure 4-9  Header Interface Location For Design N₂ Charge of 0.01498 Lb
If the fluid temperature in the circulating loop exceeds 72°F (neglecting heat exchanger ΔT's) the VCHP will open fully. The panel will reject 500 watts until the fluid loop inlet temperature decreases to within the control range 65 - 72°F. If the loop load decreases further and the temperature falls below 65°F, the VCHP will shut off completely.

Two conditions will advance the interface back into the condenser: (1) an increasing fluid loop load, or (2) a decrease in the environment \(Q_a\). Following the later case the VCHP will modulate with a 7°F span at a lower pipe temperature rejecting a little less than 500 watts. Reducing the fluid loop load will again lead to a pipe shut off condition; reducing \(Q_a\) will open it again. This process can be continued until \(Q_a = 25\) Btu/hr-ft\(^2\) (the minimum). At this point the control range will be 41-47°F.

4.3 HEAT EXCHANGER

The heat exchanger is designed to transfer heat from a Freon-21 heat transport loop to the evaporator section of the VCHP header. It is 24 in. long with an o.d. = 1.25 in. and i.d. = 1.00 in. The core of the exchanger is made of 48 circumferential aluminum strip fins that are brazed to the o.d. of the VCHP header. Brazing was required to provide good thermal contact which increased the available heat exchanger effectiveness. The actual exchanger core is shown in Figure 4-10 and a detailed assembly drawing is given in Figure 4-11.

The required number of fins was dictated by the available core material (15 fins/in.) and the pipe i.d.

\[
N_{\text{fins}} = \frac{\text{Fins}}{\text{in.}} \times \pi D_i
\]

\[
N = 15 \times \pi \times 1.0 = 48
\]

From the fin dimensions, the free flow area was calculated to be \(A_c = 0.24\) in.\(^2\) = 0.00167 ft\(^2\). The hydraulic diameter \(D_h\) was determined from:

\[
D_h = \frac{4 \times \text{Flow Area}}{\text{Wetted Perimeter}} = 0.0734 \text{ in.} = 0.0061 \text{ ft}
\]

The Reynolds number was found from:

\[
Re = \frac{D_h G}{\mu}
\]

where \(G = \frac{m}{A_c}\)

\(\mu = \text{freon viscosity}\)
Figure 4-10 Heat Exchanger Core
ALL ALLOY WELDING SHALL BE IN ACCORDANCE WITH MIL-W-8604 USING FILLER WIRE ALLOYS 5183, 5356, OR 5556.

ANODIZING & ENAMELING MAY BE USED IN SHELL OR OUTSIDE TUBE AND SLUGS.

INSTALL ALL 30° TAPERED INSERTS INTO 3 SHELL 30° TAPERED INSERT HOLES KNOCK HOLES CLEAR OF INSERTS, INSERT HOLES ENGRAVED BEYOND INSERTS.

NOTE 1 (TYPICAL): ALL HOLES 30° TAPERED INSERT HOLES PLUS 0.005" CLEARANCE.

Figure 4-11 Heat Exchanger Assembly
At a flow rate \( m = 1850 \text{ lb/hr} \), the Reynolds number was calculated to be 8900.

From a similar fin, (Ref. 14) the "Colburn" \( J \)-factor was estimated to be 0.0063.

The \( J \)" factor is defined as:
\[
J = \left( \frac{h_f}{G C_p} \right) (N_{pr})^{2/3}
\]  
(4-1)

where \( h_f \) = fluid conductance  
\( C_p \) = fluid specific heat = 0.25  
\( N_{pr} \) = Prandtl number = 3.46

Using equation (4-1), the fluid conductance \( h_f \) is calculated to be:
\[
h_f = \frac{767 \text{ Btu}}{\text{hr-ft}^2 \text{F}} = 5.33 \frac{\text{Btu}}{\text{hr-in.}^0 \text{F}}
\]

However, where an extended surface is used, temperature gradients along the fins extending into the fluid reduce the temperature effectiveness of the surface. To account for this, a surface effectiveness \( \eta_o \) is determined from:
\[
\eta_o = 1 - \frac{A_f}{A_t} (1 - \eta_f) = 0.685
\]

where \( \frac{A_f}{A_t} \) = ratio of total fin area to total heat transfer area = 0.870  
\( \eta_f \) = fin effectiveness = 0.638

The heat transfer or conductance from the freon to the header wall can now be determined from:
\[
U_1 A_T = \eta_o A_T h_f = 1150 \frac{\text{Btu}}{\text{hr-}^0 \text{F}}
\]

where \( A_T \), the total heat transfer area is 2.18 ft\(^2\)

The effectiveness of the system can be determined from
\[
\eta = 1 - e^{-NTU}
\]

where \( NTU \) is the number of heat transfer units of the heat exchanger = \( \frac{(UA)_X}{mc_p} \)

\[
(UA)_X = \frac{1}{U_1 A_T} + \frac{1}{U_2 A_H}
\]
\[ U_A = \text{header conductance} = \frac{\pi D L_{ev} h_{ev}}{144} = 1230 \frac{\text{Btu}}{\text{hr}^\circ F} \]

Therefore \((UA)_x = 588 \frac{\text{Btu}}{\text{hr}^\circ F}\) and \(NTU = 1.27\)

and \(\eta_x = 1 - e^{-1.27} = .72\) at a flow rate of 1850 lb/hr.

\(\eta_x\) as a function of flow rate is shown in Figure 4-12.

The temperature drops through the heat exchange system can be related to \(\eta_x\) by:

\[ \eta_x = \frac{T_{in} - T_{out}}{T_{in} - T_v} \] (4-2)

where \(T_{in}\) = freon inlet temperature
\(T_{out}\) = freon outlet temperature
\(T_v\) = header vapor temperature

Equation (4-2) can be rearranged as:

\[ \eta_x (T_{in} - T_v) = (T_{in} - T_{out}) = \frac{Q}{mC_p} \]

Both \((T_{in} - T_v)\) and \((T_{in} - T_{out})\) are plotted as a function of \(Q\) in Figure 4-13.

The pressure drop through the heat exchanger was estimated from

\[ \Delta P = \frac{G^2}{2 g_c \rho} \left( f A_t \right) \frac{1}{A_c} \]

Where: \(g_c\) = gravitational constant
\(\rho\) = liquid density
\(f\) = friction factor

The entrance and exit loss coefficients have been neglected since they are small compared to the friction loss. At the design flow rate of 1850 lb/hr, the pressure drop is approximately one-half psi. The details of the final heat exchanger design are presented in Table 4-2.
- FREON -21
- $C_p = 0.25$
- $\eta_x = 1 - e$
- $\eta_x = \frac{T_{IN} - T_{OUT}}{T_{IN} - T_{VAP}}$

Figure 4-12 Heat Exchanger Effectiveness
TOUT = 1850 LB/HR

HEAT EXCH

HEADER

EVAP

TVAPOR

DATA FROM SELECTED SYSTEM TEST POINTS

\[ Q, \text{ BTU/HR} \]

\[ \Delta T, \text{ OF} \]

\[ (T_{\text{IN}} - T_{\text{VAPOR}}) \]

\[ (T_{\text{IN}} - T_{\text{OUT}}) \]

\[ \bullet M = 1850 \text{ LB/HR} \]

\[ \bullet \eta_X = 0.72 \]

Figure 4-13  \( \Delta T \) vs. \( Q \) Heat Pipe Radiator Heat Exchanger
Table 4-2  Heat Exchanger Details

