



National Aeronautics and
Space Administration

ENERGY EFFICIENT ENGINE
FLIGHT PROPULSION SYSTEM
AIRCRAFT/ENGINE INTEGRATION EVALUATION

LIBRARY COPY

JUL 10 1980

by

GENERAL ELECTRIC COMPANY

LANGLEY RESEARCH CENTER
LIBRARY, NASA
HAMPTON, VIRGINIA

Prepared For

National Aeronautics and Space Administration

(NASA-CR-159584) ENERGY EFFICIENT ENGINE
FLIGHT PROPULSION SYSTEM: AIRCRAFT/ENGINE
INTEGRATION EVALUATION Status Report, Jan.
1978 - Nov. 1978 (General Electric Co.)
328 p HC A15/MF A01

N81-22051

Unclass
12078

CSCL 21E G3/07

NASA-Lewis Research Center

Contract NAS3-20643

1. Report No. NASA CR-159584		2. Government Accession No.		3. Recipient's Catalog No.	
4. Title and Subtitle ENERGY EFFICIENT ENGINE FLIGHT PROPULSION SYSTEM - AIRCRAFT/ENGINE INTEGRATION EVALUATION				5. Report Date June 1980	
				6. Performing Organization Code	
7. Author(s) R.F. Patt				8. Performing Organization Report No. R79AEG274	
9. Performing Organization Name and Address General Electric Company Aircraft Engine Group Cincinnati, Ohio 45215				10. Work Unit No.	
				11. Contract or Grant No. NAS3-20643	
				13. Type of Report and Period Covered Topical Jan 1978 - Nov 1978	
12. Sponsoring Agency Name and Address NASA Lewis Research Center 21000 Brookpark Road Cleveland, Ohio 44135				14. Sponsoring Agency Code	
15. Supplementary Notes Project Manager - Neal T. Saunders, NASA					
16. Abstract Aircraft/engine integration studies were conducted with Boeing, Douglas, and Lockheed Aircraft Companies as subcontractors to General Electric's Energy Efficient Engine Program. Economic evaluations of the preliminary design indicated that all NASA goals will be met or exceeded. Installed sfc, DOC, noise and emissions were evaluated. Aircraft installation considerations and growth were reviewed. Supplemental reports by Boeing, Douglas, and Lockheed are included.					
17. Key Words (Suggested by Author(s)) Turbofan Engines Aircraft Installation Energy Efficiency			18. Distribution Statement Unclassified - Unlimited		
19. Security Classif. (of this report) Unclassified		20. Security Classif. (of this page) Unclassified		21. No. of Pages	22. Price*

* For sale by the National Technical Information Service, Springfield, Virginia 22161

FOREWARD

This report presents the results of aircraft integration analyses of an advanced Flight Propulsion System (FPS) conducted by the General Electric Company. This work was performed for the National Aeronautics and Space Administration (NASA), Lewis Research Center, under Contract NAS3-20643 as part of the Aircraft Energy Efficiency (ACEE) Program, Energy Efficient Engine (E³) Project. Mr. Neal T. Saunders is the NASA E³ Project Manager; Mr. Lawrence E. Macioce is serving as NASA Assistant Project Manager. Mr. Roger Chamberlin and Mr. Anthony C. Hoffman were the NASA Project Engineers responsible for the effort associated with Energy Efficient Engine Propulsion System-Aircraft Integration reported here. Mr. Martin C. Hemsworth is Manager of the E³ Project for the General Electric Company.

PRECEDING PAGE BLANK NOT FILMED

TABLE OF CONTENTS

<u>Section</u>		<u>Page</u>
1.0	SUMMARY	1
2.0	INTRODUCTION	3
3.0	DESCRIPTION OF THE E ³ FPS	5
	3.1 Design Features	5
	3.2 Design Requirements	11
4.0	CYCLE AND PERFORMANCE	12
	4.1 Derivation of FPS Cycle	12
	4.2 FPS Cycle Description	14
	4.3 FPS Performance Prediction Versus Baseline CF6-50C	15
	4.4 Improved Performance Retention	17
	4.5 Thrust Flexibility and Growth	17
5.0	PROPULSION SYSTEM AIRCRAFT INTEGRATION EVALUATIONS	22
	5.1 Economic Studies - Direct Operating Cost	23
	5.2 Economic Studies - Return on Investment	38
	5.3 Aircraft Company Comments on FPS Economics	47
6.0	NACELLE DESIGN	48
	6.1 Fan Reverser	50
	6.2 Engine Mount System	53
	6.3 Accessory Package	53
	6.4 Aircraft Company Comments	57
7.0	ENVIRONMENTAL CONSIDERATIONS	62
	7.1 Acoustics	62
	7.2 Exhaust Emissions	65
8.0	PROBABILITY OF MEETING PROGRAM GOALS	70
	8.1 Performance Goal	70
	8.2 Weight, Price, and Maintenance Projections	70
	8.3 DOC Goal	70
	8.4 Noise Goals	77
	8.5 Emissions Goals	77

PRECEDING PAGE BLANK NOT FILMED

TABLE OF CONTENTS (Concluded)

<u>Section</u>	<u>Page</u>
9.0 CONCLUSIONS	83
9.1 Installed SFC	83
9.2 Deterioration	83
9.3 Direct Operating Cost	83
9.4 Noise	83
9.5 Emissions	83
9.6 Commercial Engine Practices	84
REFERENCES	85
SYMBOLS AND ABBREVIATIONS	86
APPENDIX A - Aerodynamic Analysis of GE E ³ Model Scale Nacelle Simulator, Boeing	89
APPENDIX B - Energy Efficient Engine Component Development and Integration Study, Lockheed	167
APPENDIX C - Final Report on Study Transports Powered by GE Energy Efficient Engines, Douglas	227

LIST OF ILLUSTRATIONS

<u>Figure</u>		<u>Page</u>
1.	Installed E ³ FPS Features.	7
2.	Uninstalled FPS Features.	8
3.	Installed Engine Piping and Mount Details.	11
4.	E ³ Cycle Selection.	13
5.	Long Term Performance Retention. .	18
6.	Block Fuel Savings.	24
7.	Direct Operating Cost (DOC) Improvement.	31
8.	Fractional Fuel Cost.	32
9.	Fractional Depreciation Cost.	33
10.	Fractional Crew Cost.	34
11.	Fractional Airframe Maintenance Cost.	35
12.	Fractional Engine Maintenance Cost.	36
13.	Fractional Insurance Cost.	37
14.	Fuel Contribution.	40
15.	Depreciation Contribution.	41
16.	Engine Maintenance Contribution.	42
17.	Airframe Maintenance Contribution.	43
18.	Crew Cost Contribution.	44
19.	Insurance Cost Contribution.	45
20.	Nacelle General Arrangement.	49
21.	Thrust Reverser Actuation.	51
22.	Overall Engine Reverser Thrust Comparison.	52
23.	Engine Mount System.	54

LIST OF ILLUSTRATIONS (Concluded)

<u>Figure</u>		<u>Page</u>
24.	Mount Reaction Schematic.	55
25.	Preliminary E ³ Ovalization.	56
26.	Accessory Package.	60
27.	Accessory Package.	61
28.	Energy Efficient Engine - Low Noise Design Features.	63
29.	Noise Exposure Areas for Lockheed Trijet Near Chicago O'Hare Airport, 90 EPNdB.	66
30.	E ³ Double Annular Combustor Predicted Emission Characteristics.	68
31.	Probability of Achieving SFC Goals.	71
32.	Probability of Achieving FPS Weight Projection.	72
33.	Probability of Achieving FPS Price Projections.	73
34.	Probability of Achieving FPS Maintenance Cost Projections.	74
35.	Probability of Meeting Projected DOC.	75
36.	Probability of Meeting DOC Goal.	76
37.	Probability of Meeting CO Emissions Goal.	78
38.	Probability of Meeting HC Goal.	79
39.	Probability of Meeting NO _x Goal.	80
40.	Probability of Meeting Smoke Goal.	81

LIST OF TABLES

<u>Table</u>		<u>Page</u>
I.	E ³ Flight Propulsion System Status Engine and Nacelle Dimensions.	6
II.	Comparison of E ³ FPS Status to Reference CF6-50C.	10
III.	Nominal Customer Bleed and Power Extraction, 10,668 m/0.8 M/Standard Day (35,000 ft/0.8 M/Standard Day).	10
IV.	E ³ FPS Cycle Definition.	14
V.	FPS Cycle - Maximum Cruise Component Performance.	15
VI.	E ³ FPS/CF6-50C Reference Maximum Cruise SFC Comparison.	16
VII.	E ³ Growth Capability.	19
VIII.	Growth Component Changes.	20
IX.	Economic Benefits, Block Fuel.	23
X.	Airplane Pricing Functions.	26
XI.	Engine Weight Estimate by Module - KG (1b).	27
XII.	Estimated Engine Price - K\$ (1977 Dollars).	27
XIII.	Estimated Engine Maintenance Cost, 2-Hour Mission, No Derate.	28
XIV.	Major Engine Inputs to DOC Analysis.	29
XV.	Economic Benefits, Direct Operating Cost (NASA - Coordinated Rules).	30
XVI.	Distribution of DOC Elements, E ³ Engine with Credit for Improved Performance Retention.	30
XVII.	Contributors to DOC Improvement, E ³ with Credit for Improved Performance Retention Versus CF6-50C.	39
XVIII.	Improvement in Return on Investment for E ³ Versus CF6-50C Propulsion Technology (NASA-Coordinated Rules).	47
XIX.	Comparison of Accessory Location, Economic Summary.	58

LIST OF TABLES (Concluded)

<u>Table</u>		<u>Page</u>
XX.	Nonquantitative Factors in Accessory Package Selection.	59
XXI.	Flight Noise Estimates for E ³ Advanced Aircraft.	64
XXII.	E ³ Combustor - Emission Goals (EPA 1981 Standards) for Newly Certified Engines.	65
XXIII.	E ³ Combustor - Key Performance/Operating Requirements.	67
XXIV.	Probabilities of Meeting FAR 36 (1978) Noise Rule Without Trades.	77

1.0 SUMMARY

The NASA-GE Energy Efficient Engine (E³) program is the latest in a series of progressive efforts to develop and demonstrate fuel-saving technology for future commercial transport engines. During this program, advanced compressors, fans, turbines, combustors, and exhaust mixers will be designed and run experimentally as test hardware, then combined in a core engine test vehicle and finally as an integrated-core, low spool vehicle.

Program design goals for a fully developed Flight Propulsion System (FPS) are as follows:

- Installed sfc
 - ≥12% improvement over CF6-50C at Mach 0.8 10,668 m (35,000 ft), maximum cruise conditions
- SFC Deterioration Rate
 - ≤0.5 of CF6-50C
- Direct Operating Cost
 - ≥5% improvement over a scaled CF6-50C with same advanced aircraft
- Noise
 - Meet FAR-Part 36 (March 1978) with provision for engine growth
- Emissions
 - Meet EPA-proposed 1981 Standards
- Commercial Design Practices

In order to ensure that the E³ Flight Propulsion System (FPS) represented a practical design fully capable of installation on advanced aircraft, aircraft/engine integration studies were included in the program. Through subcontracts with the major commercial aircraft companies (Boeing, Douglas, and Lockheed), mission evaluations of E³ versus current (CF6-50C) technology were performed in advanced study aircraft to determine that the program economic goals would be met. An important part of the subcontract effort dealt with review and critique of the installation design to establish suitability of the E³ engine for installation on advanced commercial aircraft of the late 1980's-early 1990's. Elements of the installation such as the inlet, thrust reverser, mount system, accessory package, and aft cowling were reviewed and, in many cases, changed to reflect aircraft company comments on aerodynamic and structural design of the installation.

The E³ FPS status performance showed an improvement in uninstalled sfc of 13.3% over the CF6-50C, and an installed (no customer bleed or power extraction, but including isolated nacelle drag) sfc improvement of 14.2%. In addition, a fully installed (including nominal customer bleed and power extraction) sfc benefit of 0.4% was identified by means of a regenerative fuel heater that would extract waste heat from the customer Environmental Control System bleed air and return that heat to the fuel system. The fully-installed sfc benefit would then be 14.6% versus the CF6-50C. Over and above this, realization of improved performance retention (50% of the performance deterioration rate of the CF6-50C) would provide a further 1% equivalent sfc benefit over the service life of the engine, for a total improvement of 15.6%.

The mission evaluations by the aircraft companies showed improvements in block fuel of from 15.5% to 21.7% without credit for the improved performance retention and 16.3% to 22.9% with credit. Using a uniform set of DOC calculation ground rules to provide consistency of comparison across the range of study aircraft, improvements of 5.0 to 11.6% in DOC were calculated from E³ technology without improved performance retention credit, and 5.3 to 12.4% with credit.

2.0 INTRODUCTION

Effective fuel saving technology is increasingly important to our national goal of energy self-sufficiency. Improvements in energy efficiency have increasing priority in commercial aviation as fuel prices continue to escalate, and fuel costs represent an increasing part of the operating costs of commercial transport aircraft.

The purpose of the NASA-Sponsored Energy Efficient Engine (E³) program is to develop and demonstrate the technology base for achieving higher thermodynamic and propulsive efficiency in future commercial turbofan engines. This technology must be realistically applicable in practical applications in order to contribute materially to fuel savings in commercial transports entering service beginning in the late 1980's-early 1990's time period. Within this framework, the General Electric Company, under contract with NASA, has undertaken the design of advanced engine components which will be demonstrated individually as component test vehicles and collectively in a core engine test and as a fully integrated core-low spool turbofan vehicle (ICLS). The basis for the design of these components is the E³ Flight Propulsion System (FPS), the preliminary design of which was reviewed by NASA in November 1978 and approved by NASA shortly afterward.

The FPS represents a commercial design that could be certified for commercial service in the late 1980's-early 1990's time period. The conceptual design was evolved in NASA-sponsored studies over the 1974-1977 time period and is intended to satisfy the NASA-E³ program design goals.

- Installed sfc
 - ≥12% improvement over CF6-50C at Mach 0.8 10,668 m (35,000 ft), maximum cruise conditions
- SFC Deterioration Rate
 - ≤0.5 of CF6-50C
- Direct Operating Cost
 - ≥5% improvement over a scaled CF6-50C with same advanced aircraft
- Noise
 - Meet FAR-Part 36 (March 1978) with provision for engine growth
- Emissions
 - Meet EPA-proposed 1981 Standards
- Commercial Design Practices

A significant part of the design effort for the FPS was aircraft/engine integration. This work has been carried out to ensure that the FPS design took into account the practical requirements for installation on advanced commercial aircraft as the major aircraft companies foresaw these requirements in the E³ application time frame. The economic benefits of E³ technology over current technology were also evaluated using the General Electric CF6-50 production engine and nacelle as a current technology baseline. In order to enhance the realism of this work, subcontracts were established with Boeing, Douglas and Lockheed Aircraft Companies to perform advanced aircraft sizing and mission evaluation studies using scaled E³ and CF6-50C engines and to review and critique the E³ installation design. The Boeing study was based on an advanced domestic twin-engined aircraft with a design payload of 196 passengers. The Douglas and Lockheed studies were based on advanced derivatives of their DC-10 and L1011 trifans. These transcontinental aircraft were sized for design payloads of 458 and 500 passengers, respectively. In addition, Lockheed studied an intercontinental quad-fan version of their advanced aircraft with a 500-passenger design payload. These studies and reviews provided the basis for evaluating the economic benefits and suitability of the installation design for the E³ FPS. These results are presented in this report.

3.0 DESCRIPTION OF THE E³ FPS

The E³ FPS design is described in detail in the Preliminary Analysis and Design Report that resulted from the November 1978 PDR. A compact summary of the design is presented here. Those interested in greater detail can obtain this from Reference 1.

The FPS design departs significantly from current practice in that much of the nacelle design is structurally integral with what is normally called the "bare engine". This is especially true of the fan cowling which is incorporated in the structure of the fan frame. The nacelle wrap (inlet, reverser, aft cowling and tailpipe, and engine buildup kit) is included in the FPS design which is, therefore, a complete propulsion system that includes everything below the strut on a pylon-mounted installation.

3.1 DESIGN FEATURES

The bare engine has many advanced design and performance features. A lightweight hybrid composite fan containment system has been integrated into the composite vane/frame assembly to reduce weight, enhance fan casing stiffness, and improve fan tip clearances.

Active clearance control has been incorporated into the aft portion of the compressor and for all stages of the high and low pressure turbines. Starting and off-design characteristics of the high pressure ratio core compressor will be enhanced through the provisions of variable geometry vanes and a starting bleed system. Off-design automatic flow matching of the core and quarter-stage booster is inherent in the quarter-stage design configuration due to the large fan duct bypass flow of the quarter stage. No moving parts will be required to achieve satisfactory flow matching under all operating conditions.

Control of the engine is through a full authority digital electronic control (FADEC) that will more accurately provide all the current engine control functions plus many other functions such as clearance control, etc. Emissions of the FPS will be significantly lower from current engines through the use of a double annular combustor design. This design employs two co-annular sets of burners to provide proper fuel/air ratios from idle to maximum power.

Core-mounted accessories have been employed for the FPS to reduce nacelle drag. The accessories are enclosed from the inner engine cowl volume by a thermal isolation compartment. This compartment is isolated from the core engine and separately ventilated to ensure reliable service and increased safety. The basic engine design can accommodate a fan-case-mounted accessory package if desired.

The major installed and uninstalled FPS features are illustrated in Figures 1 and 2. Extensive use of composites has been assumed in the nacelle both for cost and weight reduction. The nacelle is slender, relative to current practice, with a highlight diameter to maximum diameter ratio of 0.86. Because of the compact design of the turbomachinery, the nacelle installed drag is reduced relative to the CF6-50C baseline engine. Important engine and nacelle dimensions are given in Table I.

Table I. E³ Flight Propulsion System Status
Engine and Nacelle Dimensions.

TO Thrust, SLS, kN (lb)	162.4	(36,500)
Fan Diameter, cm (in.)	210.8	(83.0)
Max Nacelle Diameter, cm (in.)	248.9	(98.0)
Inlet Length from Fan Face, cm (in.)	159.0	(62.6)
Turbomachinery Length, Fan Front Flange to LP Turbine Aft Frame Flange, cm (in.)	318.0	(125.2)
Overall Nacelle Length, cm (in.)	603.3	(237.5)
Exhaust Nozzle Diameter, cm (in.)	159.0	(62.6)

The long-duct mixed-flow installation not only enhances the installed performance through an increased slenderness ratio and increased thermodynamic efficiency, it eliminates the need for a core thrust reverser. This is because deployment of the fan-stream-only reverser results in a sudden core jet expansion and consequent core thrust spoiling.

Acoustic suppression is provided by a combination of suppression material and design configuration. Advanced Kevlar-based bulk absorbers are utilized throughout the low temperature portions of the installations such as in the inlet and fan duct regions. Fan blade-to-vane spacing was established to minimize fan noise. The inlet is acoustically treated and sized to minimize forward-radiated fan noise. Turbine acoustic treatment is provided by carefully-chosen blade-to-vane spacing and selection of appropriate numbers of turbine blades. Astroquartz sound treatment is applied in the high temperature core exhaust. The mixed flow design also results in a reduced jet exhaust noise.

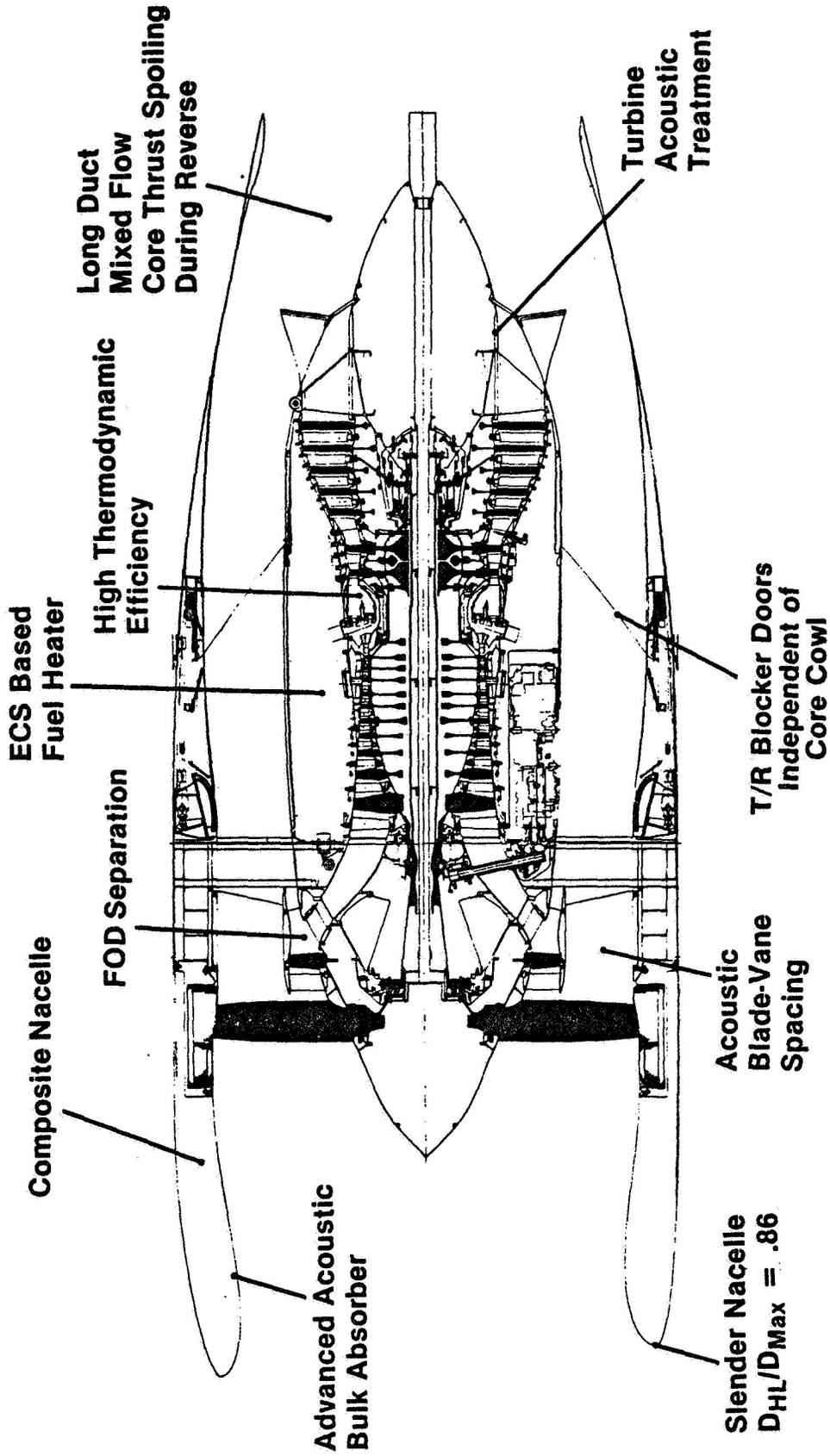


Figure 1. Installed E³ FPS Features.

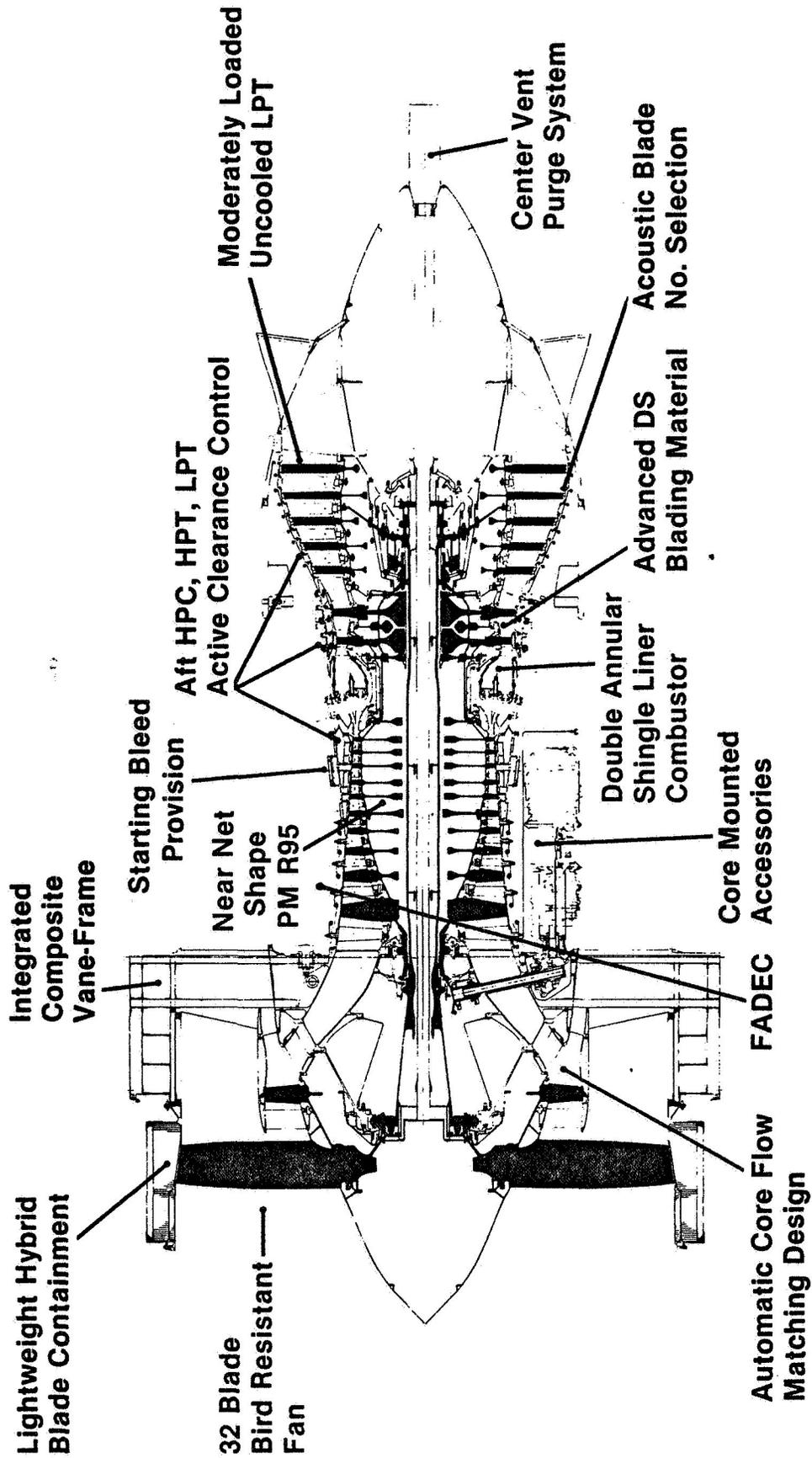


Figure 2. Uninstalled FPS Features.

Resistance of the compression portion of the engine to foreign object damage (FOD) has been enhanced by the use of the quarter-stage configuration which bleeds a significant portion (~40%) into the fan duct, thus bypassing around the core compressor the air most likely to have dust particles.

A regenerative fuel heater is proposed to extract heat from the customer Environmental Control System (ECS) air as an integral part of the engine thermodynamics. This system makes use of waste heat of the ECS air and re-injects it into the engine in the form of heated fuel. The proposed system also has the potential of possibly eliminating current ECS fan air coolers and fuel anti-icing heaters.

Table II compares the E³ FPS and the CF6-50C on the basis of some important cycle parameters, installed performance, and installed engine weight. The installed performance is given two ways: including isolated nacelle drag but with and without nominal customer bleed, and power extraction.

The assessment of performance penalties for nominal bleed and power extraction is based on the assumption that engines with the same altitude climb thrust would be called upon to deliver the same quantities of customer bleed and power for aircraft services. To arrive at this equality, the CF6-50C was scaled to the E³ FPS fully installed maximum climb thrust at the 10,668 m (35,000 ft)/0.8 Mach flight conditions with representative levels of customer bleed and power applied to both engines. These results, scaled to E³ size, are shown in Table III.

Representative levels of customer bleed and power extraction are described for each of the advanced study aircraft in the appendices to this report. Although there is some variation in aircraft requirements among the study aircraft, the nominal levels shown in Table III are within the range of requirements and are, in fact, somewhat on the high side of the range.

The major difference between the E³ FPS and CF6-50C cycles is the reduced specific thrust of the FPS as reflected in the large differences in fan pressure ratio and fan bypass ratio. This results in significantly increased propulsion efficiency. Thermodynamic engine efficiency has been improved through use of more efficient components, a higher overall engine pressure ratio, a significantly higher cruise turbine rotor inlet temperature and the mixed exhaust flow. On a comparable basis, a fully installed cruise sfc reduction of 14.6% has been projected for a fully developed FPS over the referenced CF6-50 engine.

Figure 3 illustrates what the engine would look like suspended from an aircraft pylon and with some of the required piping exposed. Use is made of the aft mounting ring to conduct starter air around the engine to the starter. Mounting of the engine is at three axial locations. The forward mount point takes thrust, side, and vertical loads; the middle mount point supplies roll reaction only; while the aft mount point takes vertical and side loads. The mount is essentially nonredundant under normal flight loads. This mount arrangement has been analyzed in a preliminary manner and results in very low

Table II. Comparison of E³ FPS Status to Reference CF6-50C

	CF6-50C	E ³	Δ
10,668 m/0.8 M/Standard Day			
Maximum Climb Cycle Pressure Ratio	32	38	
Maximum Climb Bypass Ratio	4.2	6.8	
Maximum Cruise Cycle Pressure Ratio	30.1	36.0	
Maximum Cruise Bypass Ratio	4.34	6.93	
Maximum Cruise Turbine Rotor Inlet Temperature, ° C (° F)	1093 (2000)	1188 (2170)	
Maximum Cruise sfc			
- Installed, No Customer Bleed or Power Extraction	0.667	0.572	-14.2%
- Fully Installed, Nominal Customer Bleed and Power Extraction (See Table III)	0.701	0.599	-14.6%
SLS/30° C (86° F) Day			
Turbine Rotor Inlet Temperature @ TO, ° C (° F)	1340 (2445)	1343 (2450)	
Redline Temperature, ° C (° F)	1441 (2625)	1421 (2590)	
Installed Engine Weight*, kg (lb)	4472 (9860)	4082 (9000)	
*CF6-50 Scaled to E ³ FPS Maximum Climb Thrust.			

Table III. Nominal Customer Bleed and Power Extraction, 10,668 m/0.8 M/Standard Day (35,000 ft/0.8 M/Standard Day).

Engine	CF6-50C (Scaled)	E ³
SLTO Thrust - kN (lb)	174.0 (39,110)	162.4 (36,500)
Fully Installed MCL Thrust - kN (lb)	← Same →	
Customer Bleed - kg/sec (lb/sec)	0.95 (2.1)	0.95 (2.1)
Customer Power Extraction - kw (hp)	186 (250)	186 (250)

Customer bleed and power extraction levels are set equal for the E³ FPS and the CF6-50 scaled to E³ maximum climb thrust, fully installed at 10,668 m (35,000 ft), 0.8 M.

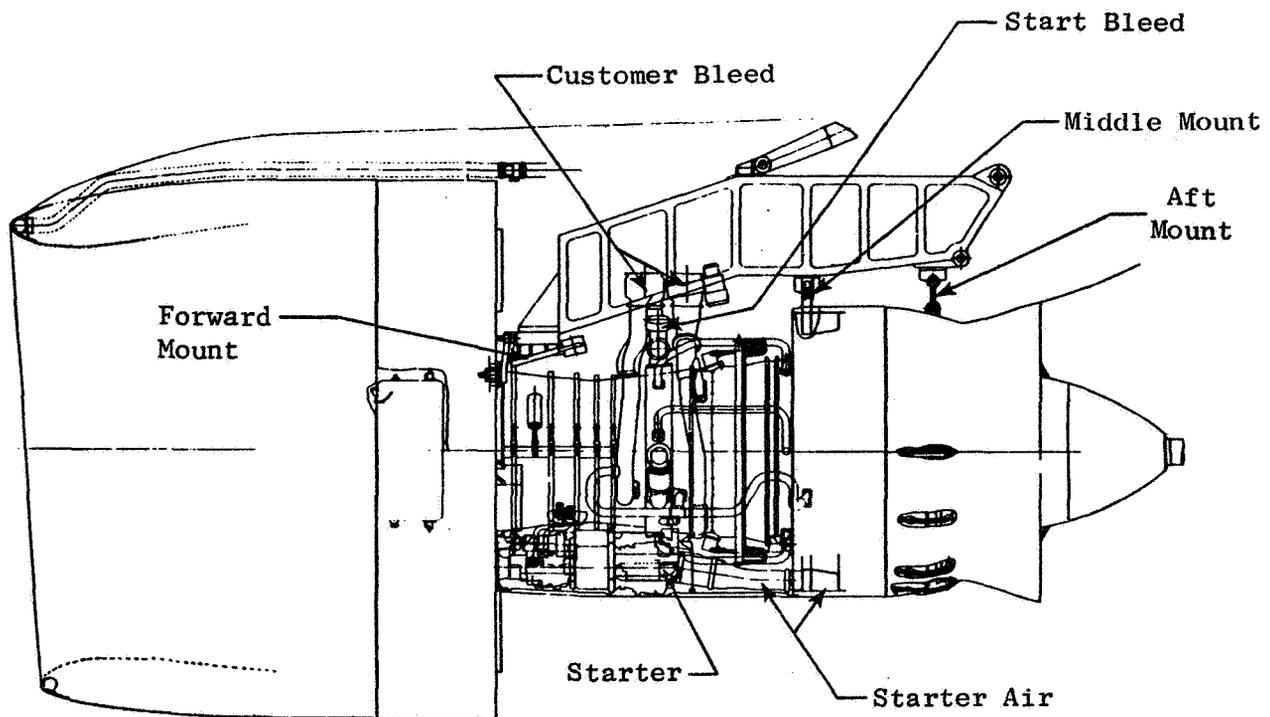


Figure 3. Installed Engine Piping and Mount Details.

levels of casing ovalization and bending. Analysis of this and other mount configurations is continuing in order to determine the optimum configuration for the FPS.

3.2 DESIGN REQUIREMENTS

The design of the FPS has been conducted in accordance with General Electric's commercial engine practices. In particular, the hot section (i.e., combustor, HP turbine blades, etc.) design lives have been increased to help reduce engine maintenance costs. Past experience has shown that a large proportion of engine maintenance costs is distributed among relatively few hot section parts.

The growth requirements for the FPS were accommodated in the following manner. Provisions were made for anticipated growth in the rotor and stator structure; but the materials, cooling and aerodynamic designs were optimized for the FPS size and cycle. When evaluating FPS weight and cost, all provisions for growth are subtracted.

4.0 CYCLE AND PERFORMANCE

4.1 DERIVATION OF FPS CYCLE

The E³ FPS preliminary design cycle is based on the results of a number of NASA Programs involving component and cycle technology studies (Reference 2). As shown in Figure 4, the development of the E³ cycle began in 1974 with the STEDLEC (Study of Turbofan Engine Designed for Low Energy Consumption, Reference 3) study. This was an extensive cycle and technology study of turbofan engines which considered separate- and mixed-flow exhaust system, boosted and nonboosted, single stage HP turbine; and direct-drive and geared fan configurations. All engines were studied as installed on advanced transport aircraft for evaluation against the NASA performance and economic goals.

This was followed by the USTEDLEC (Unconventional STEDLEC, Reference 4) program which continued the turbofan studies along with turboprop engine and regenerative cycles. This study narrowed the candidates to four engine types with separate- and mixed-flow exhaust versions of direct-drive and geared fan configurations. Concurrent with this study was the AMAC program which defined an advanced, 10-stage, 23:1 pressure ratio compressor. This compressor was to be used with a two-stage, high pressure turbine in a nonboosted direct-drive turbofan engine.

The E³ PD&I (Preliminary Design and Integration Studies, Reference 2) program evaluated four engine types using advanced components, cycles, and material technologies against the NASA goals on operating economics, fuel efficiency, and environmental factors. Mission studies were conducted by airframe contractors based on advanced transport aircraft designs. The final cycle from this study was selected as the proposal cycle for this contract.

The cycle selection process involved two phases. The first phase developed a family of engines which provided performance for a range of values of the significant cycle parameters. These were fan pressure ratio, bypass ratio, cycle pressure, HP turbine inlet temperature, and exhaust system type. These engines were then evaluated in the second phase by airframe subcontractors on a variety of missions which incorporated advanced concepts in transport aircraft designs. The aircraft designs included twin, trijet, and quadjet configurations. The mission studies were evaluated against the NASA goals for: economics (DOC), specific fuel consumption (sfc), fuel burned (W_f), emissions, and acoustics. The engines were scaled to meet specific thrust requirements.

The thrust size for the E³ FPS design was selected by General Electric based on these mission studies and corporate evaluations of likely market requirements. The basic engine design and associated technology are scalable over a wide range of thrust requirements.

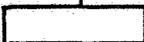
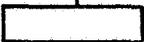
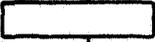
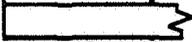
NASA Programs	1974	1975	1976	1977	1978
STEDLEC	 Cycle and Technology				
USTEDLEC		 Unconventional Engines			
AMAC		 10 Stage 23:1 Compressor			
E³ PD&I			 E³ Proposal Cycle		
E³ CD&I				 Minor Changes - FPS Cycle	

Figure 4. E³ Cycle Selection.

4.2 FPS CYCLE DESCRIPTION

The E³ cycle parameters are shown in Table IV for the three key rating points at maximum climb, maximum cruise, and SLS takeoff. The climb and cruise points are shown for a 10,668 m (35,000 ft), 0.8 Mach flight condition. All points are defined for dry air, zero bleed and power extraction, and 100% inlet ram recovery.

Table IV. E³ FPS Cycle Definition.

Parameter	Maximum Climb	Maximum Cruise	Takeoff
Uninstalled sfc (Std. Day), kg/N-hr(lbm/lbf-hr)	0.0557 (0.546)	0.0553 (0.542)	0.0300 (0.294)
Overall Pressure Ratio	37.7	36.1	29.7
Bypass Ratio	6.8	6.9	7.3
Fan Bypass Pressure Ratio	1.65	1.61	1.50
Fan Hub Pressure Ratio	1.67	1.63	1.51
Compressor Pressure Ratio	23.0	22.6	20.0
HPT Rotor Inlet Temp. °C (° F)	1281 (2340)	1244 (2272)	1343 (2450)

The engine thrust is flat-rated over a range of ambient temperatures subject to a maximum HP turbine inlet temperature as shown below:

- Standard Day +15° C (+27° F) for takeoff
- Standard Day +10° C (+18° F) for climb and cruise

The temperatures shown in Table IV for each rating are at the flat-rating temperature condition.

The uninstalled sfc values shown are for a standard day ambient temperature. The maximum cruise sfc is the reference point for the NASA goal. This value is adjusted for an isolated nacelle drag to determine the installed sfc goal of the E³ program.

The cycle data shown are calculated from the General Electric cycle model computer program system used on all engine programs. These are large scale computer programs which contain mathematical models of the engine components

as thermodynamic maps, cooling and parasitic flows, pressure losses, Reynolds number effects, and exhaust system characteristics. Steady state performance is calculated with momentum balance, energy, and flow continuity maintained from station-to-station in the engine. The model also contains models of the 1962 U.S. standard atmosphere and thermodynamics using real gas effects including dissociation effects.

Table V shows the component efficiencies at the maximum cruise condition.

Table V. FPS Cycle - Maximum Cruise Component Performance.

<u>Component</u>	<u>Performance</u>
Fan Bypass, η	0.887
Fan Hub, η	0.892
Compressor, η	0.861
Combustor, η	0.995
HP Turbine, η	0.924
LP Turbine, η	0.917
Mixing Effectiveness	0.75

4.3 FPS PERFORMANCE PREDICTION VERSUS BASELINE CF6-50C

The E³ sfc improvement goal of -12% is evaluated against a General Electric CF6-50C engine. The comparison is made for maximum cruise thrust at 10,668 m (35,000 ft), 0.8 Mach at standard day ambient temperature with zero bleed and power extraction and 100% inlet ram recovery.

Table VI shows that the E³ sfc improvement is -13.3% uninstalled and -14.2% installed as an isolated nacelle. The data identify the source of the sfc improvement based on a cycle parameter comparison of the two engines.

Initial evaluation of the data shown could lead to misinterpretation of how the E³ engine design provides the sfc improvement. For example, of the -4.1% improvement attributed to adiabatic efficiencies, -3% results from an improved fan. However, when considering a comparison of the two compressors, the E³ engine has a component with a much higher pressure ratio (23:1 versus

Table VI. E³ FPS/CF6-50C Reference Maximum Cruise SFC Comparison.

	<u>FPS % Δ sfc</u>	
● Component Efficiencies	- 4.1	
● Mixed Flow Exhaust	- 3.1	
● Propulsive Efficiency (FPR-BPR)	- 2.5	
● Increased Cycle Pressure Ratio (+20%)	- 1.0	
● Increased HP Turbine Inlet Temperature, 79° C (+175° F)	- 1.5	
● Cooling and Parasitic Flows	- 1.0	
● Flowpath Pressure Losses	<u>- 0.1</u>	
		<u>Uninstalled Δ sfc Improvement</u>
		- 13.3%
● Reduced Isolated Nacelle Drag	- 0.6	
● Integrated Aircraft Generator Cooler	<u>- 0.3</u>	
		<u>Installed Δ sfc Improvement</u>
		- 14.2%
● Bleed, HP Extraction	+ 0.4	
● Fuel Heater, Customer Air	<u>- 0.8</u>	
		<u>Fully Installed Δ sfc Improvement</u>
		- 14.6%

13:1) and represents a significant improvement in polytropic efficiency. With a higher pressure ratio compressor and advanced cooling flow technology, a higher thermal efficiency cycle can be obtained as evidence by the improvements due to cycle pressure ratio and HP turbine inlet temperatures. The propulsive efficiency improvement results from the lower fan pressure ratio and higher bypass ratio. The significant mixed flow improvement results from the fact that the CF6-50C has a separated flow exhaust system.

4.4 IMPROVED PERFORMANCE RETENTION

It is an important goal of the E³ program that the high level of engine performance be retained over the long term as the engine is used in commercial service. Current turbofans exhibit a significant deterioration in performance with time in service. The E³ engine has a design goal of halving the long-term performance loss rate exhibited by the baseline CF6-50C engine. This goal is illustrated by Figure 5. The net benefit to mission performance for improved performance retention was assessed at a 1% equivalent long-term sfc improvement over the current technology CF6-50C. Mission evaluations were made both with and without this benefit to illustrate its impact on program goals. The cruise sfc improvement over the CF6-50C did not include credit for this, however.

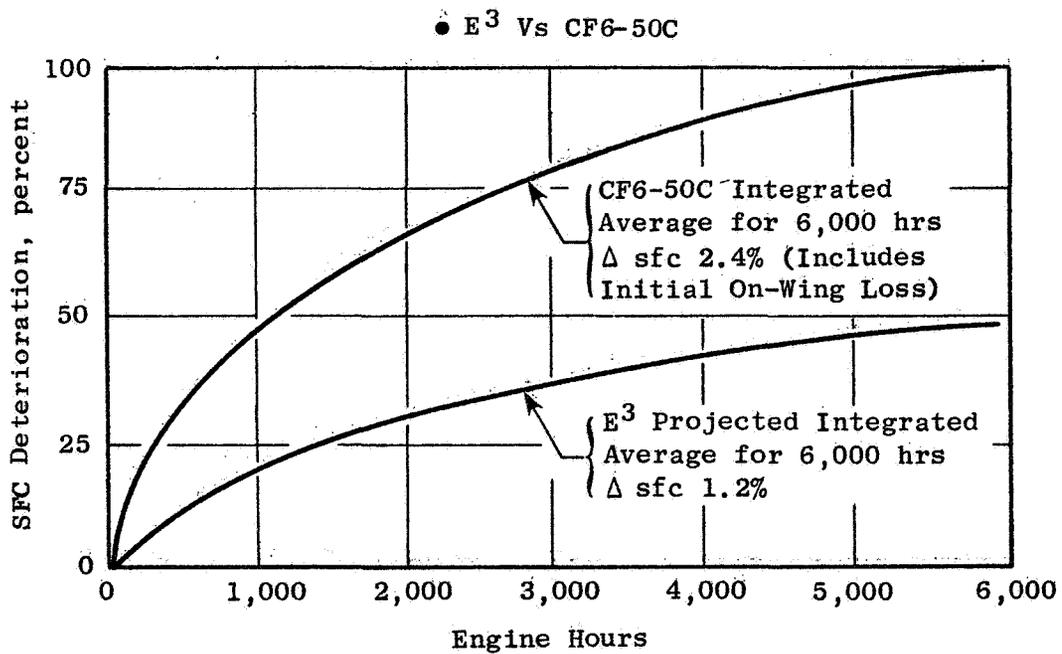
4.5 THRUST FLEXIBILITY AND GROWTH

The design of the FPS baseline engine considered growth requirements to properly assess the impact on the component design changes. Studies were conducted for balanced growth up to 20% in thrust with the constraint that the engine flowpath would remain unchanged. Flexibility for growth in steps was enhanced by the fan hub quarter-stage that could be modified to increase core engine boost.

Thrust growth levels of +5%, +10%, and +20% were evaluated and are summarized in the following tables. Table VII presents a summary of the major cycle parameters for the maximum climb and SLS takeoff conditions.

Table VIII identifies the components that require modification. Note that all the thrust growth configurations include a cooling flow modification to maintain constant turbine blade life.

The +20% growth engine requires changes to most of the components in the engine but not to the flowpath. The major items include: a new fan blade with higher tip speed and pressure ratio; a high flow compressor modification which will require some reblading and a new stator schedule; and some turbine aero changes. (The interim growth steps will overspeed the FPS fan blade to attain the required engine airflow.) The higher fan speed will permit a significant increase in hub boost of about 23%. These changes to the front of the engine require changes in the turbine diaphragms and mixer area split. The HP and LP turbine flow functions will be increased 3% and 13%, respectively. The mixer total area will remain unchanged in order to maintain the same nacelle size. The exhaust nozzle area will be decreased by approximately 2%.



Note: Improvement in performance retention (half the deterioration of CF6-50C) will result in additional ~ 1% improvement in fleet fuel consumption over the operational life of the engine.

Figure 5. Long Term Performance Retention.

Table VII. E³ Growth Capability.

Maximum Climb - 10,668 m (35,000 ft)/0.8 M

	Net Thrust				
	FPS	Throttle Push			
		+5%	+5%	+10%	+20%*
Uninstalled SFC (Standard Day) kg/N-hr (lbm/lbf-hr)	0.0557 (0.546)	0.0564 (0.553)	0.0562 (0.551)	0.0570 (0.559)	0.0574 (0.563)
Overall Pressure Ratio	37.7	39.0	42.3	42.7	45.0
Bypass Ratio	6.8	6.7	6.1	6.1	5.4
Fan Bypass Pressure Ratio	1.65	1.68	1.70	1.70	1.75
Fan Hub Pressure Ratio	1.67	1.70	1.90	1.87	2.05
<u>Takeoff - SLS/30° C (86°F)</u>					
Net Thrust, kN (lb)	162.36 (36,500)	170.50 (38,330)	170.50 (38,330)	178.60 (40,150)	194.83 (43,800)
HPT Rotor Inlet Temperature, ° C (° F)	1343 (2450)	1367 (2493)	1353 (2467)	1394 (2541)	1443 (2630)

*A larger fan might be considered for better sfc.

Table VIII. Growth Component Changes*.