<table>
<thead>
<tr>
<th>Description</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Length (fins)</td>
<td>24 in.</td>
</tr>
<tr>
<td>I.D.</td>
<td>1.00 in.</td>
</tr>
<tr>
<td>O.D.</td>
<td>1.250 in.</td>
</tr>
<tr>
<td>Number of Fins, N</td>
<td>48</td>
</tr>
<tr>
<td>Fin Thickness, t</td>
<td>0.006 in.</td>
</tr>
<tr>
<td>Fin Height, w</td>
<td>0.10 in.</td>
</tr>
<tr>
<td>Fin Material</td>
<td>3003 Aluminum</td>
</tr>
<tr>
<td>Fluid</td>
<td>Freon 21</td>
</tr>
<tr>
<td>Mass Flow Rate, m</td>
<td>1850 lb/hr</td>
</tr>
<tr>
<td>Max. Allowable Pressure</td>
<td>150 psi</td>
</tr>
</tbody>
</table>

4.4 PHOTOGRAPHS

This subsection contains photographs showing the major hardware components of the heat pipe radiator panel during various stages of fabrication.

Figure 4-14: VCHP Header Assembly

Figure 4-15: VCHP Header Components with Attached Feeder Heat Pipes

Figure 4-16: Radiator Panel Components Before Assembly

Figure 4-17: Assembled Heat Pipe Radiator
Figure 4-14  VCHP Header Assembly
Figure 4-15  VCHP Header With Feeder Pipes
Figure 4-16 Radiator Panel Components
Figure 4-17 Assembled Radiator Panel
Section 5

BENCH TEST DATA

This section contains the results of the thermal bench tests that were performed on the three major components of the heat pipe radiator prior to panel assembly. Data are presented for the feeder heat pipes, VCHP header and heat exchanger.

5.1 FEEDER HEAT PIPES

The feeder heat pipes were individually tested at a tilt of at least 0.5 in. and $75^\circ$F. However, one feeder pipe (S/N 06) was tested at tilts of .50 in., .75 in. and 1.0 in. and at temperatures ranging from 60 – $125^\circ$F. Power was applied to the pipes via electrical heaters wrapped circumferentially around the 8-in. evaporators. Each 8-ft long condenser was cooled by a variable temperature water bath. The pipes were instrumented with 13 copper-constantan thermocouples as indicated in Figure 5-1. After installation of the thermocouples, both the 8-in. evaporator and 4-in. adiabatic sections were insulated, with 1-in. thick Armaflex insulation.

During testing, it was noticed that the tunnel in the artery was fairly sensitive to the type of condenser cooling. Initially, a high velocity spray bath was used, but spray velocity variations over the 8-ft long condenser caused the tunnel to deprime, resulting in $Q_{\text{max}}$ values of about 150 watts of 0.5 in. tilt. A cooling trough was then substituted for the spray bath and pipes S/N 02, 03, 04 and 06 were retested. The data then obtained indicated that the tunnel was priming and capacities equal to or greater than 400 watts at 0.5 in. tilt were obtained. Capacities much greater than 400 watts could not be tested due to heater failures.

Figure 5-2 is a summary of the maximum capacities vs tilt for the six feeder heat pipes. Also shown is the predicted performance at $75^\circ$F. Figure 5-3 shows the average temperature drop of several of the pipes as a function of power input. The temperature drop, which is defined as the average evaporator temperature minus average condenser temperature, was approximately $4^\circ$F at 200 watts. However, it really should be considered to be smaller since the evaporator thermocouples were influenced by their close proximity to the electrical heater, which resulted in higher than actual readings.
Figure 5-1  Feeder Pipe Instrumentation
Figure 5-2  Feeder Heat Pipe Test Data, Maximum Loads vs Tilt (Temperature, 75 ± 5°F Unless Otherwise Noted)
Figure 5-3 Feeder Pipe Overall Temperature Differential

- TILT = 0.5 IN.
- EVAP = 8.0 IN.
- COND = 96.0 IN.
- PIPE SERIAL NO.
  & SYMBOLS
  06 = ○
  04 = △
  02 = ×
The three areas of performance that were evaluated during the bench test of the VCHP were: (1) single fluid maximum capacity; (2) VCHP maximum capacity, and (3) temperature control span. The header was instrumented with 33 copper constantan thermocouples as shown in Figure 5-4. The heat exchanger inlet and outlet temperatures were measured with immersion type thermocouples instrumented to give both absolute and differential millivolt readings. The latter was used to determine the heat input to the header by a \( WC_p \Delta T \) calculation.

The header was first tested as a single fluid (NH\(_3\)), fixed conductance heat pipe by omitting the inert gas (N\(_2\)) charge. Tests were conducted at 0.5 in. adverse tilt and at vapor temperatures of 75 and 115\(^\circ\)F. After completion of these tests, the header was tested as a VCHP with two different amounts of N\(_2\) control gas, 0.00557 and 0.01498 lb; the latter is the design operational charge. The smaller charge was used for initial checkouts which were done at reservoir temperatures of 55\(^\circ\)F and above.

The single fluid performance test results are plotted in Figure 4-7. The burnout point for a heat pipe being loaded by a fluid heat exchanger is determined by plotting the temperature difference between the fluid outlet and the heat pipe vapor as a function of load, \( Q \). An abrupt increase in the slope of the \( \Delta T \) vs \( Q \) curve indicates the end of effective heat pipe action and marks the burnout point. As indicated, the experimental \( Q_{\text{max}} \) (burnout) points follow the theoretical artery annulus performance line. These results indicate that the tunnel portion of the artery did not hold prime during the single fluid bench test series. Several factors may be responsible for this condition. They are: (1) a strong non-uniform coupling between the heat exchanger and the evaporator section of the heat pipe; (2) a screen discrepancy in the internal capillary structure of the pipe, or (3) a small quantity of residual inert gas in the artery. As mentioned earlier the required header pipe capacity was designed into the artery annulus, therefore, the tunnel prime condition did not impact the program goals.

The header pipe was tested in the VCHP mode with a partial N\(_2\) charge of 0.00557 lb and with the design N\(_2\) charge of 0.01498 lb. The expected degradation in \( Q_{\text{max}} \) when the control gas was present in the pipe was the same for both the partial and design N\(_2\) quantities. Typical performance of the header with control gas is shown in Table 5-1. Some of the data shown are those obtained after thorough mixing of the N\(_2\) and NH\(_3\) (or after several dryouts following gas injection). \( Q_{\text{max}} \)
NOTES
1.) T/C'S ARE CU/CON
2.) T/C 1 & 2 ARE IMMERSION TYPE THERMOCOUPLES
3.) T/C 8' RESERVED FOR CONDENSER SPRAY
4.) T/C 23 & 24 ARE PIPE TEMP CONTROL POINTS
5.) T/C 9' RESERVED FOR RESERVOIR SPRAY

Figure 5-4 VCHP Header Instrumentation
Table 5-1 - VCHP $Q_{\text{max}}$ Test Data, Reservoir Temperature = 57°F

<table>
<thead>
<tr>
<th>$Q_{\text{max}}$, W</th>
<th>$L_c$ = Open Cond. Length, in.</th>
<th>$L'$ = Effective Length, in.</th>
<th>$Q_{\text{max}} \times L'$ (W-in.)</th>
<th>Comments</th>
</tr>
</thead>
<tbody>
<tr>
<td>896</td>
<td>27</td>
<td>34</td>
<td>30,464</td>
<td>Right after gas injection</td>
</tr>
<tr>
<td>314</td>
<td>24</td>
<td>32</td>
<td>10,048</td>
<td></td>
</tr>
<tr>
<td>350</td>
<td>44</td>
<td>42</td>
<td>14,700</td>
<td></td>
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<td>640</td>
<td>48</td>
<td>44</td>
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<td>400</td>
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<td>37</td>
<td>14,800</td>
<td></td>
</tr>
<tr>
<td>830</td>
<td>21</td>
<td>31</td>
<td>25,730</td>
<td>Right after gas injection</td>
</tr>
<tr>
<td>916</td>
<td>38</td>
<td>39</td>
<td>35,274</td>
<td>Four days after gas injection</td>
</tr>
<tr>
<td>516</td>
<td>36</td>
<td>38</td>
<td>19,610</td>
<td></td>
</tr>
<tr>
<td>480</td>
<td>33</td>
<td>37</td>
<td>17,760</td>
<td></td>
</tr>
</tbody>
</table>

Values close to single fluid performance were consistently obtained on the first run-up of the pipe following gas injection. The data presented in the table tend to be minimum values for VCHP operation. The time to complete an average $Q_{\text{max}}$ run was about 30 minutes. When this time was increased, thus providing for more thorough dissolution of $N_2$ from the vapor/gas bubble region within the artery, higher $Q_{\text{max}}$ values could be realized, as evidenced by the 916 watt point obtained after a total test time of approximately one hour.

Temperature control span studies were conducted with both partial and design $N_2$ charges in the pipe. Figure 5-5 gives both test data and predictions for the gas interface location as a function of vapor temperature.

Two main features of the experimental curve for the partial charge should be noted. First, the actual temperature control span is greater than predicted. The explanation of the increase in temperature control span involves again the vapor/gas bubble in the artery. It is postulated that when the interface advances in the condenser, as a result of an evaporator load increase, or more precisely an increase in pipe
Figure 5-5 VCHP Test Data, Partial and Design Gas Charge
temperature, the vapor/gas bubble grows in length to the new interface location while
the fluid expelled from the artery collects in the reservoir. This fluid collection re-
duces the reservoir volume and in turn increases the theoretical condenser opening
temperature and the temperature control span.

The second observation in the experimental control span curve is the sudden
break in the curve at 75°F. The break indicates the start of dryout in the evaporator
and full artery depriming. Complete dryout of the evaporator was seldom noticed.
After what seemed to be a start of dryout, the heat exchanger inlet to outlet tempera-
ture difference would decrease and the temperature difference between the heat ex-
changer outlet temperature and header vapor temperature would increase. For a
given load, these ΔT's would eventually stabilize. However, control of the pipe was
lost. Increasing the inlet temperature caused the outlet temperature to increase,
while still maintaining a constant load of several hundred watts.

Figure 5-6 details the interface progression with increasing heat load for the
design charge case. The corresponding vapor temperature is also plotted on the
ordinate. Notice that the heat pipe action began at a vapor temperature of close to
97°F which was identical with the predicted value. This is indicated by the fact that
the condenser temperature is within 2°F of the vapor temperature at this point. At
lower vapor temperatures the difference between them is much greater, which means
no heat piping.

5.3 HEAT EXCHANGER

At a Freon 21 design flow rate of 1850 lbs/hr, the estimated heat exchanger
effectiveness is 72% and the calculated pressure drop is 0.5 psi. Figure 5-7 presents
some typical test data obtained for the heat exchanger using Freon 113 instead of
Freon 21 which was not available. To maintain the 72% effectiveness and compensate
for the difference in fluid properties, a Freon 113 flow rate of 3300 lb/hr (WCp = 206
w/°F) was used.

The temperature differences between the Freon inlet and header vapor and the
Freon inlet and outlet are plotted as a function of load. Also shown is the predicted
inlet to vapor differential.

5.4 PANEL ASSEMBLY

After the panel was assembled and the feeder heat pipes pinched-off, a rudili-
mentary thermal test was conducted in a 85°F room temperature environment. The
objective of this basic performance test was to establish that all heat pipe components
DESIGN GAS CHARGE = 0.0150 LB N₂

Tₚₑᵣₛ = 55°F

Figure 5-6 VCHP Header Bench Test Data
were operating prior to shipping the panel to NASA/JSC. A fan was used to blow air across the panel to help dissipate the heat load. Also, in order to obtain movement of the gas interface at room temperatures, the reservoir of the VCHP was cooled to 60°F.

Figure 5-8 shows the temperature distribution along the VCHP header and temperatures at the adiabatic section and mid-condenser fin root point of the six feeder pipes. The gas interface within the VCHP can be seen to move toward the reservoir end of the condenser as the heat load increases, as expected.

Figure 5-7 Heat Pipe Radiator Heat Exchanger Data

\[ \Delta T, ^\circ F = Q, WC_P (T_{IN} - T_{OUT}), WATTS \]
Figure 5-8 Ambient Functional Test, Heat Pipe Radiator
This section presents the results of the thermal vacuum test that was performed in Chamber A of the NASA/JSC-SESL facility. The primary test objective was to determine the feasibility of using a VCHP radiator, in conjunction with a fluid heat source, to reject waste heat to a space environment. The test was designed to evaluate the performance of the VCHP header and the heat pipe radiating fin when both components are integrated into one radiator panel.

6.1 DISCUSSION

The heat pipe radiator was installed in the test chamber on five insulated bars that supported the periphery and the center of the panel approximately 5 ft above the chamber floor. It was positioned so that the VCHP header was level, while the feeder pipe evaporators were 1/2 in. above the end of their condensers. A 12 ft by 12 ft environment simulator panel, painted black, was mounted about 6 to 10 in. below the radiating surface of the heat pipe panel. The surface temperature of the simulator was controlled by attached cooling coils using either liquid nitrogen or Freon 12, depending on the desired thermal environment. As an economy measure, the simulator panel was used to provide the environment instead of the chamber cold walls, resulting in greatly reduced liquid nitrogen requirements.

The backside of the heat pipe radiating fin and the entire VCHP header, except for the front of the reservoir, were insulated with 25 layers of aluminized mylar superinsulation. Another 25-layer insulation blanket enclosed both the simulator panel and the radiator in a cocoon.

The radiator was instrumented with 87 copper/constantan thermocouples and 8 thermistors, the latter providing specific $\Delta T$ measurements during testing. Copper/constantan immersion thermocouples were used to measure the inlet and outlet temperatures of the VCHP heat exchanger. An instrumentation drawing for the radiator is given in Figure 6-1 and a description of the thermocouple locations is contained in Table 6-1.