<u>Component Change Required</u>	<u>Throttle Push</u>			
	<u>+5%</u>	<u>+5%</u>	<u>+10%</u>	<u>+20%</u>
New Fan Blade				X
New Booster Blading		X	X	X
High Flow Compressor				X
Larger HPT Nozzle Area				X
Increased Cooling Flows	X	X	X	X
Larger LPT Flow Function		X	X	X
New Mixer - Same Total Area				X
Smaller Exhaust Nozzle				X

*Flowpath Unchanged

The identification of a +20% thrust growth path was a program requirement. The basic FPS rotors and static structures were designed to accommodate growth levels of pressure and rotor speed, although cooling flow allotments were based on FPS gas path temperatures. The +20% growth engine performance was poorer than the FPS in cruise sfc as a result of the constraint of constant flowpath. The most serious consequence of that constraint was that only a small (2.4%) increase in total airflow was available within the FPS fan diameter. As a result, most of the thrust increase was obtained from temperature and exhaust pressure ratio increases which led to a degradation in propulsive efficiency and a 2.7% cruise sfc increase over the FPS level. Another consequence was an estimated engine noise increase of 3 to 3.5 EPNdB at takeoff and 1 to 1.5 EPNdB at approach.

Exhaust emission characteristics also change when takeoff thrust has grown by 20% as evidenced by the resulting delta values shown below:

CO	-1.05	EPAP
HC	-0.02	EPAP
NO _x	+1.32	EPAP
Smoke	+4	SN

The primary cause of the changes in exhaust emissions is the increase in overall pressure ratio from 37.7 in the baseline engine to 45.0 in the growth engine (at maximum climb conditions). This increase in overall pressure ratio results in increased combustor inlet pressure and temperature at the prescribed EPA landing-takeoff cycle conditions which causes carbon monoxide and unburned hydrocarbons emissions to decrease and oxides of nitrogen and smoke emissions to increase.

Although significant thrust growth within the same flowpath/installation envelope is desirable, it is by no means the only practically useful way to obtain engine growth. If it is desired to achieve growth without sfc or noise penalties, a larger fan with greater airflow capacity could be used. In this case, cruise sfc and engine noise margin as the baseline FPS.

5.0 PROPULSION SYSTEM AIRCRAFT INTEGRATION EVALUATIONS

The aircraft integration effort was intended to ensure that the E³ Flight Propulsion System (FPS) design was consistent with the anticipated requirements of advanced commercial aircraft in the late 1980's - early 1990's. For this purpose, subcontracts were established with the Boeing, Douglas, and Lockheed Aircraft Companies. Using appropriate projections of their advanced transport designs, the aircraft companies evaluated the E³ FPS against the baseline CF6-50C current-technology engine nacelle to determine the advantage offered by E³ technology in mission fuel consumption. The advantage in direct operating cost (DOC) due to E³ technology was then evaluated by GE using calculation procedures coordinated by NASA to ensure a consistent evaluation for all the aircraft that were studied.

In addition to the direct mission economic evaluations that were performed, the aircraft company subcontracts provided for review and critique of the nacelle design, including inlet and afterbody aerodynamics, engine mounting, accessory gearbox arrangement, and thrust reverser and cowling mechanical design. Results of this effort will be discussed in Section 5.0.

The subcontracts with Boeing, Douglas and Lockheed called for evaluation of the E³ FPS and the baseline CF6-50C engines appropriately scaled in thrust size on advanced commercial transport designs representative of each company's projections into the late 1980's - early 1990's. Boeing studied a twin-engined, 196-passenger airplane with a design range of 3704 km (2000 nmi). Douglas evaluated a three-engined, 458-passenger advanced derivative of their DC-10 aircraft with a 5556 km (3000 nmi) design range. Lockheed studied two aircraft: a three-engined, 500-passenger aircraft with a 5556 km (3000 nmi) design range; and a four-engined, 500-passenger aircraft with a 12,038 km (6500 nmi) design range, both advanced derivatives of their L1011 aircraft. All of the study aircraft incorporated advanced technology features as projected by the respective aircraft companies for commercial transport studies in the E³ time period.

The aircraft companies provided descriptions of their study aircraft and associated technology features in reports that are appended to this report. The reader may refer to those reports for details concerning the advanced aircraft studied by each aircraft company.

The aircraft companies were provided with engine performance, weight, dimensions, price, and maintenance cost data for the baseline CF6-50C and E³ engines, along with scaling data to permit them to scale both engines to match the different power requirements of their aircraft. They performed their sizing and mission evaluations for each aircraft at design payload/range and for off-design payload/range combinations selected as typical by each aircraft company. These results in turn were used as inputs to the economic analysis performed by General Electric. The E³ FPS evaluations

were made with and without the 1% improvement in long-term average sfc due to improved performance retention, which was a goal that was added to the E³ requirements.

The block fuel improvement for E³ technology is shown in Table IX. Improvements from 15.5 to 21.7% were realized without credit for improved performance retention. With credit for improved performance retention, savings from 16.3 to 22.9% were realized.

Table IX. Economic Benefits, Block Fuel.

	Mission	Range km (nmi)	W/O Perf.	W/Perf.
			Ret. Benefit %Δ Block Fuel	Ret. Benefit %Δ Block Fuel
Boeing Twin Fan	Design	3704 (2000)	-17.4	-18.3
	Typical	1852 (1000)	-16.0	-16.9
	Typical	1232 (665)	-15.5	-16.3
Douglas Trifan	Design	5556 (3000)	-18.7	-19.8
	Typical	1852 (1000)	-17.2	-18.3
Lockheed Trifan	Design	5556 (3000)	-17.3	-18.3
	Typical	2593 (1400)	-16.3	-17.3
Lockheed Quadfan	Design	12038 (6500)	-21.7	-22.9
	Typical	5556 (3000)	-20.1	-21.2

The fuel savings results versus flight length are shown graphically in Figure 6. The benefits show a substantial increase with increasing distance and consequent increase in TOGW fuel fraction.

5.1 ECONOMIC STUDIES DIRECT OPERATING COST

The results of the aircraft company mission evaluations were used as inputs to a DOC analysis. The ground rules were established under NASA coordination to provide a consistent comparison of E³ versus CF6-50 technology for all the different aircraft that were studied. The study ground rules, which drew heavily from the Boeing Company economic method for evaluating operating costs, are summarized as follows:

• E³ Vs CF6-50C

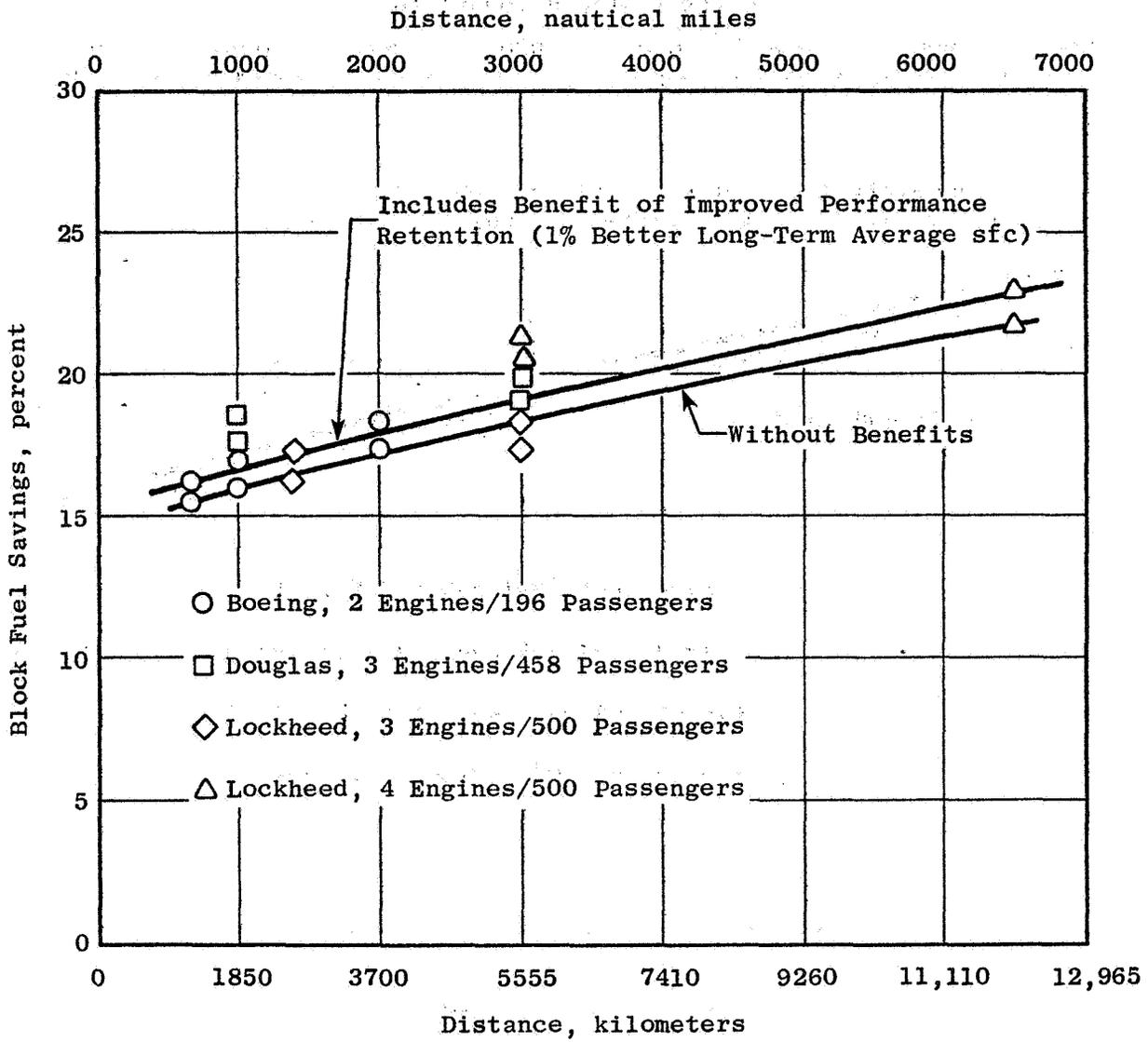


Figure 6. Block Fuel Savings.

<u>Element</u>	<u>Calculated Method</u>
Price Escalation	All costs in 1977 dollars
Flight Crew Cost	Boeing 1977 method - three-man crew for all flights
Fuel	10.6¢/liter (40¢/gal.) Domestic 11.9¢/liter (45¢/gal.) International
Block Time	Boeing 1977 method
Insurance	0.5%
Aircraft Maintenance	Boeing 1977 method - include nacelle in airframe maintenance
Maintenance Burden	200% on labor only airframe and engine
Engine Maintenance	GE methods based upon mature engine - no derates. Include bare engine, engine accessories and reverser
Depreciation	Straight line, 15 years to 10%
Spares	Airframe 6%, engine 30% (total propulsion system including nacelle and reverser)
Utilization	Boeing 1977 method, as modified in December 1977, provides a constant number of trips per year as a function of range
Ground Time	Domestic Trunk - 15 Minutes U.S. International - 20 Minutes
Fuel	Weight 802.7 kg/m ³ (6.71 lbs/gal.)
Oil	Include oil cost at \$2.64/liter (\$10/gal.), 970.4 kg/m ³ (8.1 lb/gal.) usage, 0.061 kg/hr/engine (0.135 lb/hr/engine)
Airframe Weight	$W_{AF} = O_{WE} - (\text{bare engine} + \text{reverser} + \text{engine access.} + \text{nacelle})$
Engine Maturity	All engines are mature
Labor Rate	\$9.70/hr in 1977 \$
Landing Fees	Not included in DOC

<u>Element</u>	<u>Calculated Method</u>
Average Range	Using typical mission range supplied by the airframe companies
Average Load Factor	Use load factor supplied by airframe companies
Interest	There are no borrowed funds
Aircraft Price	Per Table X

NOTE: A 2% nonrevenue flight time shall apply to fuel and maintenance costs.

Table X. Airplane Pricing Functions.

Airplane Price = Bare Airframe + Furnishing + Avionics + Engines

Bare Airframe Price

Current, New and Derivative Wide Body = $0.5 (W_{af}/1000)^{0.7}$

$W_{AF} = O_{WE} - (\text{Bare Engine} + \text{Reverser} + \text{Engine Accessories} + \text{Nacelle})$

Furnishing Price

Domestic Aircraft = $0.0080 N_{seat} - 0.284$

International Aircraft = $0.0089 N_{seat} - 0.315$

Avionics Price

Derivative and Wide Body Domestic = $0.0022 N_{seat} + 1.54$

Derivative and Wide Body Over Water = $0.0022 N_{seat} + 1.81$

Above Values in Millions 1977 \$.

Significant engine inputs to the DOC calculations included sfc and weight (as they affected mission fuel and aircraft weight), engine price and maintenance cost. Table XI shows the status weight of the FPS engine by element for a 162.4 kN (36,500 lb) takeoff thrust size.

Table XI. Engine Weight Estimate by Module.

	<u>FPS Status Wt. No Margin</u>	
<u>Bare Engine</u>	<u>kg</u>	<u>lb</u>
Fan	1066	2350
LP Turbine	753	1660
Core	1007	2220
Other	<u>463</u>	<u>1020</u>
Total Bare Engine	3289	7250
 <u>Installation</u>		
Inlet	161	355
Reverser and Duct	304	670
Core Cowl and Tailpipe	124	275
Engine Buildup	<u>204</u>	<u>450</u>
Total Installation	793	1750
 Total Installed Weight	 <u>4082</u>	 <u>9000</u>

Table XII shows the status engine estimated selling price, by element, in 1977 dollars. The price was established on the basis of CF6-50C engine manufacturing costs, projected to a mature engine scaled to the E³ engine design size and adjusted to account for design and manufacturing differences between the two engines.

Table XII. Estimated Engine Price - K\$
(1977 Dollars).

	<u>FPS Status</u>	
Fan Module	\$ 520	
LP Turbine Module	483	
Core Module	715	
Other Bare Engine	<u>237</u>	
Bare Engine Total		\$1955
 Inlet	 \$ 95	
Fan Reverser and Duct	240	
Core Cowl and Tailpipe	71	
Engine Buildup	<u>172</u>	
Installation Total		\$ 578
 Installed Engine Total		 <u>\$2533</u>

Table XIII shows the status estimated engine maintenance cost by element, in 1977 dollars, for a 162.4 kN (36,500 lb) takeoff thrust size. As with selling price, the maintenance costs were derived by comparison to a mature CF6-50C baseline.

Table XIII. Estimated Engine Maintenance Cost, 2-Hour Mission, No Derate.

<u>Materials by Module</u>	<u>\$/Engine Flight hr (1977 Dollars)</u>
Fan	\$ 1.55
LP Turbine	3.63
Core	14.32
Other	<u>8.55</u>
Total Materials	\$28.05
Direct Labor (9.00/Hour)	12.73
Labor Burden (200%)	<u>25.47</u>
Total Maintenance Cost	\$66.25

Table XIV compares the economic elements of the DOC analysis for the baseline CF6-50C and the E³ FPS at its hardware design size and scaled to the same installed thrust as the CF6-50C engine at 35,000 ft/0.8 M maximum climb rated power. The CF6-50C versus the scaled E³ provides a direct comparison of these engines for aircraft with similar cruising power requirements.

The scaled E³ engine is somewhat lower in installed weight and significantly lower in maintenance cost, which contribute to lower DOC. However, the unit price is significantly higher, which raises DOC. The impact of these effects will be discussed shortly.

Table XV shows the DOC improvements calculated for the E³ technology in all the study aircraft. The results are shown with and without credit for improved performance retention and are also presented graphically in Figure 7.

The major elements that constitute DOC are fuel and oil costs, depreciation, crew cost, airframe maintenance, engine maintenance, and insurance. The fractional contributions of each element to total DOC are shown in Table XVI for three typical aircraft/mission combinations. There is a noticeable increase in fuel cost fraction with increasing distance, as one would expect. These results are also presented graphically for all study aircraft in Figures 8 through 13.

Table XIV. Major Engine Inputs to DOC Analysis.

Engine	E ³		
	CF6-50C		
TO Thrust Size, kN (lb)	223.5 (50,250)	162.4 (36,500)	208.6 (46,900) (Scaled)**
Bare Engine Weight, kg (lb)	3,946 (8,700)	3,289 (7,250)	4,504 (9,930)
Engine + Nacelle Weight, kg (lb)	5,761 (12,700)	4,082 (9,000)	5,511 (12,150)
Engine Price, 1977 Dollars	2,281,000	2,533,000	2,951,000
Maintenance Materials, \$/EF hr*	51.00	28.05	31.70
Maintenance Labor, \$/EF hr*	15.50	12.73	14.38
Labor Burden (200%), \$/EF hr*	31.00	25.47	28.78
Total Maintenance, \$/EF hr*	97.50	66.25	74.86

*2-hr mission, no derate.

**Same maximum climb thrust at 10.7 km (35,000 ft) -0.8 M, installed as CF6-50C.

Table XV. Economic Benefits, Direct Operating Cost (NASA-Coordinated Rules).

	Mission	Range km (nmi)	W/O Perf. Retention Benefit % DOC	W/Perf. Retention Benefit % DOC
Boeing Twin Fan	Design	3,704 (2000)	-6.6	-6.9
	Typical	1,852 (1000)	-5.4	-5.6
	Typical	1,232 (665)	-5.0	-5.3
Douglas Trifan	Design	5,556 (3000)	-9.0	-9.5
	Typical	1,852 (1000)	-6.7	-7.1
Lockheed Trifan	Design	5,556 (3000)	-7.4	-8.0
	Typical	2,593 (1400)	-6.2	-6.8
Lockheed Quadfan	Design	12,038 (6500)	-11.6	-12.4
	Typical	5,556 (3000)	-9.9	-10.7

Table XVI. Distribution of DOC Elements, E³ Engine with Credit for Improved Performance Retention.

Aircraft Type	Domestic Twin Fan	Domestic Trifan	Intercontinental Quadfan
Distance - km (nmi)	1232 (665)	1852 (1000)	5556 (3000)
Load Factor - %	55	60	55
Fuel and Oil - %	23.5	31.7	33.0
Depreciation - %	31.1	29.3	27.2
Crew - %	20.2	16.0	19.0
Airframe Maintenance - %	14.0	12.9	10.4
Engine Maintenance - %	8.9	7.9	8.4
Insurance - %	2.3	2.2	2.0

● E³ Vs CF6-50C

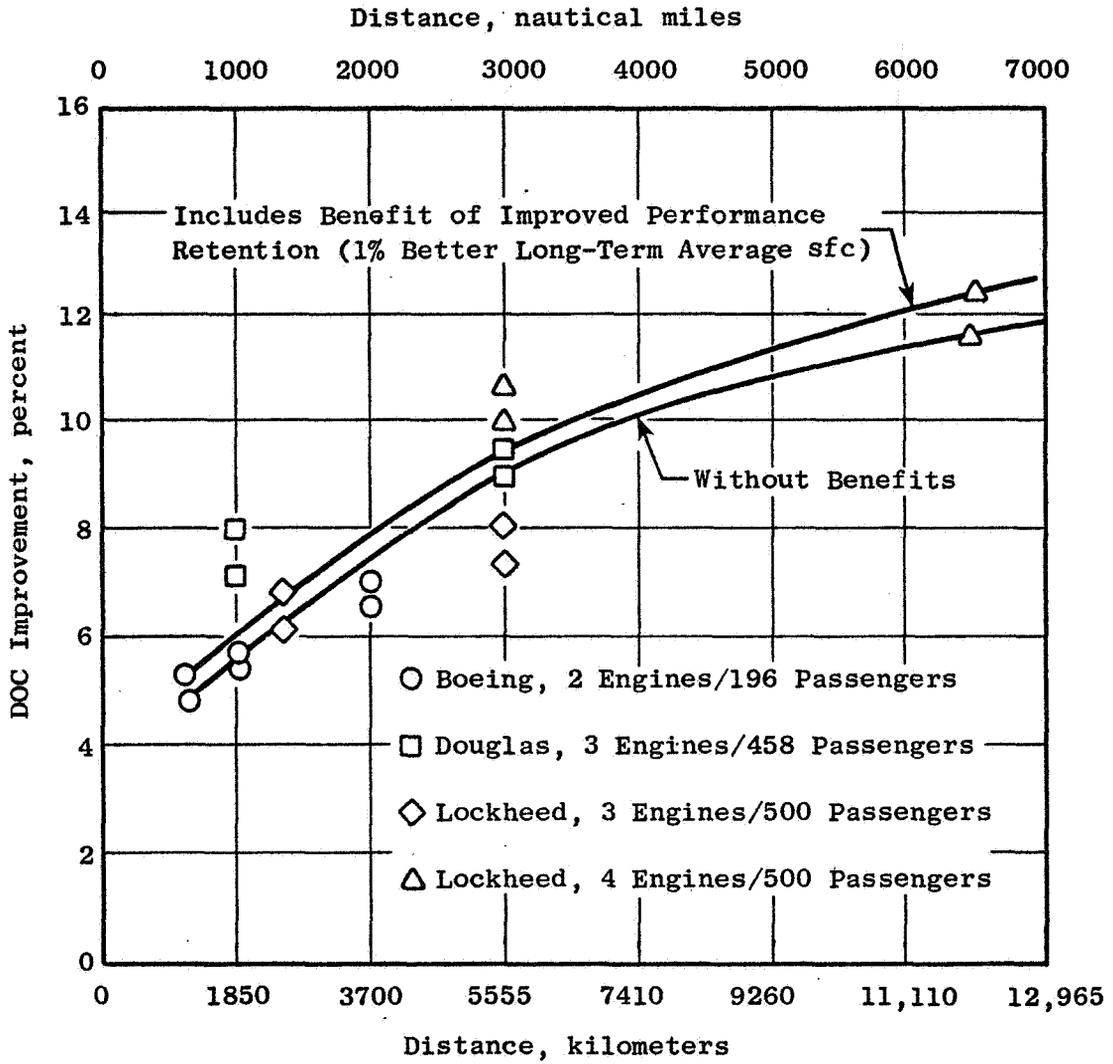


Figure 7. Direct Operating Cost (DOC) Improvement.

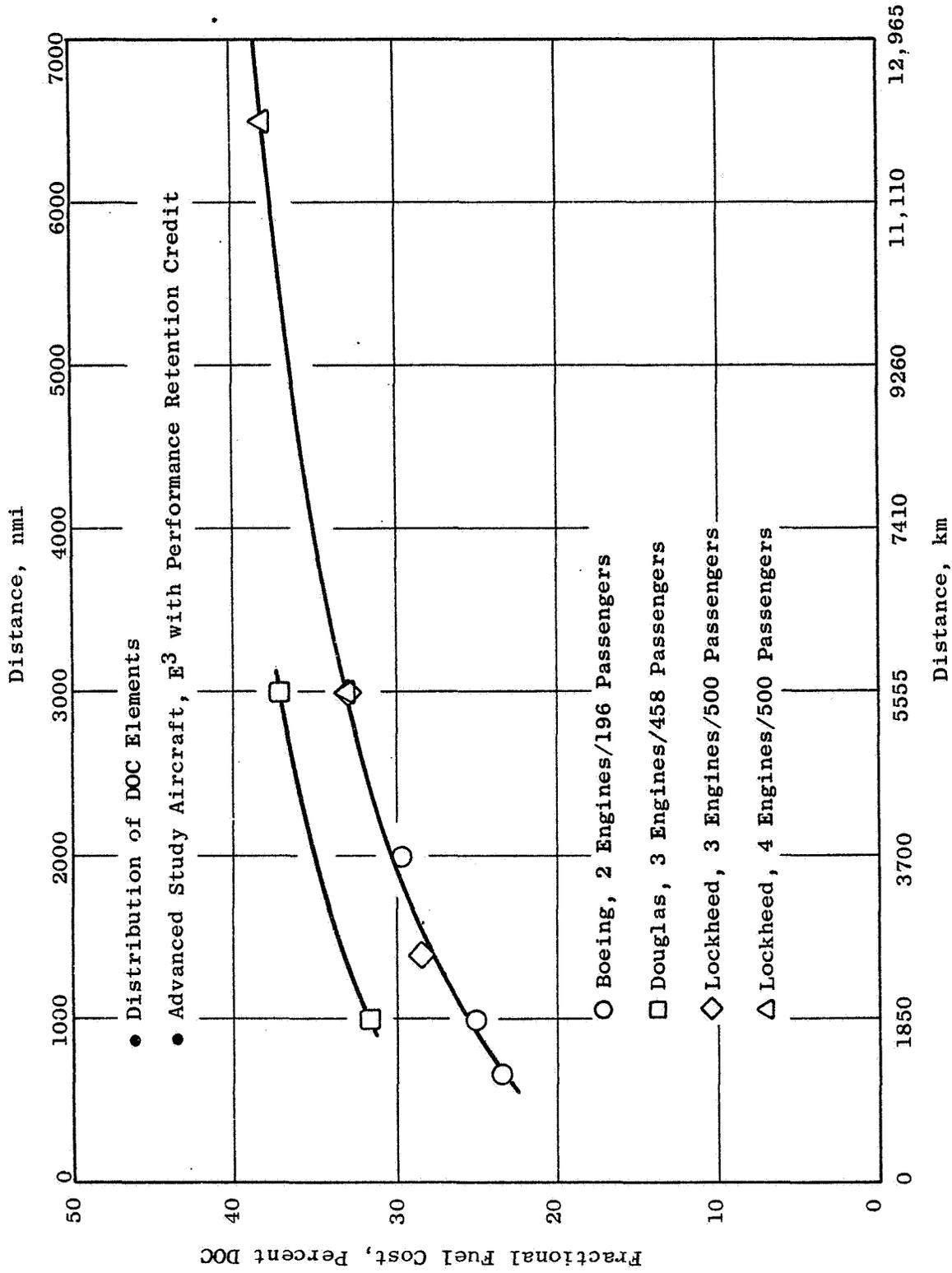


Figure 8. Fractional Fuel Cost.

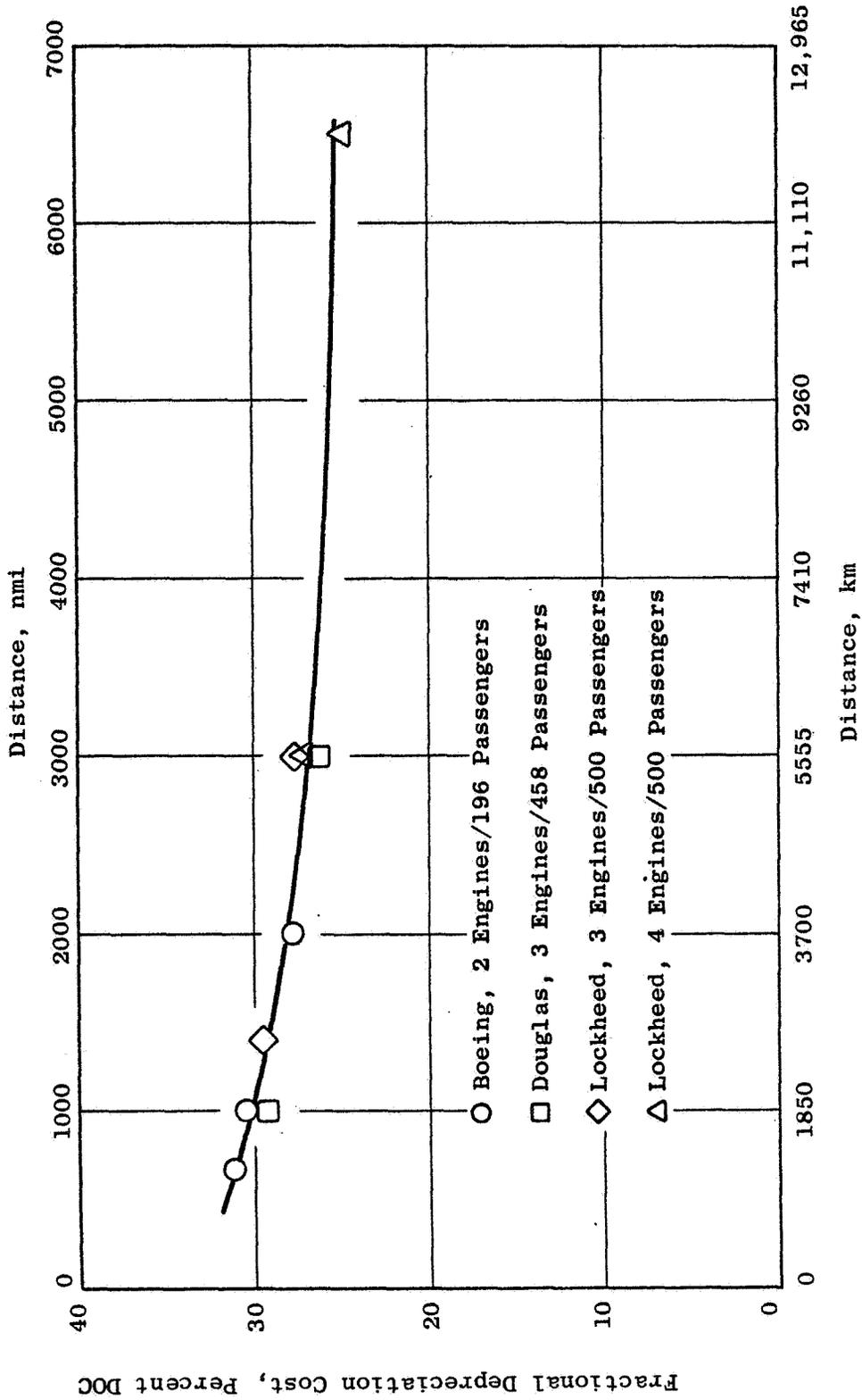


Figure 9. Fractional Depreciation Cost.

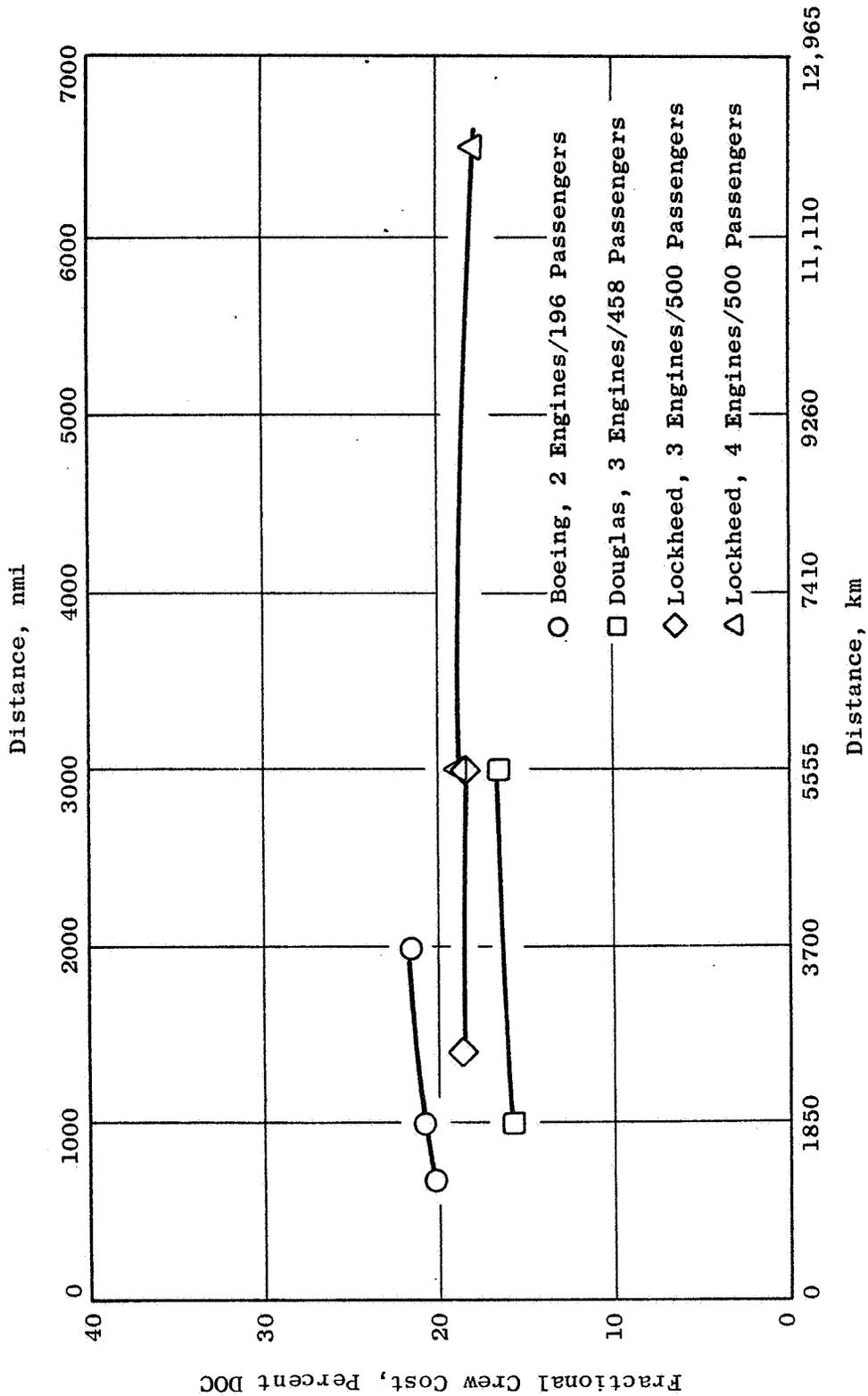


Figure 10. Fractional Crew Cost.

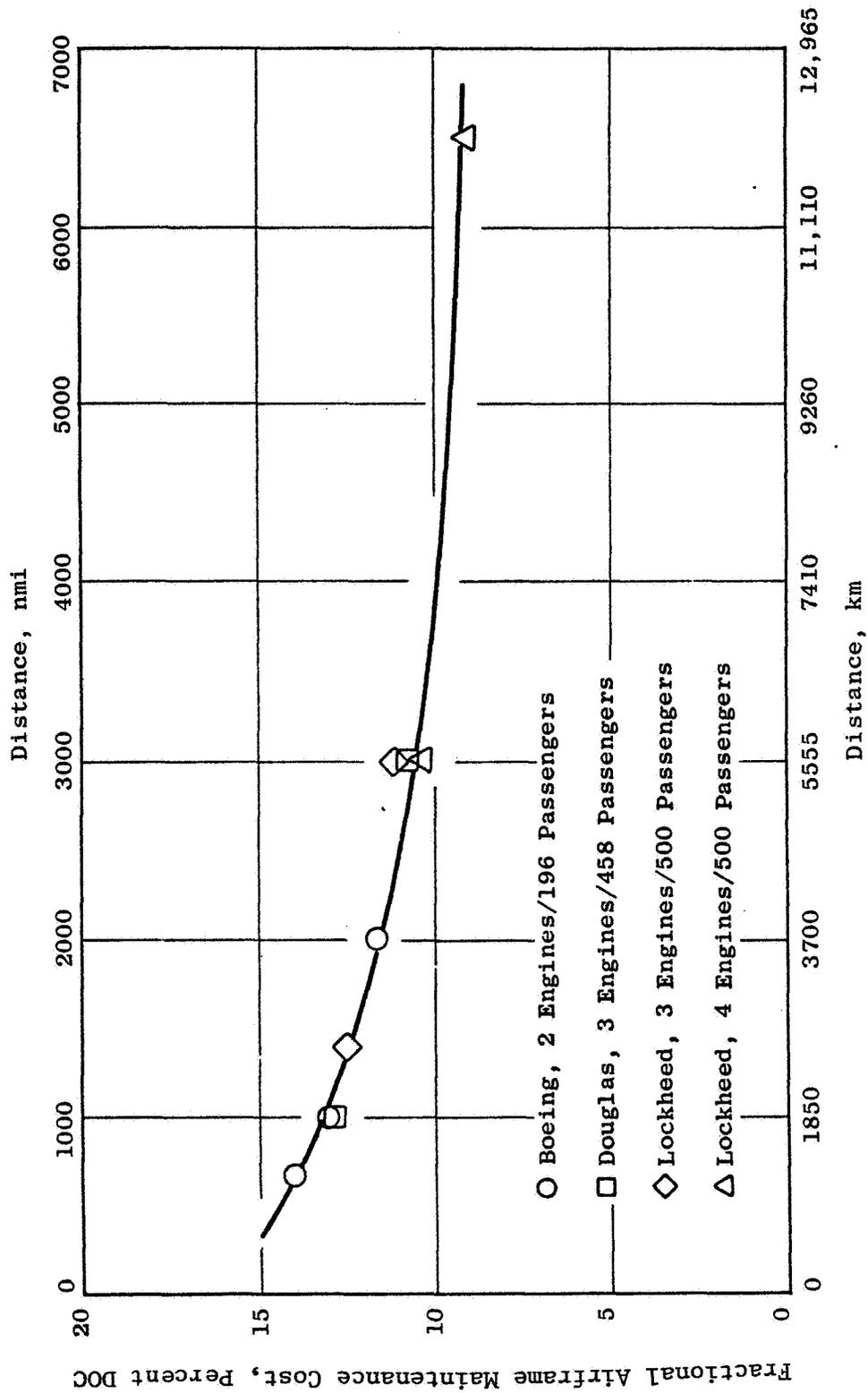


Figure 11. Fractional Airframe Maintenance Cost.

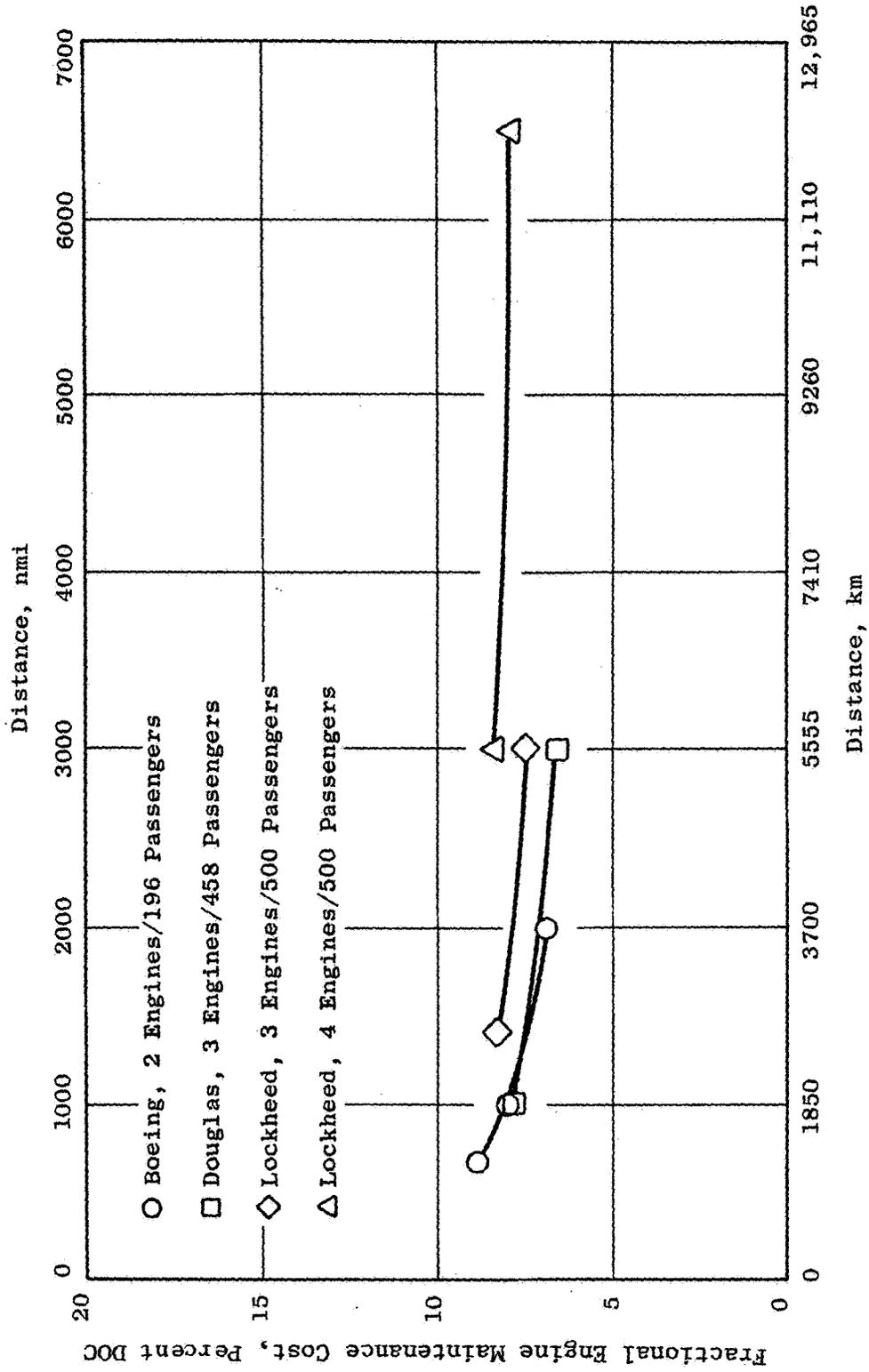


Figure 12. Fractional Engine Maintenance Cost.

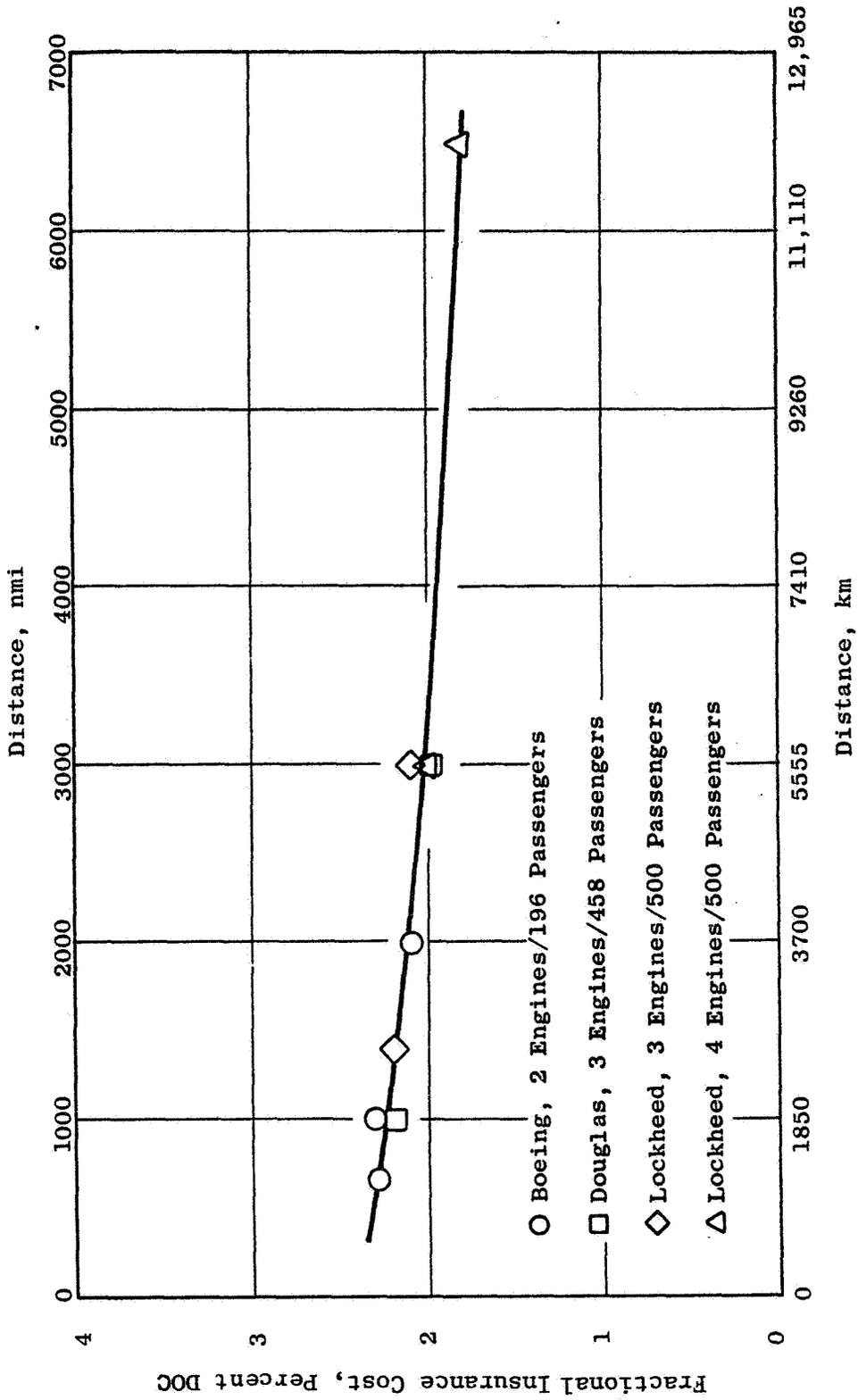


Figure 13. Fractional Insurance Cost.

The contribution of each element of DOC to the total improvement for E³ versus CF6-50C technology is shown in Table XVII for the same three typical aircraft/mission combinations. The largest contributor to DOC improvement is fuel and oil costs. Maintenance cost also provides a significant benefit for the E³ technology. However, the higher engine price for the E³ engine results in an offset in favor of the CF6-50C. These results are presented graphically for all study aircraft in Figures 14 through 19.

5.2 ECONOMIC STUDIES - RETURN ON INVESTMENT

Return on Investment (ROI), usually defined as the discount rate that equates cash flows to initial investment, is an indicator of the overall economic worth of a change in technology. In order to evaluate the E³ technology from the standpoint of the total economic system, NASA established a set of ground rules for an ROI calculation to be performed on the advanced study aircraft using baseline CF6-50C and E³ engines. These ground rules, involving the calculation of Indirect Operating Cost (IOC) and ROI, are as follows:

INDIRECT OPERATING COST

<u>Element</u>	<u>Calculation Method</u>
Maximum Loading Weight	Use value supplied by airframe company or if none supplied, use the equation - Max Ldg. Wt. = TOGW x (0.95 - 5 x 10 ⁻⁵ x Rn Des.) where Rn Des. = Design Range in Nautical Miles.
Seat Split	Use split supplied by airframe company.
Enplaned Ratio	For passengers and cargo use Boeing 1977 curve I-08.
Cargo	Use cargo supplied by airframe company - use powered loading.
Cash DOC	Defined as cash DOC = DOC - depreciation.

Table XVII. Contributors to DOC Improvement, E³ with Credit for Improved Performance Retention Versus CF6-50C.

Aircraft Type	Domestic Twinfan	Domestic Trifan	Intercontinental Quadfan
Distance - km (nmi)	1232 (665)	1852 (1000)	5556 (3000)
Load Factor - %	55	60	55
Fuel and Oil - ADOC - %	-4.3	-5.1	-7.9
Depreciation - %	+1.6	+1.0	+0.8
Engine Maintenance - %	-2.2	-2.4	-2.8
Crew - %	-0.3	-0.3	-0.6
Airframe Maintenance - %	-0.2	-0.4	-0.3
Insurance - %	<u>+0.1</u>	<u>+0.1</u>	<u>+0.1</u>
Total ADOC - %	-5.3	-7.1	-10.7

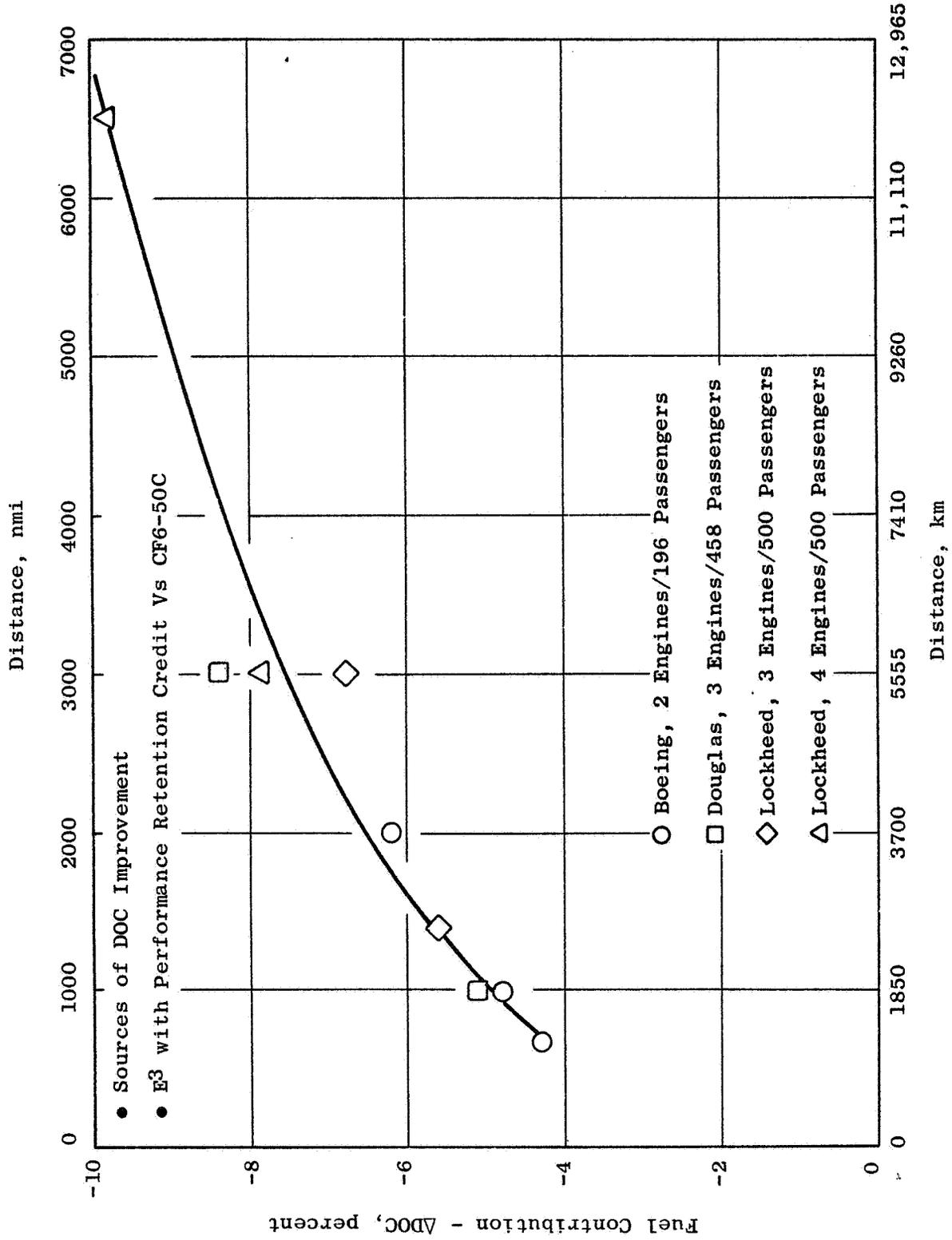


Figure 14. Fuel Contribution.

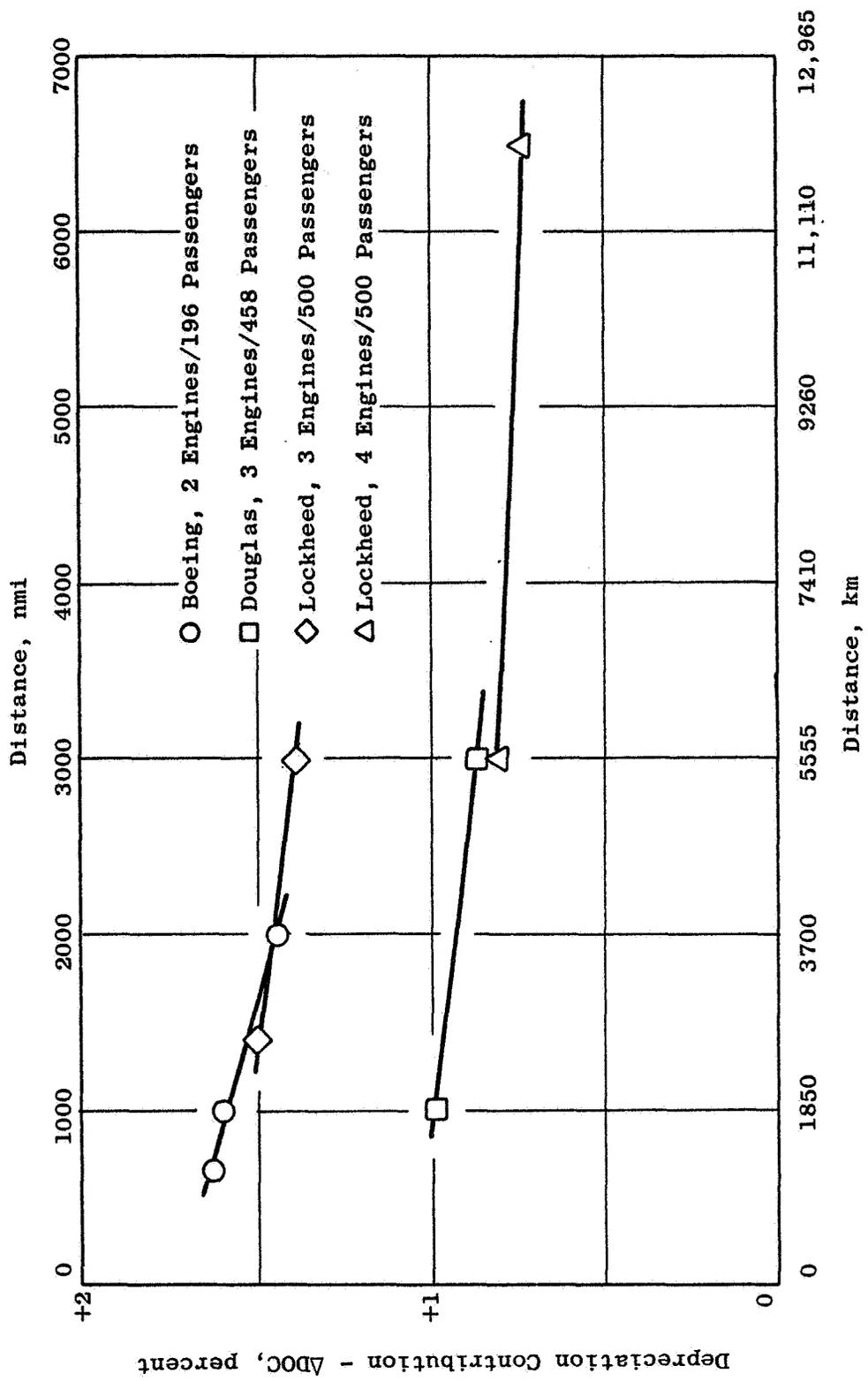


Figure 15. Depreciation Contribution.

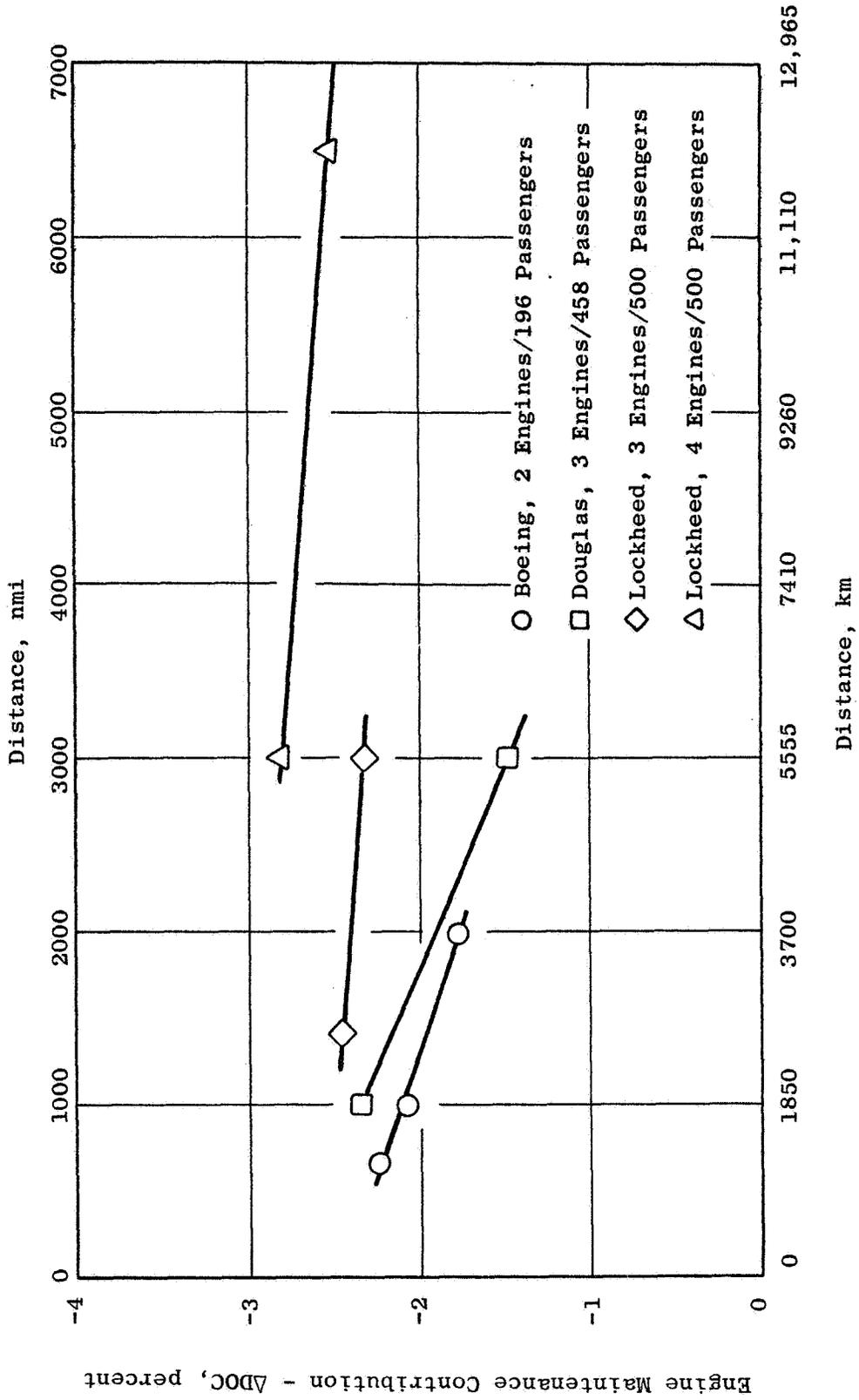


Figure 16. Engine Maintenance Contribution.

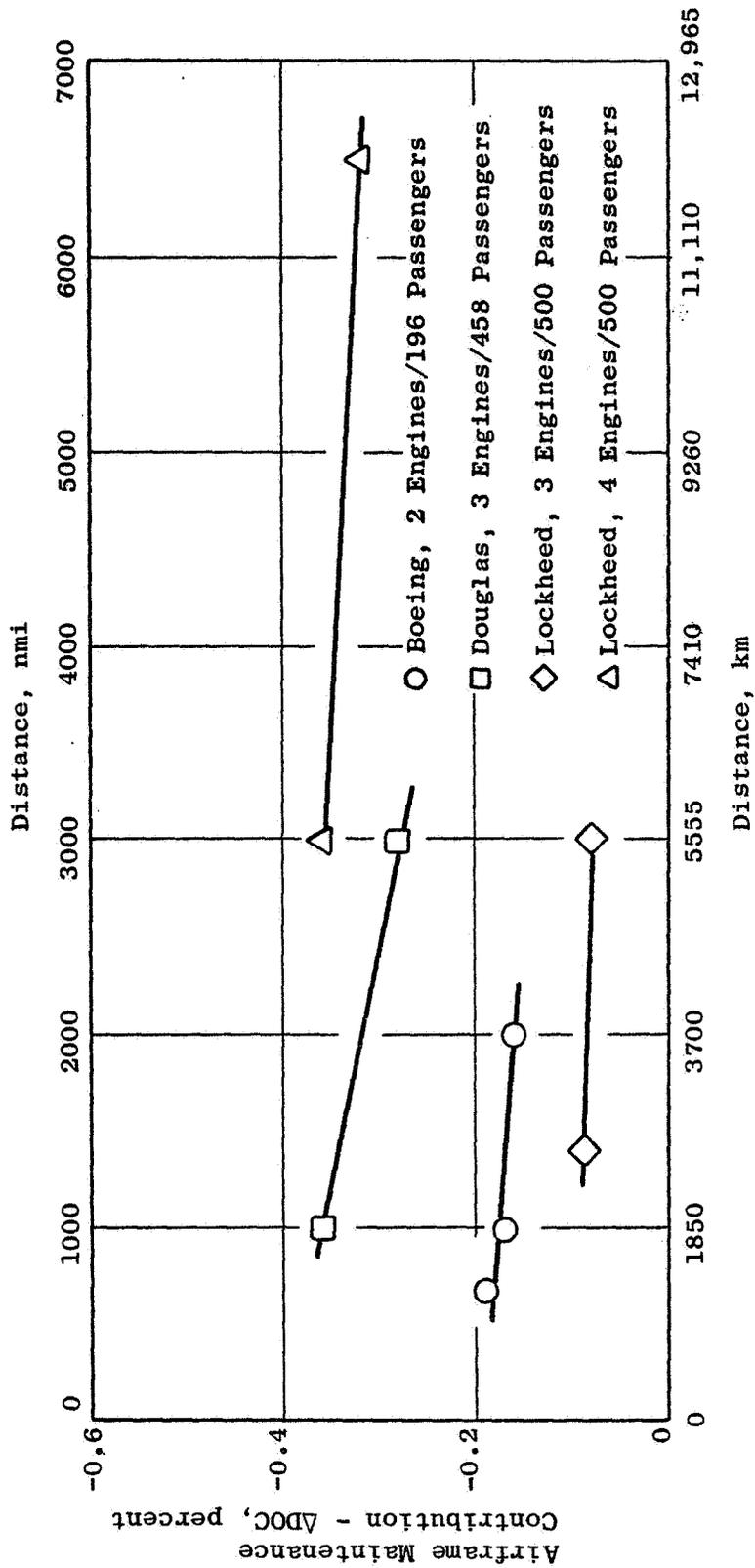


Figure 17. Airframe Maintenance Contribution.

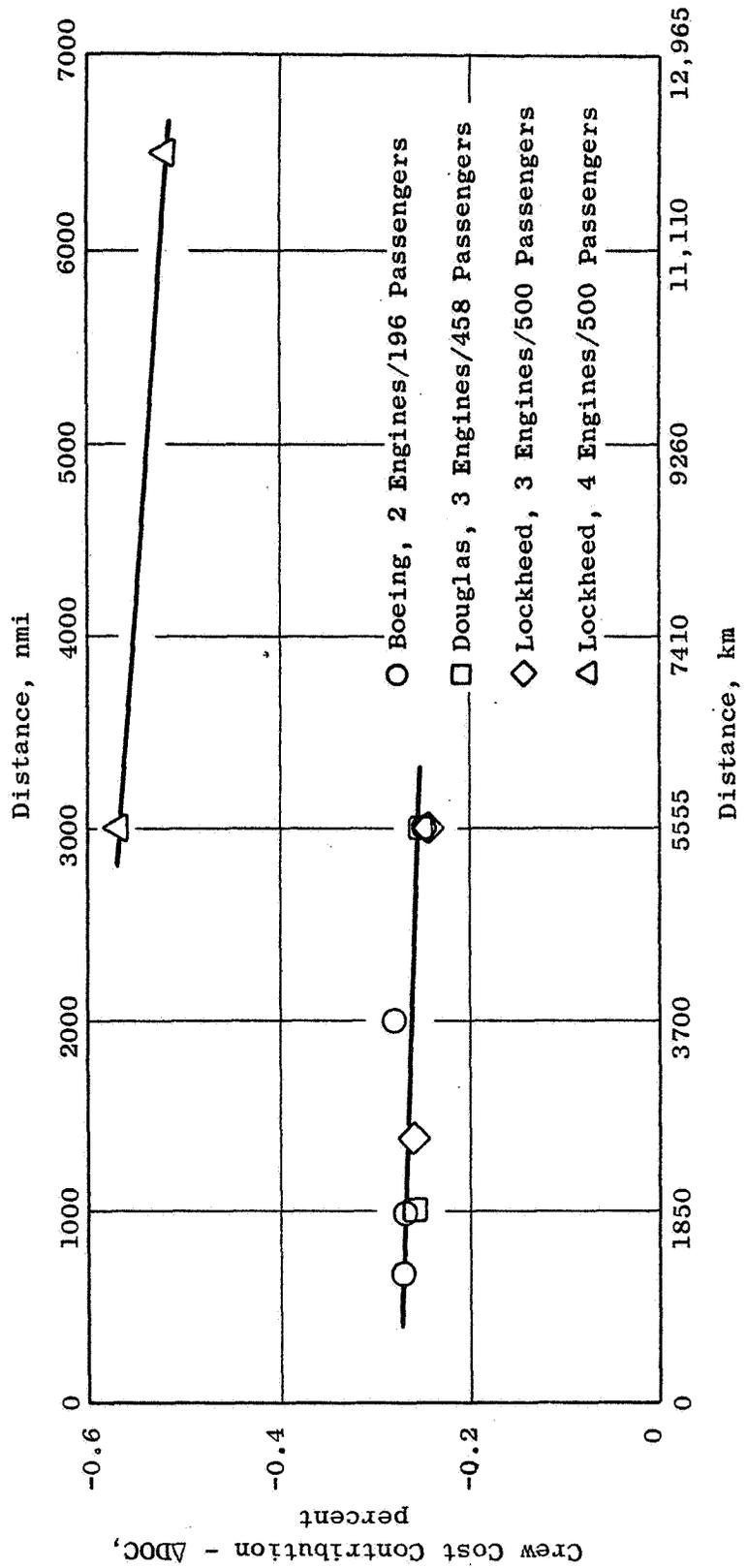


Figure 18. Crew Cost Contribution.

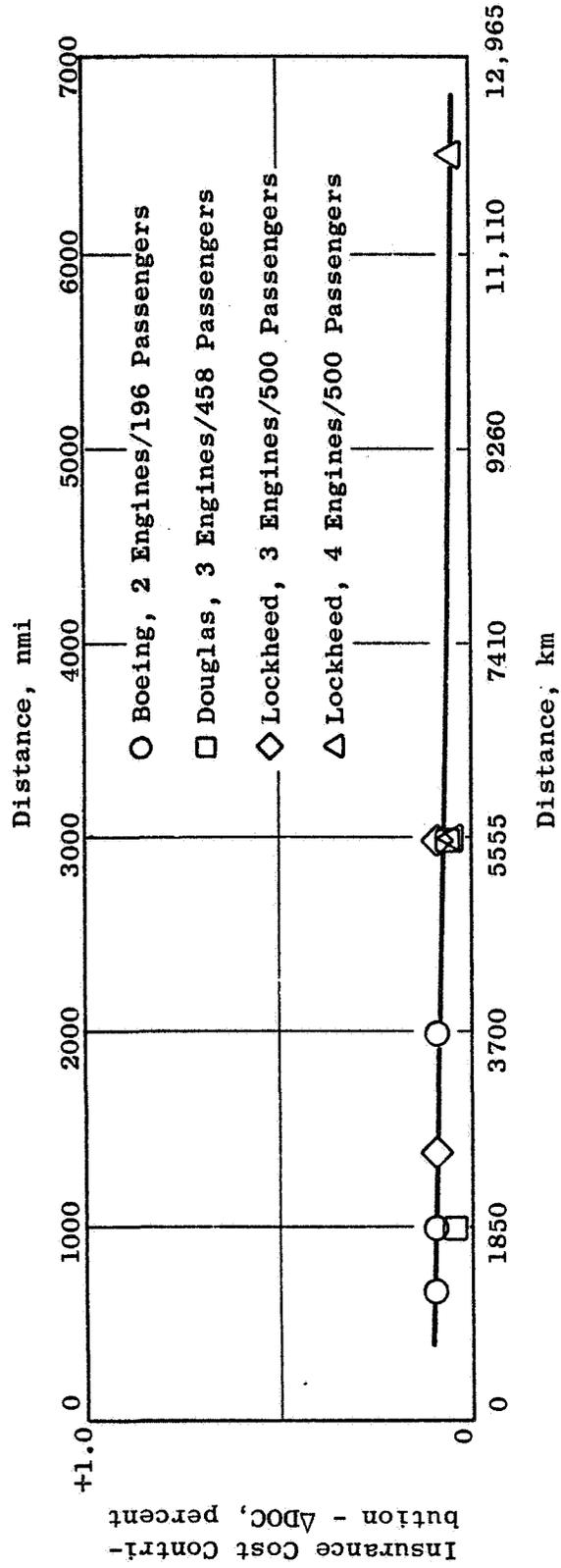


Figure 19. Insurance Cost Contribution.

RETURN ON INVESTMENT

<u>Element</u>	<u>Calculation Method</u>
Depreciation	Straight line 15 years to 10% residual
Quantity	Block Feed
Initial Investment	100% of aircraft, engines, and spares
Interest - Discounted Rate of Return	Based on no borrowed funds
Revenues	Domestic Passengers - \$/Trip = 20.88 + 0.0582 x Dist. St. Mi. International Passengers - 23.42 + 0.0653 x Dist. St. Mi. Cargo (Wide Body) \$/Ton - St. Mi. = <u>131.6</u> + 0.142. Dist. St. Mi.
Average Range	Use typical mission supplied by airframe company
Cash Flow	No principal payment
Taxes	50%

NOTE: A 2% nonrevenue flight time shall apply to fuel and maintenance costs for both DOC and ROI.

Return on investment levels calculated by this method would differ significantly from ROI calculated by any particular airline, as the assumptions affecting costs and revenues are very operator-specific in practice. No airline would calculate ROI on the basis of no borrowed funds, for example. However, the difference in ROI for competing technologies would be indicative of their respective economic values. Hence, the results that are presented in this report are the differences in ROI between advanced aircraft using CF6-50C and E³ propulsion technologies.

Table XVIII shows the results of these calculations for a domestic twin fan, a transcontinental trifan and an intercontinental quadfan with typical mission lengths and payloads.

Table XVIII. Improvement in Return on Investment for E³ Versus CF6-50C Propulsion Technology (NASA-Coordinated Rules).

Aircraft	Domestic <u>Twin Fan</u>	Transcontinental <u>Trifan</u>	Intercontinental <u>Quadfan</u>
Design Range km (nmi)	3704 (2000)	5556 (3000)	12,038 (6500)
Typical Range km (nmi)	1232 (665)	1852 (1000)	5556 (3000)
Typical Load Factor - %	55	60	55
Fuel Price ¢/ℓ (¢/gal.)	10.6 (40)	10.6 (40)	11.9 (45)
Δ ROI - Improvement for E ³ Technology	+0.7	+0.5	+1.0

5.3 AIRCRAFT COMPANY COMMENTS ON FPS ECONOMICS

Although all aircraft company studies showed significant reductions in mission fuel consumption for the E³ technology, the Boeing Company qualified their results in the areas of nacelle installation weight and engine price. They felt that the nacelle weight reported by General Electric for the E³ system was lighter than they would have estimated for construction technology appropriate for the late 1980's-early 1990's. They also noted that the E³ engine price was high relative to their Economics Department projections of future market requirements.

For a discussion of nacelle weights, see Section 5. The price difference of 20% was reviewed by General Electric and no obvious grounds were discovered to lower the GE projection at this time. However, the strong influence of engine price on economic benefits is fully noted and efforts will continue to be made throughout the program to arrive at a favorable balance between cost, weight, and performance.

6.0 NACELLE DESIGN

The E³ FPS was designed with an integrated nacelle to permit a significant weight reduction for the total installed system. Major elements of the nacelle design included:

- Integral, composite construction of the fan frame, the outer portion of which forms the outer surface of the nacelle.
- Substantial use of composite materials in the inlet and aft cowling and in acoustic treatment of the exhaust flowpath.
- Lightweight fan containment based on the use of Kevlar fibers to trap and hold engine-generated debris in the event of fan damage.
- A long-duct mixed-flow exhaust system to enhance propulsive efficiency, achieving a higher level of engine performance with a smaller fan and low pressure turbine than would be required for a comparable separate flow system.
- A reverser contained entirely in the outer wall of the nacelle without need for bifurcation and cross-duct linkage. Extensive application of composite materials was made in the reverser to achieve light weight in the design.
- The engine-mount system chosen with particular attention to minimization of engine deflections due to mount loads in order to promote close control of turbomachinery clearances.
- The aerodynamic lines of the nacelle chosen for slimness and low cruise drag. To achieve as small an external nacelle profile as possible, the accessory package was installed in the core compartment.
- For ease of maintenance access to the core engine and accessories, the reverser designed in two halves hinged at the pylon attachment and latched at the bottom. In this way, the reverser provided access to the core component. The core cowl panels were hinged to the pylon to form a separate inner door system.

The aggressive use of advanced structural design and low-drag aerodynamics was established to contribute a 0.6% cruise drag reduction (out of 6%) and a 15 to 20% installation weight saving relative to the current technology of the CF6-50C nacelle that is the E³ program baseline.

The general arrangement of the E³ nacelle is shown in Figure 20.

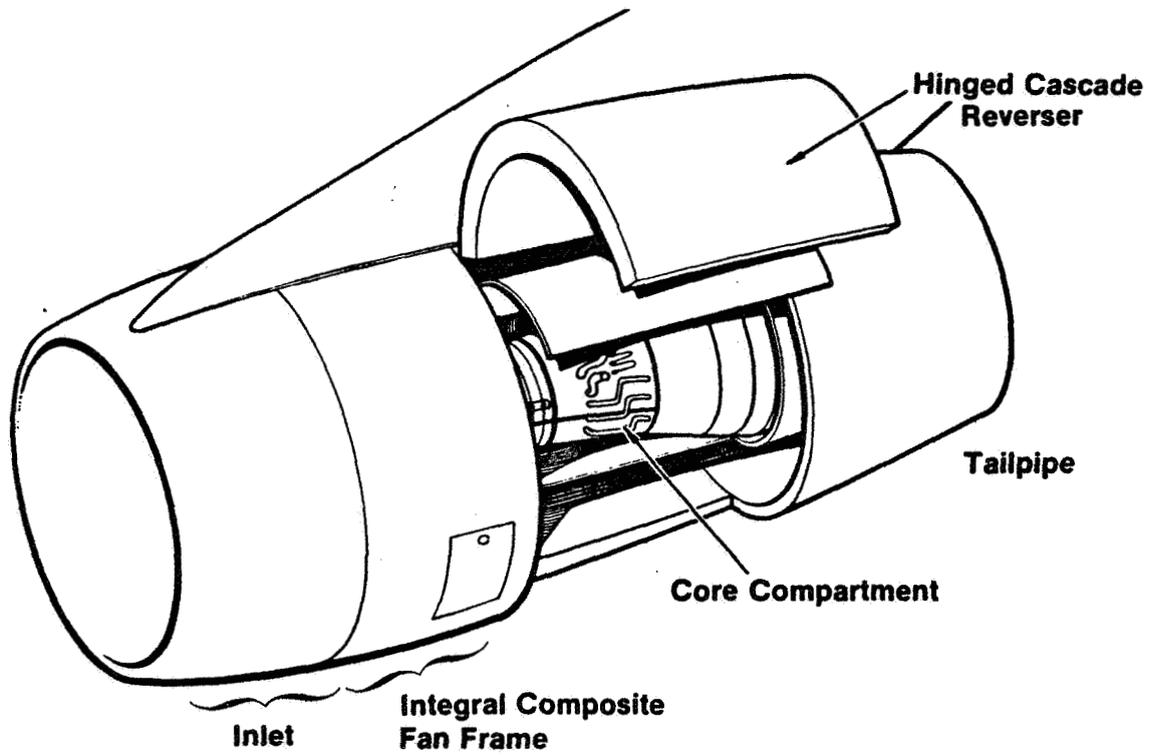


Figure 20. Nacelle General Arrangement.

6.1 FAN REVERSER

The preliminary fan thrust reverser design is of the fixed cascade, translating sleeve/blocker door configuration.

The reverser is made in symmetrical circumferential halves, each half being hinged to the aircraft pylon and latched to the other half along the bottom centerline allowing ready access to the engine. The reverser consists of the fixed support structure, including the cascade section, the outer translating sleeve, the blocker doors and linkage mechanism and the actuation system. As the actuation system is located outboard of the cascades, the cascade section is made in circular arc sectors with passageways (slots) between them for the blocker door links to pass through.

The reverser is contained entirely in the outer duct wall. There is no attachment to the core cowl which is independently hinged to the pylon to provide access to the core compartment. There are no links between the blocker doors and the core cowl-translation, and swingdown of the blocker doors is controlled by linkages contained in the outer cowl structure. The cascades are covered externally by the outer translating sleeve which incorporates the reverser sealing arrangement.

Figure 21 illustrates the reverser design in its stowed and deployed positions.

The aerodynamics of the reverser were based on previous General Electric experience with the large turbofan reverser designs. The desired fan operating line for reverse operation is 4% lower in pressure ratio at corrected airflow than the normal forward thrust mode fan operating line at static operating conditions. This was chosen in order to provide additional stall margin if required and to provide a reduction in core engine speed and turbine temperature at fan speed compared to forward mode operation.

Overall thrust effectiveness of the fan reverser is improved by the core thrust spoiling of the mixed exhaust system. In the reverse mode, the absence of bypass flow in the tailpipe causes a reduction in low pressure turbine back pressure which allows the core speed to be reduced relative to forward mode operation. This "rotor matching" effect causes a significant reduction in core stream thrust potential which is reduced still further by the aerodynamic spoiling effect of dump-diffusion out of the mixer core chutes into the tailpipe. These effects, which were evaluated in a cycle computer model, are based on previous scale model exhaust mixer tests.

The overall system reverse thrust effectiveness is shown in Figure 22 compared to a CF6-50C with and without the turbine reverser. The E³ 50 knots effectiveness of 45% compares closely to the 51% effectiveness achieved with the CF6-50C with turbine reverser and exceeds the -50C level without turbine reverser.

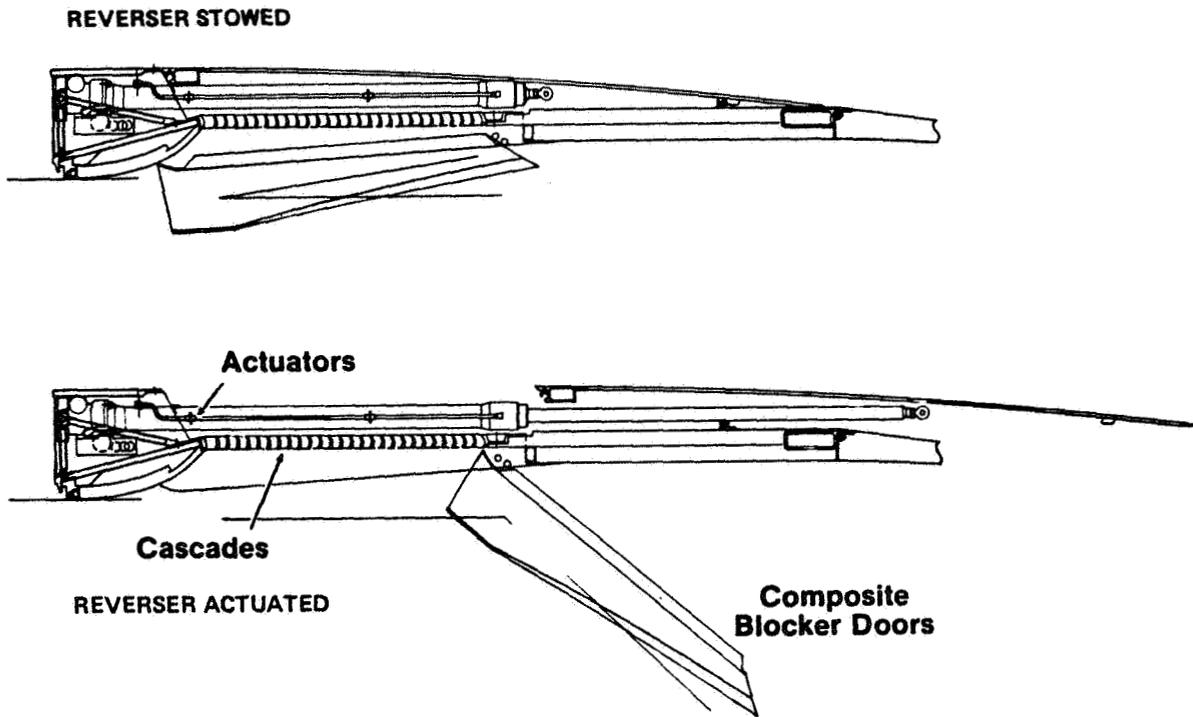


Figure 21. Thrust Reverser Actuation.

● E³ Vs CF6-50C

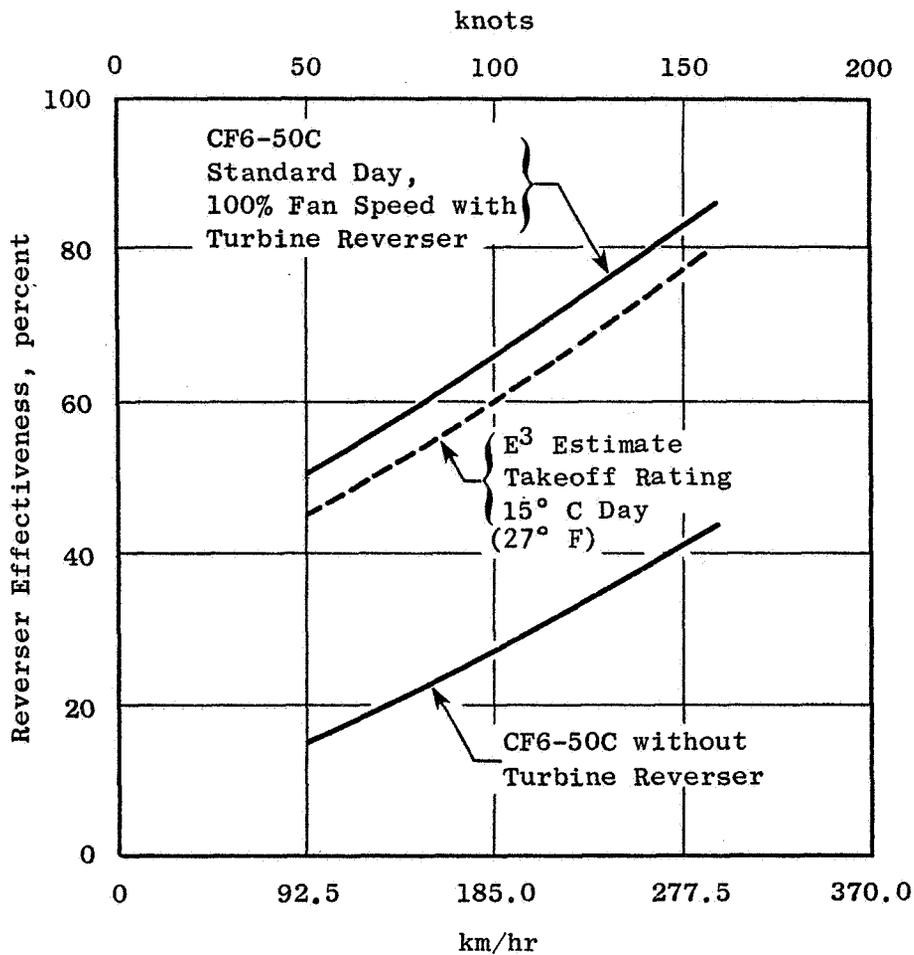


Figure 22. Overall Engine Reverse Thrust Comparison.

6.2 ENGINE MOUNT SYSTEM

The mount system design was selected to achieve the following important objectives:

- Compatibility with aircraft pylon structural design requirements.
- Reduction or elimination of concentrated "punch" loads into the engine structure.
- Reduction of engine ovalization and bending loads due to mount reactions.

The mount system chosen for the E³ engine is shown in Figure 23. It consists of a front mount with twin thrust links and a uniball to take vertical and side loads, a midmount to take out roll and side loads, and an aft mount taking vertical loads only. The mount reactions are shown schematically in Figure 24.

The front mount was derived from the improved CF6-50C mount with additional emphasis on lowering the thrust reaction line to be closer to the engine centerline to reduce the thrust-induced moment. The two links were made self-adjusting by means of a whiffletree arrangement, and this also helped to reduce load concentrations at the fan frame attachment points.

The mid and aft mounts were arranged to take out roll, side, and vertical forces. Reactions were distributed to avoid concentrated punch loads into the engine structure.

Structural analysis of the FPS engine in response to typical thrust, aerodynamic and maneuver loads shows encouragingly low engine deflections. Figure 25 shows maximum local deflections versus engine axial length for a takeoff rotation condition where these loads are relatively large. The maximum deflection of approximately 0.23 mm (9 mils) was found to occur over the turbine area. These deflections would be in addition to clearance changes resulting from thermal and elastic behavior of the engine.

Although the mount system described here achieves the goals established for the FPS, there was some concern expressed by the Boeing Company over possible redundancy problems with the arrangement. In response to this, General Electric is continuing to work on an alternate arrangement that could eliminate that concern and still achieve the design goals.

6.3 ACCESSORY PACKAGE

The accessory package for the FPS was designed to help reduce fuel consumption and direct operating cost (DOC).

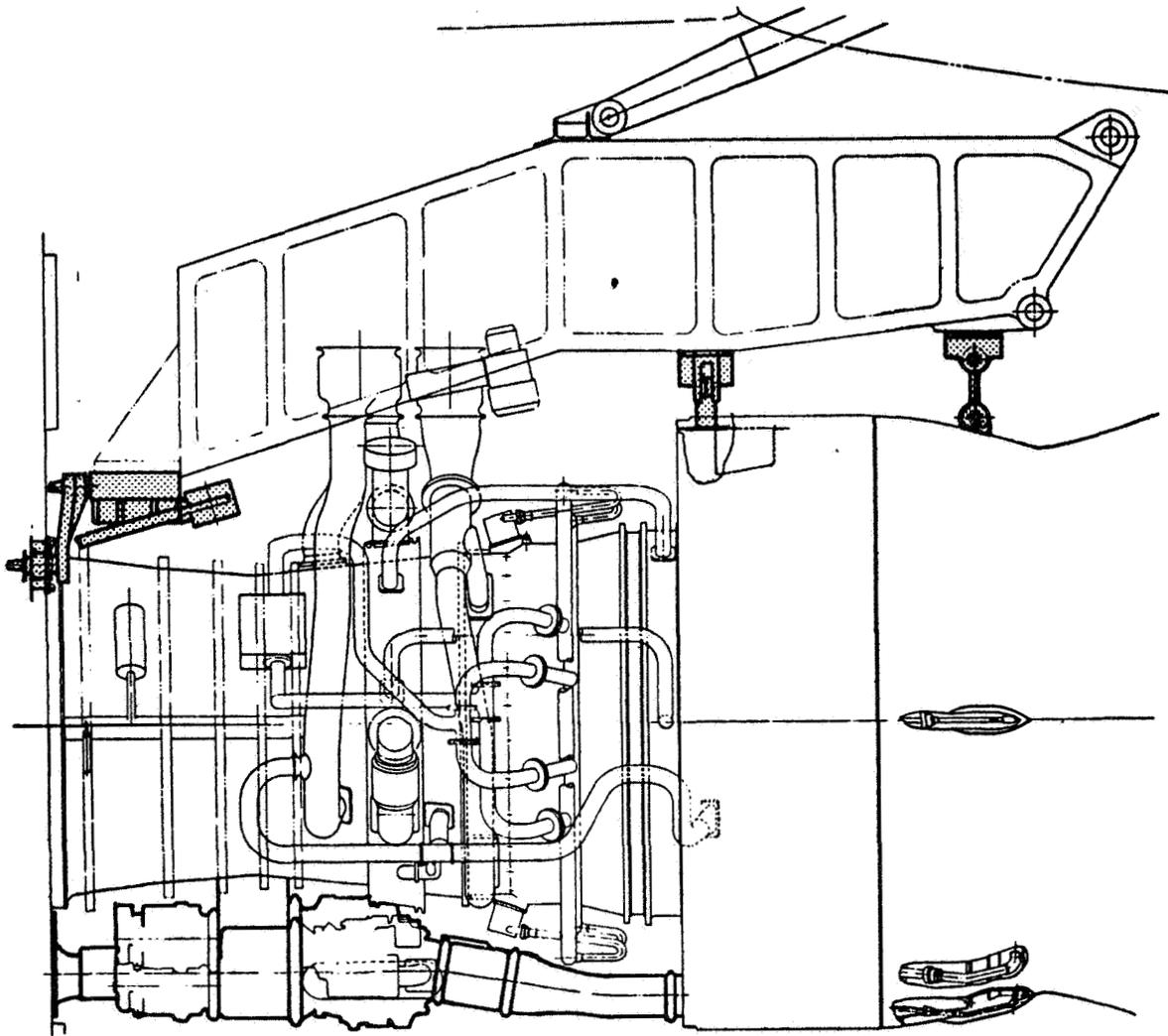


Figure 23. Engine Mount System.

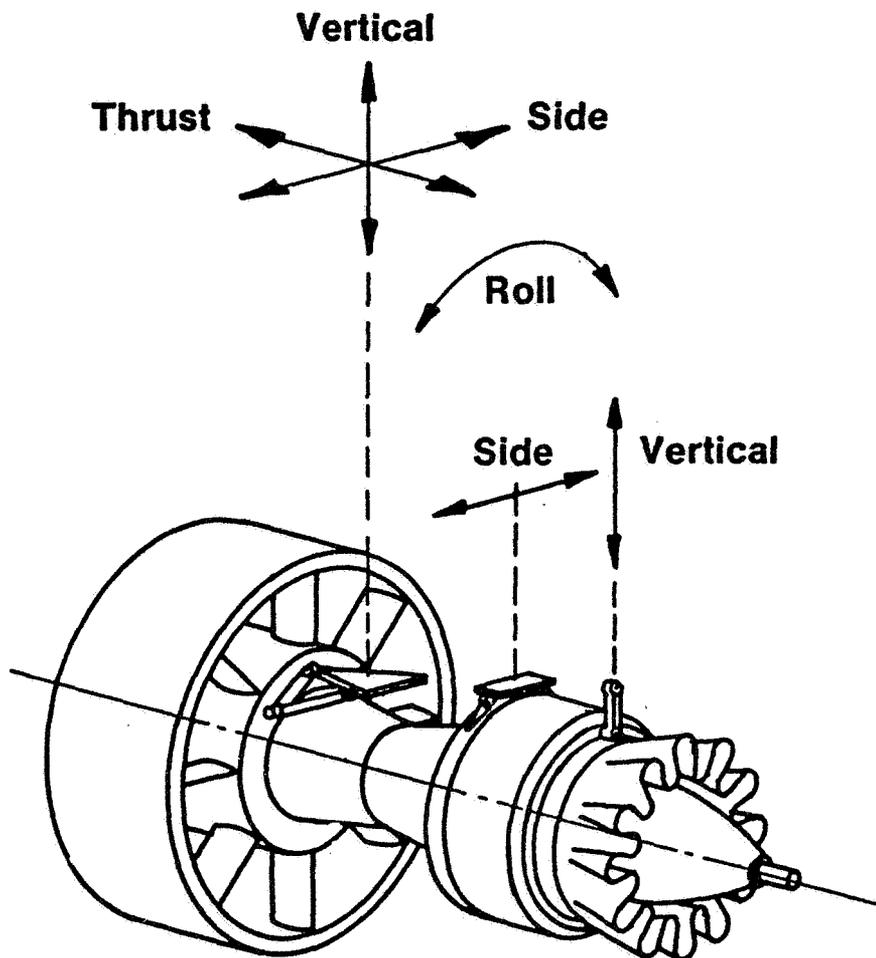


Figure 24. Mount Reactions Schematic.

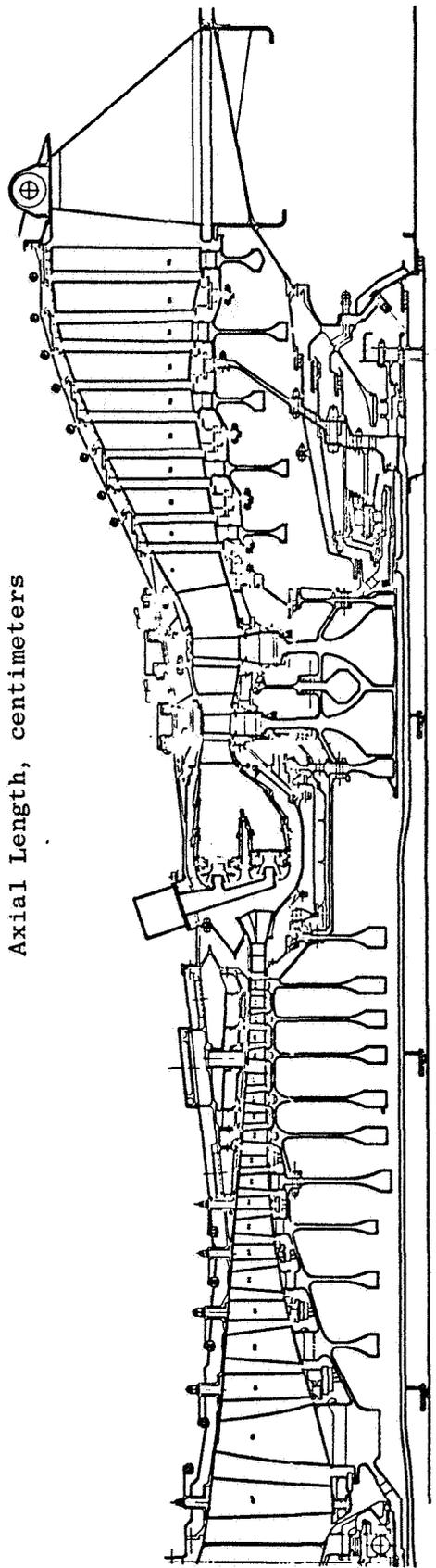
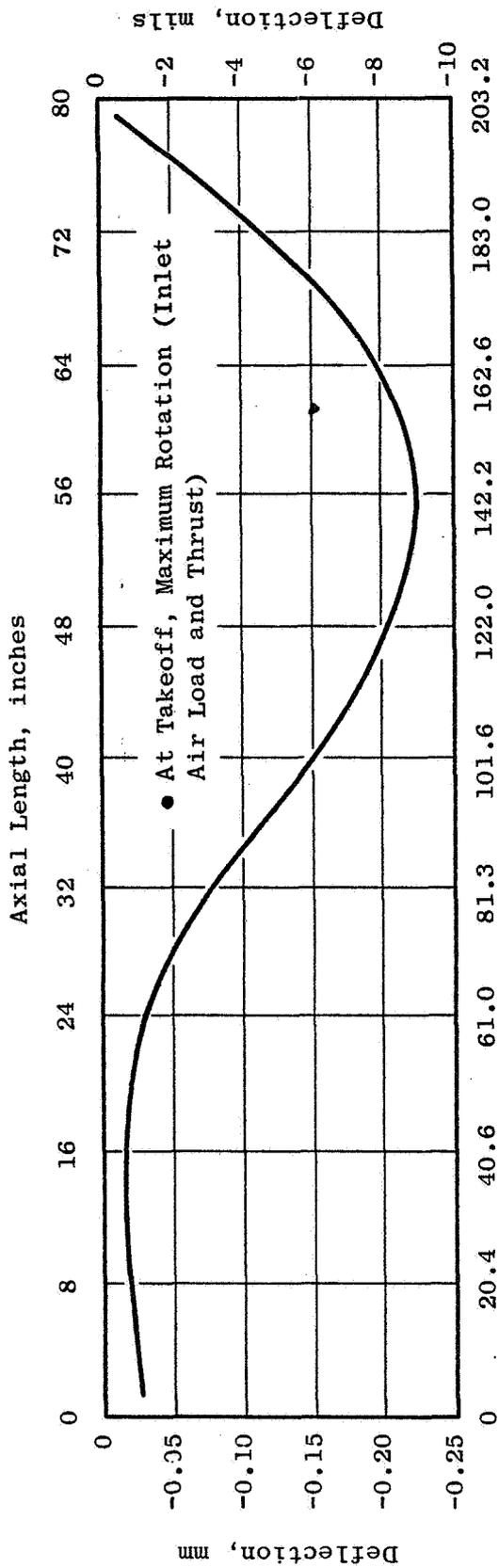


Figure 25. Preliminary E³ Ovalization.