The basic test plan called for measuring VCHP header and heat pipe panel temperatures for various combinations of environment, heat exchanger flow rate and
TYPICAL THERMOCOUPLE GENERALLY LOCATED ON SURFACE OPPOSITE TO AD111-I09-15PAE (OR COLD SIDE) +---n---T---S---... .. o THE THERMOCOUPLE DISTRIBUTION -I-_____--__--__ 29 EF)--c ------- -C (REPNEADER'S TEMPERATURE CHANGE (TT-.) S-5CA LOW "K" SECTION (SEA SHEET) 18 RESERVOIR BODY 3 RESERVOIR FINS FEEDER PIPES EVAPORATOR (ZEA) IS CONDENSER 24 ADIABATIC (LIA) 6 3... RADIATOR PANEL DISTRIBUTED AS CV 19... RADIATOR PANEL SUPPORT ASSEMBLY VIEW LOOKING DOWN WITH SIMULATED SPACE (OR COLD SIDE) ON FAR SIDE OF RADIATOR

Figure 6-1 Panel Instrumentation
<table>
<thead>
<tr>
<th>TC No.</th>
<th>Code</th>
<th>Location</th>
<th>TC No.</th>
<th>Code</th>
<th>Location</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>EN01</td>
<td>Freon inlet tube strap-on</td>
<td>33</td>
<td>FA33</td>
<td>Feeder A, condenser</td>
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<td>1a</td>
<td>AJ0020</td>
<td>Freon inlet, immersion</td>
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<td>FA34</td>
<td>Feeder A, condenser</td>
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<td>2</td>
<td>EX02</td>
<td>Freon outlet tube strap-on</td>
<td>35</td>
<td>FB35</td>
<td>Feeder B, evaporator</td>
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<tr>
<td>2a</td>
<td>AJ0024</td>
<td>Freon outlet, immersion</td>
<td>36</td>
<td>FB38</td>
<td>Feeder B, evaporator</td>
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<tr>
<td>3</td>
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<td>Low conduction section</td>
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<td>FB37</td>
<td>Feeder B, adiabatic section</td>
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<td>HC05</td>
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<td>40</td>
<td>FB40</td>
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<td>FC41</td>
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<td>FC46</td>
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<td>Header condenser</td>
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<td>FD47</td>
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<td>HC14</td>
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<td>48</td>
<td>FD48</td>
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<td>49</td>
<td>FD49</td>
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<tr>
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<td>HC16</td>
<td>Header condenser</td>
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<td>FD50</td>
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<td>HC17</td>
<td>Header condenser</td>
<td>51</td>
<td>FD51</td>
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<td>HC18</td>
<td>Header condenser</td>
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<td>FE55</td>
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<td>FE57</td>
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<td>Feeder F, evaporator</td>
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<td>Location</td>
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<td>Code</td>
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<td>RR67</td>
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<td>73</td>
<td>PA73</td>
<td>Panel assembly</td>
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<td>Panel assembly</td>
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<td>PG78</td>
<td>Panel assembly</td>
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</tbody>
</table>
inlet temperature. Table 6-2 gives the nominal values for these test conditions. Major emphasis was given to evaluating performance at the panel design point of 60 Btu/hr-ft$^2$, $Q_a$, and 1850 lb/hr, flow rate. For this condition the inlet temperature was varied in 5° increments between 40°F and 140°F. In addition to the basic test envelope, the panel's response from a frozen condition was also investigated.

6.2 TEST RESULTS

It was evident early in the test program that the VCHP header would not function exactly as anticipated. The condenser section opened at the predicted inlet temperatures whenever the reservoir temperature was equal to, or colder than, the shutoff portion of the condenser. But, no matter what the environment and flow rate, the condenser could never be made to open completely -- even when inlet temperatures were increased well beyond the predicted full-open value. Many of the planned test points were sacrificed in an attempt to obtain a fully operative VCHP condenser and this resulted in obtaining a fewer number of valid steady state performance points than scheduled.

An example of this behavior is given in Figure 6-2 which shows the temperature distribution along the VCHP header for several values of inlet temperature for the design condition. At an inlet temperature of 74°F, the condenser should have been fully open but it is actually only about half open (24 in.). Increasing the inlet to 90°F opens it further, to about 32 in. But another increase to 95°F has no effect; the interface has stabilized at about 32 in. from the end of the evaporator. Figures 6-3 and 6-4 give the corresponding temperatures of the panel feeder heat pipes for the 74°F inlet and 95°F inlet cases, respectively. In general, the temperature difference between a feeder condenser root and the VCHP condenser wall is less than 20°F. Most of this drop occurs between the VCHP condenser and the feeder evaporator due to the much smaller heat transfer area that is available.

Failure of the VCHP header to completely open can be explained by two factors. First, since the tunnel never primed, there was excess fluid in the reservoir that resulted from the deprimed tunnel plus artery fluid that was displaced by gas/vapor bubbles trapped in the spiral. This has the effect of decreasing the reservoir gas volume, and the $V_R/V_C$ ratio, and results in a much wider control span. That is, a much greater increase in vapor temperature is needed for a fully open condenser. This same observation was previously noted in the discussion of the VCHP bench test data (see Section 5.2). The second contributing factor impeding the gas interface from moving through the last third of the condenser is a reservoir temperature that was
Figure 6-2  T/V Test Results VCHP Condenser Temperatures
Table 6-2 Heat Pipe Radiator Thermal Vacuum Test Conditions

<table>
<thead>
<tr>
<th>Test parameter</th>
<th>Nominal values</th>
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<tbody>
<tr>
<td>1. Environment, $Q_a$, Btu/hr-ft$^2$</td>
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</tr>
<tr>
<td>2. Freon-21 Flow Rate, lb/hr</td>
<td>265, 1060, 1850*</td>
</tr>
<tr>
<td>3. Inlet Temperature, $T_{in}$</td>
<td>40, 80, 120, 140</td>
</tr>
</tbody>
</table>

*DESIGN POINT. Inlet temperature varied in 50F increments between 400F and 1400F, for this point only.

Figure 6-3 T/V Test Results, $\Delta T$ Header to Feeder Heat Pipes
RUN: SEQ 17
193/00/49

- \( T_{IN} = 95^\circ F \)
- \( W = 1967 \text{ LB/HR} \)
- \( Q_s = 60 \text{ BTU/HR-FT}^2 \)

Figure 6-4 T/V Test Results, \( \Delta T \) Header to Feeder Heat Pipes
warmer than the design value. The ideal reservoir radiation equilibrium temperatures that correspond to the test environments are given below.

<table>
<thead>
<tr>
<th>( Q_a, \text{ Btu/hr-ft}^2 )</th>
<th>( T_{Res}, ^\circ F )</th>
</tr>
</thead>
<tbody>
<tr>
<td>25</td>
<td>-103</td>
</tr>
<tr>
<td>60</td>
<td>-16</td>
</tr>
<tr>
<td>100</td>
<td>45</td>
</tr>
<tr>
<td>140</td>
<td>89</td>
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</tbody>
</table>

For an inlet temperature of 74\(^\circ\)F and a 60 Btu/hr-ft\(^2\) environment, an increase in reservoir temperature of only 6\(^\circ\)F from the ideal results in a theoretical change in blocked length of 7.2 in. This highly sensitive behavior is due to the relatively narrow condenser vapor space of .09 in, which results from having an overly large spiral annulus.

The fact that the reservoir temperatures were, in general, running warmer than the design values was largely due to a conduction heat gain of several Btu/hr through the leads of a reservoir heater and also to 4-in.\(^2\) of unpainted (low emittance) reservoir area. The reservoir heater was used only during a room temperature bench check of the VCHP to determine if it was operational. It was never used during the actual system tests. The effect on reservoir temperature of even a small heat gain can be seen in Figure 6-5 which shows reservoir temperature as a function of environment and an additional heat gain. The point of intersection between the environment curve and the X-axis locates the ideal radiation equilibrium temperature of the reservoir. As seen, in a 60 Btu/hr-ft\(^2\) environment a gain of only 2 Btu/hr causes an increase in reservoir temperature of 12\(^\circ\)F, from -16\(^\circ\)F to -4\(^\circ\)F. The effect at the colder 25 Btu/hr-ft\(^2\) environment is even more pronounced with an increase of 21\(^\circ\)F.