The principal choices for accessory arrangement were:

- Fan case bottom-mounted aircraft and engine accessories.
- Core-mounted aircraft and engine accessories, thermally isolated in a shielded and vented compartment.
- Pylon-mounted aircraft accessories with engine accessories in the core compartment.

Evaluation of these systems included consideration of differences in installation drag and pressure losses, weight, maintenance cost, and the impact of these on mission fuel and DOC. Summaries of these results are shown in Tables XIX and XX. As these results tend to favor the core compartment arrangement, this was chosen as the baseline configuration for the E³ engine. However, the engine design retains the ability to be modified to other arrangements if desired by users.

Figures 26 and 27 show front and bottom views of the core-mounted accessory package chosen for the E³ FPS. A side view is shown on Figure 23.

6.4 AIRCRAFT COMPANY COMMENTS

In order to ensure that the E³ FPS design was consistent with the installation requirements of advanced commercial transports, the aircraft subcontracts with Boeing, Douglas, and Lockheed included reviews and critiques of the nacelle design. As a result, the major elements of the nacelle design, including choice of external aerodynamic lines, mount system, accessory arrangement, thrust reverser, and maintenance access provisions, were reviewed with the aircraft companies and many of their recommendations were incorporated in the design.

The Boeing Company expressed the view that the General Electric installation weight goals were optimistic for commercial service introduction in the late 1980's-early 1990's. It was their view that a substantial development effort that is not now in place would be required to achieve the technology required to meet those goals. General Electric concurs that the E³ nacelle weight goals require aggressive development work in order to achieve them. However, based on its experience in designing and building reversers for the TF39 and CF6 engines, the composite nacelle structure experience on the QCSEE program and ongoing programs in nacelle structural development, General Electric believes that the E³ technology projections are realistic.

Table XIX. Comparison of Accessory Location, Economic Summary.

Accessory Location	Fan Case	Core Compartment/	Pylon
% Δ SFC	0.3-0.7 Higher	Base	0-0.5 Higher
% Δ Block Fuel*	0.3-0.7 Higher	Base	0-0.5 Higher
Δ Weight - kg/Engine (lb/Engine)	22.7-56.7 Lighter (50-125) Lighter	Base	22.7-45.4 Heavier (50-100) Heavier
Δ Maintenance Cost, \$/EF hr	\$0.42-1.27 Lower	Base	\$3.11 Higher
% Δ DOC*	0.1-0.2 Higher	Base	0.2-0.3 Higher

*Based on Economic Trades for Domestic Short Range Aircraft

Table XX. Nonquantitative Factors in Accessory Package Selection.

Fan Case Mount

- Must be Designed to Comply with FAA Wheels-Up Landing Regulation.
- Accessory Fairing Tends to Block Reverser if Side-Mounted.
- Aircraft Asymmetry or Left-Hand/Right-Hand Engines if Side-Mounted
- Best Accessibility of Candidate Configurations

Core Compartment Mount

- Some Airline Disfavor from Maintenance, Accessibility Aspect

Pylon Mount

- Airline Disfavor from Accessibility Aspect
- May have Significant Drag Penalty in Close Nacelle-Wing Placement
- Access and Mounting Problem with DACO-Type Tail Engine Installation

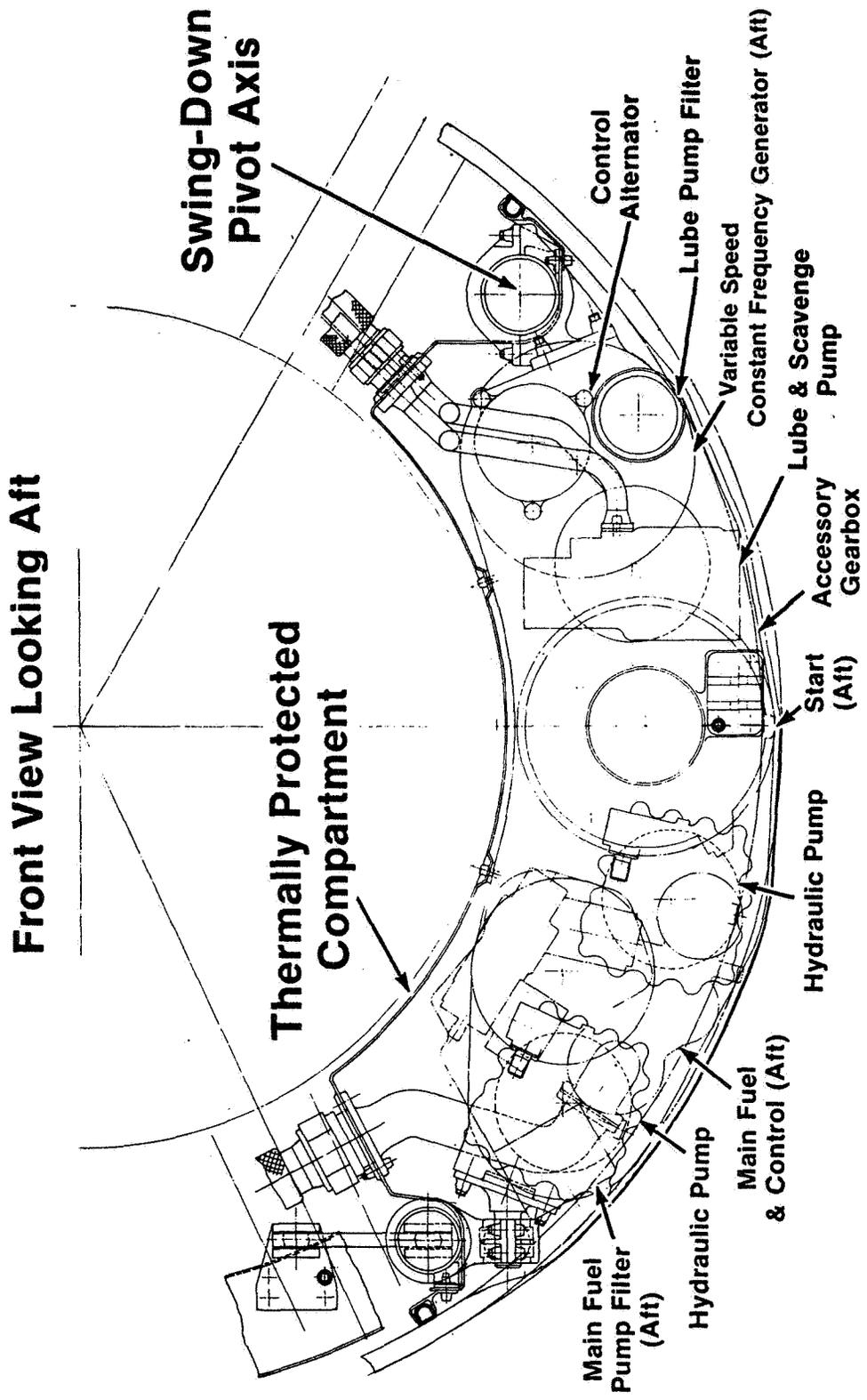


Figure 26. Accessory Package.

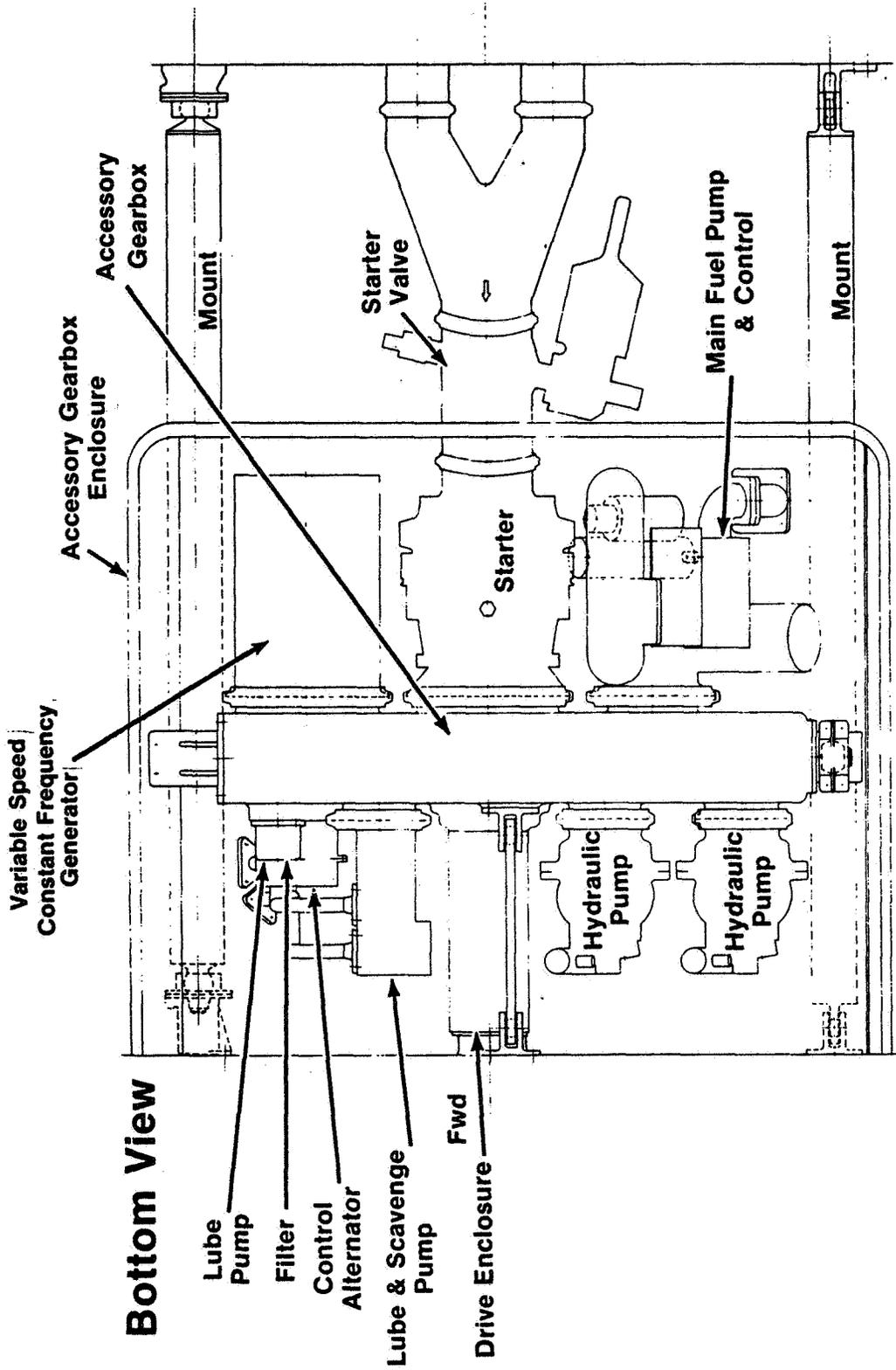


Figure 27. Auxiliary Package.

7.0 ENVIRONMENTAL CONSIDERATIONS

Part of the aircraft/engine integration effort provided for evaluation of the FPS design against the program goals for noise and exhaust emissions levels. For this purpose, aircraft noise contributions were estimated by the aircraft companies and combined with engine noise projections by General Electric. The exhaust emissions estimates were based on tests made with the double-annular combustor on other NASA-funded programs which are presented in References 5 and 6.

7.1 ACOUSTICS

Recent modifications to the FAR Part 36 noise regulations have significantly reduced the current noise limits for the next generation of commercial aircraft. In light of such changes, powerplants for these new generation aircraft must be designed employing advanced acoustic technology.

The Energy Efficient Engine (E³) acoustics program has, as its primary objective, the acoustic design and demonstration of an advanced engine which will meet FAR Part 36 (1978) with a minimum 3 EPNdB margin at each monitoring condition on an advanced aircraft. To ensure that this objective is achieved, the acoustics program will monitor the design and development of each major engine component, incorporating advanced low noise design features consistent with program performance goals. In addition, supporting component test programs are in place to evaluate the integral vane-frame design and the mixer from an acoustic point of view.

The acoustic design of the Energy Efficient Engine is summarized in Figure 28 which shows the pertinent low noise design features, including:

- High Bypass Ratio
- Low Velocity, Mixed Flow Jet
- Moderate Tip Speed Fan
- Integral Vane-Frame with Wide Blade-to-Vane Spacing
- Long Duct Nacelle
- Reduced Turbine Source Noise
- Advanced Bulk Absorber Acoustic Treatment

The basic cycle and bypass ratio resulted from previous fuel efficient engine studies for NASA (Reference 2). The acoustic design, while drawing on

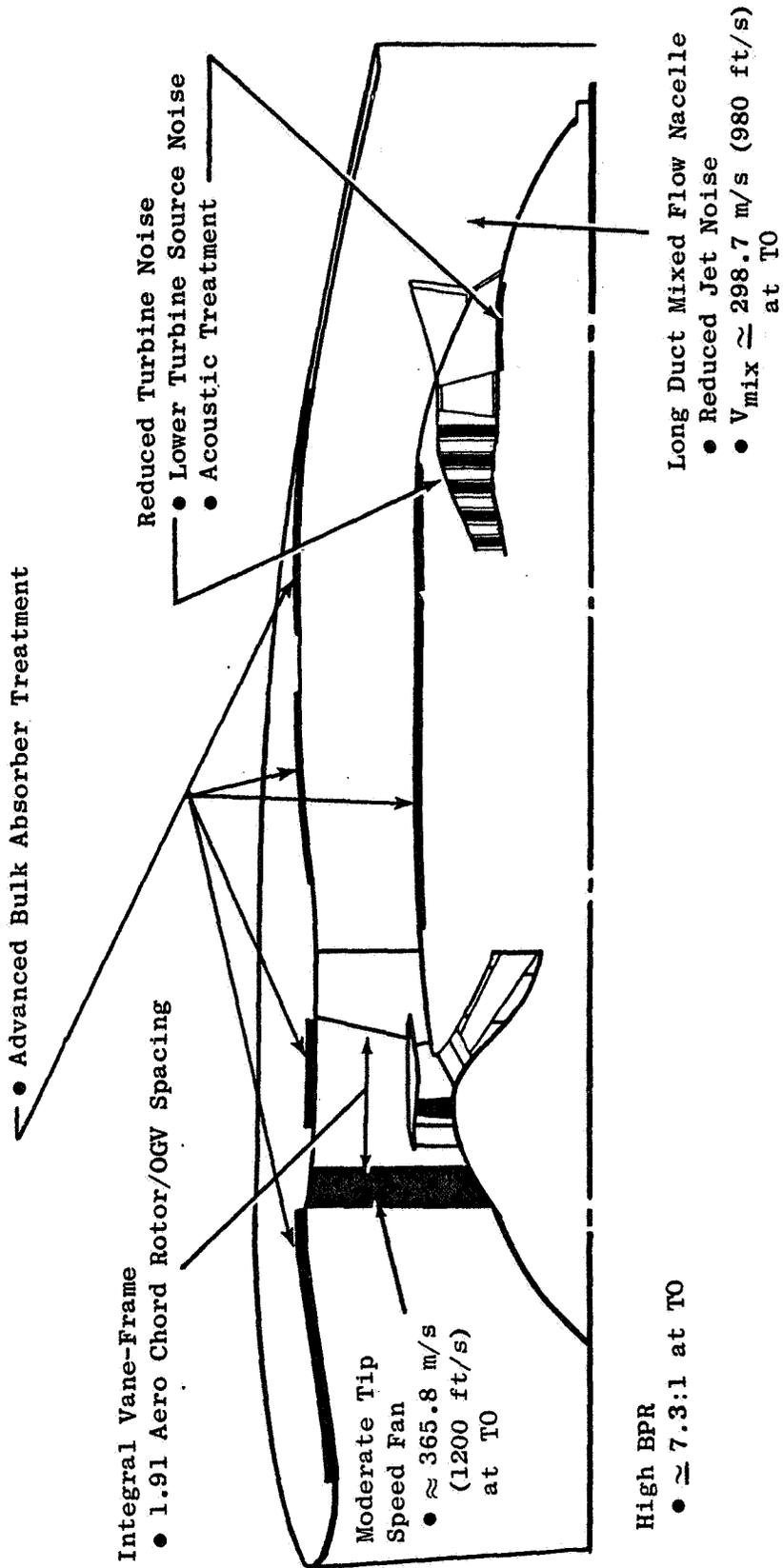


Figure 28. Energy Efficient Engine - Low Noise Design Features.

Table XXI. Flight Noise Estimates for E³ Advanced Aircraft.

	<u>Boeing Twin Jet</u>	<u>Lockheed Trijet</u>	<u>Lockheed Quadjet</u>	<u>Douglas Trijet</u>
TOGW - kg =	110,524	205,416	284,335	225,370
(1b) =	(243,660)	(452,857)	(626,841)	(496,850)
SLS F _n - N =	167,734	181,287	167,988	183,391
(1b) =	(37,710)	(40,757)	(37,767)	(41,230)
<u>TAKEOFF</u>				
Level EPNdB	88.7	93.7	98.3	94.4
Margin				
Re: FAR 36 (1978)	-5.0	-6.7	-5.9	-6.5
<u>SIDELINE</u>				
Level EPNdB	89.0	91.6	92.8	92.2
Margin				
Re: FAR 36 (1978)	-9.2	-8.9	-8.9	-8.7
<u>APPROACH</u> (With A/F Noise)				
Level EPNdB	99.3	100.8	101.1	97.9
Margin				
Re: FAR 36 (1978)	-2.6	-3.2	-3.9	-6.6
<u>AIRFRAME SUPPLIED</u> (Aircraft Noise)				
Level EPNdB	93.2	95.9	96.0	92.3

previous studies, evolved as the detailed characteristics of the advanced study aircraft became better defined. System noise studies were carried out in areas such as fan inlet and turbine to evaluate various methods of reducing total system noise and permit the various advanced engine aircraft systems to meet the program objective.

Incorporating the results of the various component noise reduction studies, the flight noise levels for various advanced aircraft powered by the FPS were estimated. The aircraft performance characteristics, including airframe noise at approach, were provided by the Boeing Commercial Aircraft Company and the Douglas Aircraft Company as part of a subcontract to the overall E³ program. These aircraft, therefore, represent a wide spectrum of design philosophies and a typical cross section of what is anticipated for the future needs of the commercial aircraft market. Table XXI shows the resultant system noise levels for each aircraft, and the associated margin relative to FAR 36 (1978), including that all aircraft meet FAR 36 (1978) with at least 3 EPNdB margin at each point, except the Boeing twin jet which has 2.6 EPNdB margin at approach.

Figure 29 shows a comparison of noise footprint contours for a typical current and future trijet aircraft near a major metropolitan airport. The advanced engine/aircraft system offers a 50% reduction in noise exposure area when compared to current aircraft. This reduction in noise exposure area significantly diminishes the community noise problem near high density airports.

In conclusion, incorporation of advanced low noise design features, including bulk absorber acoustic treatment, reduced turbine noise, and integral vane-frame, permit advanced aircraft powered by the General Electric Energy Efficient Engine to meet the FAR 36 (1978) noise regulation goal with a 3 EPNdB margin.

7.2 EXHAUST EMISSIONS

The overall objectives and goals of the combustion system for the E³ are to design and develop an advanced combustor configuration which will meet the E³ program goals for CO, HC, and NO_x emissions which are equivalent to the current requirements proposed by the Environmental Protection Agency (EPA) for Class T2 aircraft engines newly certified after 1981. These requirements are shown in Table XXII.

Table XXII. E³ Combustor - Emission Goals (EPA 1981 Standards) for Newly Certified Engines.

• Carbon Monoxide (CO)	} 1b/1000 lb Thrust - Hours Per Cycle	3.0
• Hydrocarbons (HC)		0.4
• Nitrogen Oxides (NO _x)		3.0
• Smoke	SAE Smoke Number	20.0

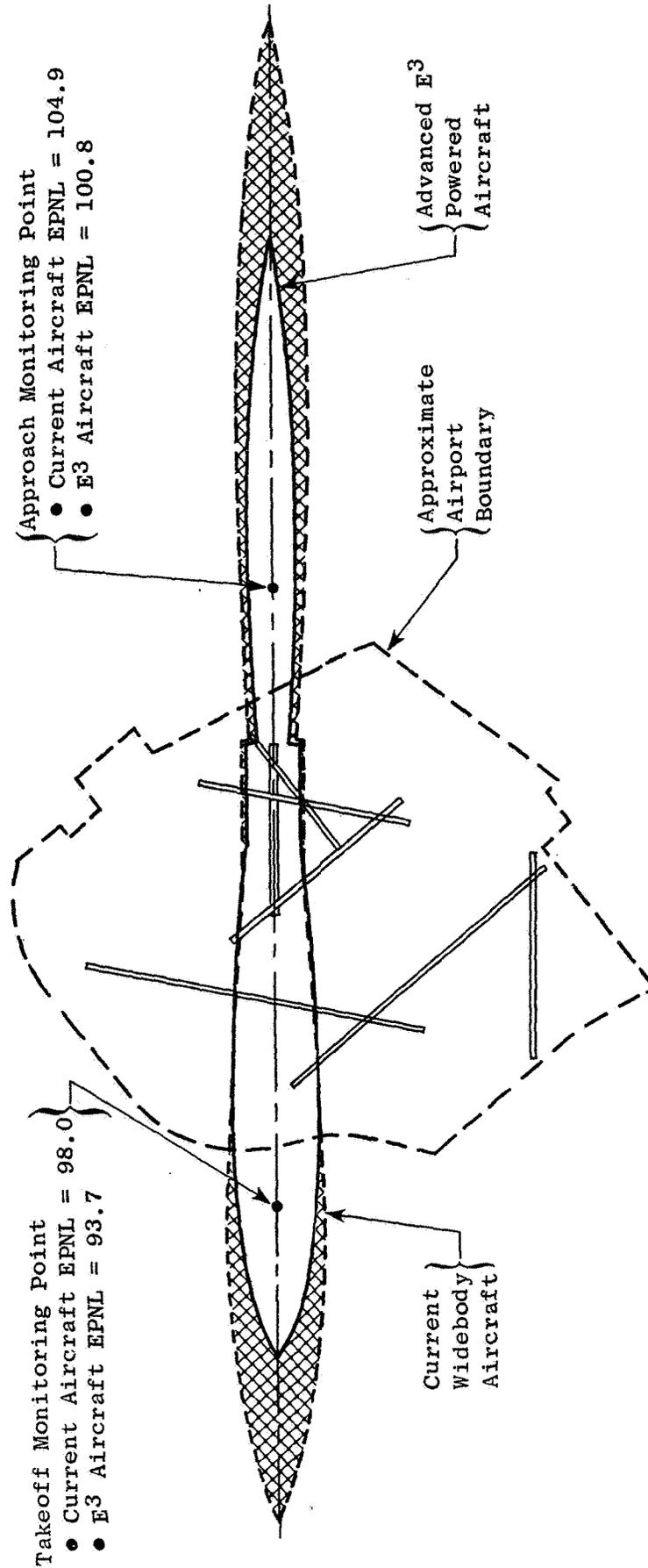


Figure 29. Noise Exposure Areas for Lockheed Trijet Near Chicago O'Hare Airport, 90 EPNdB.

The major emphasis in the combustion system design is directed at meeting the technically challenging emissions and life goals of the program; however, the combustion system also must provide the characteristics required for operation of a typical modern turbofan engine.

The performance parameters generally considered most important in a combustion system are shown in Table XXIII. It should be noted that not only is high combustion efficiency required at SLTO conditions for this design, but must be maintained at a level greater than 99.5% at idle in order to meet the CO and HC emissions goals of the program.

Table XXIII. E³ Combustor - Key Performance/Operating Requirements.

●	Combustion Efficiency @ SLTO (%)	99.5	(Min.)
●	Total Pressure Drop @ SLTO (%)	5.0	(Max.)
●	Exit Temperature Pattern Factor @ SLTO	0.250	(Max.)
●	Exit Temperature Profile Factor @ SLTO	0.125	(Max.)
●	Altitude Relight Capability, m (ft)	9,144 (30,000)	(Min.)
●	Ground Idle Thrust (% of SLTO)	6.0	(Max.)

The design condition generally selected for evaluating combustor performance is the sea level takeoff condition. However, in the case of emissions, the definition of design conditions is much more complicated. The EPA requirements are based on a prescribed landing-takeoff cycle consisting of specific operating times at idle, approach, climbout, and takeoff power settings. The emissions are then based on the total weight of pollutants emitted per unit of thrust per hour over the prescribed cycle. Therefore, the design conditions selected for evaluating emissions are directly related to the cycle conditions which exist at each of the prescribed power settings.

The predicted emissions levels for this double-annular dome combustor design are shown in Figure 30. These predictions were based on existing data developed in the NASA-GE ECCP (Reference 5) and NASA-GE QCSEE (Reference 6) double-annular dome combustor programs with appropriate adjustments made to the data to account for differences in combustor size and inlet operating conditions for the different engine cycle.

These estimates were based primarily on data from component tests of development combustors where dimensional tolerances and combustor inlet operating conditions can be controlled to the prescribed cycle conditions. For

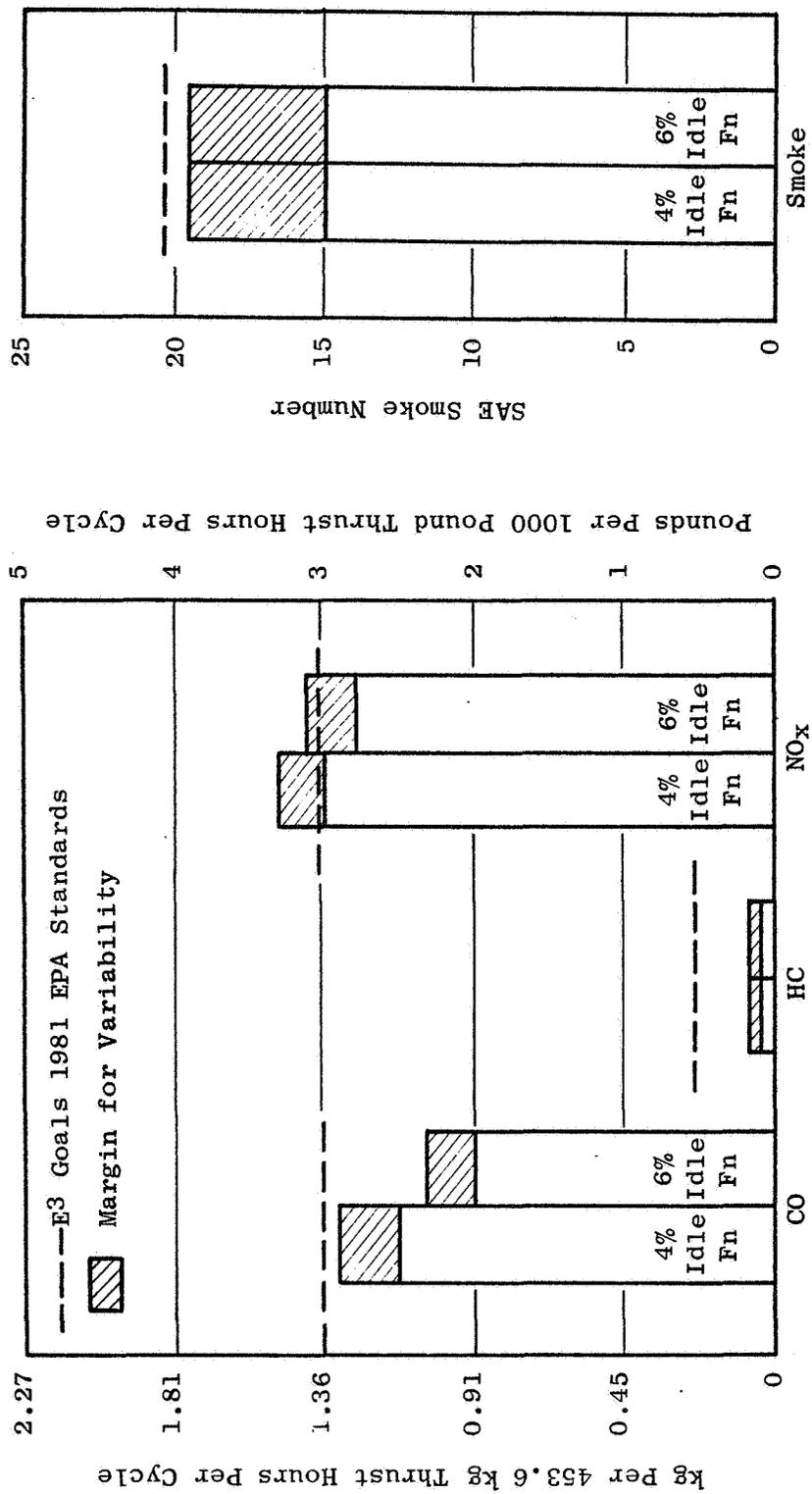


Figure 30. E3 Double Annular Combustor Predicted Emission Characteristics.

the case of a production engine, some added margin equivalent to 2 standard deviations is required to account for engine-to-engine variation as well as measurement variations. Based on variability data obtained at General Electric, a variability margin of about 20% is considered necessary for CO emissions, whereas a much larger variability margin of about 40% is considered necessary for HC emissions. The emissions of NO_x are somewhat more repeatable and are expected to vary only about 10% from the average level.

Even after applying these variability factors to the E³ emissions estimates, based on previous development test results, it is expected that, at completion of the initial E³ combustor development program, the CO and HC emissions levels will meet or closely approach the E³ program emissions goals with a prescribed ground idle thrust of 4% takeoff thrust. For ground idle operation with 6% takeoff thrust, ample margin would be available for both CO and HC emissions compared to the program goals. However, in the case of NO_x emissions, although the average engine would be expected to meet the goals, there would be a small percentage of engines under adverse conditions which would not meet the program goals. Smoke is expected to meet the standard even when the large variability in smoke levels is taken into consideration.

8.0 PROBABILITY OF MEETING PROGRAM GOALS

Probability of meeting program goals was assessed previously in Reference 2. The probability analysis dealt primarily with the projected performance of engine components and the resultant performance of the engine system. The analysis was updated to reflect the projected performance of the FPS and ICLS vehicles at the time of the November 1978 PDR, and expanded to include consideration of the probability of meeting the other program goals for DOC, noise, and emissions.

8.1 PERFORMANCE GOAL

The probability assessment of the E³ engine performance level is shown in Figure 31. Two curves are shown; one for the programmed effort culminating in the running of the ICLS vehicle in 1982, and one projected for full development and certification in the late 1980's-early 1990's. These curves show a 90% probability of achieving the ICLS performance projection of 12.2% sfc improvement in the course of the current E³ program, and an equal certainty of achieving the FPS projection of 14.6% in a follow-on full-scale development program.

8.2 WEIGHT, PRICE, AND MAINTENANCE PROJECTIONS

Figures 32 through 34 show the probability assessment for achieving the FPS weight, price, and maintenance cost projections through a full-scale development program. Curves for the ICLS are not shown, as these goals for a service-type engine can only truly be demonstrated by proceeding to full development and certification.

8.3 DOC GOAL

The probabilities of meeting performance, weight, price, and maintenance projections can be combined to assess the probability of achieving the FPS DOC projections, using DOC sensitivity factors. As has been shown, the DOC improvement for E³ technology is dependent strongly on average flight distance. So, too, are the sensitivities of DOC to performance, weight, price, and maintenance cost. To simplify the projected probability of meeting the E³ program goal of 5% DOC improvement for a fully developed service engine, the DOC sensitivities were applied for a short-range domestic twin fan, a medium-range domestic trifan, and a long-range intercontinental quadfan. These results are shown in Figure 35. This presents the probability of each of these aircraft to deviate from their FPS projected Δ DOC. When these deviations are superimposed on the FPS projection for each aircraft, the result is shown in Figure 36.

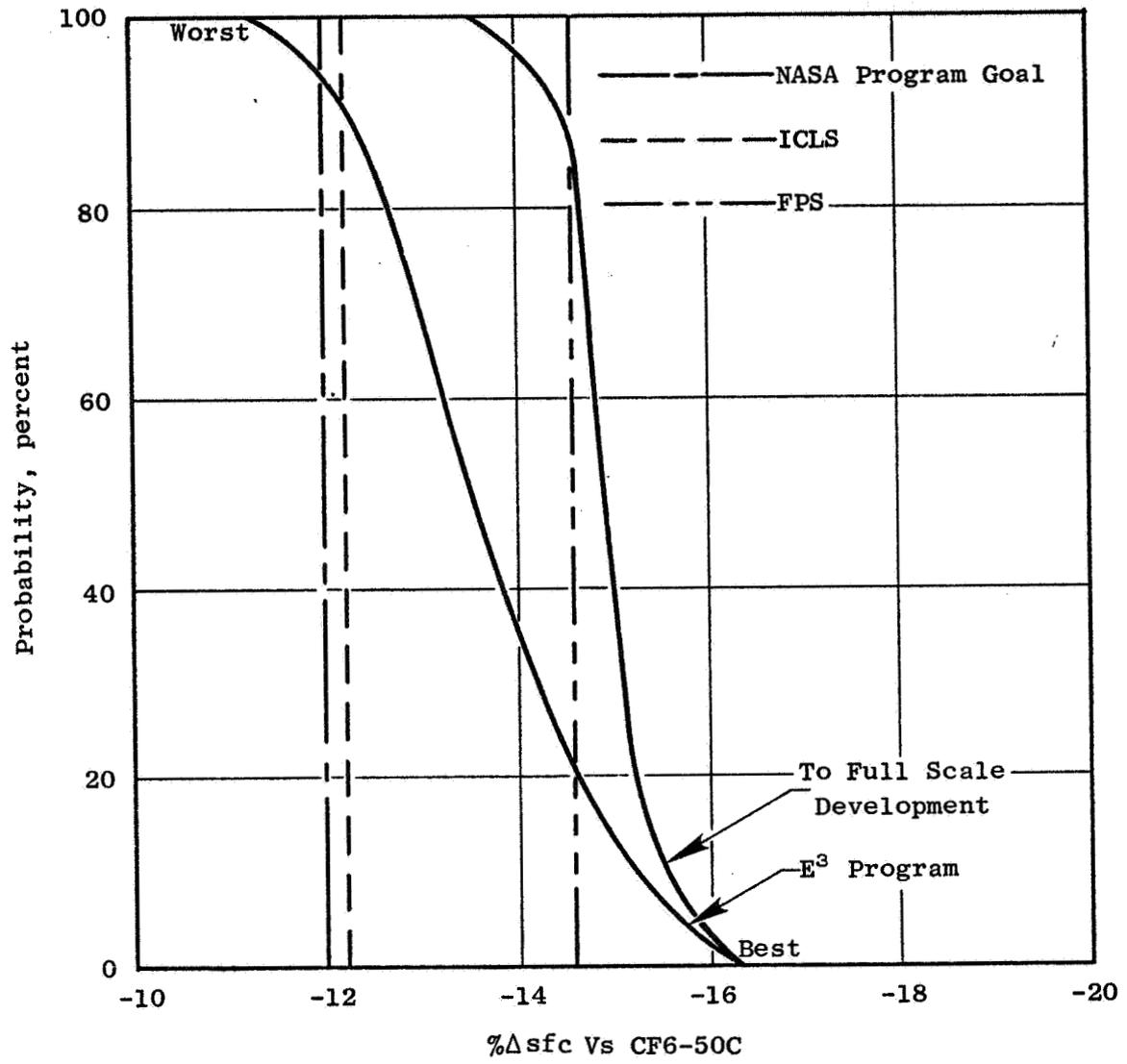


Figure 31. Probability of Achieving SFC Goals.

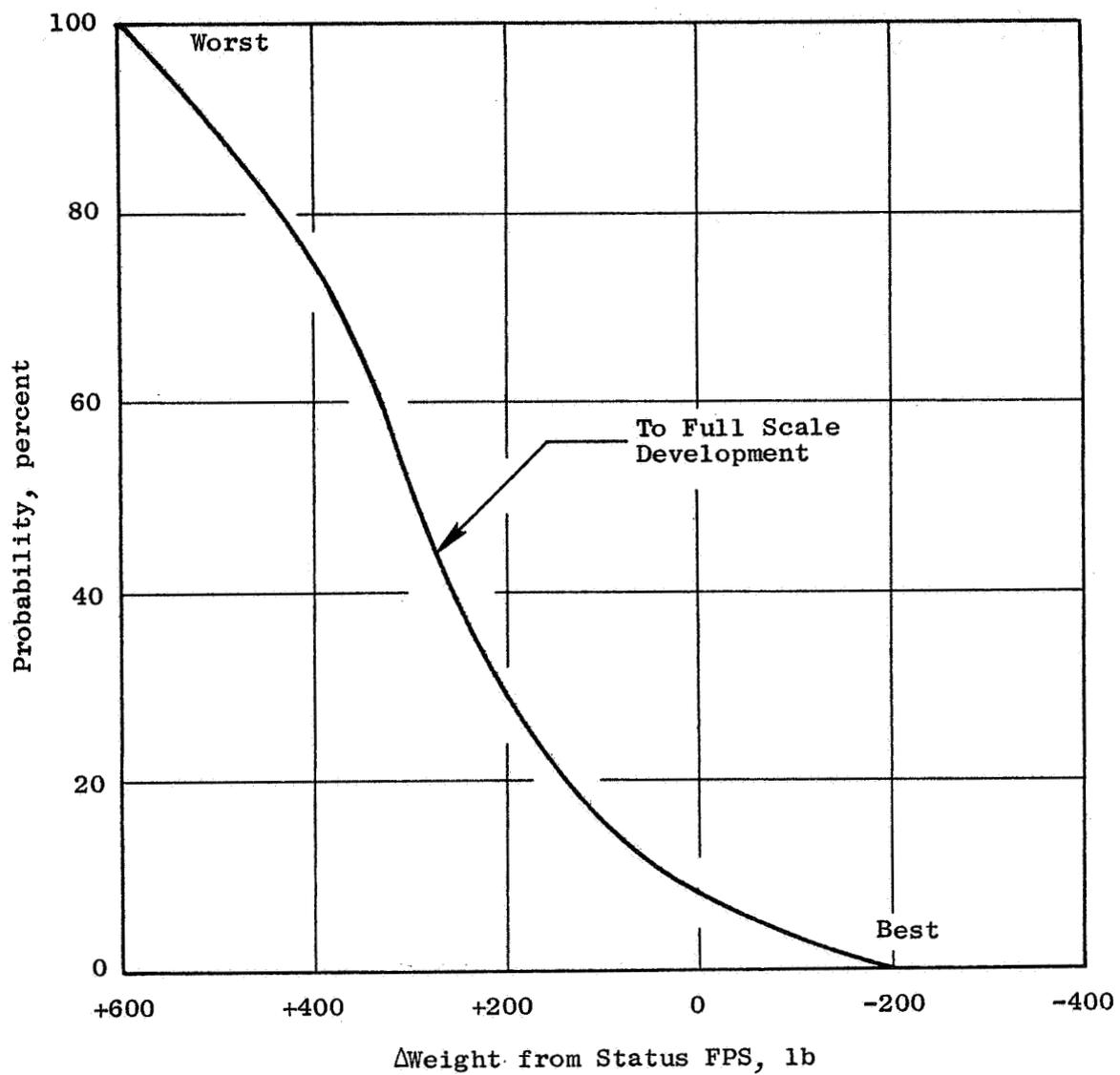


Figure 32. Probability of Achieving FPS Weight Projection.

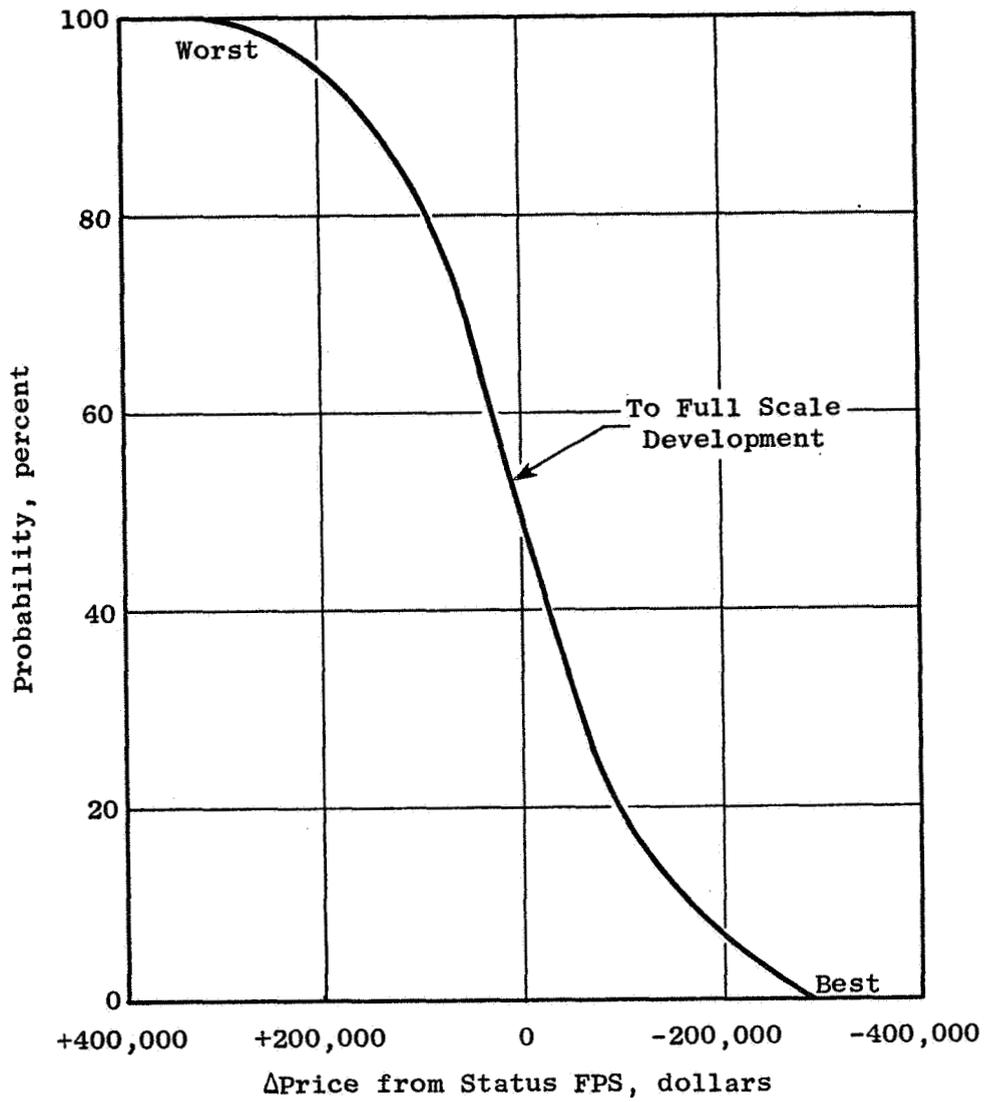


Figure 33. Probability of Achieving FPS Price Projections.

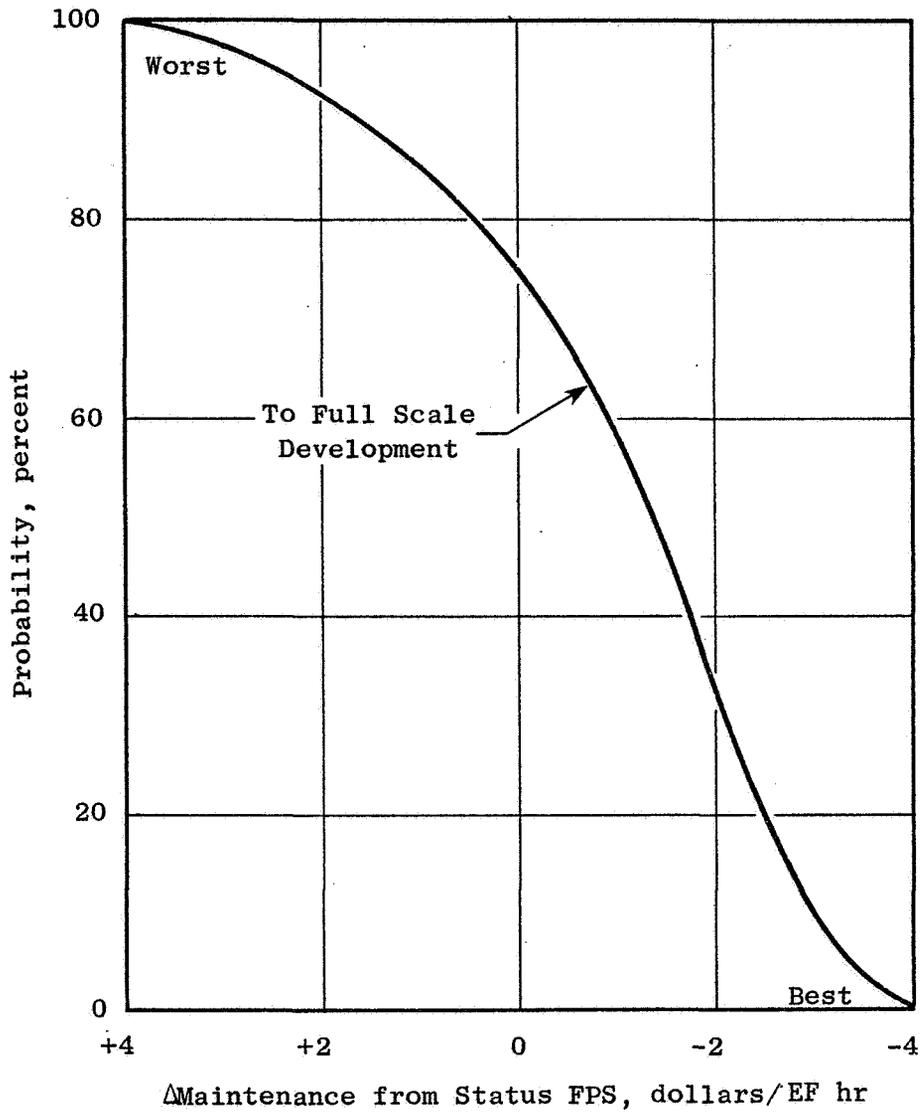


Figure 34. Probability of Achieving FPS Maintenance Cost Projections.

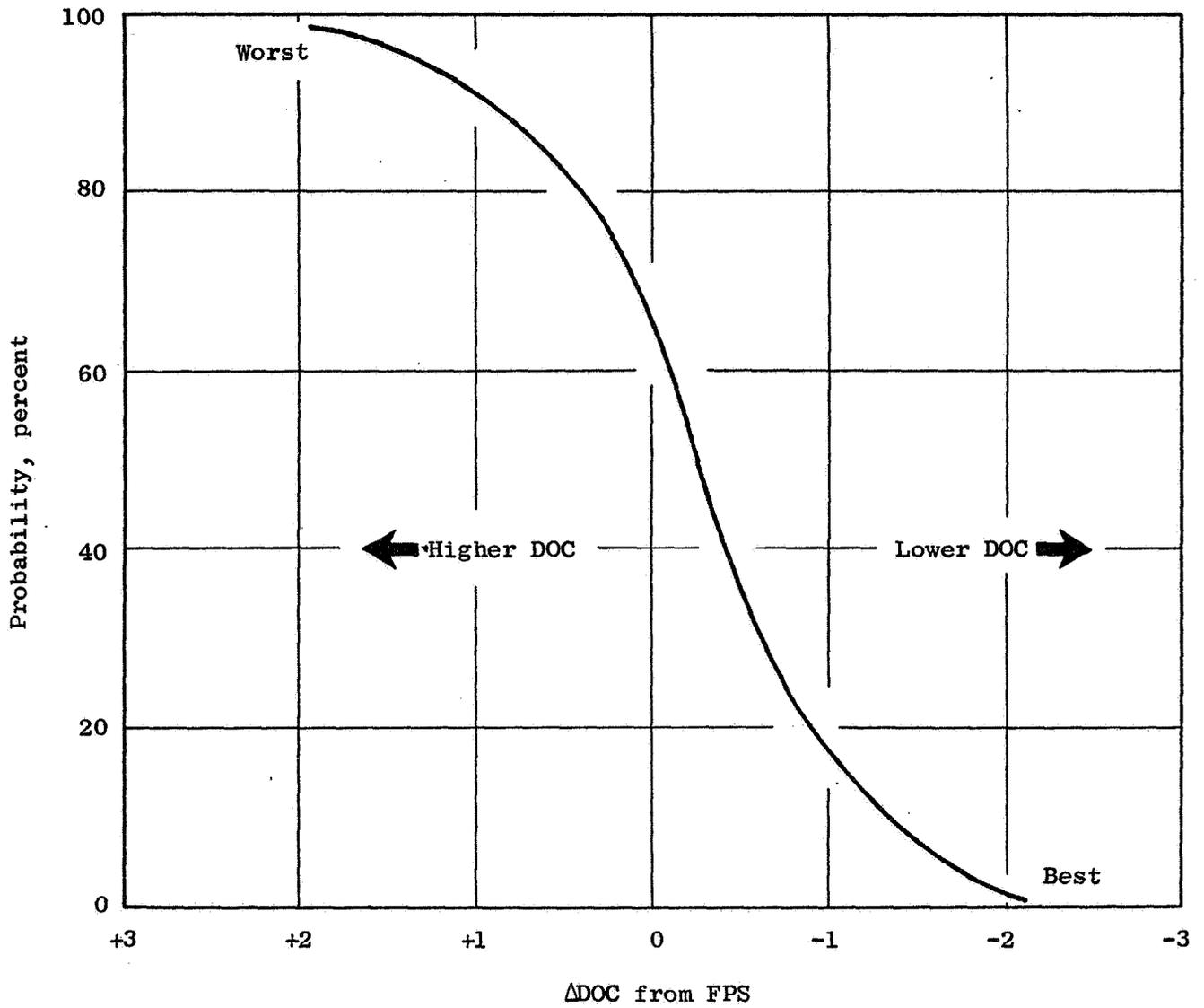


Figure 35. Probability of Meeting Projected DOC.

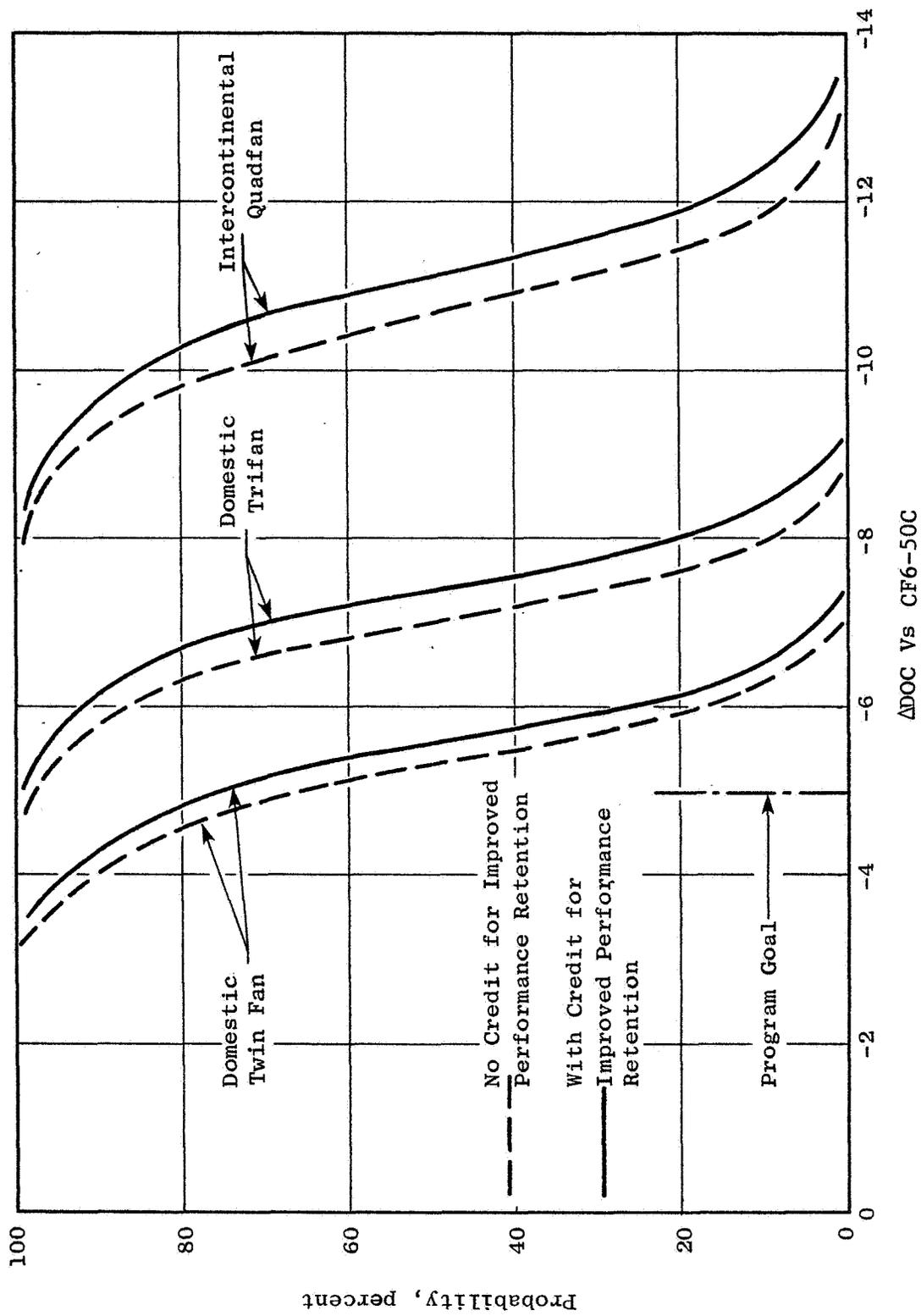


Figure 36. Probability of Meeting DOC Goal.

8.4 NOISE GOALS

The probability of meeting the noise goals has been calculated for the various aircraft used in the E³ acoustics evaluations. The calculation assumed standard deviations of 1.3, 1.4, and 1.7 EPNdB at takeoff, sideline, and approach, respectively. These are based on past experience and include:

- Measurement scatter
- Treatment effectiveness
- Air attenuation
- Prediction accuracy
- Source features
- Sideline shielding.

A Monte Carlo simulation (Reference 7) was further used to model noise level distribution. The resulting probabilities of meeting FAR 36 (1978) Noise Rules are shown in Table XXIV.

Table XXIV. Probabilities of Meeting FAR 36 (1978) Noise Rule Without Trades.

<u>Aircraft</u>	<u>Probability of Certification Without Trades (%)</u>
Boeing Twin Jet	94
Lockheed Trijet	97
Lockheed Quadjet	99
Douglas Trijet	99

8.5 EMISSIONS GOALS

Estimated probabilities for meeting emission goals are presented in Figures 37 through 40. These curves were developed using the following standard deviations:

CO	10%
HC	20%
NO _x	5%
Smoke	12.5%

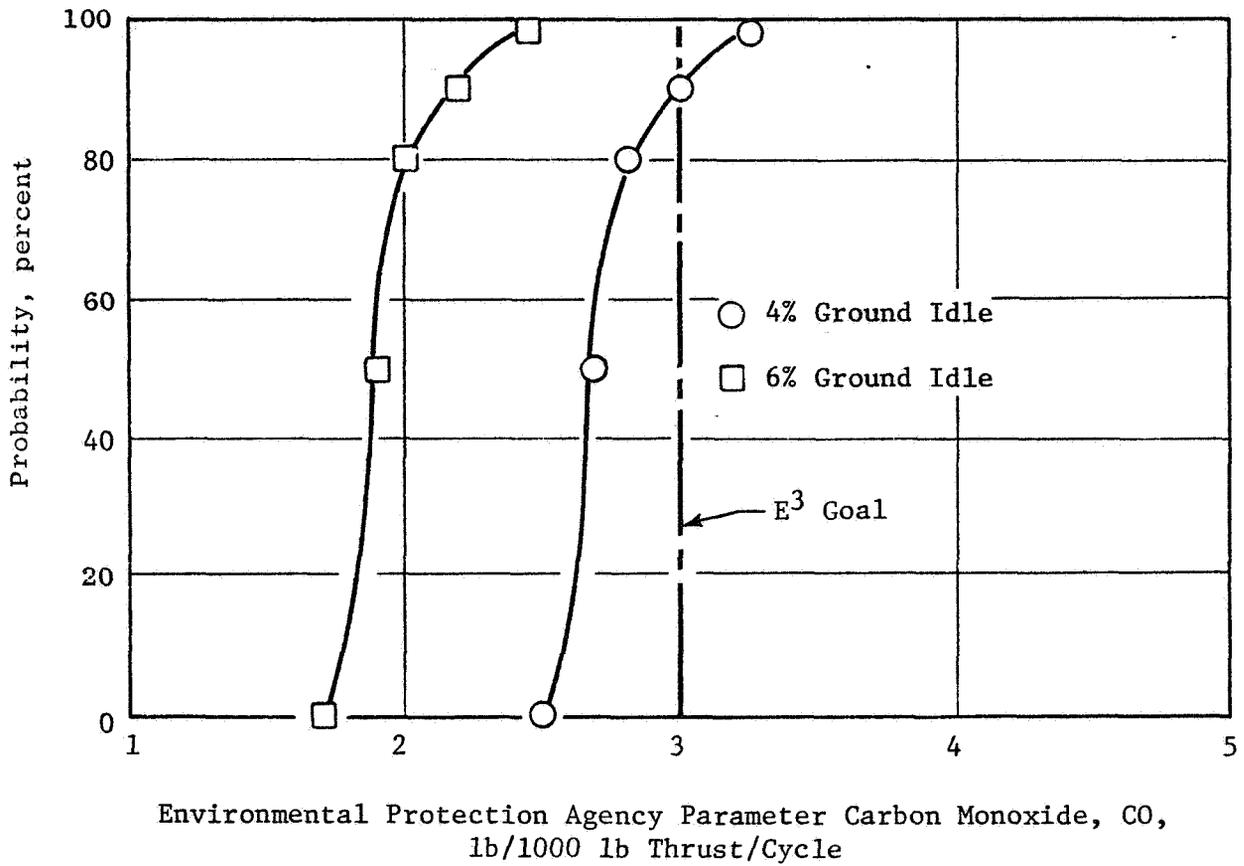
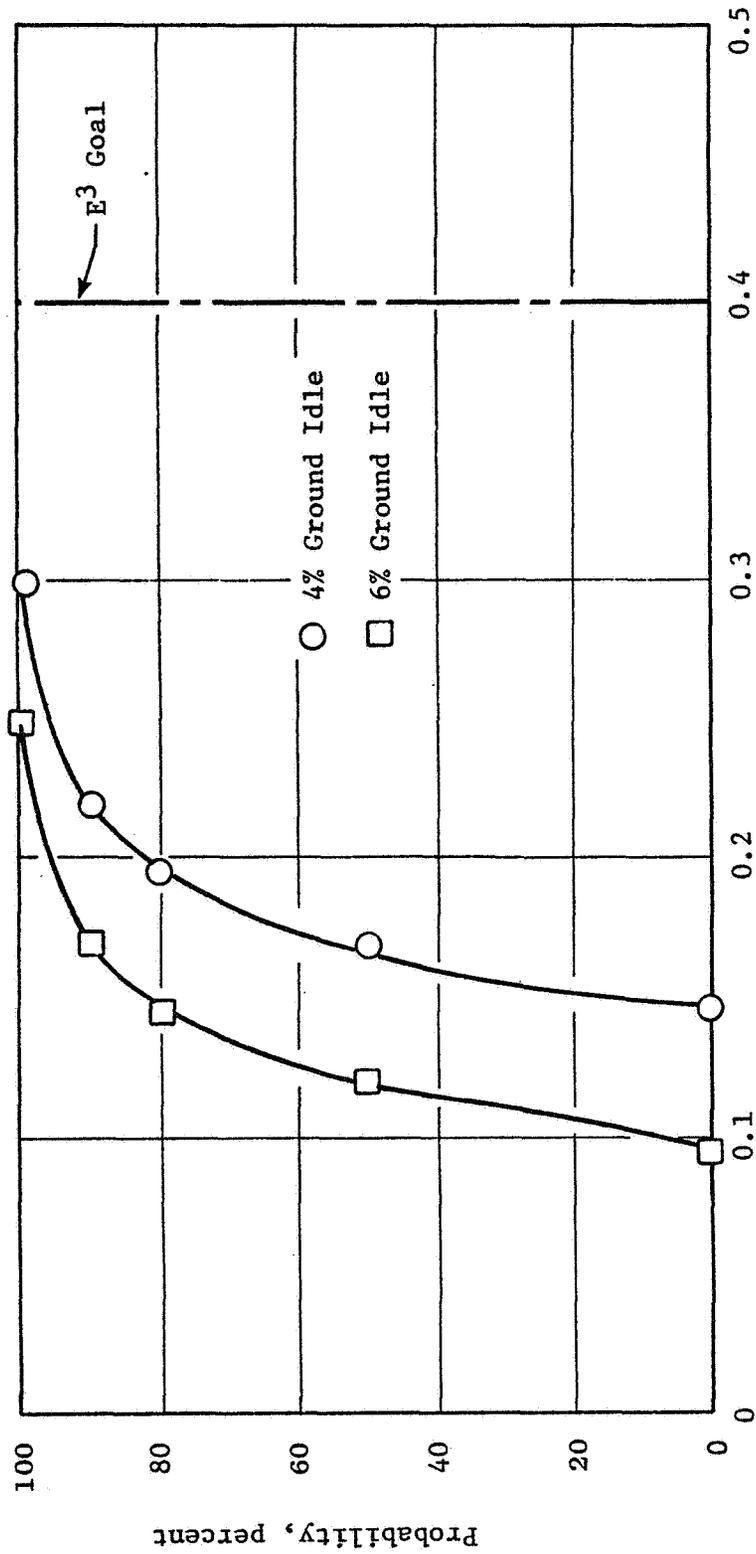


Figure 37. Probability of Meeting CO Emissions Goal.



Environmental Protection Agency Parameter Unburned Hydrocarbon,
 HC, lb/1000 lb Thrust/Cycle

Figure 38. Probability of Meeting HC Goal.

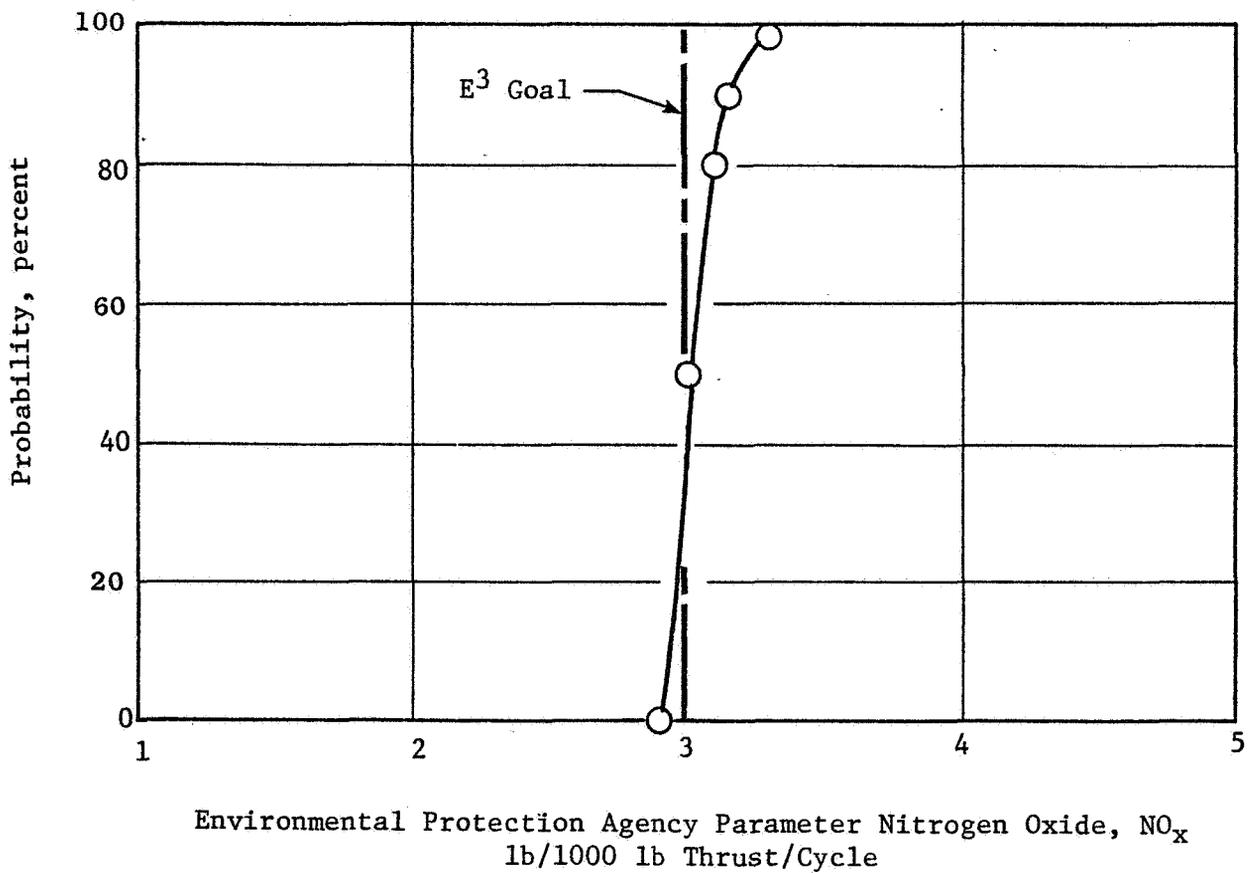


Figure 39. Probability of Meeting NO_x Goal.

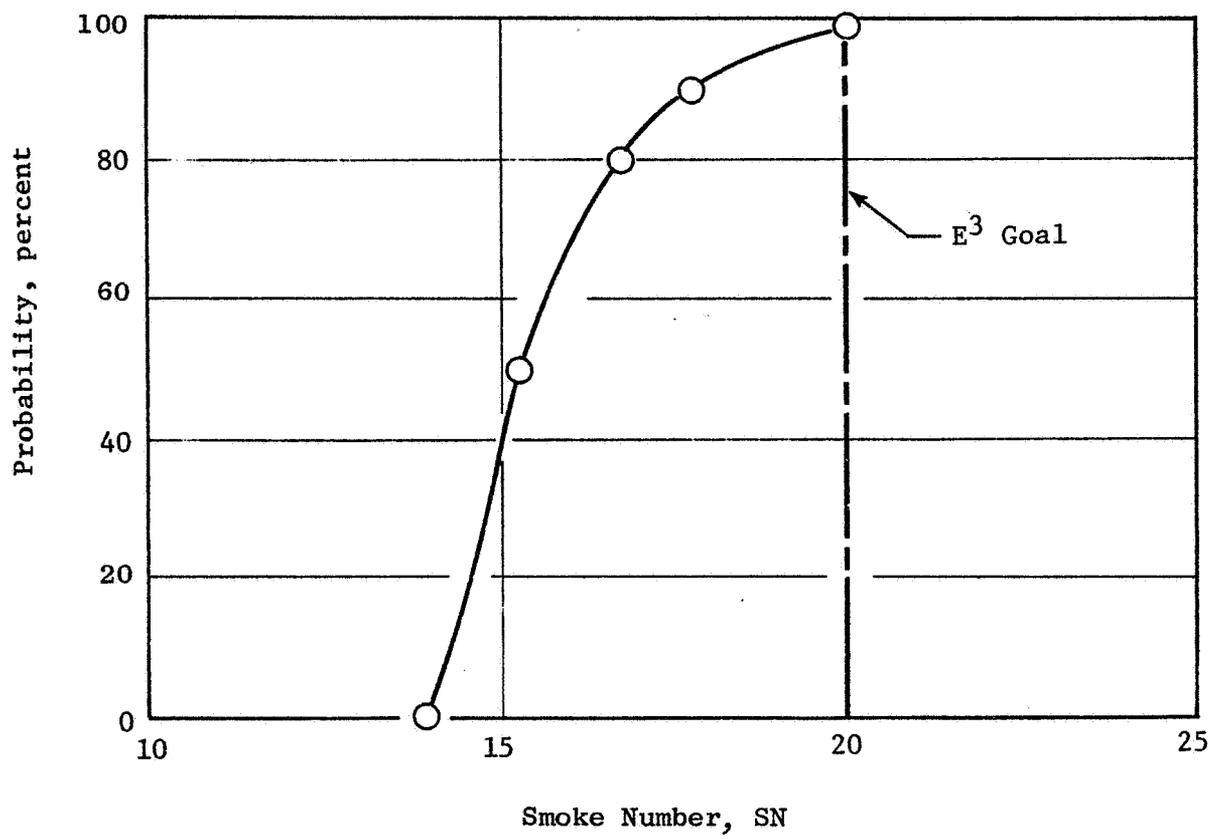


Figure 40. Probability of Meeting Smoke Goal.

The above standard deviations were derived from available engine and component test data and include engine-to-engine variations and measurement variations.

The results of the study indicate (Figure 37) that the probability of meeting the CO goal is 90% for a 4% ground idle requirement and 100% for a 6% ground idle requirement. The HC and smoke goals are expected to be met with 100% probability as shown in Figures 38 and 40. The probability of meeting the NO_x goal, however, is estimated to be 50% (Figure 39).

9.0 CONCLUSIONS

Preliminary design of the E³ Flight Propulsion System has indicated that all NASA program goals will be met or exceeded. However, the noise level margin on the Boeing twin jet was 2.6 EPNdB instead of the desired 3, and the NO_x margin for the double annular combustor is slightly less than desired for production variability. An item-by-item discussion follows.

9.1 INSTALLED SFC

The installed sfc of the FPS, without customer bleed or power extraction, was projected to be 14.2% better than the baseline CF6-50C versus the NASA goal of 12%. In addition, with customer bleed extraction, the use of a regenerative fuel heater was projected to provide an additional net 0.4% improvement relative to the baseline engine, for a total potential benefit of 14.6%.

The improvement in sfc translated into improvements in mission fuel burned of 15.5 to 21.7% over the range of study aircraft and missions.

9.2 DETERIORATION

The NASA goal is a 50% reduction in performance deterioration rate in service relative to the CF6-50C. It was projected this goal will be met. This translated into an equivalent 1% improvement in average, in-service sfc over the usage life of the engine. Credit for this improvement raised the mission fuel savings to 16.3 to 22.9% over the range of study aircraft and missions.

9.3 DIRECT OPERATING COST

The NASA goal was a 5% improvement in DOC. The improvements shown were 5 to 12.3% depending on the study aircraft, mission, and whether credit was given for improved performance retention.

9.4 NOISE

The NASA goal was to meet FAR 36 (1978) standards. Acoustic evaluations showed the E³ engine in the advanced study aircraft has at least 3 EPNdB margin relative to the standard, except for the Boeing twin jet which has 2.6 EPNdB margin.

9.5 EMISSIONS

The NASA goal was to meet the EPA-proposed 1981 Standard. The E³ engine was projected to meet CO, HC, and Smoke requirements with margin and NO_x with less margin than is needed for production engine variation.

9.6 COMMERCIAL ENGINE PRACTICES

The NASA goal was that the design had to meet commercial operating requirements. The E³ Flight Propulsion System was designed according to General Electric commercial design practices to meet this goal.

REFERENCES

1. Johnston, R.P., et al., "Energy Efficient Engine Flight Propulsion System, Preliminary Analysis and Design Report," Contract NAS3-20643, CR-159583, February 1979.
2. "Energy Efficient Engine Preliminary Design and Integration Studies," Contract NAS3-20627, CR-135444, September 1978.
3. Neitzel, R.E., Hirschkron, R., and Johnston, R.P., "Study of Turbofan Engines for Low Energy Consumption," Contract NAS3-19201, CR-135033, August 1976.
4. "Study of Unconventional Aircraft Engines Designed for Low Energy Consumption," Contract NAS3-19519, CR-135136, December 1976.
5. Gleason, C.C., Rogers, D.W., and Bahr, D.W., "Experimental Clean Combustor Program," Contract NAS3-18551, CR-134971, August 1976.
6. Bahr, D.W., Burrus, D.L., and Sabla, P.E., "Quiet Clean Short-haul Experimental Engine (QCSEE) Double Annular Clean Combustor Technology Development," Contract NAS3-18021, CR-159483, July 1978.
7. Charles, Lipson and Sheth, Narendra J., Statistical Design and Analysis of Engineering Experiments, McGraw-Hill Inc., 1973.

SYMBOLS AND ABBREVIATIONS

A/F	Airframe
AMAC	Advanced Multistage Axial Flow Compressor
BPR	Bypass Ratio
CD&I	Component Development and Integration
cm	Centimeter
CO	Carbon Monoxide
D _H L	Nacelle Highlight Diameter
D _{max}	Nacelle Maximum Diameter
DOC	Direct Operating Cost
DS	Directionally Solidified
E ³	Energy Efficient Engine
ECCP	Experimental Clean Combustor Program
ECS	Environmental Control System
EPA	Environmental Protection Agency
EPAP	EPA Parameter (measure of emissions)
EPNdB	Effective Perceived Noise in Decibels
EPNL	Effective Perceived Noise Level (in Decibels)
FADEC	Full Authority Digital Electronic Control
FAR	Federal Airworthiness Regulations
FOD	Foreign Object Damage
FPR	Fan Pressure Ratio
FPS	Flight Propulsion System
fps	Feet per Second
ft.	Feet

SYMBOLS AND ABBREVIATIONS (Continued)

gal.	Gallon
HC	Hydrocarbon
HPC	High Pressure Compressor
HPT	High Pressure Turbine
hr	Hour
ICLS	Integrated Core - Low Spool Vehicle
in.	Inch
IOC	Indirect Operating Cost
kg	Kilogram
km	Kilometer
kn	Knots
K \$	Thousands of Dollars
l	Liter
lb	Pound
LPT	Low Pressure Turbine
m	Meter
MCL	Maximum Climb
M	Mach Number
N	Newton
NO _x	Oxides of Nitrogen
nmi	Nautical Mile
OEW	Operating Weight Empty
O _{WE}	Operating Weight Empty
PDR	Preliminary Design Review

SYMBOLS AND ABBREVIATIONS (Concluded)

PD&I	Preliminary Design and Integration
QCSEE	Quiet Clean Short-haul Experimental Engine
ROI	Return on Investment
sfc	Specific Fuel Consumption
SLS	Sea Level Static
SLTO	Sea-Level-Takeoff
SN	Smoke Number
STEDLEC	Study of Turbofan Engine Designed for Low Energy Consumption
St Mi.	Statute Mile
TO	Takeoff
TOGW	Takeoff Gross Weight
T/R	Thrust Reverser
USTEDLEC	Unconventional STEDLEC
VSCF	Variable Speed Constant Frequency (Generator)
W_{AF}	Airframe Weight
W_f	Fuel Weight
η	Efficiency
Δ	Change in

APPENDIX A

Appendix A is a reproduction of report D6-48069 supplied by Boeing Aircraft Company as their contribution to aircraft integration. The format and printing have been altered to coordinate with this publication.

**BOEING COMMERCIAL AIRPLANE COMPANY
A DIVISION OF THE BOEING COMPANY
SEATTLE, WASHINGTON**

**ENERGY EFFICIENT ENGINE
AND
AIRPLANE INTEGRATION STUDY**

**PURCHASE ORDER 200-4XX-14N43049
UNDER
NASA CONTRACT NAS3-10643**

FOR

**GENERAL ELECTRIC COMPANY
AIRCRAFT ENGINE GROUP
EVENDALE, OHIO**

C-2

APPENDIX A

TABLE OF CONTENTS

<u>Section</u>		<u>Page</u>
1.0	SUMMARY	95
2.0	INTRODUCTION	98
3.0	SYMBOLS AND ABBREVIATIONS	100
4.0	AIRPLANE AND MISSION DEFINITION	101
4.1	Mission Selection	101
4.2	Advanced Technology Features	103
4.2.1	Aerodynamics	103
4.2.2	Weight and Structures	103
4.3	Airplane Geometry Guidelines	103
4.4	Engine Installation	103
4.4.1	Engine Placement	103
4.4.2	Nacelle Drag	111
4.4.3	Engine Bleed and Power Extraction	111
4.5	Preliminary Airplane Configuration	111
4.5.1	Airplane Description	111
4.5.2	Engine Description	111
4.6	Procedures for Determining Direct Operating Cost (DOC) and Return on Investment (ROI)	113
4.6.1	Direct Operating Cost	113
4.6.2	Return on Investment	113
5.0	AIRPLANE PERFORMANCE AND SENSITIVITY	119
5.1	Airplane Sizing	119
5.1.1	Airplane Performance and Characteristics	119
5.1.2	Airplane Weight	119
5.1.3	Airframe Noise and FAR 36 Flight Conditions	119
5.1.4	Engine and Airframe Noise	130
5.1.5	Airplane Drawings of Sized Airplane	123
5.1.6	Airplane Drag Polars	123

APPENDIX A

TABLE OF CONTENTS (Concluded)

<u>Section</u>		<u>Page</u>
	5.2 Airplane Sensitivity Factors	123
	5.3 Takeoff Gross Weight and Fuel Burned Comparison	123
	5.4 Typical Mission DOC and ROI	130
6.0	AIRCRAFT ENGINE INTEGRATION	138
	6.1 Nacelle Arrangement and Construction	138
	6.2 Airframe Accessory Requirements and Location	141
	6.3 Maintainability, Accessibility, and Safety Requirements	146
	6.4 Fuel Heater System	146
	6.5 Nacelle Mount System	146
	6.6 Nacelle Design	149
	6.7 Nacelle Weight Evaluation	157
7.0	CONCLUSIONS AND RECOMMENDATIONS	164
	REFERENCES	165

APPENDIX A
LIST OF ILLUSTRATIONS

<u>Figure</u>		<u>Page</u>
A-1.	Domestic Passenger Jet Fuel Consumption as a Function of Range.	102
A-2.	Typical Mission Profile.	104
A-3.	Energy Efficient Engine Configuration (General Arrangement) - Model 768-865.	105
A-4.	Airplane Geometry Guidelines.	107
A-5.	Nacelle Placement Guidelines.	108
A-6.	Engine Placement Ground Rules.	109
A-7.	Installation Comparison.	110
A-8.	Airplane Bleed Airflow Requirement.	112
A-9.	F _w Factor for Crew Pay.	116
A-10.	Crew Utilization.	117
A-11.	Airplane Performance Trades.	120
A-12.	Energy Efficient Engine Configuration (General Arrangement) - Model 768-869.	126
A-13.	Energy Efficient Engine Configuration (General Arrangement) - Model 768-868.	127
A-14.	Block Fuel Comparison.	129
A-15.	November 1978 PDR Status Fuel Saving.	131
A-16.	Percent Block Fuel by Mission Profile Segment.	132
A-17.	November 1978 PDR Status Direct Operating Cost Comparison.	136
A-18.	General Electric Energy Efficient Nacelle.	139
A-19.	Thrust Reverser Concerns.	142
A-20.	Hydraulic Loads.	143
A-21.	Electric Loads.	144
A-22.	E ³ Fuel Heater System (GE).	147
A-23.	E ³ Fuel Heater System (Boeing Modification).	148
A-24.	Long Duct Nacelle Mount.	150
A-25.	Airloads - Maximum Takeoff.	152
A-26.	Airloads - Maximum Dynamic Pressure.	153
A-27.	Airloads - 0-deg Flap, 1.3 V _{stall} .	154
A-28.	Airloads - 10-deg Flap, 1.3 V _{stall} .	155

APPENDIX A
LIST OF TABLES

<u>Table</u>	<u>Page</u>
A-I. Airplane Characteristic and Performance.	96
A-II. Nominal Noise Estimates.	97
A-III. Advanced Airframe Structure for E ³ Studies.	106
A-IV. DOC Elements.	114
A-V. Basic Characteristics of Boeing 1977 Coefficients.	114
A-VI. Domestic Direct Operating Cost Formulas.	115
A-VII. Return on Investment Method.	118
A-VIII. Airplane Characteristics and Performance.	121
A-IX. Weight Statement for General Electric E ³ Airplanes.	122
A-X. Flight Conditions for FAR 36 Noise Calculations - 77° F.	124
A-XI. Nominal Noise Estimates.	125
A-XII. Domestic Airplane Sensitivity Factors - Model 768-868.	128
A-XIII. Domestic Airplane Sensitivity Factors - Model 768-868.	128
A-XIV. Initial Economic Analysis.	131
A-XV. November 1978 PDR Status Economic Analysis.	134
A-XVI. November 1978 PDR Status Economic Analysis (Boeing Engine Price).	135
A-XVII. E ³ Engine Gearbox Location.	145
A-XVIII. Nacelle and Strut Design Load Factors.	151
A-XIX. Engine Nacelle Airloads.	156
A-XX. GE Advanced Nacelle Evaluation.	158
A-XXI. General Electric Energy Efficient Engine Estimated Weights.	159
A-XXII. Reduction Factors for Advanced Technology Application.	160
A-XXIII. Boeing Weight Analysis Summary.	161

1.0 SUMMARY

NASA objectives for the Energy Efficient Engine (E³) program are to develop technology to achieve: (1) a 12% reduction in cruise specific fuel consumption, (2) 5% reduction in direct operating cost (DOC), and (3) reduction of engine performance deterioration common to current technology high-bypass-ratio engines. Future noise and emission requirements must also be met. Boeing's role in the E³ program was first to help determine if the GE Advanced Technology Engine (ATE) met NASA performance goals and secondly to ensure that E³ nacelle met airplane requirements and objectives, aircraft manufacturer's design practice, and FAA certification requirements. In this capacity, Boeing defined an advanced technology airplane and provided mission performance, economics, noise, and nacelle assessment data with E³ and current technology engines installed.

An advanced technology one-stop transcontinental airplane was selected for the Boeing study. Scalable ATE and CF6-50C engine data supplied by GE were cycled with the airplane to achieve the most fuel-efficient and economical airplane for each engine installation. Table A-I shows the airplane design point performance and characteristics. The design-mission fuel burned for the ATE was 18.3% lower than for the CF6-50C engine. Based on GE supplied maintenance cost and engine price data, the ATE also had 6% lower design-mission DOC than the CF6-50C-powered airplane.

Table A-II shows that noise levels for the ATE-powered airplane meet FAR 36 - Amendment 8 requirements for a twin-engine airplane. A 3 EPNdB margin between nominal noise estimates and the FAR 36 - Amendment 8 requirements is achieved except at approach where the margin is 2 EPNdB. Since no attempt was made in this preliminary estimate to refine the nacelle treatment to the lowest noise levels, it was concluded that refinement of noise treatment could attain the 3 EPNdB margin Boeing generally considers acceptable to assure certifiable noise levels.

The fuel burned, economics, and noise results based on engine data supplied by GE for the ATE show that the NASA goals for the GE E³ cycle could be met. However, Boeing's assessment of the engine data and nacelle design indicated a number of unresolved issues. These issues and the results of the Boeing evaluation follow.

- Boeing preliminary evaluation of the ATE nacelle weights indicated the nacelle to be over 1000 lb heavier than the GE estimated weight. Boeing's weight estimate was based on methods reflecting low technical risk for commercial operation. A 1000 lb weight increase reduces fuel burned savings from 18.3% to about 17% and reduces the design-mission DOC advantage from 6 to 5.8%.
- The ATE engine price supplied by GE is too high according to Boeing projections. Boeing's assessment indicated an engine price 22% less than the GE estimate. The Boeing estimated price increased the Design Mission DOC advantage of the ATE from 6% to 7.5%.

Table A-I. Airplane Characteristics and Performance

	MODEL 768-869 (CF6-50C ENGINE)	MODEL 768-868 (ATE)
DESIGN RANGE, N.MI.	2000	2000
DESIGN PAYLOAD, PASSENGERS/LB	196/40 180	196/40 180
NUMBER OF CREW	3	3
CRUISE MACH NUMBER	0.80	0.80
NUMBER OF ENGINES	2	2
ENGINE PERFORMANCE AND WEIGHT DATA	REF 3	REF 3
ENGINE PERFORMANCE RETENSION ALLOWANCE, % TSFC	BASE	0
TAKEOFF THRUST/ENGINE, LB (SEA LEVEL WITHOUT BLEED OR HPX)	37,970	57,710
TOGW, LB	257,350	243,560
OPERATING WEIGHT EMPTY, LB	160,940	156,930
MANUFACTURER EMPTY WEIGHT, LB	149,540	145,530
MAXIMUM LANDING WEIGHT, LB	230,650	218,290
BLOCK FUEL, LB		
-AT DESIGN RANGE AND PAYLOAD	41,730	34,400
-AT 1000 N.MI. RANGE, 108 PASSENGERS	19,130	16,040
-AT 665 N.MI. RANGE, 108 PASSENGERS	13,260	11,205
		PDR STATUS
		NOV. 20, 21, 1978
		-1.0 0
		37,930
		245,090
		158,480
		147,030
		219,660
		34,400
		15,890
		11,100
		11,205

NOTE: ABOVE DATA BASED ON G.E. SUPPLIED ENGINE PERFORMANCE, ENGINE WEIGHT,
AND NACELLE WEIGHT.

- Nacelle assessment and evaluation requires continual review as the design evolves to ensure that the nacelle design meets airplane requirements and objectives, aircraft manufacturer's design practice, and airline and FAA certification requirements. During the Boeing assessment, several versions of the ATE nacelle design were reviewed. In GE's nacelle layouts, however, material callouts and construction details were too incomplete to conduct an indepth evaluation. Concerns based on a critique of the nacelle design were developed and coordinated with GE. Some nacelle design problems were identified. Much additional effort would be required to ensure a flight-acceptable nacelle installation.

To ensure that the E³ program results in an engine configuration that meets the program goals and that can be installed in a nacelle acceptable to the airframer and airlines, it is important for the airframer to be actively involved in the installation design and evaluation.

Table A-II. Nominal Noise Estimate

	<u>ATE</u>	<u>FAR 36 (1978)</u>	<u>Margin</u>
	<u>EPNdB</u>	<u>Requirement</u>	<u>EPNdB</u>
		<u>EPNdB</u>	
Takeoff	90.0	93.8	-3.8
Sideline	90.0	98.2	-8.2
Approach	100.0	102.0	-2.0

2.0 INTRODUCTION

The NASA Aircraft Energy program (ACEE) has the objective of improving the energy efficiency of future U.S. aircraft so that substantial fuel savings and economics can be achieved.

The "Energy Efficient Engine (E³) Preliminary Design and Integration Study" is one of the elements of this program. The recommended advanced technology propulsion system resulting from this study is projected for use on airplanes introduced into service in the late 1980's or early 1990's. NASA goals for the E³ program are a 12% improvement in installed cruise specific fuel consumption, a 5% improvement in DOC, and performance retention of 50% or more as compared with a current technology high-bypass-ratio turbofan engine.

The present study is a follow-on to work performed for the General Electric Company (GE) under subcontract No. P.O. 200-4X X 14K 40096 in support of the GE prime contract NAS3-20627. Objective of the GE prime contract was to evaluate advanced technology engine cycles and to select an advanced cycle that best fulfilled the NASA E³ program goals. Objective of the current study was to evaluate the advanced technology turbofan engine comparing it with a current technology reference engine to determine if NASA goals will be met when these engines are installed on commercial airplanes of the late 1980's.

The tasks designed to accomplish this objective included:

- Task 1 - Aircraft and Mission Definition. Under this task an advanced technology transport aircraft was defined with a design range, performance passenger capacity, and mission appropriately for domestic use.
- Task 2- Aircraft Performance and Sensitivity. This task evaluated a current technology reference engine, the CF6-50C (Ref.3) scaled to the airplane requirements and a similarly scaled advanced technology engine, the ATE (Ref.3) as installed in the advanced technology airplane. The aircraft size was optimized for each engine for the defined mission. Aircraft performance and mission sensitivities were then generated for the aircraft power with the advanced engine.
- Task 3 - Aircraft and Engine Integration. Under this task a GE nacelle Subtask A was evaluated for nacelle construction, nacelle aerodynamics airframe accessory requirements and location, maintainability, accessibility and safety requirements. Results of the aerodynamic study were reported in Reference 5.
- Task 3 - Long Duct Wind Tunnel Study. It was intended that Boeing Subtask B assess and comment on wind tunnel tests of a GE-designed nacelle simulator test model. Because of delay in model

fabrication the tests could not be completed in the contract schedule. Boeing therefore expects to complete this task on a contract extension and report on this task in a later report.

Task 4 - Reports

Section 4.0 of this report reviews and updates the mission selection and airplane definition studies accomplished in earlier E³ studies reported in Reference 5. Mission definition differed from these earlier studies primarily in its reduction of takeoff field length (TOFL) requirement from 7500 ft. to 6000 ft. The major airplane-configuration change was an aft relocation of the engine exhaust plane to 40% wing chord. The latter change was made as a result of a flutter-weight penalty trade study.

Section 5.0 summarizes the sizing studies of the CF6-50C and ATE-powered airplanes and compares the resulting performance, noise, and economics of the two airplanes. These studies were based on the GE-supplied engine performance, engine weight, engine noise, and engine economic data. DOC and ROI sensitivity to fuel price was determined by using fuel prices of 35, 40 and 45 ¢/gal. Also, an additional DOC and ROI calculation shows the impact of a Boeing estimated engine price that was about 22% lower than GE's estimate.

Section 6.0 comments on the Boeing assessment and evaluation of the GE-designed nacelle installation. Design comments, accessory requirements and location, design loads, mount structure, and a weight assessment are included in the critique of the GE nacelle design.

3.0 ABBREVIATIONS AND SYMBOLS

A/P	airplane
AR	aspect ratio
ATE	advanced technology engine
BLKF	block fuel, pounds
BLKT	block time, hours
c	local chord
C_L	wing lift coefficient, L/qS_{REF}
C_{LR}	C_L ratio
C_D	drag coefficient, D/qS_{REF}
C_{DNAC}	nacelle drag coefficient, D_{NAC}/qS_{NAC}
CET	combustor exit temperature, °F
D	airplane drag, pounds
dB(A)	weighted sound pressure level, decibels
D_{NAC}	nacelle drag, pounds
DOC	direct operating cost
E ₃	energy efficient engine
EPNL	effective perceived noise level
EPNdB	effective perceived noise, decibels
f _{VB}	nacelle vertical bending frequency, Hertz
F _N	net thrust, pounds
FSPP	full standards prediction procedure
GL	ground line
ICAC	initial cruise altitude capability, feet
LE	leading edge
M	flight machine number
MCR	maximum cruise
MEW	manufacturer's empty weight, pounds
OEW	operational empty weight, pounds
q	dynamic pressure, lb/ft ²
PDR	preliminary design review
PNL	perceived noise level
SFC	specific fuel consumption lb/hr-lb
SLST	sea level static thrust (uninstalled)
S_{REF}	wing reference area, ft ²
S_{NAC}	nacelle wetted area, ft ²
t/c	wing thickness-to-chord ratio, measured streamwise
TE	trailing edge
TOGW	takeoff gross weight, pounds
TOFL	takeoff field length, feet
WCP	wing chord plane
WRP	wing reference plane
VAPP	approach speed, keas
V _D	design dive speed
Λ 0.26C	sweepback angle at wing quarter chord, degrees

4.0 AIRPLANE AND MISSION DEFINITION

Selection of the design mission and a corresponding design payload and range was based on a projection of the commercial airplane market of the 1990's and considerations of potential fuel saving. Various design requirements, wing geometry, and advanced technology features were established for a 1990 domestic service airplane.

4.1 MISSION SELECTION

Examination of the possible 1990 market suggested that the future airline market would be similar to the existing marketplace. This prediction was based on the assumption that the air traveling community in the 1990's will constitute approximately the same percentage of the total population as today's air travelers, with a 4 to 6% annual growth. The air cargo market should experience similar growth.

Many of the current narrow body aircraft will be retired from active service by the major airlines in the late 1980's. These include the inter-continental range 707-320B and -320C models, the DC-8 Sixty series airplanes, and some of the early 727-200 model domestic airplanes. Hence, there should be a market in the late 1980's for a large number of replacement aircraft in the 180 to 220 passenger size range.

Statistics of airplane fuel consumption for various stage lengths have shown that over 85% of total domestic passenger-jet fuel consumption occurs at stage lengths at or below 2000 statute miles. Furthermore as Figure A-1 shows, the shorter ranges account for the bulk of the fuel used.

Considering the potential market and the opportunity or fuel saving at shorter ranges the design mission and sizing constraints selected for the E³ study are:

	<u>Domestic Airplane</u>
Design range, nmi	2000
Nominal payload, passengers (15/85% mix)	196
Cruise Mach number	0.8
TOFL, feet (max)	6000
VAPP, knots (max)	125
ICAC, feet (min)	33 000
Reserves	ATA Domestic

The following off-design missions were also selected for economic assessments:

	<u>Domestic Airplane</u>	
Range, nmi	665	1000
Payload, passengers (15/85% mix)	108	108
Cruise Mach number	0.8	0.8

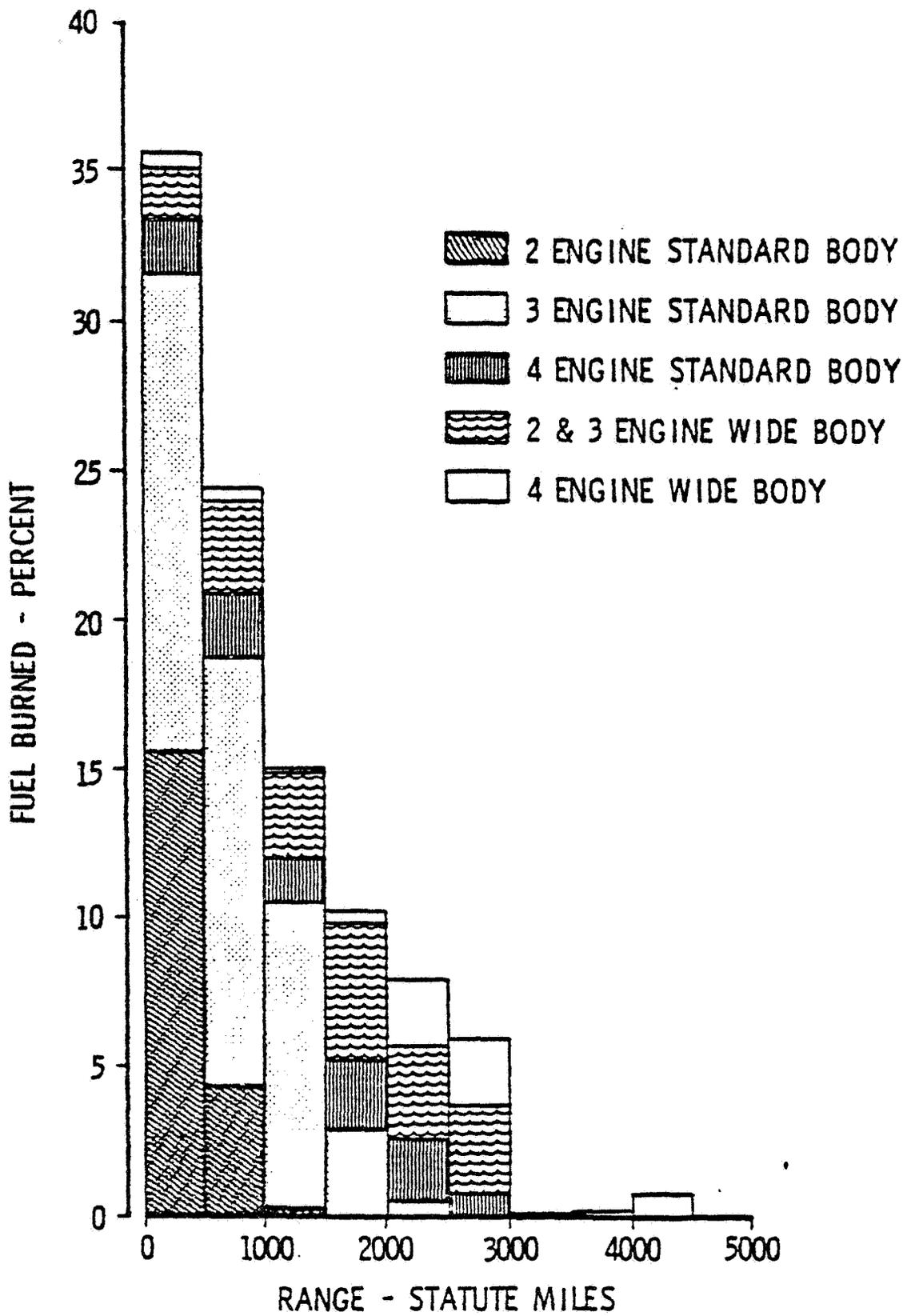


Figure A-1. Domestic Passenger Jet Fuel Consumption as a Function of Range

A typical mission profile is shown in Figure A-2.