Detailed data for the steady state test points are given in Appendix B. A temperature map of the panel and temperature profiles along the VCHP header and feeder pipe A are provided for each test condition. A summary of these steady state test points is given in Table 6-3 along with the corresponding net heat rejection of the panel. Two values for heat rejection are given; one based on the measured fluid heat loss (\(W_{cp} \Delta T\)) and the other based on the panel temperatures (\(\Sigma \sigma T^4\)) and the environment. Ideally, in a system without losses, both values should be the same, but as seen from the table this is not the case.
Figure 6-5 Reservoir Temperature vs Heat Gain
Table 6-3 Summary of Results

<table>
<thead>
<tr>
<th>Figure No.</th>
<th>Run No.</th>
<th>$Q_a$, Btu/HR-ft</th>
<th>Flow Rate, Lb/HR</th>
<th>$T_{in}$, $\sigma_F$</th>
<th>$T_{out}$, $\sigma_F$</th>
<th>$Q_{REJ'}$ (Btu/HR)</th>
</tr>
</thead>
<tbody>
<tr>
<td>B-1a,b,c</td>
<td>193/08/30</td>
<td>56</td>
<td>1850</td>
<td>71</td>
<td>67.9</td>
<td>1435</td>
</tr>
<tr>
<td>B-2a,b,c</td>
<td>193/01/10</td>
<td>60</td>
<td>1990</td>
<td>96</td>
<td>92</td>
<td>1990</td>
</tr>
<tr>
<td>B-3a,b,c</td>
<td>192/10/50</td>
<td>55</td>
<td>1064</td>
<td>71</td>
<td>67.9</td>
<td>855</td>
</tr>
<tr>
<td>B-4a,b,c</td>
<td>192/15/30</td>
<td>58</td>
<td>276</td>
<td>106.5</td>
<td>88</td>
<td>1240</td>
</tr>
<tr>
<td>B-5a,b,c</td>
<td>191/21/40</td>
<td>41</td>
<td>276</td>
<td>71</td>
<td>57.4</td>
<td>938</td>
</tr>
<tr>
<td>B-6a,b,c</td>
<td>191/18/05</td>
<td>23</td>
<td>284</td>
<td>88.3</td>
<td>70.1</td>
<td>1300</td>
</tr>
<tr>
<td>B-7</td>
<td>191/18/45</td>
<td>23</td>
<td>276</td>
<td>94</td>
<td>75</td>
<td>1310</td>
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<tr>
<td>B-8a,b,c</td>
<td>193/10/25</td>
<td>93</td>
<td>1976</td>
<td>93</td>
<td>90</td>
<td>1482</td>
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<tr>
<td>B-9a,b,c</td>
<td>193/14/50</td>
<td>137</td>
<td>1985</td>
<td>129.6</td>
<td>127.7</td>
<td>943</td>
</tr>
</tbody>
</table>

(1) Figures are in Appendix B. (a)= radiator panel temperature map  
(b)= VCHP temperature distribution  
(c)= temperature distribution along feeder pipe A  

(2) $\Sigma T^4$ values courtesy of Dr. J. Sellers, Jr., Tuskegee, Univ.
Agreement is fairly good (within 8%) at the low flow rate (276 lb/hr) but very poor at the high flow rate (≈1850 lb/hr). There is evidence of a definite heat leak through the insulation blanket at the start of the condenser of feeder pipe A. This can be seen by looking at any of the plots of the temperature distribution and observing that the temperature for thermocouple no. 26 is far below the rest of the condenser readings. The environment is having a stronger influence on it than the others. For example, consider run 193/08/30 (Figures B-1a,c). Agreement between T/C 26 and the others becomes better when the environment is higher and the effective sink temperature is closer to the panel temperature, as seen in Run 193/14/50 (Figures B-9a,c). The possibility of a faulty thermocouple at no. 26 is disallowed since it gave the same reading as the others when the panel was in a no-load, frozen condition.

However, if the disagreement in the net heat rejection calculations was entirely due to a heat leak then the error should be completely dependent on the panel temperature and the environment. Yet for two cases with similar conditions, but different flow rates, this does not appear to be true. Consider Figures B-1a,c with the higher 1850 lb/hr flow and Figures B-4a,c with the lower 276 lb/hr flow. Agreement in the former case is poor but in the latter case it is good. This evidence would seem to minimize the influence of the heat leak.

The only other plausible explanation for the difference in heat rejection rates is an error in the immersion thermocouple readings, estimated at +1/2°F for each thermocouple. This would have a much more pronounced affect at the higher flow rates since the difference between inlet and outlet temperatures is much smaller than at the lower flow rate. The fact that these readings were absolute measurements doesn't help either. A more accurate determination of ΔT would have been possible with a differential millivolt measurement between the inlet and outlet.

The steady state performance of the radiator, as measured by its heat rejection capability, is compared to predictions in Figure 6-6. The indicated test points correspond to the net heat rejection as determined by the actual panel temperatures. These data were previously given in Table 6-3. The agreement between test and prediction is fairly decent for the 1850 lb/hr flow rate—especially at inlet temperatures that are within, or close to, the design temperature control range. When the inlet temperature exceeds the higher bound of that range, as for the 96°F inlet point at \( Q_a = 60 \text{ Btu/hr-ft}^2 \), the test value, falls far short of the prediction. This is due to the fact that the VCHP header is not fully opened and thus all of the available panel surface area is not being used. The agreement for the lower flow rate is good only
TEST POINTS (SEE TABLE 6-3)

<table>
<thead>
<tr>
<th>$Q_a$, BTU/HR·FT$^2$</th>
<th>25</th>
<th>60</th>
<th>100</th>
<th>140</th>
</tr>
</thead>
<tbody>
<tr>
<td>$W = 1850$ LB/HR</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>$W = 300$ LB/HR</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

[$Q_a = 140$ BTU/HR·FT$^2$]

Figure 6-6 Heat Pipe Radiator Performance
for the 60 Btu/hr-ft\(^2\) environment, also because the inlet temperature is close to the
design control range. At the lower 25 Btu/hr-ft\(^2\) environment the agreement is
especially poor because the inlet is so far removed from the 40 - 60\(^\circ\)F control range.
Once again the panel is throttled by the inability of the VCHP to fully open.

As a general observation, complete dryout of the VCHP header was seldom
witnessed during the performance testing. This would have been indicated by the
outlet temperature converging toward the inlet temperature. What was noticed were
partial evaporator dryouts, as indicated by an increasing outlet to vapor temperature
difference. After the partial dryout began, the vapor temperature would remain
fairly constant with a corresponding constant heat rejection rate.

The liquid to heat pipe heat exchanger worked as predicted and duplicated the
performance of the previous bench tests. An effectiveness of 72\%, at a flow rate of
1850 lb/hr, was verified from the measured fluid and vapor temperature differences.
Selected test points are plotted in Figure 4-13. However, the pressure drop across
the heat exchanger was higher than expected. At 1850 lb/hr flow the \(\Delta P\) was about
3.5 psi compared to the estimated value of 0.5 to 1.0 psi.

After the radiator performance tests were run, a freezing test was performed
by reducing the simulated environment to 1 Btu/hr-ft\(^2\) and stopping the Freon flow.
After several hours, the feeder pipes were at -259\(^\circ\)F (NH\(_3\) freezes at -108\(^\circ\)F) and
the header condenser reached temperatures below -110\(^\circ\)F. The thermal inertia of
the Freon in the heat exchanger kept the evaporator section of the header from going
below -90\(^\circ\)F. A start-up from this frozen condition was attempted by slowly in-
creasing the flow rate to 265 lb/hr with an inlet temperature of 25\(^\circ\)F.

Movement of the inert gas interface within the VCHP was noticed very quickly. As seen in Figure 6-7, the interface was completely out of the first low "K" section
in about 22 minutes from the start of the sequence. The VCHP was completely
thawed in about 70 minutes at a vapor temperature of 65\(^\circ\)F and an inlet temperature
of 78\(^\circ\)F.

However, during this time period the feeder pipes never thawed. Because of
a restricted test schedule, and considering the cold 1 Btu/hr-ft\(^2\) environment, there
was not enough time available to wait for thawing to occur. Therefore, a test devia-
tion was initiated to increase the environment to 25 Btu/hr ft\(^2\). However, the tech-
nique used in changing the environment, involved draining the LN\(_2\) from the simulator plate

6-14
Figure 6-7  Heat Pipe Radiator Thaw Test, VCHP Header Response
and replacing it with Freon 12. In the process of clearing the LN2 the simulator increased to a temperature equivalent to \( Q_a = 50 \text{ Btu/hr-ft}^2 \). At this level, the feeder pipes thawed. Once thawed, however, the feeder pipes did not initially operate since the load imposed on them was probably beyond their reprime limit. In order to prime the feeder pipes after they thawed the flow to the heat exchanger was stopped for 10 - 15 minutes, thereby removing most of the heat load. They then primed and functioned normally, as demonstrated by a repetition of the data point previously cited in Figure B-2.

6.3 CONCLUSIONS

The significant conclusions that can be drawn from this program are:

- Heat pipe radiators are feasible for waste heat rejection to space. Heat pipes are extremely effective in uniformly distributing energy and maintaining an isothermal surface.

- VCHP control of the panel is also feasible. The panel came "on-line" at the predicted inlet temperatures and partial VCHP control was demonstrated.

- The net heat rejection capability of the panel was limited to about 400 watts because only about half of its available area could be activated. This was a problem of the VCHP header and not the radiating fin. Full panel capacity was not achieved due to the restricted VCHP control span.

- Close control over reservoir temperature is particularly important for predictable VCHP operation and more careful attention must be paid to eliminating unaccounted for heat leaks. Also, the header design, with its narrow vapor space, was too sensitive to slight variations in reservoir behavior. It must be made less sensitive for more reliable VCHP operation.

- Heat pipes can be reliably coupled to fluid loops, with predictable performance, using integral heat exchanger units.

- The panel cannot be thawed within a reasonable time period in a deep space environment. If this is a definite mission requirement the use of low freezing point feeder pipes in conjunction with the higher capacity ammonia pipes would be necessary.

- Successful heat pipe operation was demonstrated after the panel had been completely frozen for an extended period and then thawed. The freeze/thaw cycle had no lingering adverse effects on the performance of the ammonia heat pipes.
The feasibility of using variable conductance heat pipe radiators for waste heat rejection has been established. But this was only a first step toward their eventual implementation as flight hardware. Before that goal can be attained there are several intermediate steps that are necessary.

- The problem experienced with the restricted operating span of the VCHP header must be solved and a higher, 1000-2000 watt, VCHP capacity must be demonstrated. If the solution is not quickly in hand, an alternative control concept must be identified and the hardware built and tested.

- The VCHP radiator panel must be weight optimized and realistic flight weight designs must be tested.

- Mission requirements must be more clearly defined before realistic solutions to the freeze/thaw problem can be formulated.

- Finally, several VCHP radiator panels must be assembled and tested as a waste heat rejection system to verify overall system performance.
REFERENCES


REFERENCES (Cont.)


Appendix A Radiator Sizing Program

// JOB T
// SUB

"(IN) INTEGER
10C
REAL LEVP, NFEED, LFEED, LCOND
NR=3
 MK=2
 NT=1
 NR=6

C INPUT
218 READ (MR,100) MPN
 READ (MR,101) TIN, W, ETA, QABS1, EPS, AREA, ODIAM
 READ (MR,101) UDEEP, NFEED, LFEED, HEVAP, HCOND, LEVP, LCOND, D3
100 FORMAT (I3)
101 FORMAT (8F10.4)
216 SUMQ=0.0
 TP=100.

C DEFINE CALCULATED VARIABLES
FINS=11.1*3.1416*(ODIAM+.25)
NFINS=FIX(FINS+.5)
FINS=NFINS
FLOWA=3.1416*((ODIAM+.5)**2-ODIAM**2)-FINS**.006**.25
WPER=3.1416*(ODIAM+.5+ODIAM)+2.*FINS**.25
DHYO=4.*FLOMA/WPER
G=W/FLOMA
RE=DHYO**12./.760
QAS=QABS1*AREA/ETA
AREA2=LEVP+D3*3.1416/(2.*144.)
AREA3=NFEED*DFEED**3.1416*LFEED/144.

C CALCULATE 'COLBURN J-FACTOR' FROM KAYS + LONDON CURVE
IF (RE=1000.) 5,5,10
5 COLBJ=.00514(RE/1000.)**(-.743)
 GO TO 25
10 IF (RE=10000.) 11,11,12
11 IRE=1.*FIX(RE/1000.)
 GO TO 13
12 IRE=10
13 GO TO (15, 16, 17, 18, 19, 20, 21, 22, 23, 24), IRE
15 COLBJ=1.4*3**(RE/1000.)**2-.0051*RE/1000.*.0089
 GO TO 25
16 COLBJ=.0061+.0002*(RE-3000.)/1000.
6U TO 25
17 COLBJ=.0039+.0002*(RE-4000.)/1000.
6U TO 25
18 COLBJ=.0037+.0002*(RE-5000.)/1000.
6U TO 25
19 COLBJ=.0035+.0002*(RE-6000.)/1000.
6U TO 25
20 COLBJ=.0034+.0001*(RE-7000.)/1000.
6U TO 25
21 COLBJ=.0033+.0001*(RE-8000.)/1000.
6U TO 25
22 COLBJ=.0032+.0001*(RE-9000.)/1000.
6U TO 25
23 COLBJ=.0031+.0001*(RE-10000.)/1000.
6U TO 25
25 CONTINUE

HELP=COLBJ**.25/2.125
AREA=13.1416**((ODIAM+.25)**.25)*LEVP
ETA=140**.006/(SQRT(2.*HFLU/10.67**.006)**.25)**(2.*HFLU/10.67**.006)**.25
ETA=.00514(RE/1000.)**(-.743)
AREA=13.1416**((ODIAM+.25)**.25)**(1.-ETAF)
R1=1./(ETA*DAREA**H**2)
C OUTPUT OF INPUT, CALCULATED VARIABLES

WRITE (MW, 107) NPANEL, TIN
107 FORMAT (1H1, 2X, 'INPUT VARIABLES',//, 5X, 'NUMBER OF PANELS = ', I3, 2X,
1X, 'WITH FLUID INLET TEMP = ', F5.2, ' DEG F'.//)