4.2 ADVANCED TECHNOLOGY FEATURES

An available aerodynamic and structural technology data base was used as a baseline for projecting advanced airplane technology for the E³ program. Reviews in each technology identified advanced technology features assumed to be available for a 1986 program start and for in-service use in the early 1990's. The advanced technology features are summarized on airplane configurations drawings (Fig. A-3).

A further discussion of aerodynamics, weight, and structural advanced technology follows.

4.2.1 Aerodynamics

A baseline drag level was derived from representative wind tunnel model data. Improvements to this baseline drag data base were applied as follows:

- a. Cruise--2% reduction in cruise drag was to be achieved by improved wing-airfoil design and improved component integration. In addition, it was assumed that an advanced active control system would produce zero trim drag.
- b. Takeoff and Landing--a 5% improvement in lift-drag ratio was assumed for the domestic two-engine airplane. This reflected the following changes: sealed leading edge (LE) flaps, seals between nacelle struts and lateral edges of the LE flaps, and aileron droop for high lift.

4.2.2 Weight and Structures

Possible application of advanced aluminum alloys and advanced composite structures on airframe components is shown with potential weight savings on Table A-III.

4.3 AIRPLANE GEOMETRY GUIDELINES

The airplane geometry guidelines shown in Figure A-4 were adopted to ensure adequate ground clearance during taxi, takeoff, and landing. These are the same guidelines used in the earlier study under subcontract No. P.O. 200-4XX-14K40096.

4.4 ENGINE INSTALLATION

4.4.1 Engine Placement

Engine placement guidelines were revisions of those used in the cycle selection studies. The revised guidelines established for chordwise engine placement (Figs. A-5 and A-6) provided balance between interference drag and flutter weight penalty. Figure A-7 compares the ATE and CF6-50C installations using these guidelines.

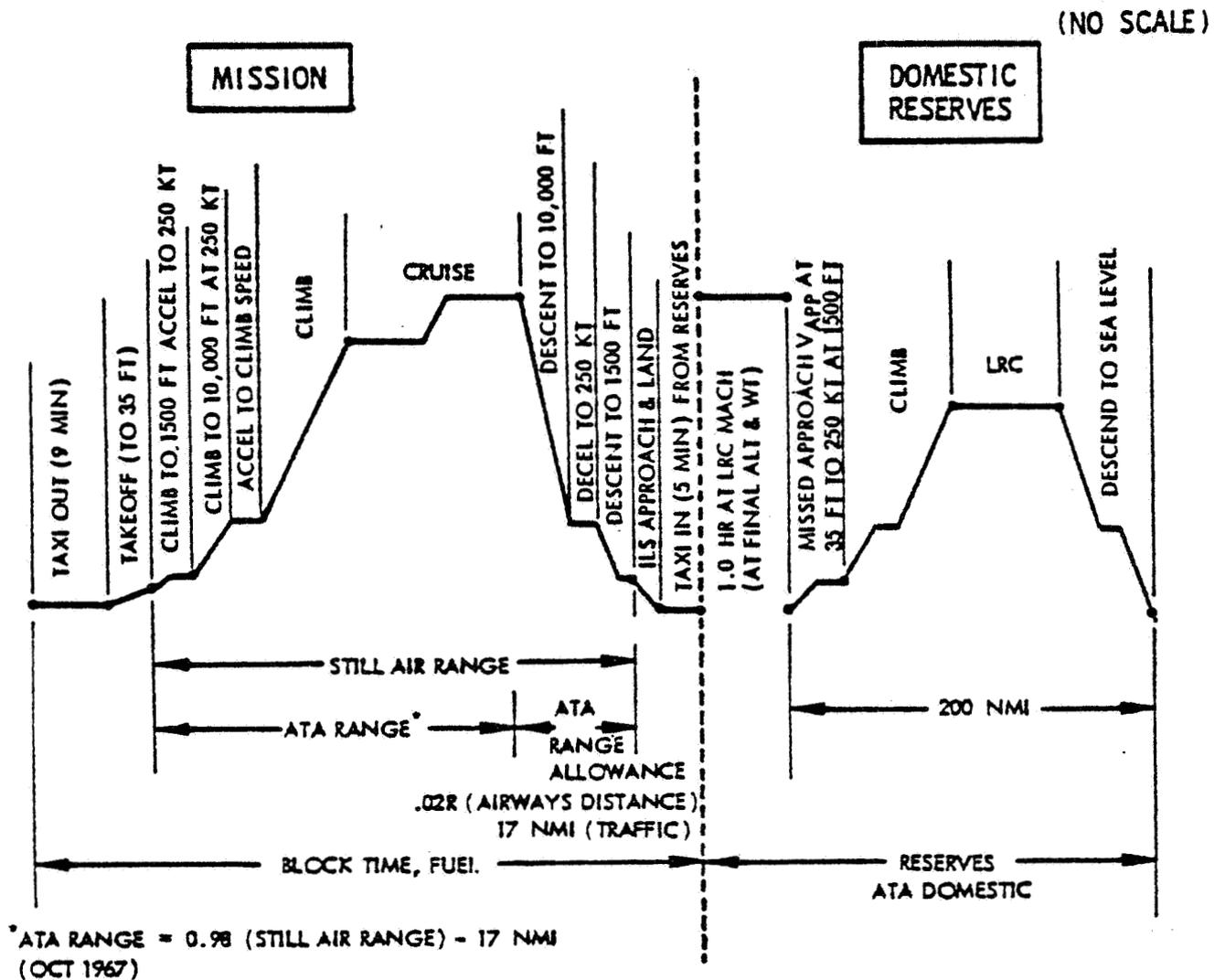
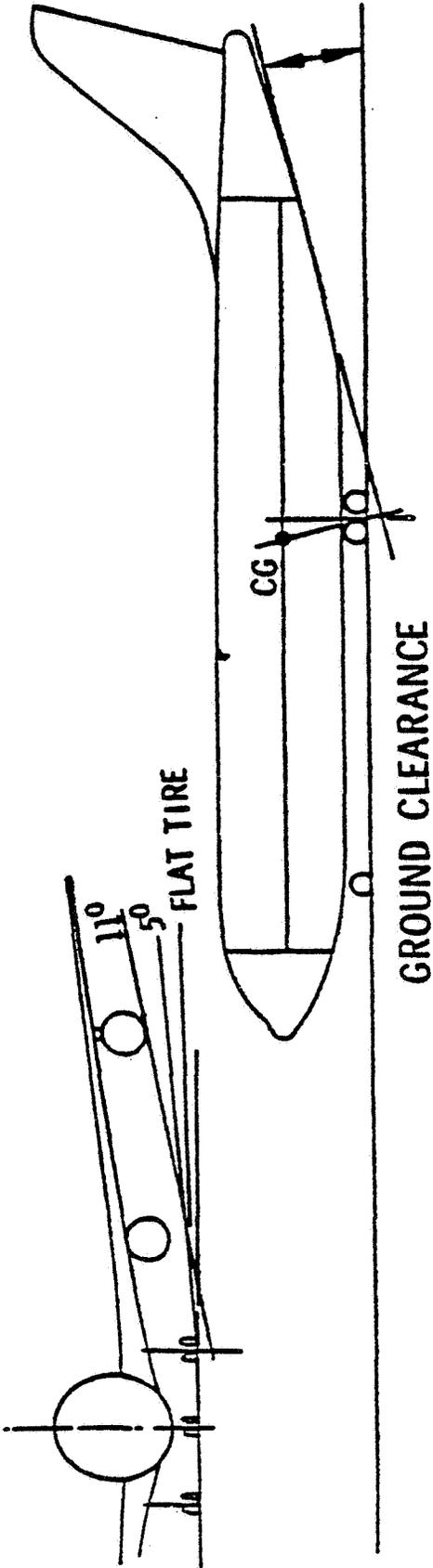


Figure A-2. Typical Mission Profile

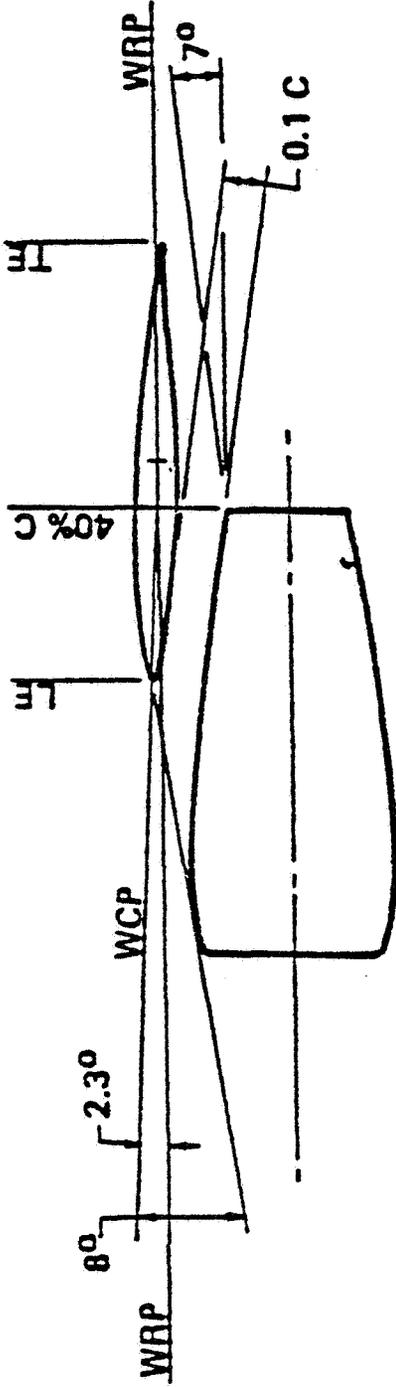
Table A-III. Advanced Airframe Structure for E³ Studies

CURRENT TECHNOLOGY	NEW TECHNOLOGY		
MATERIAL	MATERIAL	STRUCTURAL COMPONENT	WEIGHT SAVING % OF COMPONENT WEIGHT
STANDARD ALUMINUM ALLOYS (CURRENT 747)	ADVANCED ALUMINUM ALLOYS	WING BOX FUSELAGE EMPENNAGE BOX	6% 4% 6%
CONVENTIONAL ALUMINUM CONSTRUCTION	ADVANCED COMPOSITE STRUCTURE (GRAPHITE)	CONTROL SURFACES LANDING GEAR DOORS	25%
	CARBON	MAIN LANDING GEAR BRAKES	40%
	TITANIUM FITTINGS	LANDING GEAR SUPPORT SIDE OF BODY RIB EMPENNAGE BODY ATTACH ENGINE STRUT ATTACH FLAP SUPPORT	20%



- TAKE OFF ROTATION
15.5 DEGREES DOMESTIC
- TOUCH DOWN
ROLL CLEARANCE ANGLE 11 DEGREES WITH GEAR EXTENDED
- TAXI
ROLL CLEARANCE ANGLE 5 DEGREES WITH OLEO COMPRESSED
- NO GROUND CONTACT WITH FLAT TIRE AND COLLAPSED OLEO

Figure A-4. Airplane Geometry Guidelines



- **NACELLE PLACEMENT**

- **NACELLE PRIMARY NOZZLE AT 40% OF CHORD.
FAN COWL VERTICAL POSITION BELOW WING LOWER
SURFACE BY 10% CHORD OR GREATER.**

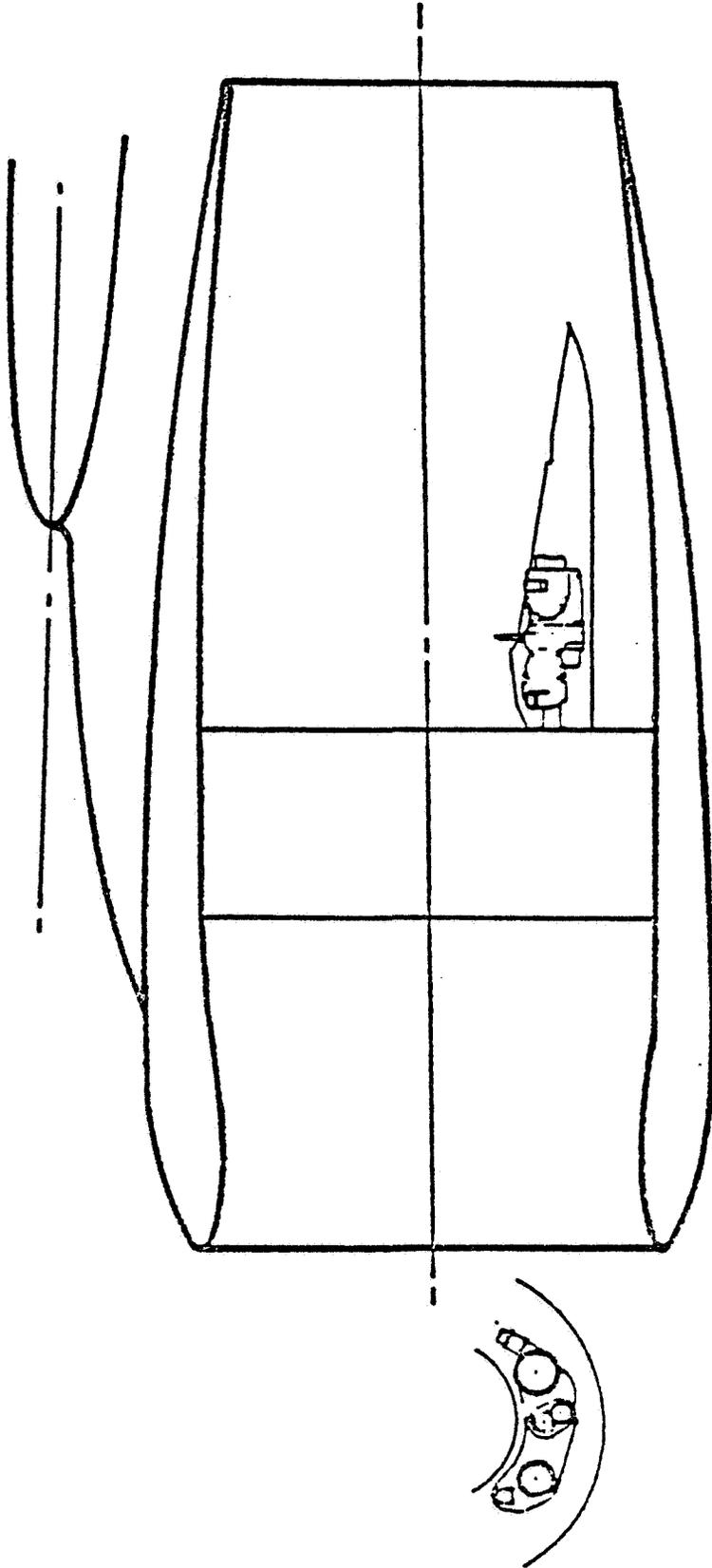
- **NO VORTEX SHEDDING OVER WING**

- **FORWARD LIP OF COWL MUST BE BELOW AN 8-DEG LINE
MEASURED WITH RESPECT TO LOCAL CHORD PLANE.**

- **NO JET WAKE IMPINGEMENT**

- **JET WAKE BASED ON EQUIVALENT DIAMETER AT THE PLANE
OF PRIMARY NOZZLE AND EXPANDING 7 DEG MUST NOT
CONTACT LOWER WING SURFACE.**

Figure A-5. Nacelle Placement Guidelines



- **Strut profile will have no negative slope.**
- **Strut profile will not exceed WCP height at leading edge.**
- **Hilite clearance, 0.5 diameters to ground.**
- **Engine centerline horizontal and toed inboard, 1 deg.**

Figure A-6. Engine Placement Ground Rules

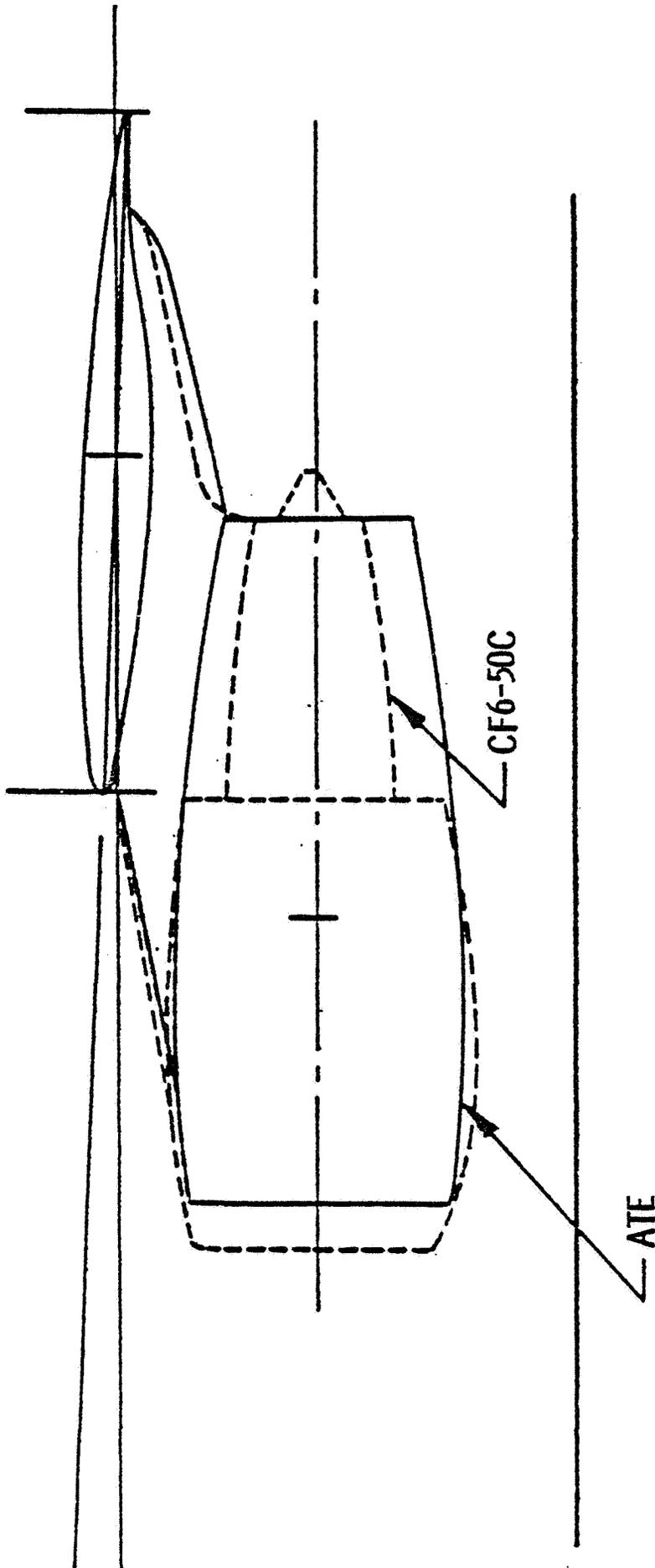


Figure A-7. Installation Comparison

Spanwise engine location was based on considerations of wing flutter, engine-out control, and landing gear length.

4.4.2 Nacelle Design

Installed engine performance included cowl scrubbing drag where applicable. External drag of the nacelle and interference drag effects among wing, strut, and nacelle were included in airplane drag polars.

4.4.3 Engine Bleed and Power Extraction

Engine bleed air extraction values allowed cabin air ventilation at design cruise with sufficient margin for cabin altitude control. Recirculation reduced engine bleed requirements and fuel consumption due to air-conditioning by about 50%. Cabin bleed air requirements are shown in Figure A-8.

Engine shaft power extraction was based on load characteristics established by previous experience. Power extraction is split between airplane operational functions and passenger loading. Operational functions include basic hydraulic and electric loads for operating the airplane systems. Passenger loading directly affects galley loads and passenger lighting. This study used a base load of 180 hp/airplane, which is adequate for 200 passengers.

Engine power extraction for airplane off-design operation (e.g., operation in icing conditions) was not required for the airplane parametric studies. System designs, however, considered off-design requirements.

4.5 PRELIMINARY AIRPLANE CONFIGURATION

4.5.1 Airplane Description

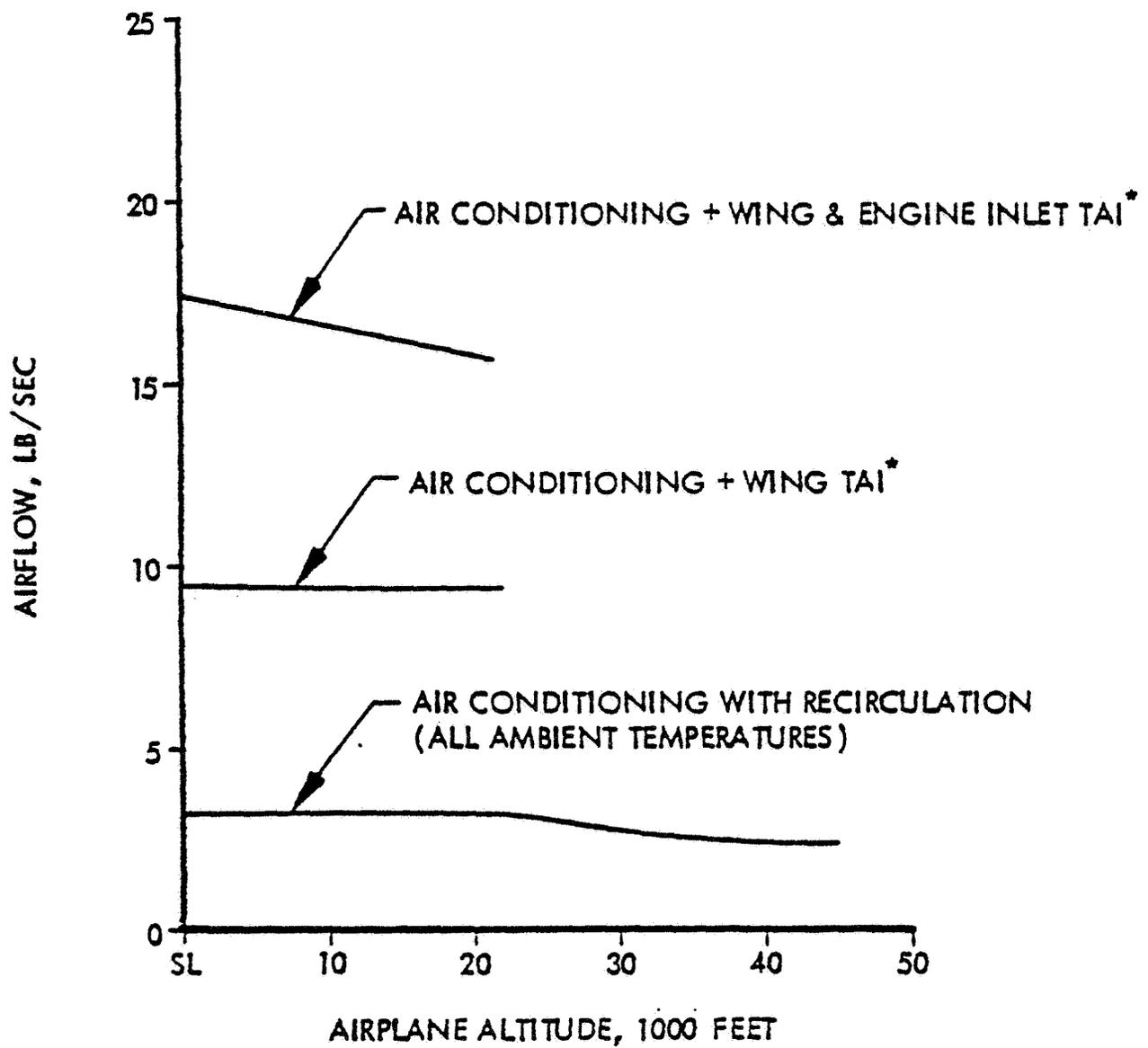
For the preliminary airplane, this study selected a twin-engine wide-body configuration with double-aisle seven-abreast seating. Wing geometry ($AR = 10$, $\Lambda_{0.25C} = 30$ deg) was consistent with the cruise speed and takeoff and landing characteristics. The lower lobe cargo space was configured to accommodate 17 LD-3 containers side by side.

A preliminary drawing of the baseline airplane is shown in Figure A-3.

4.5.2 Engine Description

Scalable CF6-50C and ATE turbofan engines (Ref. 3) were used for sizing the advanced technology airplanes. Both the current technology engine and advanced engine were installed to ensure only the differences in engines were reflected in the performance improvements resulting from this study. The CF6-50C engine was installed in a short-fan-duct nacelle similar to the Boeing model 747 engine installation; the ATE was installed in a long-duct nacelle that included a forced mixer.

Main characteristics of the two engines at maximum climb thrust, 0.8 Mach, and an altitude of 35 000 ft are:



* ICING CONDITIONS DEFINED BY FAR 25.1419

Figure A-8. Airplane Bleed Airflow Requirement

	<u>ATE</u>	<u>CF6-50C</u>
Bypass ratio	6.8	4.2
Installed SFC	0.546	0.629
Fan pressure ratio	1.65	1.76
Overall pressure ratio	38	32
Maximum turbine rotor inlet temp. (SLS hot-day takeoff)	2340°F	--

4.6 PROCEDURES FOR DETERMINING DIRECT OPERATING COST (DOC) AND RETURN OF INVESTMENT (ROI)

The following method was used for determining the DOC and ROI of the airplane powered by the CF6-50C and the ATE advanced engine. The airplanes were sized to minimize fuel burned and airplane gross weight for the given engine. Then airplane block fuel and block time for a representative mission were used to determine the DOC and ROI based on 1977 dollars.

4.6.1 Direct Operating Cost

The Boeing DOC method has evolved over several years from the formulas published by the Air Transport Association of America in 1967. The DOC calculation includes cost of crew, fuel, airframe maintenance, engine maintenance, depreciation, and insurance. Utilization of the airplane is determined from the block time derived by mission analysis. The DOC calculation method is detailed in Tables A-IV, A-V, and A-VI and in Figures A-9 and A-10.

4.6.2 Return on Investment

The Boeing economic analysis of the E³ program used the discounted cash flow ROI method to evaluate each engine. ROI is the discount rate that makes the sum of the projected annual cost savings equal to the initial investments. It is the best comparator of alternative investment opportunities in a general business context. ROI recognizes the value of money over time, and it can be directly related to any airline's cost of capital to show how much a modification is above or below the hurdle rate. In this study's context, the hurdle rate is the ROI required before an airline would consider undertaking an investment opportunity. Cash flows were calculated using constant (1977) dollars to ensure consistent comparison of each concept.

It should be noted that there is an inherent uncertainty in any generalized figure of merit applied to a specific airline due to considerable variation in individual airline operations, rules, and evaluation criteria. Specific ROI analysis should be made using an airline's individual rules and hurdle criteria. A hurdle rate of 15% after taxes is considered an acceptable criterion.

In the E³ study, the average range flown by domestic medium-range airplanes was determined, and a representative average range of 665 nmi was selected as a base for economic calculations. With a mission profile defined for the selected range, the initial investment, operational costs, and cash inflows were calculated for this profile and airplane utilization. The ROI was calculated with the method defined by Table A-VII.

Table A-IV. DOC Elements

Crew Cost	=	f(TOGW, cruise speed, mission type)
+ Fuel	=	fuel burn and fuel price specified
+ Airframe maintenance	=	specified (Boeing)
+ Engine maintenance	=	specified (engine manufacturer)
+ Depreciation	=	f(useful life, residual value, utilization, initial price, spares price)
+ Insurance	=	f(initial flyaway price)
<hr/>		
	=	DOC per trip
Utilization	=	f(block time)

Table A-V. Basic Characteristics of Boeing 1977 Coefficients

Applicability	New airplanes, domestic trunk
Mission profile	1967 ATA with revised taxi, air maneuver, and airway distance factors
Utilization	Function of average block time, maximum of 15 trips/day
Cruise procedure	Minimum cost constant mach, step climb
Crew expenses	Function of gross weight, speed and airplane utilization
Fuel price	35 ¢/gal. U.S. domestic and local service
Maintenance	Mature-level maintenance based on current level with material escalation of 8% over 1976. Labor rate = \$9.70/man-hour Burden = 200% of direct labor
Depreciation	New-15 yr. to 10% residual on airplane and spares
Insurance rate	0.5% of new airplane price
Assumed spares	6% of airframe price 30% of total engine price
Nonrevenue factor	2% added to fuel and maintenance for nonrevenue flying

Table A-VI. Domestic Direct Operating Cost Formulas

	BOEING 1977	
CREW PAY (\$/BLK-HR) 2-MAN CREW 1 3-MAN CREW 1	$(29.67F_w + 2.838) F_u + 19.80$ $(33.54F_w + 3.483) F_u + 29.70$	Definitions of terms and units
FUEL (\$/U.S. GAL)	0.35	TOGW Maximum takeoff gross weight-lb
NONREVENUE FACTOR	1.02 ON FUEL AND MAINTENANCE	Ca Airframe price-\$
AIRFRAME MAINTENANCE -CYCLE MATERIAL (\$/CYC) DIRECT LABOR (MH/CYC)		Ca Engine price/engine-\$ (excluding reverser)
AIRFRAME MAINTENANCE -HOURLY MATERIAL (\$/FH) DIRECT LABOR (MH/FH)		Ne Number of engines
ENGINE MAINTENANCE-CYCLE MATERIAL /\$/CYC DIRECT LABOR (MH/CYC)		T Sea level static thrust -lb
ENGINE MAINTENANCE-HOURLY MATERIAL (\$/FH) DIRECT LABOR (MH/FH)		M High speed cruise mach number
BURDEN (MH/DIRECT LABOR MH)	2.0	Wa Airframe weight-lb
MAINTENANCE LABOR RATE (\$/MH)	9.70	FH Flight-hours
INVESTMENT SPARES RATIO AIRFRAME ENGINE	0.06 0.03	MH Man-hours
DEPRECIATION SCHEDULE (YEARS/% RESIDUAL)	15/10	CYC Cycle
INSURANCE RATE (% OF TOTAL PRICE/YEAR)	0.5	Tb Block time-hr
UTILIZATION (BLK-HR/YEAR)	$U = \frac{4,000}{1 + \frac{1}{T_b + 0.5}} + 650$ (15 TRIPS/DAY MAXIMUM)	Notes: 1. See attachments for Fw and Fu crew pay factors. 2. For flight-hours 2 use: Cost at 2 hr -0.73 (hourly cost) x (2 - flight-hours) For flight-hours 4 use: Cost at 4 hr + 1.53 (hourly cost) x (flight-hours-4)

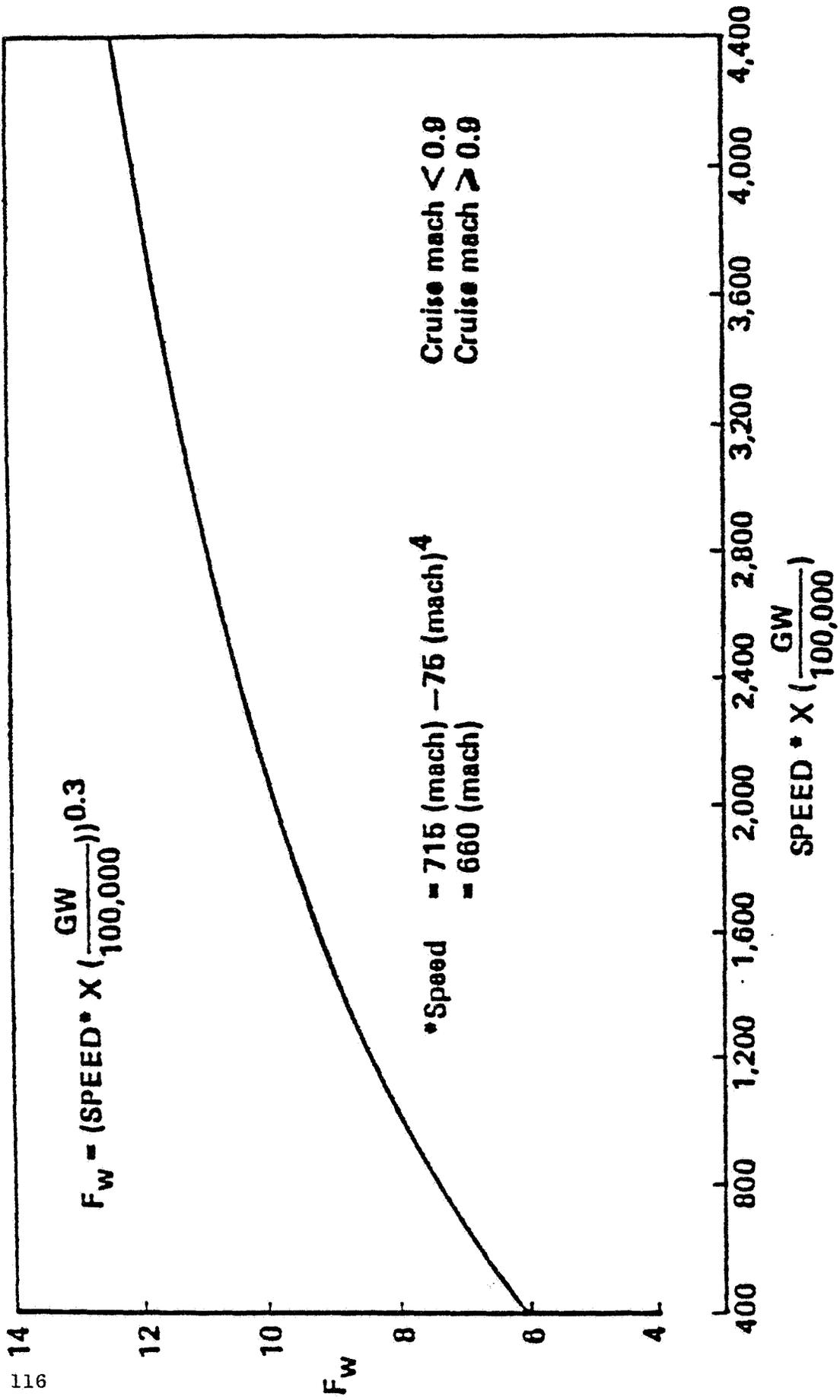


Figure A-9. F_w Factor for Crew Pay

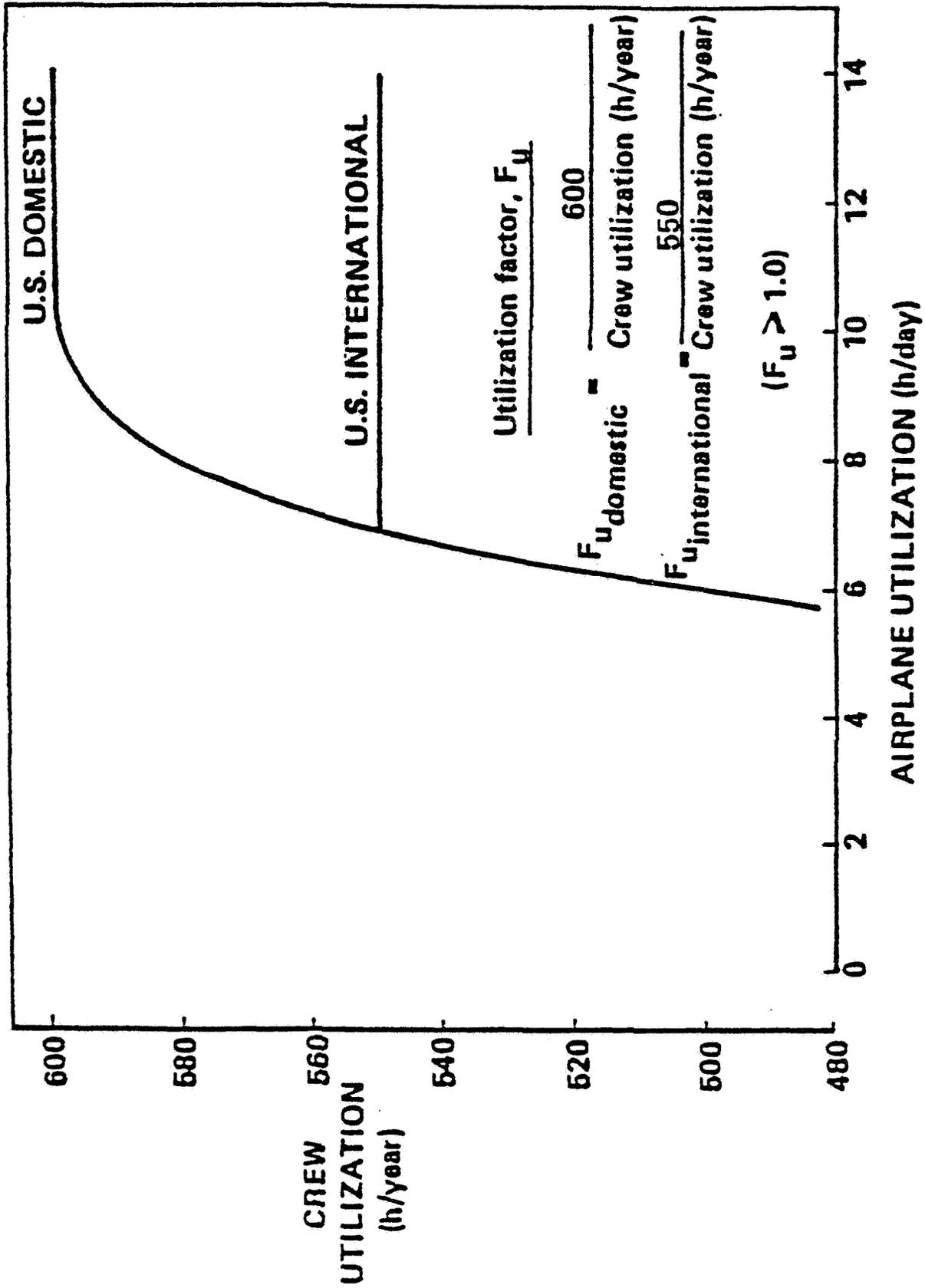


Figure A-10. Crew Utilization

Table A-VII. Return on Investment Method

Definition: ROI is the discount rate at which the net present value of future cash inflows (cost savings) is equal to the initial cash outlay (investment)

$$\text{Net present value (NPV)} = -C_{\text{OUT}} + \sum_{n=1}^{\text{useful life}} C_{\text{IN}}/(1+r)^n$$

When NPV = 0, r = ROI = discount rate

- Calculations:
1. Before tax cash outflows (C_{OUT})
 - Incremental airplane price or modification cost
 - Additional spares inventory
 2. Before tax cash inflows (annual) (C_{IN})
 - Cash operating cost savings
 - Fuel
 - Maintenance
 3. After tax equivalence
 - Depreciation tax effects
 - Investment tax credit (if applicable)

5.0 AIRPLANE PERFORMANCE AND SECURITY

5.1 AIRPLANE SIZING

Both the CF6-50C and the ATE powered airplanes were sized to meet the same design mission. The effect of engine technology on airplane size and performance is shown in Figure A-11. The wing loading for these airplanes was chosen for minimum block fuel (BLKF) and takeoff gross weight (TOGW), but with an 84°F day sea-level takeoff field length (TOFL) constraint of 6000 ft determining the thrust loading. Selected wing loadings (w/s) were 100 lb/sq.ft. for the ATE-powered airplane and 105 lb/sq.ft. for the CF6-50C-powered airplane. Engine thrust to weight (T/W) difference at given wing loading shown in Figure A-11 were due to difference in BPR between the two engines.

5.1.1 Airplane Performance and Characteristics

Characteristics and performance of the CF6-50C and the ATE-powered airplanes are compared in Table A-VIII. Each airplane was designed to meet airplane and mission requirements (Sec. 4.1). The BLKF and TOGW shown in Table A-VIII are based on an airplane sizing program.

5.1.2 Airplane Weight

Table A-IX shows results of a weight analysis on domestic E³ airplanes with the ATE and CF6-50C engines. These weights reflect the advanced technology features discussed in Section 4.2. The nacelle weights were supplied by GE and scaled to the appropriate thrust level. A preliminary balance analysis indicated acceptable loadability for both airplanes.

5.1.3 Airframe Noise and FAR 36 Flight Conditions

The airframe noise prediction method applied is part of the Boeing standard aircraft-community noise prediction procedure. This method was based on airframe noise being predominantly generated by turbulent flow at the edges of airfoils, cavities, and landing gear members. Quantitative values contained in the method were determined from flight tests of in-service Boeing aircraft. All methods are under continual review to maintain a technology level consistent with their status as validated Boeing standards.

Noise was predicted as 1/3 octave band sound pressure levels having directionally defined by a 150-ft polar arc from 10 to 170 deg at 10 deg intervals. The spectra were extrapolated for the required flight condition in order to generate airplane flyover time histories of sound pressure level and weighted noise values (SPL, dB(A)). The perceived noise level (PNL) time history was calculated and converted to effective perceived noise level (EPNL).

In normal use, the predicted airframe noise component is added to other noise components at the spectral level for extrapolation and derivation of total airplane EPNL. In addition, as used here, airframe noise can be predicted and extrapolated separately.

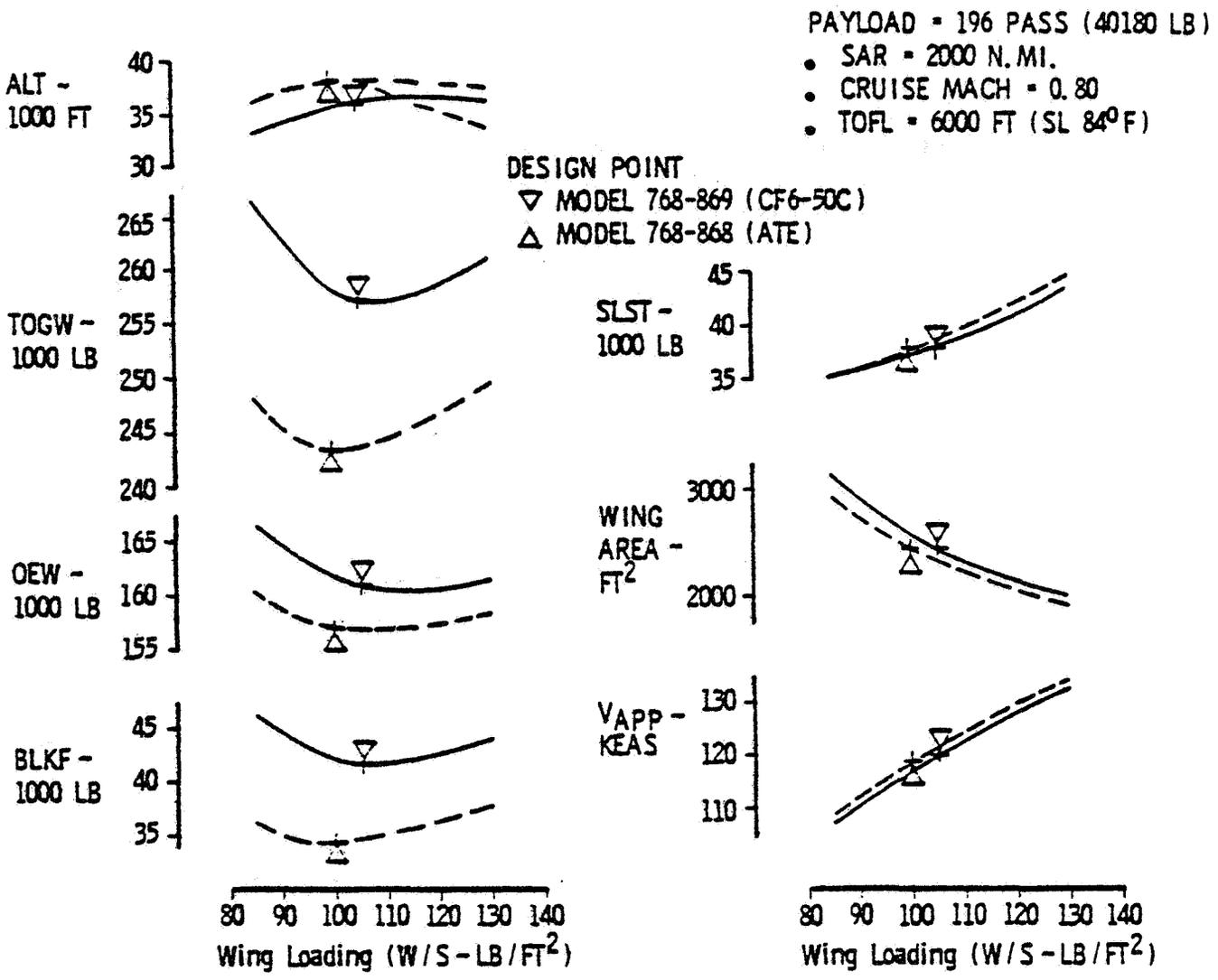


Figure A-11. Airplane Performance Trades

Table A-VIII. Airplane Characteristics and Performance

	MODEL 768-869 (CF6-50C ENGINE)	MODEL 768-868 (ATE)
DESIGN RANGE, N.MI.	2000	2000
DESIGN PAYLOAD, PASSENGERS/LB	196/40 180	196/40 180
NUMBER OF CREW	3	3
CRUISE MACH NUMBER	0.80	0.80
NUMBER OF ENGINES	2	2
ENGINE PERFORMANCE AND WEIGHT DATA	REF 3	REF 3
ENGINE PERFORMANCE RETENSION ALLOWANCE, % TSFC	BASE	0
TAKEOFF THRUST/ENGINE, LB (SEA LEVEL WITHOUT BLEED OR HPX)	37,970	37,710
TOGW, LB	257,350	243,560
OPERATING WEIGHT EMPTY, LB	160,940	156,930
MANUFACTURER EMPTY WEIGHT, LB	149,540	145,530
MAXIMUM LANDING WEIGHT, LB	230,650	218,290
BLOCK FUEL, LB	41,730	34,400
-AT DESIGN RANGE AND PAYLOAD	19,130	16,040
-AT 1000 N.MI. RANGE, 108 PASSENGERS	13,260	11,205
BLOCK TIME, HRS	4.70	4.70
-AT DESIGN RANGE AND PAYLOAD	2.51	2.51
-AT 1000 N.MI. RANGE, 108 PASSENGERS	1.80	1.80
		PDR STATUS NOV. 20, 21, 1978
		-1.0 0
		37,840 37,930
		244,460 245,090
		158,260 158,480
		146,820 147,030
		219,090 219,660
		34,090 34,400
		15,890 16,040
		11,100 11,205
		4.70 4.70
		2.51 2.51
		1.80 1.80

NOTE: ABOVE DATA BASED ON G.E. SUPPLIED ENGINE PERFORMANCE, ENGINE WEIGHT, AND NACELLE WEIGHT.

Table A-IX. Weight Statement for GE E³ Airplanes

	<u>Weight (LB)</u>	
	<u>Model 768-868</u>	<u>Model 768-869</u>
	<u>(ATE)</u>	<u>(CF6-50C)</u>
Wing	30,280	31,820
Empennage	4,440	4,470
Body	33,430	33,710
Nacelle*	6,870	9,060
Gear	12,700	12,630
Total structure	(87,630)	(91,690)
Propulsion system	(15,600)	(15,280)
Fixed equipment and options	(42,300)	(42,570)
Standard and operational items	<u>(11,400)</u>	<u>(11,400)</u>
OEW	156,930	160,940

*GE provided nacelle weight plus Boeing estimated pylon and mount weight.

Table A-X gives flight conditions at FAR 36 measuring points for the CF6-50C and ATE-powered airplanes. This table also shows nominal airframe noise component EPNL values. For a study engine, it is standard Boeing practice to add an uncertainty margin of 3 EPNdB to the total predicted noise level. This ensures that airplane noise will fall within certifiable limits.

5.1.4 Engine and Airframe Noise

In the Boeing analysis, the acoustical design point was an 80% level of confidence of certification. This goal could be achieved with current and near-future lining technology. The estimated noise levels for the ATE (Table A-XI) were based on a nominal acoustic treatment to the engine and nacelle, not on a fully iterated lining design study. It was concluded that with further refinement the approach noise could attain the 3 EPNdB margin generally considered acceptable for assuring certifiable noise levels.

Because quiet operation was not the prime objective in configuring this airplane, no adjustments were made to the performance or flight configuration for the purpose of lowering noise levels. Optimization of linings, flap settings, and thrust levels could improve the margin for the approach case.

5.1.5 Airplane Drawings of Sized Airplanes

Figures A-12 and A-13 show drawings of the CF6-50C and ATE-powered airplanes.

5.1.6 Airplane Drag Polars

The airplane drag polars were derived from wind tunnel test data obtained from a model closely resembling the study configurations. Beyond that, drag optimism associated with advanced technology was incorporated as discussed in Section 4.2. Estimated drag of isolated nacelles and drag caused by interference between the nacelles and the airframe were included in the airplane polars.

5.2 AIRPLANE SENSITIVITY FACTORS

Sensitivities for airplanes are shown in Table A-XII and A-XIII. The airplanes are sized by TOFL and the sensitivity results are nonlinear for some parameters. In some cases, better airplane solutions (i.e., lower TOGW or BLKF) can be obtained by sizing to more stringent performance constraints. This, however, requires additional diagnostic point designs that are time-consuming and costly. It is recommended that the sensitivities be used with caution and not outside the amount of change shown.

5.3 TAKEOFF GROSS WEIGHT AND FUEL BURN COMPARISON

Figure A-14 shows BLKF and BLKT versus range for both CF6-50C and ATE-powered airplanes. For the domestic airplane on the average mission, the airplane with ATE engines uses 15.5% less fuel than the CF6-50C airplane. For the design mission without performance retention, the saving for the ATE-powered airplane is 17.6%. These savings represent about 3% improvement

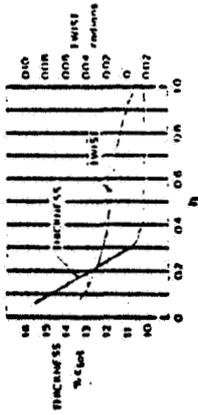
Table A-X. Flight Conditions for FAR-36 Noise Calculations--77°F

<u>Domestic Airplane</u>	<u>Takeoff</u>	<u>Sideline</u>	<u>Approach</u>
Model 768-868	(1)	(2)	(3)
(ATE Engine)			
% of takeoff thrust at flight condition	100	100	100
Speed, knots	153	153	134
Altitude, feet	2,200	900	394
Bleed (lb/sec)/HPX (per engine)	(0.0/160)	(0.0/160)	(0.0/160)
Engine angle relative to flight path, degrees	7.7	7.7	5.5
Climb angle, degrees	7.3	7.3	-3
Airframe noise, EPNdB*	72.5	72.6	93.0
(1) 6500m from brake release at maximum takeoff weight			
(2) 2000m from touchdown at design mission landing weight			
(3) 450m sideline distance			
* Nominal noise estimate shown -- appropriate design/demonstration tolerances are required for certifiable/guarantee levels.			

Table A-XI. Nominal Noise Estimates

	<u>ATE *</u>	<u>FAR 36-8</u> <u>Requirement</u>	<u>Notes</u>
Takeoff	90.0	93.8 dB	No cutback 6500m point
Sideline	90.0	98.2 dB	Sideline distance 450m point
Approach	100.0	102.0 dB	2000m from threshold (two extended flap segments, 3 deg glide slope)

*Note: Nominal noise estimates are shown -- appropriate design/demonstration tolerances are required for certifiable/guarantee levels.



Item	Part No.	Material	Quantity	Weight (lb)	Volume (cu in)
1	101	ALUMINUM	1	10.0	10.0
2	102	STEEL	2	20.0	10.0
3	103	COPPER	1	15.0	10.0
4	104	BRASS	1	12.0	10.0
5	105	INCONEL	1	18.0	10.0
6	106	TITANIUM	1	14.0	10.0
7	107	ALUMINUM	1	11.0	10.0
8	108	STEEL	2	22.0	11.0
9	109	COPPER	1	16.0	11.0
10	110	BRASS	1	13.0	11.0
11	111	INCONEL	1	19.0	11.0
12	112	TITANIUM	1	15.0	11.0
13	113	ALUMINUM	1	12.0	11.0
14	114	STEEL	2	24.0	12.0
15	115	COPPER	1	18.0	12.0
16	116	BRASS	1	14.0	12.0
17	117	INCONEL	1	20.0	12.0
18	118	TITANIUM	1	16.0	12.0
19	119	ALUMINUM	1	13.0	12.0
20	120	STEEL	2	26.0	13.0
21	121	COPPER	1	20.0	13.0
22	122	BRASS	1	15.0	13.0
23	123	INCONEL	1	21.0	13.0
24	124	TITANIUM	1	17.0	13.0
25	125	ALUMINUM	1	14.0	13.0
26	126	STEEL	2	28.0	14.0
27	127	COPPER	1	22.0	14.0
28	128	BRASS	1	16.0	14.0
29	129	INCONEL	1	22.0	14.0
30	130	TITANIUM	1	18.0	14.0
31	131	ALUMINUM	1	15.0	14.0
32	132	STEEL	2	30.0	15.0
33	133	COPPER	1	24.0	15.0
34	134	BRASS	1	17.0	15.0
35	135	INCONEL	1	23.0	15.0
36	136	TITANIUM	1	19.0	15.0
37	137	ALUMINUM	1	16.0	15.0
38	138	STEEL	2	32.0	16.0
39	139	COPPER	1	26.0	16.0
40	140	BRASS	1	18.0	16.0
41	141	INCONEL	1	24.0	16.0
42	142	TITANIUM	1	20.0	16.0
43	143	ALUMINUM	1	17.0	16.0
44	144	STEEL	2	34.0	17.0
45	145	COPPER	1	28.0	17.0
46	146	BRASS	1	19.0	17.0
47	147	INCONEL	1	25.0	17.0
48	148	TITANIUM	1	21.0	17.0
49	149	ALUMINUM	1	18.0	17.0
50	150	STEEL	2	36.0	18.0
51	151	COPPER	1	30.0	18.0
52	152	BRASS	1	20.0	18.0
53	153	INCONEL	1	26.0	18.0
54	154	TITANIUM	1	22.0	18.0
55	155	ALUMINUM	1	19.0	18.0
56	156	STEEL	2	38.0	19.0
57	157	COPPER	1	32.0	19.0
58	158	BRASS	1	21.0	19.0
59	159	INCONEL	1	27.0	19.0
60	160	TITANIUM	1	23.0	19.0
61	161	ALUMINUM	1	20.0	19.0
62	162	STEEL	2	40.0	20.0
63	163	COPPER	1	34.0	20.0
64	164	BRASS	1	22.0	20.0
65	165	INCONEL	1	28.0	20.0
66	166	TITANIUM	1	24.0	20.0
67	167	ALUMINUM	1	21.0	20.0
68	168	STEEL	2	42.0	21.0
69	169	COPPER	1	36.0	21.0
70	170	BRASS	1	23.0	21.0
71	171	INCONEL	1	29.0	21.0
72	172	TITANIUM	1	25.0	21.0
73	173	ALUMINUM	1	22.0	21.0
74	174	STEEL	2	44.0	22.0
75	175	COPPER	1	38.0	22.0
76	176	BRASS	1	24.0	22.0
77	177	INCONEL	1	30.0	22.0
78	178	TITANIUM	1	26.0	22.0
79	179	ALUMINUM	1	23.0	22.0
80	180	STEEL	2	46.0	23.0
81	181	COPPER	1	40.0	23.0
82	182	BRASS	1	25.0	23.0
83	183	INCONEL	1	31.0	23.0
84	184	TITANIUM	1	27.0	23.0
85	185	ALUMINUM	1	24.0	23.0
86	186	STEEL	2	48.0	24.0
87	187	COPPER	1	42.0	24.0
88	188	BRASS	1	26.0	24.0
89	189	INCONEL	1	32.0	24.0
90	190	TITANIUM	1	28.0	24.0
91	191	ALUMINUM	1	25.0	24.0
92	192	STEEL	2	50.0	25.0
93	193	COPPER	1	44.0	25.0
94	194	BRASS	1	27.0	25.0
95	195	INCONEL	1	33.0	25.0
96	196	TITANIUM	1	29.0	25.0
97	197	ALUMINUM	1	26.0	25.0
98	198	STEEL	2	52.0	26.0
99	199	COPPER	1	46.0	26.0
100	200	BRASS	1	28.0	26.0
101	201	INCONEL	1	34.0	26.0
102	202	TITANIUM	1	30.0	26.0
103	203	ALUMINUM	1	27.0	26.0
104	204	STEEL	2	54.0	27.0
105	205	COPPER	1	48.0	27.0
106	206	BRASS	1	29.0	27.0
107	207	INCONEL	1	35.0	27.0
108	208	TITANIUM	1	31.0	27.0
109	209	ALUMINUM	1	28.0	27.0
110	210	STEEL	2	56.0	28.0
111	211	COPPER	1	50.0	28.0
112	212	BRASS	1	30.0	28.0
113	213	INCONEL	1	36.0	28.0
114	214	TITANIUM	1	32.0	28.0
115	215	ALUMINUM	1	29.0	28.0
116	216	STEEL	2	58.0	29.0
117	217	COPPER	1	52.0	29.0
118	218	BRASS	1	31.0	29.0
119	219	INCONEL	1	37.0	29.0
120	220	TITANIUM	1	33.0	29.0
121	221	ALUMINUM	1	30.0	29.0
122	222	STEEL	2	60.0	30.0
123	223	COPPER	1	54.0	30.0
124	224	BRASS	1	32.0	30.0
125	225	INCONEL	1	38.0	30.0
126	226	TITANIUM	1	34.0	30.0
127	227	ALUMINUM	1	31.0	30.0
128	228	STEEL	2	62.0	31.0
129	229	COPPER	1	56.0	31.0
130	230	BRASS	1	33.0	31.0
131	231	INCONEL	1	39.0	31.0
132	232	TITANIUM	1	35.0	31.0
133	233	ALUMINUM	1	32.0	31.0
134	234	STEEL	2	64.0	32.0
135	235	COPPER	1	58.0	32.0
136	236	BRASS	1	34.0	32.0
137	237	INCONEL	1	40.0	32.0
138	238	TITANIUM	1	36.0	32.0
139	239	ALUMINUM	1	33.0	32.0
140	240	STEEL	2	66.0	33.0
141	241	COPPER	1	60.0	33.0
142	242	BRASS	1	35.0	33.0
143	243	INCONEL	1	41.0	33.0
144	244	TITANIUM	1	37.0	33.0
145	245	ALUMINUM	1	34.0	33.0
146	246	STEEL	2	68.0	34.0
147	247	COPPER	1	62.0	34.0
148	248	BRASS	1	36.0	34.0
149	249	INCONEL	1	42.0	34.0
150	250	TITANIUM	1	38.0	34.0
151	251	ALUMINUM	1	35.0	34.0
152	252	STEEL	2	70.0	35.0
153	253	COPPER	1	64.0	35.0
154	254	BRASS	1	37.0	35.0
155	255	INCONEL	1	43.0	35.0
156	256	TITANIUM	1	39.0	35.0
157	257	ALUMINUM	1	36.0	35.0
158	258	STEEL	2	72.0	36.0
159	259	COPPER	1	66.0	36.0
160	260	BRASS	1	38.0	36.0
161	261	INCONEL	1	44.0	36.0
162	262	TITANIUM	1	40.0	36.0
163	263	ALUMINUM	1	37.0	36.0
164	264	STEEL	2	74.0	37.0
165	265	COPPER	1	68.0	37.0
166	266	BRASS	1	39.0	37.0
167	267	INCONEL	1	45.0	37.0
168	268	TITANIUM	1	41.0	37.0
169	269	ALUMINUM	1	38.0	37.0
170	270	STEEL	2	76.0	38.0
171	271	COPPER	1	70.0	38.0
172	272	BRASS	1	40.0	38.0
173	273	INCONEL	1	46.0	38.0
174	274	TITANIUM	1	42.0	38.0
175	275	ALUMINUM	1	39.0	38.0
176	276	STEEL	2	78.0	39.0
177	277	COPPER	1	72.0	39.0
178	278	BRASS	1	41.0	39.0
179	279	INCONEL	1	47.0	39.0
180	280	TITANIUM	1	43.0	39.0
181	281	ALUMINUM	1	40.0	39.0
182	282	STEEL	2	80.0	40.0
183	283	COPPER	1	74.0	40.0
184	284	BRASS	1	42.0	40.0
185	285	INCONEL	1	48.0	40.0
186	286	TITANIUM	1	44.0	40.0
187	287	ALUMINUM	1	41.0	40.0
188	288	STEEL	2	82.0	41.0
189	289	COPPER	1	76.0	41.0
190	290	BRASS	1	43.0	41.0
191	291	INCONEL	1	49.0	41.0
192	292	TITANIUM	1	45.0	41.0
193	293	ALUMINUM	1	42.0	41.0
194	294	STEEL	2	84.0	42.0
195	295	COPPER	1	78.0	42.0
196	296	BRASS	1	44.0	42.0
197	297	INCONEL	1	50.0	42.0
198	298	TITANIUM	1	46.0	42.0
199	299	ALUMINUM</			

Table A-XII. Domestic Airplane Sensitivity Factors - Model 768-869

MODEL 769-869
(CF6-50C ENGINES)
5% CHANGE

	BASED CYCLE	5% FNCR +/-	5% SFC +/-	5% CR DRAG +/-	5% OEW +/-	5% FFNT0 +/-
TOGW	257350	-0.3/+0.4	+1.2/-1.5	+2.0/-1.9	+6.1/-5.7	-0.5/+0.8
OEW	160940	-0.2/+0.2	+1.6/-0.8	+1.1/-1.0	+8.5/-7.9	-1.0/+1.3
MEW	149540	-0.2/+0.2	+0.9/-0.9	+1.2/-1.1	+8.7/-8.1	-1.0/+1.4
BLKF	41730	-1.2/+1.8	+4.7/-4.6	+6.4/-5.8	+3.9/-3.5	-0.3/+1.1
SLST	37970	-0.3/+0.4	+1.1/-1.4	+2.2/-2.1	+5.6/-5.2	-5.2/+6.2
196 PASSENGERS 2000 N.MI. RANGE TOFL = 6000 FT WING LOADING = 105 LB/SQ FT						

Table A-XIII. Domestic Airplane Sensitivity Factors - Model 768-868

MODEL 768-868
(G.E. ADVANCED TECHNOLOGY ENGINES)
5% CHANGE

	BASED CYCLE	5% FNCR +/-	5% SFC +/-	5% CR DRAG +/-	5% OEW +/-	5% FFNT0 +/-
TOGW	243600	-0.1/+0.3	+1.4/-1.4	+1.7/-1.5	+6.3/-5.8	-0.7/+1.1
OEW	156930	-0.1/+0.1	+0.7/-0.7	+0.9/-0.8	+8.5/-7.9	-1.0/+1.5
MEW	145530	-0.1/+0.2	+0.8/-0.7	+1.0/-0.9	+8.8/-8.1	-1.1/+1.6
BLKF	34400	-0.6/+1.3	+4.6/-4.5	+5.8/-5.1	+4.3/-3.8	+0.4/+0.8
SLST	37710	-0.1/+0.2	+1.3/-1.2	+1.9/-1.7	+5.8/-5.3	-5.4/+6.4
196 PASSENGERS 2000 N.MI. RANGE TOFL = 6000 FT WING LOADING = 100 LB/SQ FT						

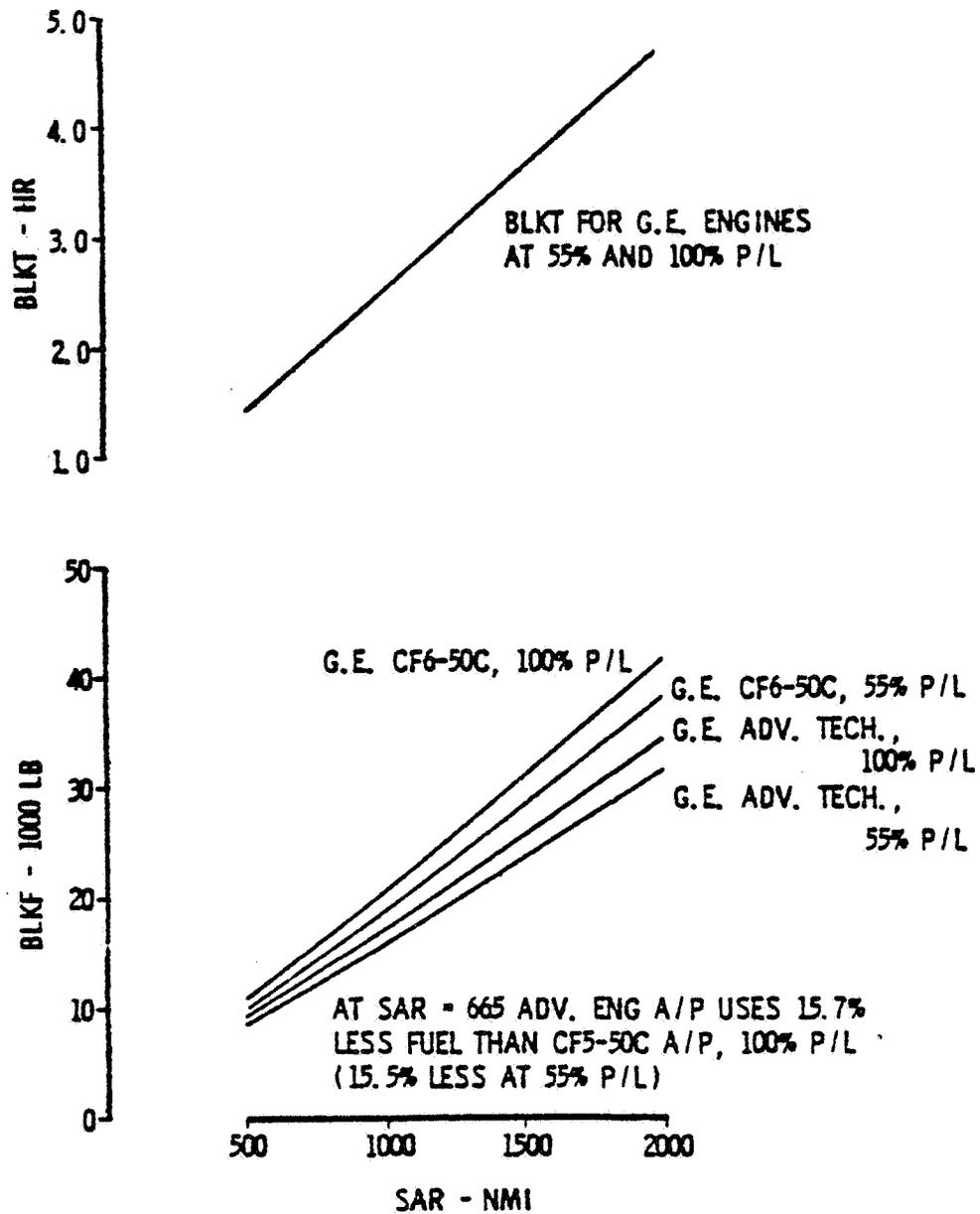


Figure A-14. Block Fuel Comparison

over the earlier study. This improvement is explained by a more accurate accounting of specific fuel consumption (SFC) reduction for the ATE engine during climb and descent mission segments. Allowing a 1% TSFC improvement over the lifetime of the engine for performance retention improves these savings by about 0.9% as shown in Figure A-15.

A breakdown in fuel used during various mission segments is shown in Figure A-16. The large percentage of fuel burned during climb for typical stage lengths shows the importance of maintaining the advance-engine SFC improvement at climb power setting.

Overall fuel burned improvement for the ATE-powered airplane was about 15% to 18% for all payload-range combinations. Reduced engine-out windmilling drag could improve takeoff performance or reduce the engine size at a given TOFL constraint.

5.4 TYPICAL MISSION DOC AND ROI

Results of the economic analysis for the GE E³ program are presented in Tables A-XIV, A-XV, and A-XVI. The initial economic analysis (Table A-XIV) was based on the May 8, 1978 engine data of Reference 3. This analysis considered three fuel prices of 35, 40 and 45 /gal and used a typical range of 665 nmi. GE updated the engine data prior to the November 20-21, 1978 preliminary design review (PDR). This later data was used to update the economic analysis summarized in Table A-XV. This updated analysis was for 40 /gal fuel and mission stage lengths of 665, 1000, and 2000 nmi. Also considered in this analysis was the effect of a 1% TSFC improvement allowance for performance retention over the engine life.

In comparison with current high bypass ratio engine prices GE's ATE engine price appeared higher than could be supported by a competitive market. Based on this consideration Boeing projected an engine price approximately 22% lower than the GE-estimated price. The effect of this lower price on DOC and ROI is shown in Table A-XV.

A summary of DOC improvement for the November 20-21, 1978 PDR status is shown in Figure A-17. At the design mission the NASA 5% DOC improvement goal is exceeded for all ranges when the lower Boeing estimated engine price is used; however, when the GE price is used only the design-mission DOC exceeds the goal.

The DOC and ROI calculations were based on methods discussed in section 4.6. In addition the following assumptions were used in the airplane ROI calculations:

- a. Airplane ROI is the rate that makes the present value of future net annual cash inflows equal to the outflow at the time of equipment purchase.
- b. Cash flows and their timing are considered as follows:

<u>Time prior to delivery</u>	<u>Percent (%) of price paid</u>
-------------------------------	----------------------------------

15 mo.	20
12 mo.	5
9 mo.	5
6 mo.	5
0 mo. (delivery)	65 + spares

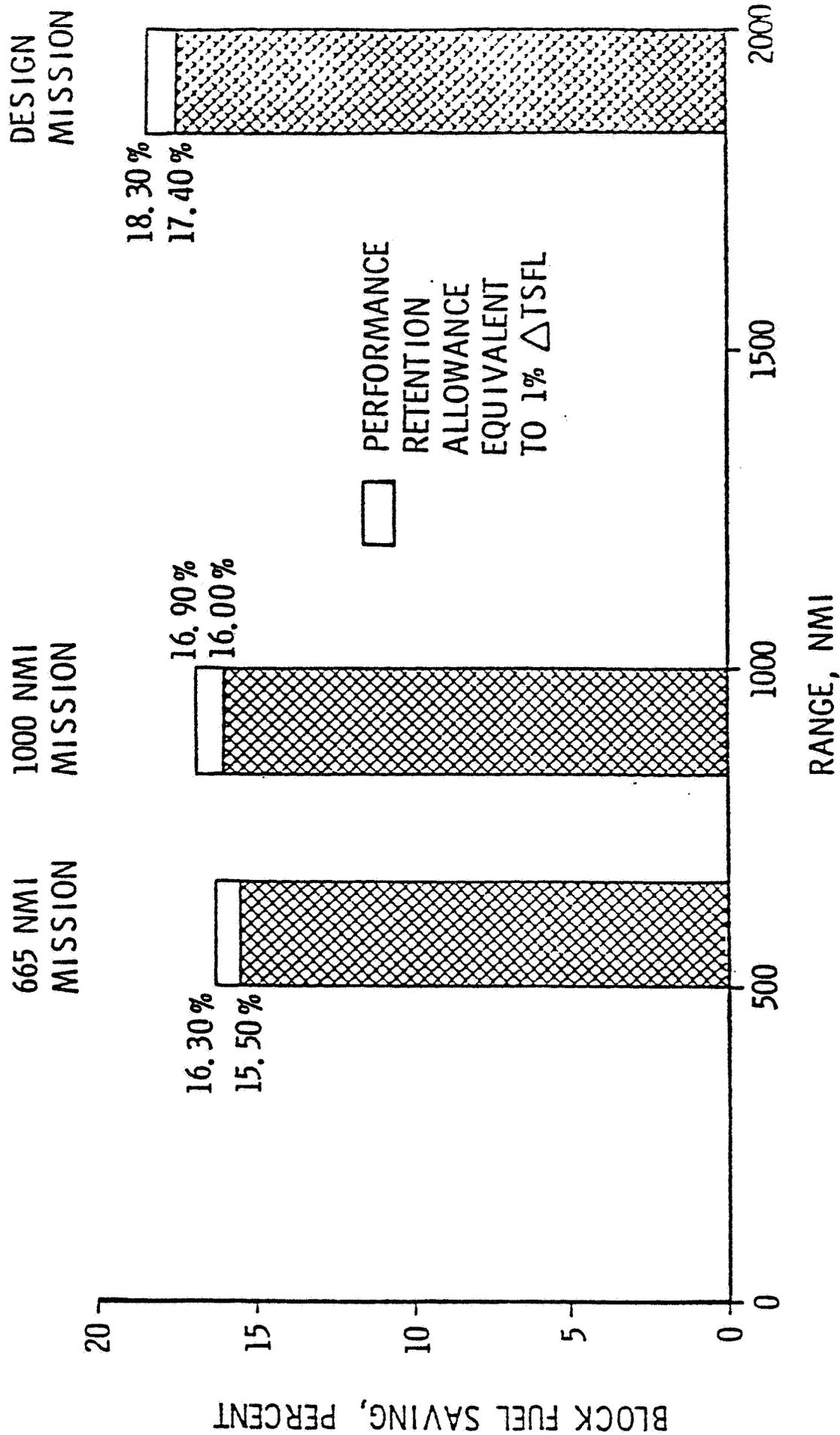
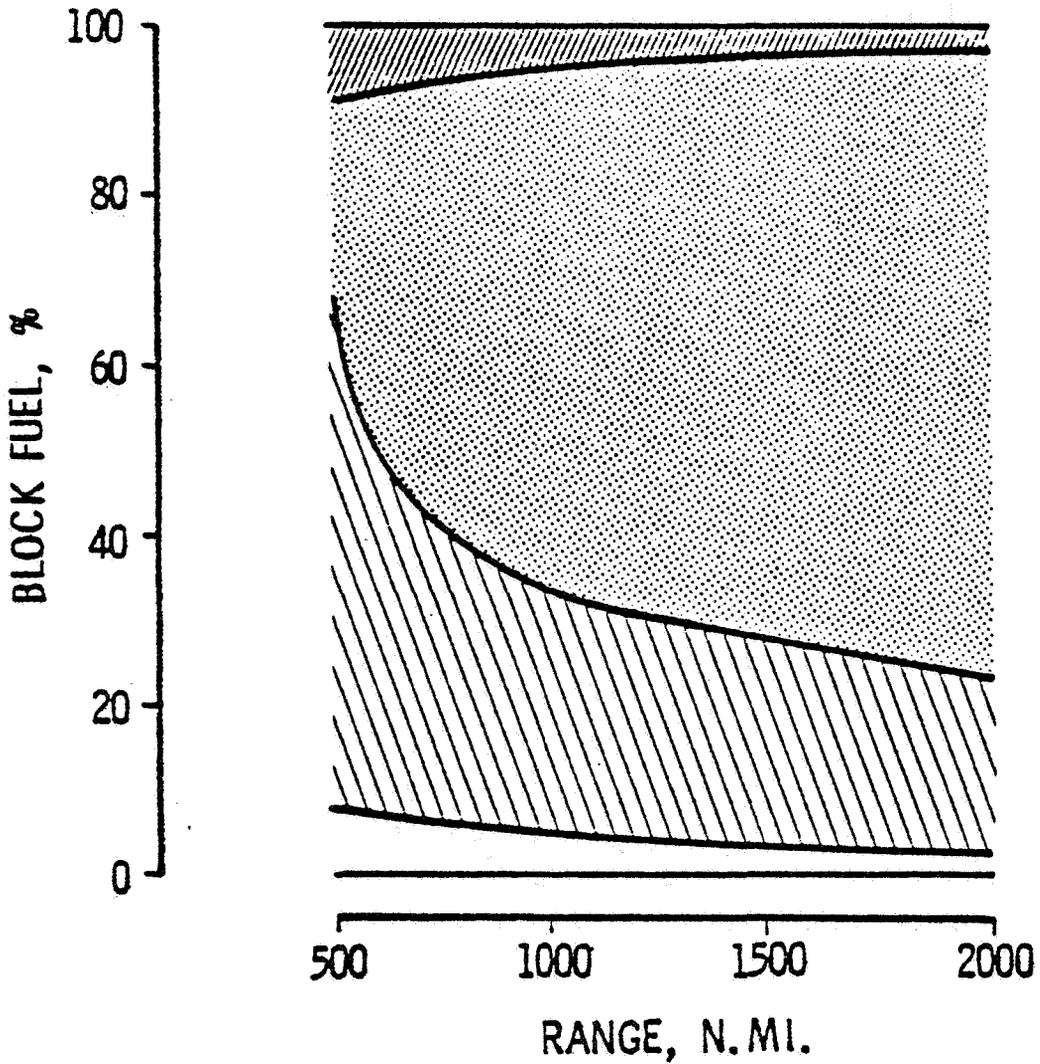


Figure A-15. November 1978 PDR Status Fuel Saving



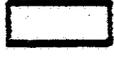
-  DESCENT + APPROACH + TAXI
-  CRUISE
-  CLIMB + ACCELERATION
-  TAXI + TAKEOFF

Figure A-16. Percent Block Fuel by Mission Profile Segment

Table A-XIV. Initial Economic Analysis

- MAY 1978 ENGINE DATA
- 665 N.MI. TYPICAL MISSION

ENGINE	CF6-50C			G.E. - E ³ ENGINE		
	35	40	45	35	40	45
FUEL /GAL						
DOC: (\$ MILLIONS/YEAR)	5.072	5.253	5.435	4.935	5.089	5.242
FUEL	1.273	1.455	1.637	1.076	1.230	1.383
CREW	1.092	--	--	1.076	--	--
INSURANCE	0.111	--	--	0.114	--	--
BURDEN	0.500	--	--	0.494	--	--
ENGINE LABOR	0.084	--	--	0.081	--	--
ENGINE MATERIAL	0.273	--	--	0.233	--	--
AIRFRAME LABOR	0.166	--	--	0.166	--	--
AIRFRAME MATERIAL	0.123	--	--	0.123	--	--
DEPRECIATION	1.449	--	--	1.568	--	--
AIRPLANE AFTER TAX						
ROI (%)	11.55	11.0	10.4	11.53	11.1	10.7
INCREMENTAL AFTER TAX						
ROI (%)				4.2	5.5	6.8

Table A-XV. November 1978 PDR Status Economic Analysis

55% PAYLOAD

ENGINE	CF6-50C			GE - E ³ ENGINE PERFORMANCE RETENTION = 1% TSFC			G.E.-E ³ ENGINE		
	665	1000	2000	655	1000	2000	665	1000	2000
RANGE N.MI.									
DOC: (\$ MILLIONS/YEAR)	5.253	5.431	6.107	5.021	5.163	5.716	5.033	5.176	5.732
FUEL (\$ 0.40/GALLON)	1.455	1.599	2.118	1.218	1.328	1.730	1.230	1.341	1.746
CREW	1.092	1.154	1.308	1.076	1.137	1.289	1.076	1.137	1.289
INSURANCE	0.111	0.111	0.111	0.118	0.118	0.118	0.118	0.118	0.118
BURDEN	0.500	0.489	0.492	0.494	0.480	0.483	0.494	0.480	0.483
ENGINE LABOR	0.084	0.082	0.079	0.081	0.078	0.074	0.081	0.078	0.074
ENGINE MATERIAL	0.273	0.264	0.259	0.177	0.170	0.163	0.177	0.170	0.163
AIRFRAME LABOR	0.166	0.163	0.167	0.166	0.163	0.167	0.166	0.163	0.167
AIRFRAME MATERIAL	0.123	0.120	0.124	0.123	0.121	0.124	0.123	0.121	0.124
DEPRECIATION	1.4	1.4	1.4	1.568	1.568	1.568	1.568	1.568	1.568
AIRPLANE AFTER TAX									
ROI:	11.0	13.1	15.7	11.3	13.3	16.0	11.3	13.3	16.0
INCREMENTAL AFTER TAX									
ROI:				7.7	9.2	13.8	7.2	8.7	13.2

Table A-XVI. November 1978 PDR Status Economic Analysis (Boeing Engine Price)

- NOVEMBER 1978 PDR STATUS, 1% TSFC PERFORMANCE RETENTION ALLOWANCE
- BOEING E³ ENGINE PRICE
- 55% PAYLOAD

ENGINE	CF6-50C			G.E. - E ³ ENGINE		
	665	1000	2000	665	1000	2000
RANGE, N.MI.						
DOC: (\$ MILLIONS/YEAR)	5.253	5.431	6.107	4.951	5.093	5.646
FUEL (\$0.40/GALLON)	1.455	1.599	2.118	1.218	1.328	1.730
CREW	1.092	1.154	1.308	1.076	1.137	1.289
INSURANCE	0.111	0.111	0.111	0.114	0.114	0.114
BURDEN	0.500	0.489	0.492	0.494	0.480	0.483
ENGINE LABOR	0.084	0.082	0.079	0.081	0.078	0.074
ENGINE MATERIAL	0.273	0.264	0.259	0.177	0.170	0.163
AIRFRAME LABOR	0.166	0.163	0.167	0.166	0.163	0.167
AIRFRAME MATERIAL	0.123	0.120	0.124	0.123	0.121	0.124
DEPRECIATION	1.449	1.449	1.449	1.502	1.502	1.502
AIRPLANE AFTER TAX						
ROI (%)	11.0	13.1	15.7	11.8	13.9	16.6
INCREMENTAL AFTER TAX						
ROI (%)				21.4	23.9	31.9

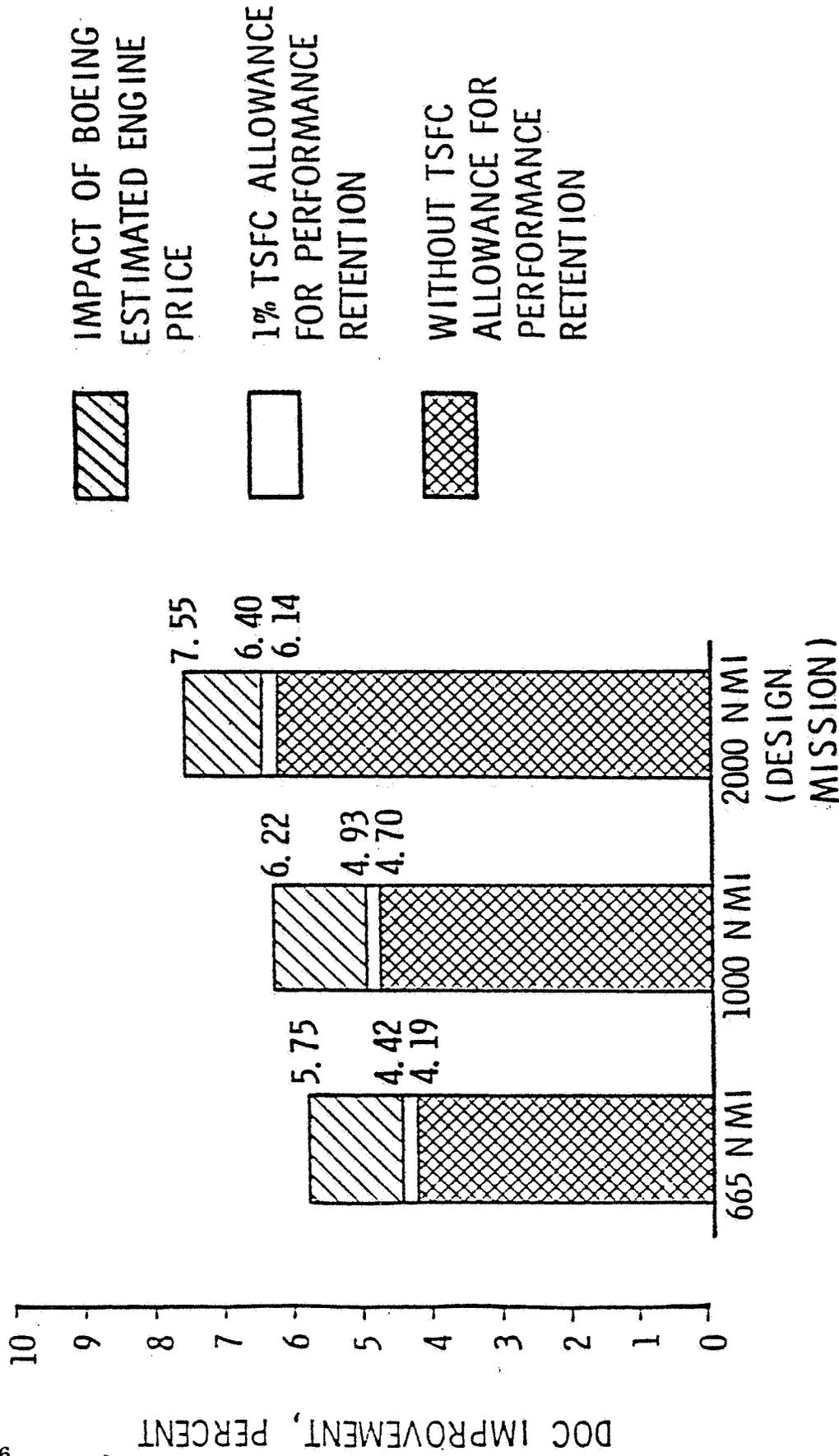


Figure A-17. November 1978 PDR Status Direct Operating Cost Comparison

- c. Investment tax credit of 10% spread over the first three years of operation.
- d. Annual operating costs and revenue at stated missions and load factors.
 - Accelerated depreciation for tax purposes (sum of years digits method)
 - Income taxes at 48%
- e. Airplane life is 15 years and residual value is 10% of price plus spares (new airplane).

Since airplane ROI is based on airplane profitability compared to total airplane costs, it measures the value of investing in the total airplane system. On the other hand, incremental ROI, as shown in Tables A-XIV, A-XV, and A-XVI, was based on savings realized by using the ATE compared to its increased price. Incremental ROI thus shows return on only the money invested in the engine. Because the airplane performance and cost differences between the CF6-50C and ATE-powered airplanes are minimal, the improved economics are generated primarily by engine improvements. It is therefore more realistic to use incremental ROI for deciding the economic value of the new engine.

6.0 ENGINE/AIRPLANE INTEGRATION

This section describes the Boeing assessment and evaluation of the GE designed ATE engine/nacelle installation defined by GE drawings, References 6, 7, 8 and 9. Comparison of nacelle features with Boeing standards and airline requirements is covered where appropriate.

6.1 NACELLE ARRANGEMENT AND CONSTRUCTION

The inlet and major nacelle dimensions were generally consistent with Boeing practice. Aerodynamic lines for a nacelle simulator model were evaluated, and results in Reference 5.

Being preliminary, the GE drawings lacked numerous construction details, and in-depth critique of detail construction was not possible. Comments were provide on areas where some detail was shown. Figure A-18 represents the GE designed nacelle.

a. Inlet

Apparently the attachment between inlet and cowl/engine structure is provided by means of bolts installed in a clevis with the bolt installed in a radial direction. To maintain internal and external contour control, the clevis surfaces must be machined very accurately, otherwise the contours will be subject to steps and gaps which are not aerodynamically acceptable. The potential for bolt to hole misalignment is also very high. Access to the bolt heads is not apparent. The load path between the inlet and engine/cowl structure appears to be very soft and subject to deflection, which will also increase the gaps on both inner and outer flow surfaces. The inlet bulkhead form is not conducive to attachment of bulkhead connectors for electrical, pneumatic, or hydraulic lines, so passing services through the bulkhead will be difficult.

b. Fan Case and Cowl

Due to the integrated nature of the fan case and fan cowl it is important to examine the interface details to ensure compatibility. Comments have already been made relative to the inlet attachment. The interface at the forward tongue and groove joint must pass radially upward to gain access to the core mounted accessories, but it is not clear where the break in the outer shell is located. The section of honeycomb forward of the reverser seal appears to be an extension of the outer fan case/cowl, yet the inner wall of the reverser illustrates seals and means for opening the ducts. More clarification in this area is needed.

In the absence of a primary reverser the diffusing primary gas will tend to flow forward when the fan flow is being reversed. For this reason the materials in the fan duct/cowl must be chosen carefully to prevent inadvertent structural damage from hot gases or provide some controlled leakage through the blocker door array.

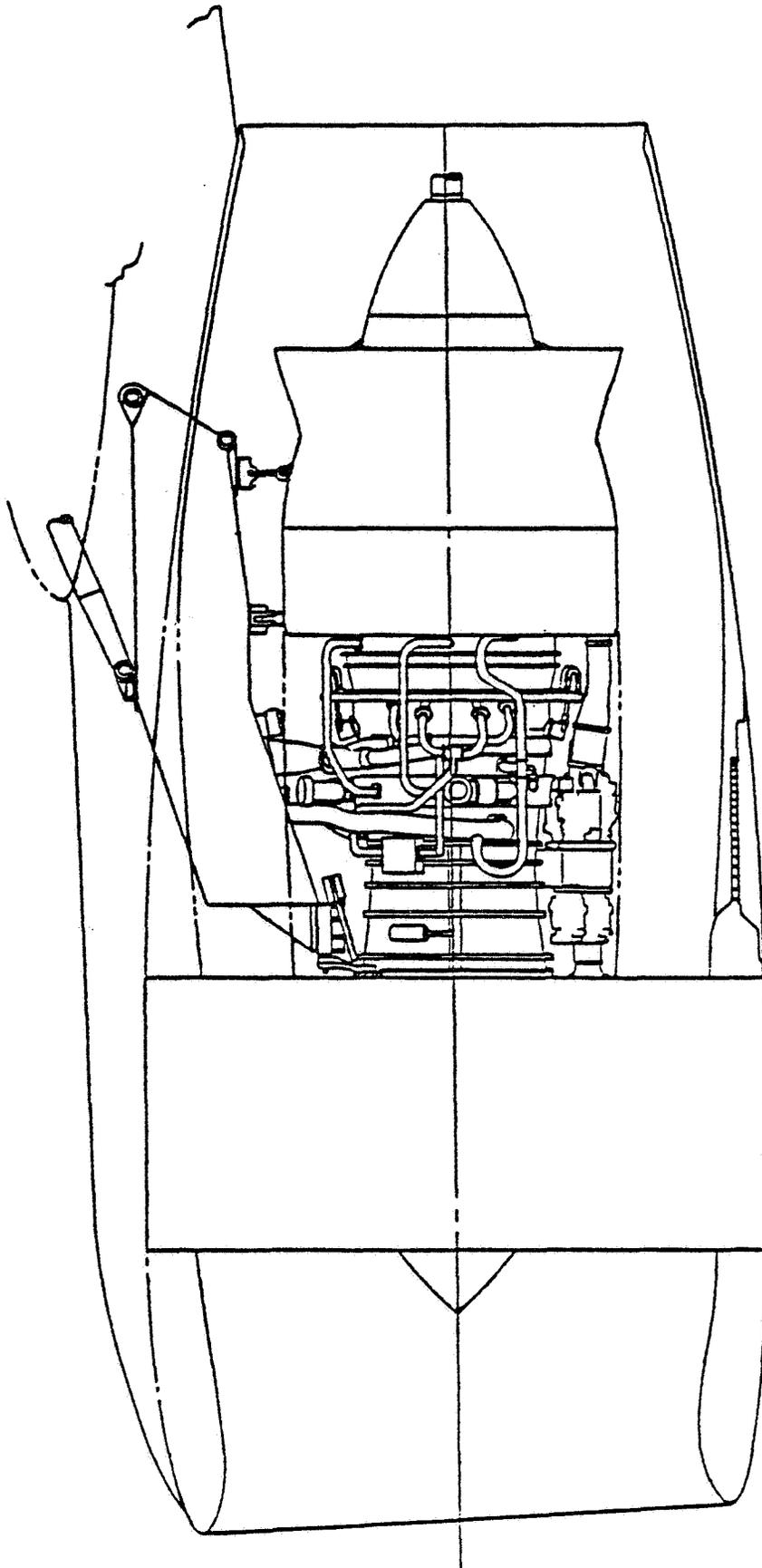


Figure A-18. General Electric Energy Efficient Nacelle

The controlled leakage concept must be evaluated very carefully because for each pound of forward thrust generated the system is penalized 3 pounds of reverse thrust.

The seal and V groove between the fan duct/cowl and the tailpipe is not continuous at the top and thus hoop loads must be carried around the slot made by the strut penetration. This can cause serious stress concentrations at the aft end of the slot, as well as problems with supporting the pressure load on the flat sides of the strut and nozzle.

The duct inner wall contour shown does not provide room for a longeron or latches at the bottom centerline. Minimum acceptable clearance between accessory items and cowl structure is 0.375 inches. This contour also is too tight for installation of an accessory drain system, or cowl venting provisions.

The air seal (garlock type) at the forward end of the fan duct inner wall appears to be backwards, unless the accessory compartment is pressurized to a level greater than fan duct pressure. If the compartment pressure is higher than fan duct pressure, drainage and venting of the compartment will be difficult if exterior aerodynamic losses are to be avoided. Since no lower bifurcation is shown clarification of the vent and drain system is needed.

At the aft end of the fan duct outer wall of the V groove joint should be inverted to facilitate opening the main cowl for access to the accessories. The configuration as shown has no lower bifurcation, and thus the system requires the following sequence of operation to gain access to the accessories.

1. Unlatch and remove the tailpipe.
2. Unlatch and remove or hinge outer fan duct wall and reverser up and out of the way.
3. Remove the inner fan duct wall by unlatching and removing.

This is necessary to gain access each time a mechanic wishes to check the oil or any other routine maintenance task. This would not be acceptable to most airlines.

c. Fan Thrust Reverser

Location of the actuation mechanism for the reverser is not apparent. The space between inner and outer fan case walls appears marginal for installation of an actuation system for the reverser. The logical place for actuation is occupied by the cascades and the structural thickness of the fan cowl limits putting the actuator in the line with the sleeve. The axial length provided in the outer fan duct ahead of the cascades and aft of the sweep plane for duct opening is not adequate for installation of an actuator with 29-inch stroke.

Further concerns relative to the thrust reverser include the method of providing positive longitudinal sealing in the stowed position, the interference of the door leading edge with duct structure during translation, and the blockage door angle in the deployed position.

These concerns are illustrated by Figure A-19. With regard to the door angle, Boeing data show a 90 degree door angle (i.e., perpendicular to the duct wall) to give the most effective thrust reversing and highest effective area.

d. Mixer

Details of the mixer attachment are lacking. It appears that the engine plug is attached and supported from the outer engine exhaust case.

The purpose of the link between the plug and lobe valley is not clear. It appears to be for support of the lobe of the mixer, but as drawn it could impose loads on the mixer and change the primary/secondary area relationship. Since the plug is always bathed in primary flow up to the link and the lobe is bathed by both fan and primary flow, the plug will grow thermally more than the mixer. When this happens the link will move aft at the plug attached end and thus pull the lobe inward. To be neutral in its motion the link should be more nearly perpendicular to the plug contour. The link must also be positioned such that it does not change the area ratio.

c. Tailpipe

The joint between the tailpipe and the fan duct should be inverted to allow for the simplest and lightest construction of the tailpipe.