WRITE (MW, 108)
108 FORMAT (7X, 'INPUT VARIABLES',//)

WRITE (MW, 109) W, ETA, QABS, EPS, AREA, UDIA
109 FORMAT (5X, 'INPUT VARIABLES',//)

WRITE (MW, 110) W, ETA, QABS, EPS, AREA, UDIA
110 FORMAT (5X, 'INPUT VARIABLES',//)

WRITE (MW, 111) W, ETA, QABS, EPS, AREA, UDIA
111 FORMAT (5X, 'INPUT VARIABLES',//)

WRITE (MW, 112)
112 FORMAT (2X, 'CALCULATED VARIABLES',//)

WRITE (MW, 113) COLBJ, HFLU, RE, QABS
113 FORMAT (2X, 'CALCULATED VARIABLES',//)

WRITE (MW, 114) AREAl, AREA2, AREA3, CON01, CON02
114 FORMAT (2X, 'CALCULATED VARIABLES',//)

WRITE (MW, 115) COLBJ, HFLU, RE, QABS
115 FORMAT (2X, 'CALCULATED VARIABLES',//)

C BEGIN EXECUTION OF CAPACITY CALCULATIONS

WCP=.25*W
EX=EXP(CON01/WCP)
Z=(ETA/WCP)*(EX/(1.-EX))-ETA/CON02
I=0
TPR=EPS*AREA*.1713E-8*TIN**4-QABS
F=TIN-TPR+460.
35 I=I+1
30 FP=1.4+Z4*EPS*AREA*.1713E-8*TIN**4-QABS
TPN=TP+FP
TPR=TPN+460.
RTPN=EPS*AREA*.1713E-8*TIN**4-QABS
F=TIN-TPN+460.
IF (ABS(F)=.001) 50, 50, 40
40 T=TPN
TPR=TP+460.
GO TO 30
50 QREJ=RTN-ETA
TVAP=TPN-QREJ/CON02
SUM=QREJ+SUMO
TOUT=TIN-(ETA/W)*TPN
QREJ=QREJ/3.413
WRITE (MW, 103) I, TOUT, TVAP, TPN, QREJ, SUMO, QREJW
103 FORMAT (5X, I, 13, 3(5X, F7.2), 3(F7.2))
TIN=TOUT
IF (I=NPANEL) 35, 60, 60
60 CONTINUE
WRITE (NT, 104)
104 FORMAT (5X, 'READY FOR PARAMETRIC CHANGES',//)
200 READ (NK, 105) NPAR
105 FORMAT (13)
GO TO (201,202,203,204,205,206,207,208,209,210,211,212,213,214,215
4,215,217,218,219), NPAR
201 READ (NR,105) NPAN
GO TO 200
202 READ (NR,106) TIN
106 FORMAT (F10.5)
GO TO 200
203 READ (NR,106) W
GO TO 200
204 READ (NR,106) ETA
GO TO 200
205 READ (NR,106) QABS1
GO TO 200
206 READ (NR,106) EPS
GO TO 200
207 READ (NR,106) AREA
GO TO 200
208 READ (NR,106) DFEED
GO TO 200
209 READ (NR,106) NFEED
GO TO 200
210 READ (NR,106) LFEED
GO TO 200
211 READ (NR,106) HEVAP
GO TO 200
212 READ (NR,106) HCOND
GO TO 200
213 READ (NR,106) LEVP
GO TO 200
214 READ (NR,106) LCOND
GO TO 200
215 READ (NR,106) D3
GO TO 200
219 READ (NR,106) ODIAM
GO TO 200
217 CONTINUE
CALL EXIT
END
// XEO
30
150. 2000. .9 45. .9 32. 1.125
0.5 6. 96. 2700. 3500. 24. 48. 1.//
<table>
<thead>
<tr>
<th>Code</th>
<th>Name</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>001</td>
<td>NPAN</td>
<td># of panels (I3)</td>
</tr>
<tr>
<td>002</td>
<td>TIN</td>
<td>fluid inlet temp, °F</td>
</tr>
<tr>
<td>003</td>
<td>W</td>
<td>mass flow rate, lb m/hr</td>
</tr>
<tr>
<td>004</td>
<td>ETA</td>
<td>radiator efficiency</td>
</tr>
<tr>
<td>005</td>
<td>QABSI</td>
<td>ambient absorbed heat, ( \text{btu} \frac{\text{hr}}{\text{ft}^2} )</td>
</tr>
<tr>
<td>006</td>
<td>EPS</td>
<td>( e \sim \text{emissivity} )</td>
</tr>
<tr>
<td>007</td>
<td>AREA</td>
<td>area of one panel, ft(^2)</td>
</tr>
<tr>
<td>008</td>
<td>DFEED</td>
<td>I.D. of feeder heat pipe</td>
</tr>
<tr>
<td>009</td>
<td>NFEED</td>
<td>number of feeder pipes per panel</td>
</tr>
<tr>
<td>010</td>
<td>LFEED</td>
<td>length of feeder condenser, in.</td>
</tr>
<tr>
<td>011</td>
<td>HEVAP</td>
<td>( h_{\text{evap}} ), ( \text{btu} \frac{\text{hr}}{\text{ft}^2 \circ F} )</td>
</tr>
<tr>
<td>012</td>
<td>HCOND</td>
<td>( h_{\text{condenser}} ), ( \text{btu} \frac{\text{hr}}{\text{ft}^2 \circ F} )</td>
</tr>
<tr>
<td>013</td>
<td>LEVP</td>
<td>evaporator length of header, in.</td>
</tr>
<tr>
<td>014</td>
<td>LCOND</td>
<td>condenser length of header, in.</td>
</tr>
<tr>
<td>015</td>
<td>D3</td>
<td>inside diam. of header, in.</td>
</tr>
<tr>
<td>016</td>
<td></td>
<td>execute with new parameters</td>
</tr>
<tr>
<td>017</td>
<td></td>
<td>end computer session ~ kill program</td>
</tr>
<tr>
<td>018</td>
<td></td>
<td>read new set of data cards, then execute</td>
</tr>
<tr>
<td>019</td>
<td>ODIAM</td>
<td>outside diameter of header evaporator, in</td>
</tr>
</tbody>
</table>

execute with new parameters

A-4
Appendix B

System Test Results

The data that are presented correspond to definite steady state conditions. The results for each test point are described by three data plots.

(a) Radiator panel temperature map
(b) Temperature distribution along VCHP header
(c) Temperature distribution along feeder pipe A

Appendix B Contents

<table>
<thead>
<tr>
<th>Figure No.</th>
<th>Run No.</th>
<th>$Q_{Absorbed}$ BTU/Hr Ft$^2$</th>
<th>Flow Rate lb/Hr</th>
<th>$T_{Inlet}$ °F</th>
</tr>
</thead>
<tbody>
<tr>
<td>B-1a,b,c</td>
<td>193/08/30</td>
<td>56</td>
<td>1850</td>
<td>71</td>
</tr>
<tr>
<td>B-2a,b,c</td>
<td>193/01/10</td>
<td>60</td>
<td>1990</td>
<td>96</td>
</tr>
<tr>
<td>B-3a,b,c</td>
<td>192/10/50</td>
<td>55</td>
<td>1064</td>
<td>71</td>
</tr>
<tr>
<td>B-4a,b,c</td>
<td>192/15/30</td>
<td>58</td>
<td>276</td>
<td>106.5</td>
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<td>B-5a,b,c</td>
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<td>41</td>
<td>276</td>
<td>71</td>
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<td>23</td>
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<td>B-7</td>
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<td>93</td>
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<tr>
<td>B-9a,b,c</td>
<td>193/14/50</td>
<td>137</td>
<td>1985</td>
<td>129.6</td>
</tr>
</tbody>
</table>
Figure B-1a
Run: 193/08/30
Tin = 71°F
W = 1850 #/hr
Qabs = 96 BTU/hr ft²
WGT = 1435 BTU/hr

Typical component generally located on surface opposite to pipe for cold side
Figure B-1b
VCHF CONDENSER TEMP
SEQ. NO. 17
TIME 193/8/30
Tin = 71.0 F
M = 1855 lb/hr
Qa = 56 BTU/hr ft²
* = Reservoir Temp

Distance along Condenser, in.
Figure B-1c

TEMP. DISTRIBUT. ALONG FEEDER A

SEQ. NO. 17

TIME 193/8/30

Tin = 71.0 F

M = 1855 lb/hr.

Qa = 56 Btu/hr Ft²

Reservoir Temp = -19 F

Distance along Feeder, in.
Figure B-2a
Run: 193/01/10
W = 1990 #/hr.
Qabs = 60 BTU/hr ft²
WQPAT = 1990 BTU/hr

GENETALLY LOCATED
AC
H
E
8
a
TEL
AS
PaeE
(OR COLD 510R)
Figure B-2b
VCHP CONDENSER TEMP
SEQ. NO 17
TIME 135/ 1/10
Tin = 96.0°F
M = 1990 lb/hr
Qa = 60BTU/hr Ft^2
* = Reservoir Temp

Distance along Condenser, in.
Figure B-2c
TEMP. DISTRIBUT. ALONG FEEDER A
SEQ. NO. 17
TIME 193/1/10
Tin = 96.0 F
M = 1950 lb/hr
Qa = 60BTU/hr/ft²
Reservoir Temp = -3.0 F
Figure B-3a
Run: 192/10/50
Tin = 71°F
W = 106#/hr
Qabs = 55 BTU/ft²
Wop×T = 895 BTU/hr

ENERGIZED C.

WP = 855 BTU/HR

OVERHEAD PANE ASSY

TYPICAL THERMOGRAPHY
GENERAL LOCATION ON SURFACE OPPOSITE TO SHADION (OLD SIDE)
Figure B-3b

VCHP CONDENSER TEMP

Tin = 71.00°F
M = 1064
Qa = 55 BTU/ft²*

Reservoir Temp

M = 1064

P = 80

Distance along Condenser, in.

0.0
10.0
20.0
30.0
40.0
50.0
60.0

* = Reservoir Temp

P = 80
Figure B-3c

TEMP. DISTRIBUTION ALONG FEEDER A

SEQ. NO. 15

TIME 192/10/50

Tin = 71.00 F

Qa = 55 BTU/HR FT²

Reservoir Temp = -15.50 F

Distance along Feeder, in.
Figure B-4a
Run: 192/15/30
Tin = 106.5 °F
W = 276 #/Br
Qabs = 58 BTU/Hr Ft²
WCpΔT = 1240 BTU/Hr
Figure B-4b
YCHF CONDENSER TEMP
SEQ. NO. 15
TIME 192/15/30
Tin = 106.0 F
M = 276 lb/hr
Qa = 58 BTU/hr Ft²
* = Reservoir Temp

Distance along Condenser, in.
Figure B-4c
TEMP. DISTRIB. ALONG FEEDER A
SER. NO. 15
TIME 192/15/30
Tin = 106.0 F
M = 276 lb/hr²
Qa = 58 Btu/Hr Ft
Reservoir Temp = -7.0 F

Distance along Feeder, in.
Figure B-5a
Run: 19L/21/40
Tin = 71°F
W = 276 #/hr
Qabs = 4.1 BTU/hr ft²
WCpT = 938 BTU/hr

GENERAL NOTE:
TYPICAL THERMOSHELF
IS USUALLY LOCATED ON
SURFACE OPPOSITE TO
SPACE ON COLD SIDE.

34
Figure B-5b
CHIP CONDENSER TEMP
SEQ. NO. 1
TIME 191/21/40
Tin = 71.00 F
M = 276 lb/hr.
Qa = 4 lb/hr F
* Res Temp

Distance along Condenser, in.
Figure B-5c

TEMP. DISTRIBUTION ALONG FEEDER A

SEQ. NO. 14
TIME 19/21/40
Tin = 71.00 F
M = 276 lb/hr.
Qa = 41 Btu/hr Ft²
Reservoir Temp = -67.97 F

Distance along Feeder, in.
Figure B-6a
Run: 191/18/05
Tin = 88.3
W = 284 #/hr
Qabs = 23 BTU/hr ft²
WCMT = 1300 BTU/hr

TYPICAL TRER
COELE
COCA Tom Oct
= 1300 BTU/hr.

SURFACE OPPOSITE TO BACK OR COLD SIDE

FRAME ASSEMBLY
Figure B-6b
VCMP CONDENSER TEMP
SER. NO. 7
TIME 191/18/5
Tin = 88.3 F
M = 284 lb/hr.
Qa = 23 BTU/hr ft²
* = Res Temp

Distance along Condenser, in.
Figure B-6c
TEMP. DISTRIB. ALONG FEEDER A
SEQ. NO. 7
TIME 1/18/5
Tin = 88.3°F
M = 284 lb/hr.
QA = 23 Btu/hr Ft
Reervoir Temp = 81.5°F

Distance along Feeder, ft.
Figure B-7
Run: 191/18/45
Tin = 94°F
W = 276 lb/hr
Qabs = 23 BTU/hr ft²
WCPAT = 1310 BTU/hr
Figure B-8a
Run: 193/10/25
Tin = 93°F
W = 1976 #/Hr
Qabs = 100 BTU/Er ft²
Wpat = 1482 BTU/Hr

General location on panel A151

Typical thermocouple generally located on surface opposite to space for cold box.
Figure B-8b
VCHP CONDENSER TEMP
SEQ. NO. 20
TIME 193/10/25
Tin = 93 F
M = 1976 lb/hr
Qa = 93 BTU/HR Ft^2
* = Res. Temp

Distance along Condenser, in.
Figure B-8c
TEMP. DISTRIB. ALONG FEEDER A
SEQ. NO. 20
TIME 193/10/25
Tin = 93 F
M = 1976 lb/hr
Qa = 93 BTU/ hr ft²
Reservoir Temp = 33 F

Distance along Feeder, in.
Figure B-9a

Run: 193/14/50

Tin = 129.6 °F

W = 1985 #/hr

Qabs = 137 BTU/hr ft²

Wchf,T = 93 BTU/hr

Typical Thermocouple generally located on surface opposite to area for cold side.
Figure B-9b
VCNP CONDENSER TEMP
SEQ. NO. 17
TIME 193/1/50 + 193/1/47 3
Tin = 193.6 F
M = 1985 lb/hr.
Qa = 137 BTU/Hr Ft²
* = Res. Temp.

Distance along Condenser, in.
Figure B-9c
TEMP. DISTRIB. ALONG FEEDER A
SEQ. NO. 17
TIME 193/14/50
Tin = 129.6 F
M = 1985 lb/hr.
Qa = 137 BTU/hr Ft
Reservoir Temp = 93 F

Distance along Feeder, in.