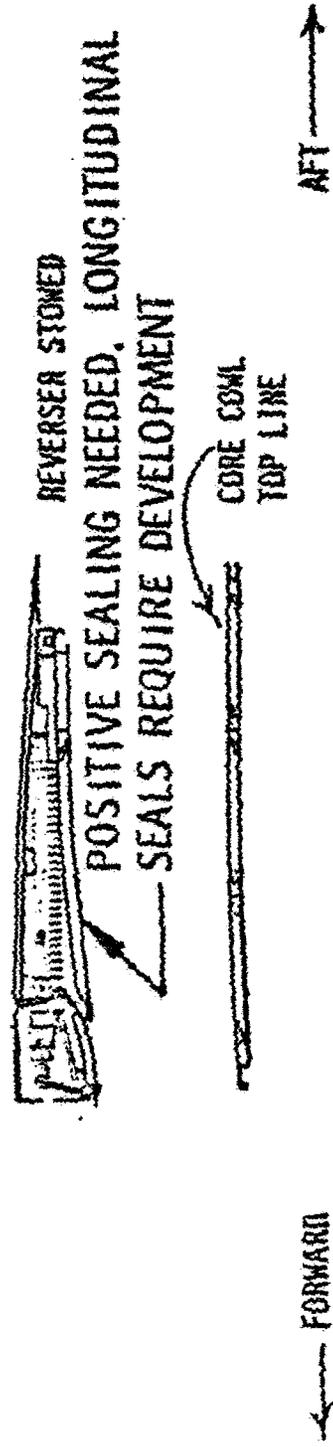
6.2 AIRFRAME ACCESSORY REQUIREMENTS AND LOCATION

Hydraulic and electric loads are shown in Figures A-20 and A-21. These loads can be handled by one hydraulic pump and one alternator on each engine gear box.

Gearbox and accessory location studies generally have shown the core mounting to have the least weight and best performance; however, accessibility, especially in a long duct nacelle, is not as good as for the chin-mounted accessories.

Table A-XVII presents a general study of accessory location. A numerical rating system, where 0 is unacceptable and 5 is the best or most acceptable, was used to obtain an overall figure of merit. Recent surveys of Boeing customers showed that chin mounting and core mounting had widest acceptance. There also appeared to be a strong feeling against split gearboxes. Gearboxes apparently are high-maintenance items and airlines believe that splitting a gearbox increases its maintenance problems significantly. Another important consideration was the fuel spill requirement (DOT/FAA order 8110.19) that

THRUST REVERSE MECHANICAL ARRANGEMENT



DOOR LEADING EDGE INTERFERES WITH DUCT STRUCTURE DURING TRANSLATION

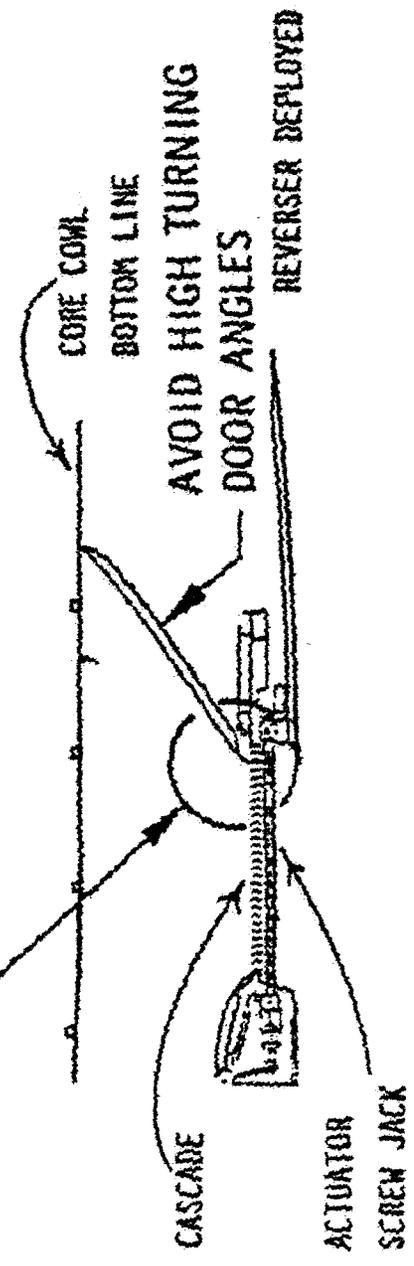
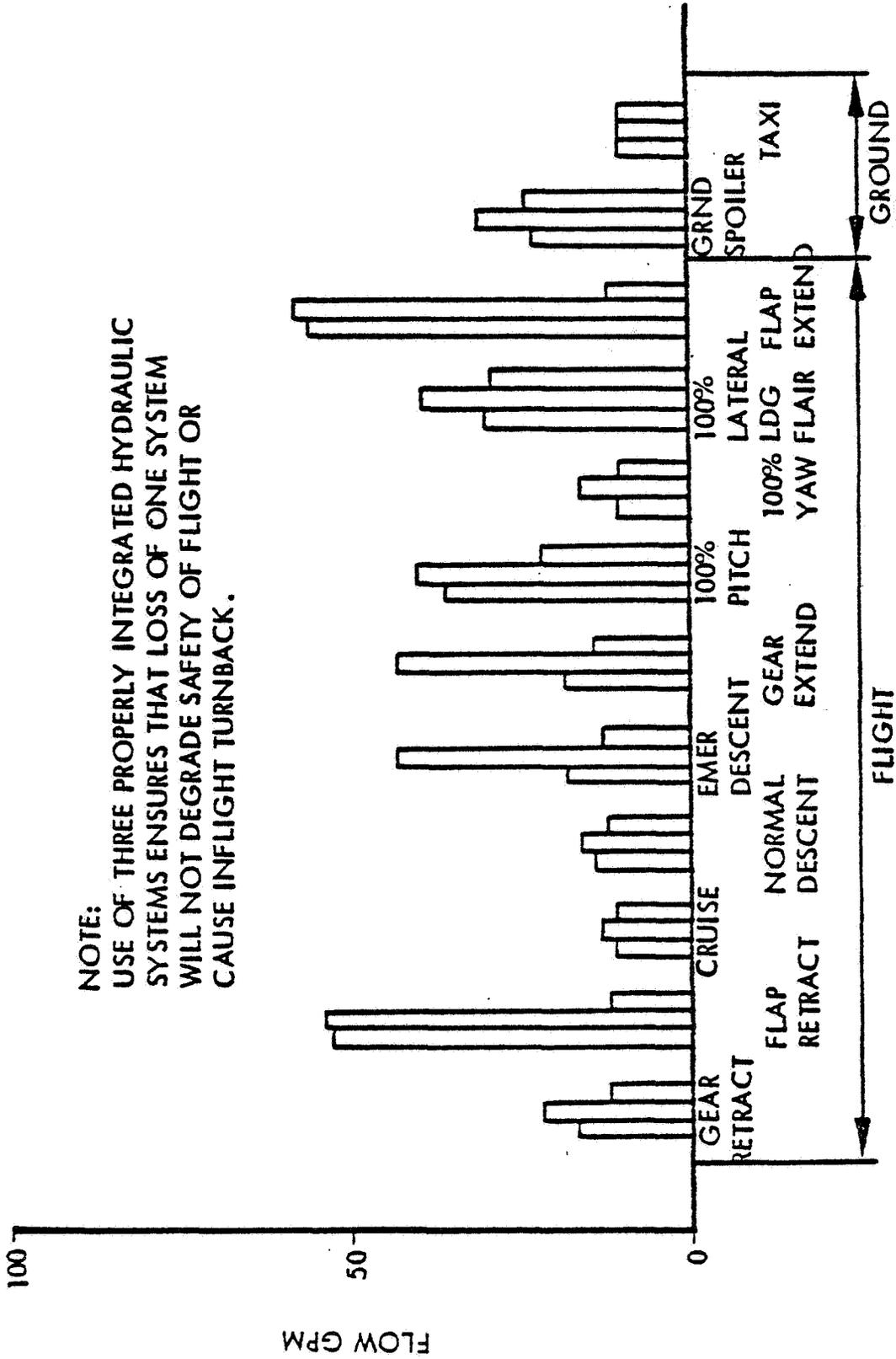


Figure A-19. Thrust Reverse Concerns



NOTE:
 USE OF THREE PROPERLY INTEGRATED HYDRAULIC
 SYSTEMS ENSURES THAT LOSS OF ONE SYSTEM
 WILL NOT DEGRADE SAFETY OF FLIGHT OR
 CAUSE INFLIGHT TURNBACK.

Figure A-20. Hydraulic Loads

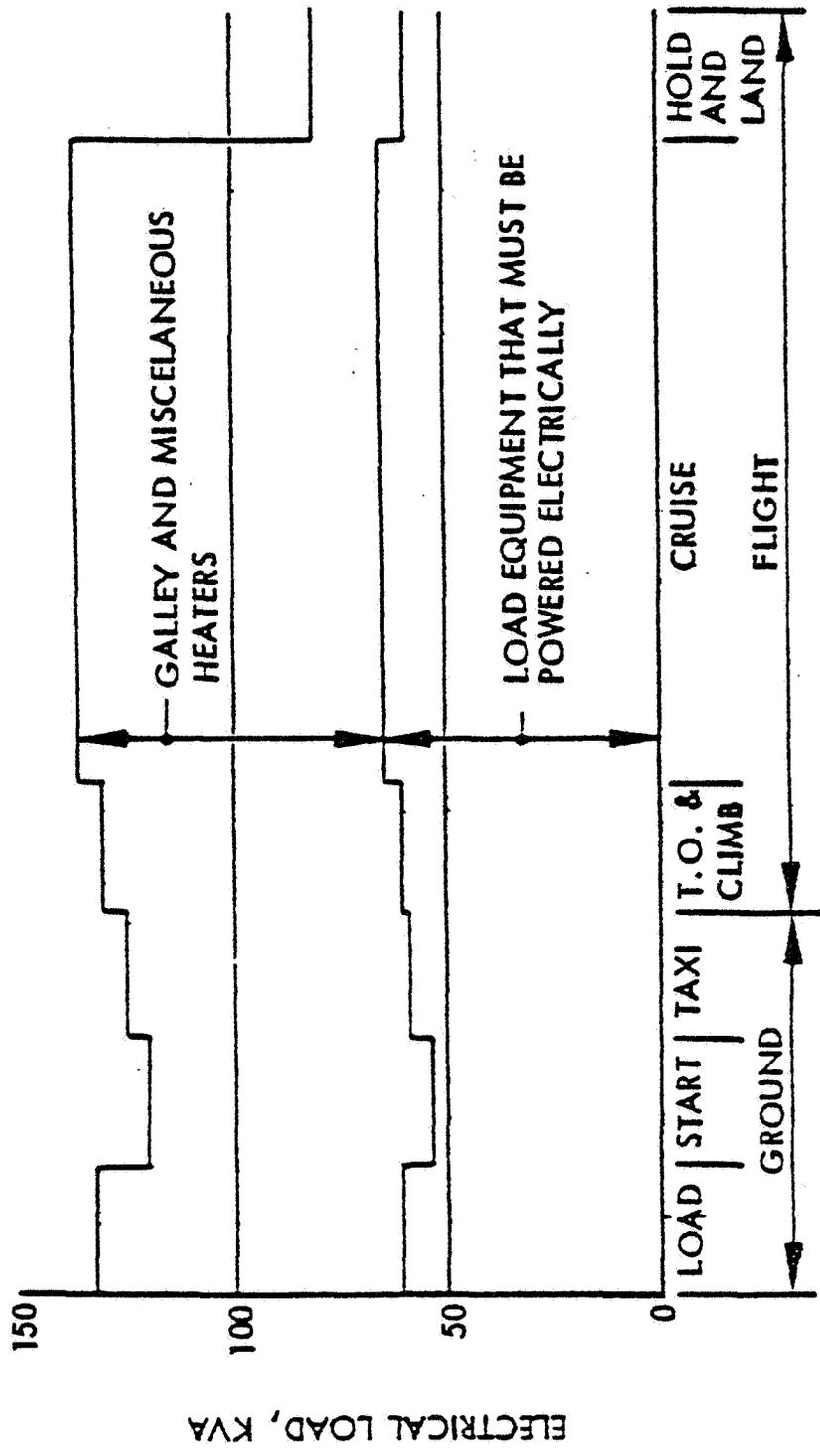


Figure A-21. Electric Loads

Table A-XVII. E³ Engine Gear Box Location Study

	Core Mount	Split Fuel Pump Top	Fuel Pump Bottom	Split Fan Frame at 60° and 270°	Fan Chin	Top Only
Fuel Spill per DOT/FAA order 8110.19	5	5	0	5	0	5
Accessibility to accessories	4	3	3	5	5	1
Heat rejection	2	5	5	5	5	5
Accessibility to variable IGV	2	5	5	5	5	5
Compatibility with load reduction	5	5	5	5	5	5
Compatibility with zero moment mount	2	5	5	5	5	5
Customer Acceptance	4	0	0	0	5	0
	24	28/0	23/0	35/0	30/0	26/0

Note: Rating 0 to 5, with 5 most acceptable and 0 not acceptable

specified that no fuel may be spilled during a wheels-up landing. The chin-mounted gearbox and engine fuel pump would be difficult to certify this requirement.

Table A-XVII reflects these considerations and shows the core-mounted gearbox to be the most acceptable location.

6.3 MAINTAINABILITY, ACCESSIBILITY, AND SAFETY

Maintainability, accessibility, and safety provisions were reviewed and found to be generally acceptable. The reference layouts did not contain sufficient detail, nor was it sufficiently complete, to warrant detailed study of these features.

6.4 FUEL HEATER SYSTEM

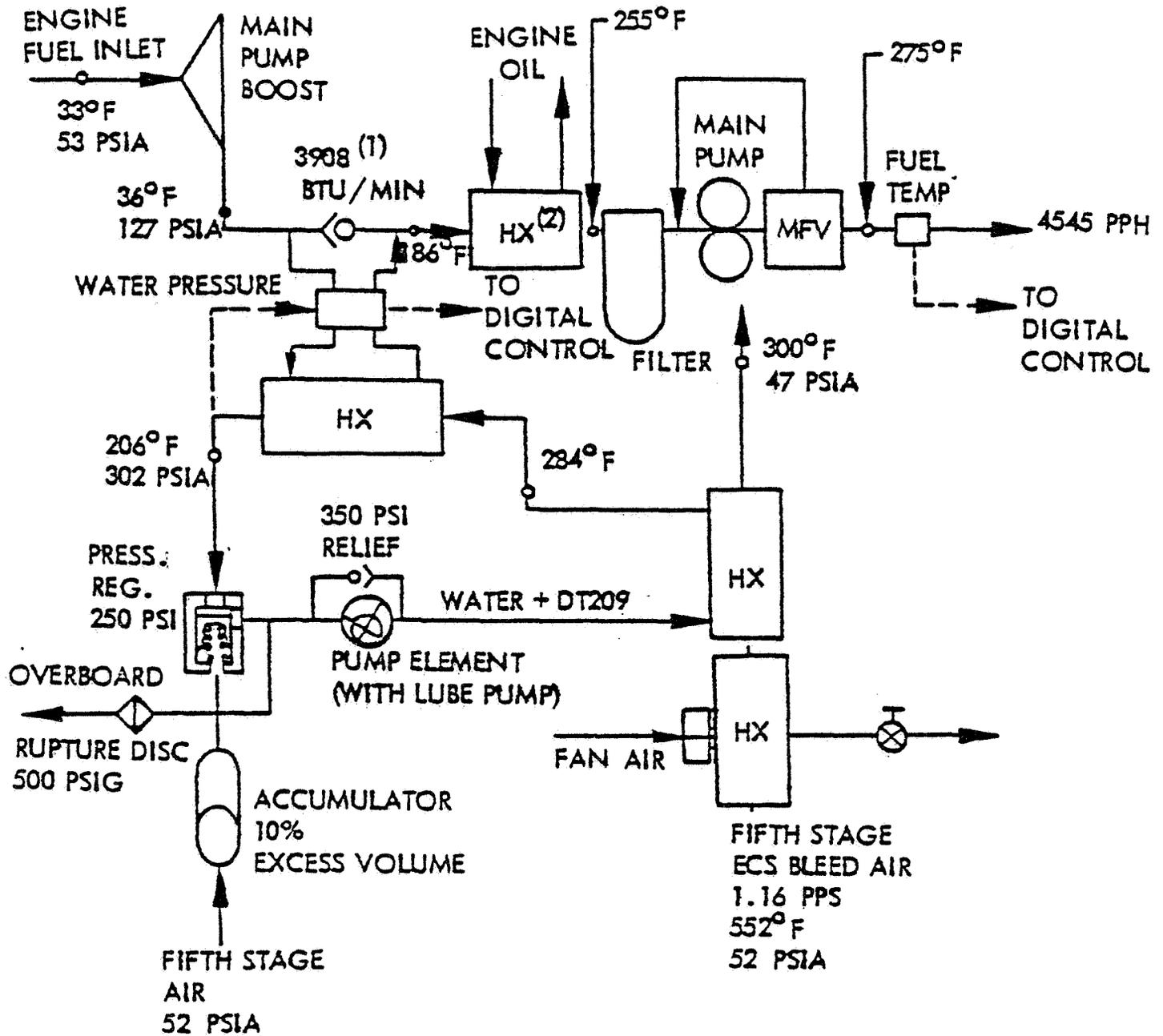
GE has proposed that engine fuel be used as a heat sink for cooling the ECS bleed air. This system will improve engine TSFC by retaining thermal energy in the engine cycle rather than dumping heat overboard by the conventional use of fan air for ECS air cooling. GE estimates a net TSFC improvement as high as 0.8% when both retained heat and elimination of fan-air bleed are considered. In the proposed system heat is transferred from the ECS air-to-water precooler to a water-to-fuel heat exchanger located in the fuel system between the boost-and high-pressure fuel-pump elements. The GE fuel-heater system is shown in Figure A-22.

As proposed the fuel-heater system becomes inadequate as a heat sink during maximum anti-icing operation. For such a condition one engine is considered inoperative, and using the heat sink from the remaining engine, the precooler is required to have sufficient capacity to provide cooled air for one airconditioning pack and thermal anti-icing air for one inlet cowl and both wings. The required capacity was provided by modifying the GE fuel-heater system as shown in Figure A-23 to include an air-to-air heat exchanger to supplement the fuel heat sink. In the Boeing modification, a control valve opens to permit fan airflow through the cool side of the supplemental heat exchanger as the fuel temperature approaches its upper limit of 275°F. During the maximum anti-icing condition the heat rejection rate of the bleed air increases to 26000 BTU/min compared to 3900 BTU/min during maximum cruise at 35000 ft. For safety the maximum temperature of the bleed air circulated through the airplane is 450°F and for operational reasons the minimum is 300°F.

The fuel-heater system has potential for fuel saving and should be further investigated. With additional study consideration could be given to elimination of the intermediate fluid between the fuel and air and to recirculation of fuel to the fuel tanks during anti-icing operation when a larger heat sink is required.

6.5 NACELLE MOUNT SYSTEM

The GE nacelle design and mount systems were continuously reviewed during the course of the current E³ study to ensure that the GE design



(1) Values shown for 35,000 maximum cruise with 1.16 PPS ECS Bleed.

(2) Lube oil/fuel HX would be downstream of main pump when ECS heat provides all fuel anti-ice heating.

Figure A-23. E³ - Fuel Heater System (Boeing Modification)

would meet Boeing criteria and design practices. The mount system illustrated in Figure A-18 reflects GE's attempt at resolving the issues that were raised during Boeing's review. Figure A-24 shows the GE mount system adapted to a Boeing-designed pylon structure.

The GE mount system departs from Boeing practice by using a four-point rather than a three-point support. This type of support must be designed to accommodate tolerance buildup and to avoid preloading and indeterminate load paths. Because of the preliminary nature of the mount design Boeing did not attempt a detail structural assessment.

Boeing would prefer a three-point support system; however, the four-point system with proper design considerations will meet Boeing criteria. A definite advantage of the four point support system is that it has a potential for reducing engine bending, one of the causes of performance deterioration in current engines. The GE mount system may thus aid in meeting performance retention goals of the E³ program.

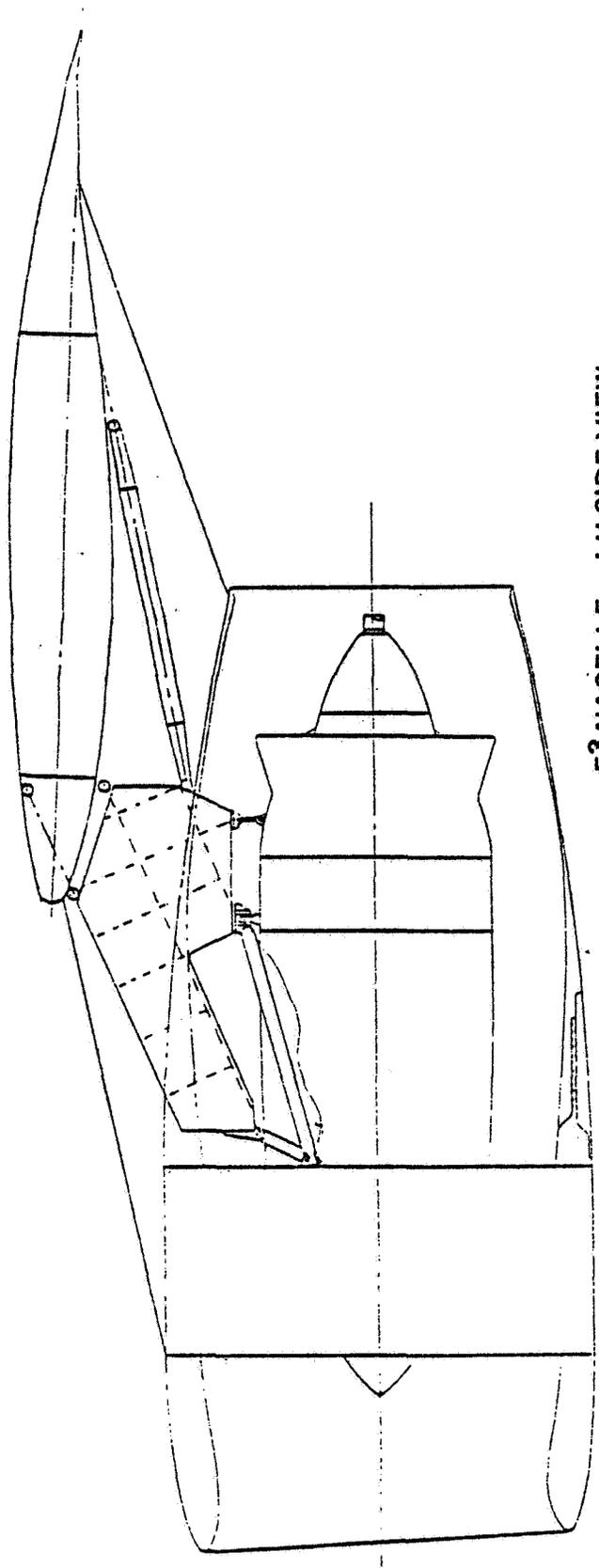
The loads shown on Table A-XVIII give Boeing engine mount design criteria. Table A-XIX summarizes resultant airloads that occur once per flight. Figures A-25, A-26, A-27, and A-28 illustrate the airloads on the nacelle from which the resultants of Table XIX were derived. These loads were estimated using data from flight test, wind tunnel test, and analysis. They were based on a 45,500 lb SLST engine and must be scaled to the E³ thrust levels for use in designing E³ nacelle components.

6.6 NACELLE MATERIAL

Boeing was in general agreement with the type of nacelle materials selected by GE. Boeing had good results with Kevlar/aluminum containment structures in laboratory experiments, and based on this experience the fan containment concept shown appears feasible. Boeing used Dyna Rohr in the inlet cowling of the 737 for about two years and experience was acceptable.

Graphite/Kevlar fabric skins, with a metal core on the exterior of the inlet cowl, would be particularly vulnerable to lightning strikes; however the GE materials list shows consideration of a lightning protection system. Use of aluminum brazed titanium honeycomb for the core cowl structure would be satisfactory provided cowl skin temperatures do not exceed 800°F. Because the tailpipe could be subjected to temperatures above 1000°F, aluminum brazed titanium honeycomb is not recommended. Inconel would be a logical material selection for the tailpipe.

In Boeing practice, new materials selected for application to flight structures are subjected to a rigorous time consuming test and evaluation program. This evaluation consists of laboratory tests of candidate materials, destructive tests to determine allowables, noncritical service testing of lightly loaded structure, and noncritical service tests of loaded structure. This evaluation process may take several years, the actual time depending on the severity of the intended application. Candidate materials may be dropped at any time during the evaluation process.



E3 NACELLE -- LH SIDE VIEW

Figure A-24. Long Duct Nacelle Mount

Table A-XVIII. Nacelle and Strut Design Load Factors

The nacelle, nacelle strut and primary engine mounts shall be designed for the following inertia load conditions which are assumed to occur only once in the lifetime of the airplane:

<u>Condition</u>	<u>Ultimate load factors</u>
Vertical	6.5 6.5 + 1.5 T(c) -3.5 -3.5 + T(c)
Thrust	3.0 T(max) + 3.0 vertical 3.0 T(max) + 1.5 vertical 3.0 T(R) 3.0 T(R) + 3.0 vertical
Side	<u>+ 3.0</u>
Gyroscope	<u>+ 2.25 rad/sec yaw + 1.5T(c) + 1.5 vertical</u> <u>+ 2.25 rad/sec. pitch + 1.5T(c) + 3.75 vertical</u>
Engine seizure	Torque equivalent to stopping rotating mass in approximately 0.60 sec
T(max)	= maximum takeoff thrust at sea level
Where: T(C)	= cruise thrust (maximum or minimum, whichever is critical)
T(R)	= reverse thrust

Note: For design purposes, these ultimate factors shall be applied at the nacelle and content weight and C.G. exclusive of thrust and contents.

THRUST = 36,000 LB/ENGINE
VERTICAL LOAD FACTOR: $\eta = 1.0$

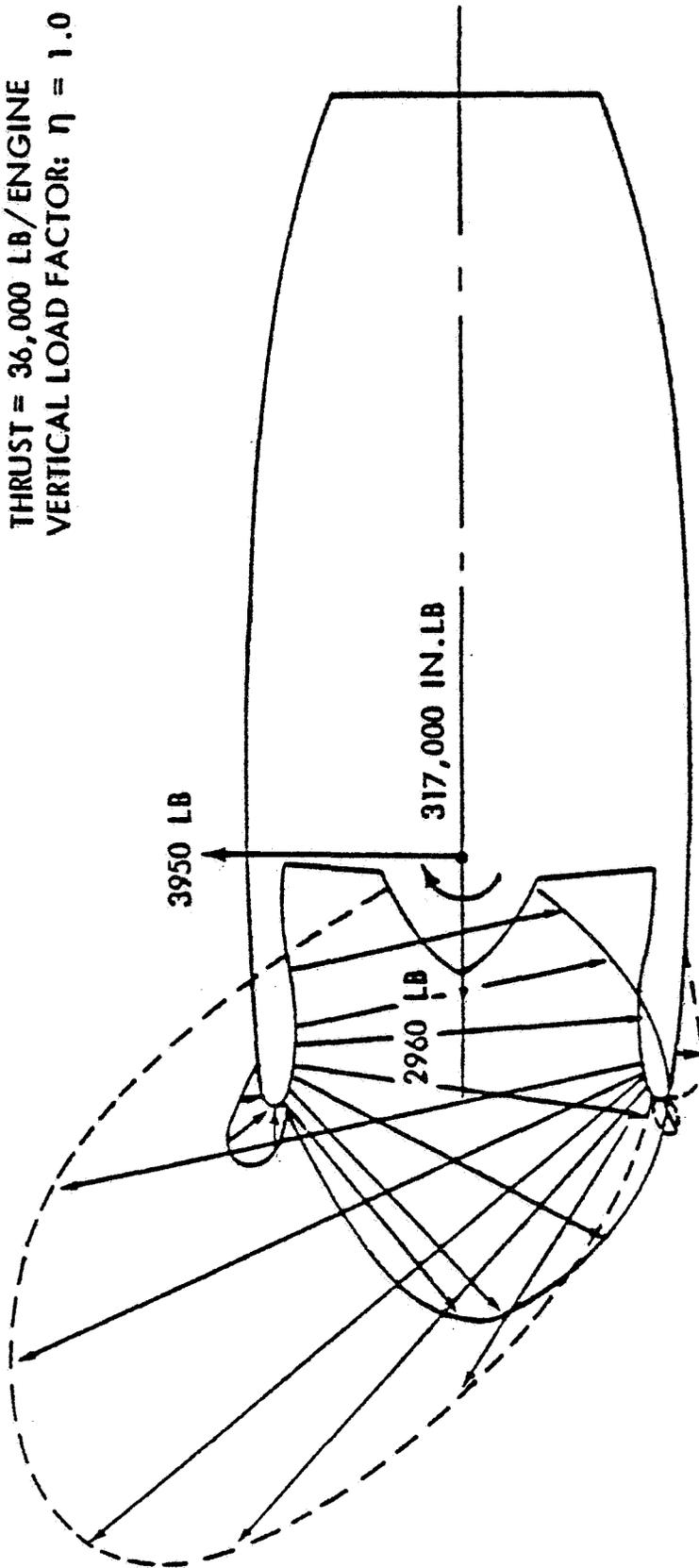


Figure A-25. Airloads--Maximum Takeoff

THRUST = 15,600 LB/ENGINE, NET
VERTICAL LOAD FACTOR: $\eta = 1.0$

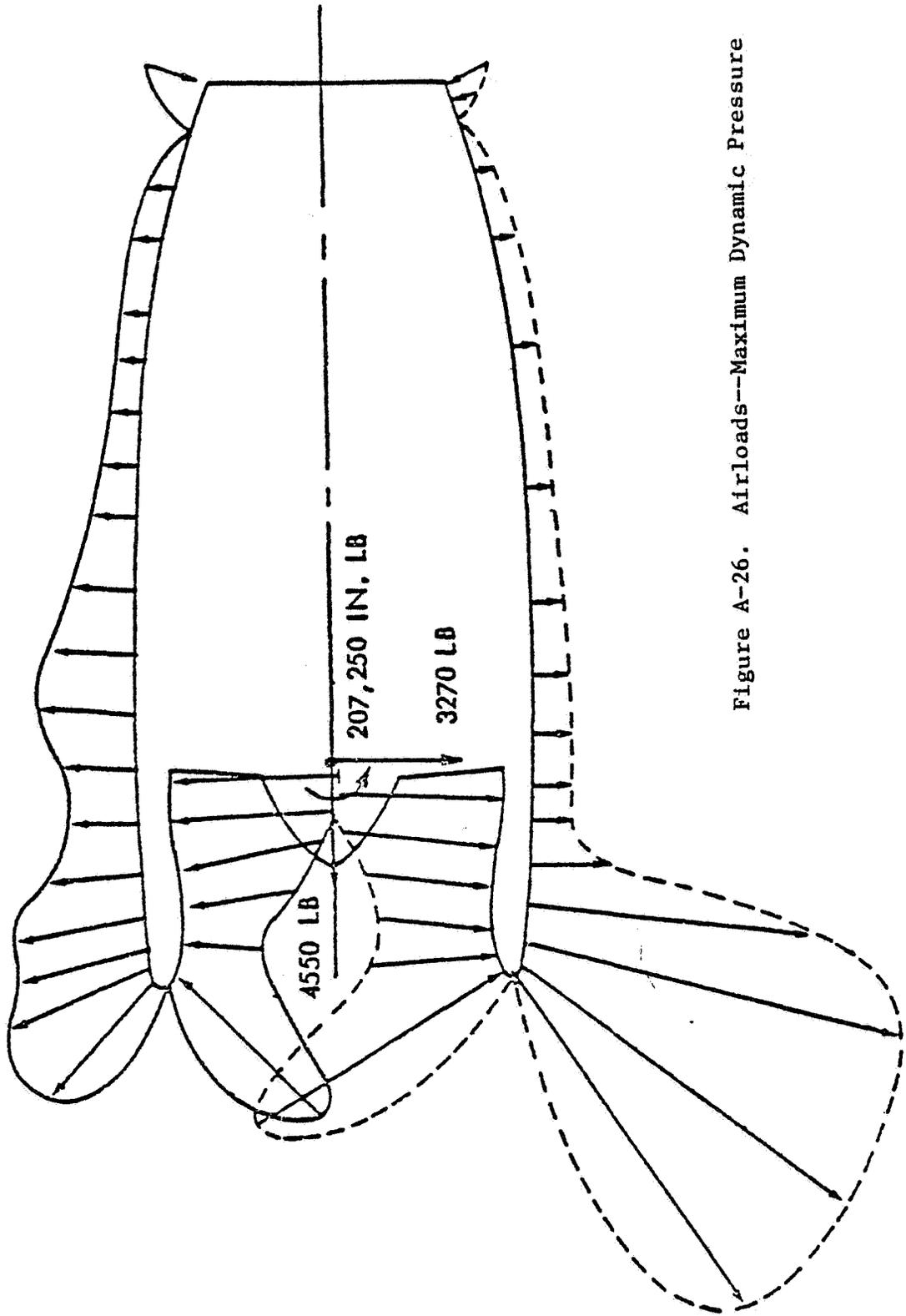


Figure A-26. Airloads--Maximum Dynamic Pressure

THRUST = 18,500 LB/ENGINE, NET
VERTICAL LOAD FACTOR: $\eta = 1.0$

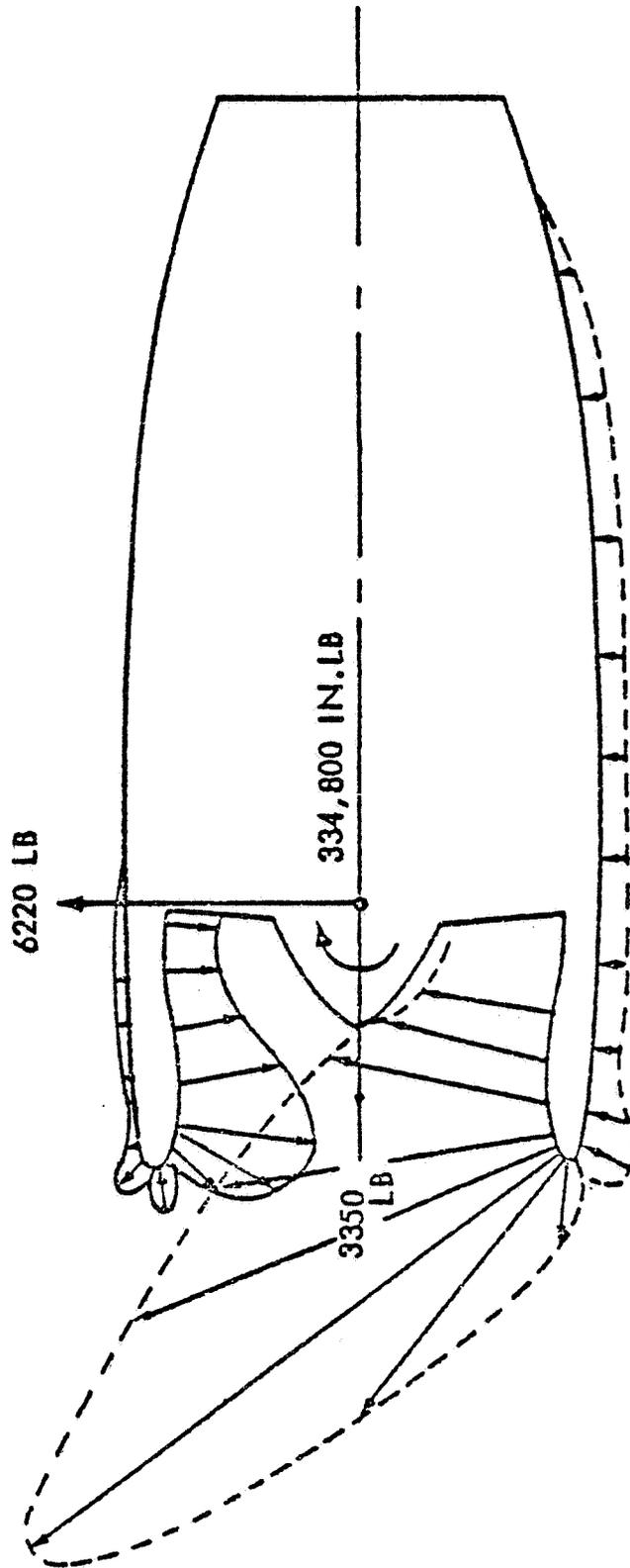


Figure A-27. Airloads--0-deg Flap, 1.3V_{stall}

THRUST = 18,500 LB/ENGINE, NET
VERTICAL LOAD FACTOR; $\eta = 1.0$

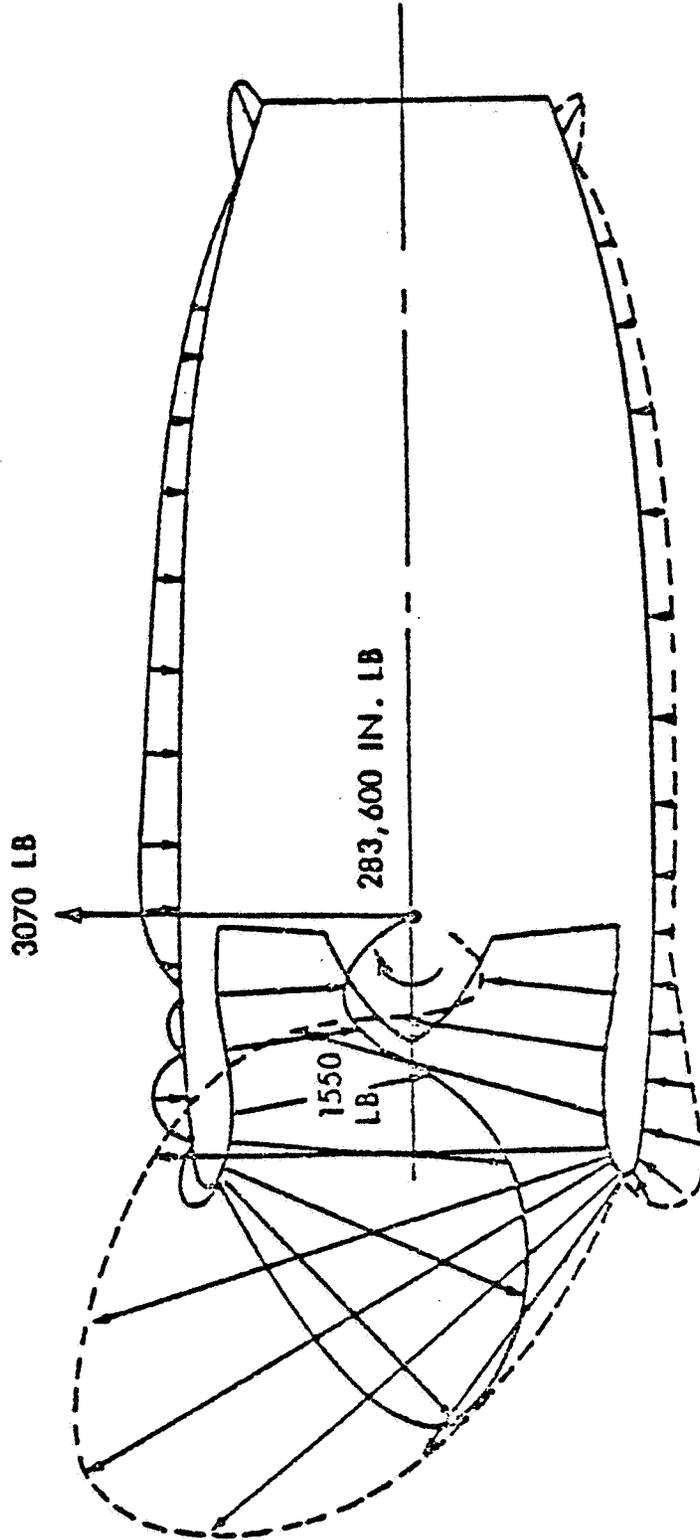
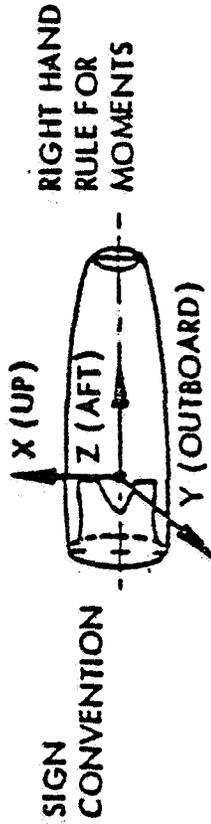


Figure A-28. Airloads--10-deg Flap, 1.3V_{stall}

Table A-XIX. Engine Nacelle Airloads

NOTE:
THE FOLLOWING RESULTANT
AIRLOAD CONDITIONS ARE
OCCURRING ONCE PER FLIGHT
AND THE ASSORTED VERTICAL
LOAD FACTOR IS 1.0 g.



CONDITION:	ALT. FEET	V_e KNOTS	THRUST LB/ENG	F_x LBS	F_y LBS	F_z LBS	M_x 10^3 IN. LBS	M_y 10^3 IN. LBS	M_z 10^3 IN. LBS
MAXIMUM TAKE OFF [1]	0	126.0	36000	3945	2890	-2960	162.3	-317.0	-11.0
MAXIMUM Q	20000	372.3	15600	-3270	-2370	-4550	-104.6	207.3	6.1
1.3 V_{STALL} , 0° FLAPS	17000	161.2	18500	6220	3800	-3350	184.8	-334.8	-12.7
1.3 V_{STALL} , 10° FLAPS	17000	161.2	18500	3070	2140	-1550	150.0	-283.6	-10.2

[1] $\alpha_W = 16$ DEG. AND $\alpha_{INLET} + 12$ DEG.

BASED ON SLS THRUST $F = 45,500$ LBS

SCALE: LOADS BY F
MOMENTS BY $(F)^{1/4}$

6.7 NACELLE WEIGHT EVALUATION

Table A-XX compares Boeing and GE weight estimates of selected components of the E³ long-duct mixed-flow nacelle. Due to differences in the method by which the various nacelle components were functionally accounted for by Boeing and GE, it was not possible to provide a weight comparison for all items. Consequently, comparisons were made for only those components on which GE provided weight data. Table A-XXI presents the weight data received from GE.

Differences in Boeing and GE estimated weight levels were primarily due to differences in assumptions. An in-depth weight evaluation of the GE composite nacelle required more detailed design and structural sizing than could be accomplished within the airframer's funded activity; therefore, Boeing used existing nacelles and advanced designs as a basis for estimating nacelle weight and potential benefits due to use of composites. The weight differences between Boeing and GE represent differences in nacelle design and levels of technical risk. Table A-XXII summarizes the advanced technology weight reduction factors used in the Boeing analysis. These factors were based on advanced technology application. Weight analysis details can be found in Table A-XXIII.

For the November 1978 PDR GE revised the nacelle weight downward and increased the ATE engine weight. The net result was a weight decrease of over about 495 lb./nacelle compared to Reference 3 data for a sized nacelle and engine.

Table A-XX. GE Advanced Nacelle Evaluation

Nacelle Component	Nacelle Weight (lb/pod) SLST = 46900 lb		Weight Difference (GE minus Boeing)	
	Boeing Estimate	GE Estimate	lb	%
Inlet	770*	510	-260	-33.8
Fan Cowl	180	Included in Fan Module	---	
Fan Duct, Reverser And Core Cowl	2188	1469	-719	-32.9
Mixer	118	Included In	---	
Plug	96	LPT Module		
Tail Pipe	549	191	-358	-65.2
	(3901)	**	**	**

* Includes 90 lb burst containment allowance.

** Total not computed due to weight distribution differences between Boeing and GE.

Table A-XXI. General Electric Energy Efficient Engine
Estimated Weights

E³ ENGINE ESTIMATED WEIGHTS

<u>ESTIMATED ENGINE WEIGHT</u>		<u>46,900 LBS. T.O. THRUST</u>	<u>36,500 LBS. T.O. THRUST</u>
FAN MODULE		3322 LBS	2316 LBS.
LPT MODULE *		1950 LBS	1360 LBS.
CORE	Engine 8750 lb	2503 LBS	1745 LBS.
C&A, SUMPS & DRIVES		975 LBS	680 LBS.
INLET		510 LBS	385 LBS.
FAN REVERSER & DUCT**		1265 LBS	958 LBS.
CORE COWL	Nacelle 2825 lb	204 LBS	154 LBS.
TAILPIPE		191 LBS	145 LBS.
ENGINE BUILD-UP		655 LBS	495 LBS.

*INCLUDES REAR FRAME, MIXER AND EXHAUST CENTERBODY.

**INCLUDES PYLON WALLS INTERNAL TO THE BYPASS DUCT.

Table A-XXII. Weight Reduction Factors for Advanced Technology Application

<u>Nacelle Component</u>	<u>Weight Reduction Factor(%)</u>
Inlet	5
Fan Cowl	20
Fan duct, reverser, core cowl	4.6
Mixer	0
Plug	0
Tailpipe	0

Table A-XXIII. Boeing Weight Analysis Summary

<u>Nacelle Component</u>	<u>Assumed Substructure and Material</u>	<u>Remarks</u>
Inlet Cowl	<p>Lip: spun or explosion formed aluminum sheet.</p> <p>Bulkhead: built-up aluminum webs, chords and stiffener.</p> <p>Cowling: Graphite/Kevlar fabric outer skin, nonmetallic heat resistant phenolic (HRP) core, Dyna-Rohr Inner face structural acoustic panels</p> <p>Attach ring: machined aluminum</p> <p>Anti-icing components: aluminum spray tube, aluminum and Inconel ducting, aluminum mixing chamber</p>	<p>Weight estimate includes 5% reduction to reflect Graphite/Kevlar application to outer skin. The inner skin construction appears to be same as used on CF6-50C nacelles, hence no potential for weight saving.</p>
Fan Cowl	<p>Outer skin: Graphite/Kevlar</p> <p>Inner core: nonmetallic HRP</p> <p>Hinges, latches, hold-open rods access doors, fire shield, and cowl hinge supports on strut.</p>	<p>Data base used consisted of cowls with both skin-stringer and fiberglass-and-aluminum sandwich construction. No clear weight advantage for either type was apparent. Based on amount of composites, 20% weight reduction was used in the Boeing weight estimate.</p>

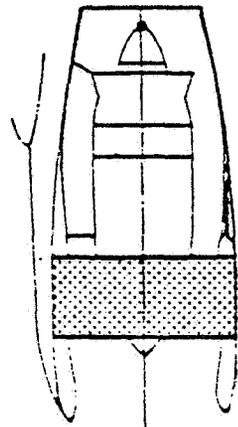
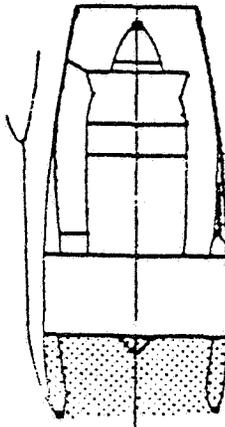


Table A-XXIII. Boeing Weight Analysis Summary (continued)

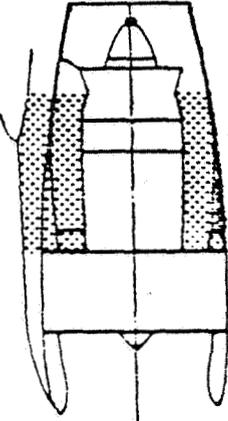
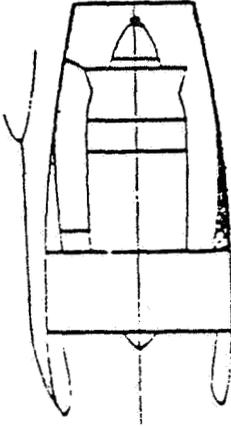
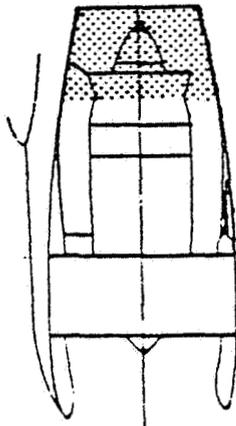
<u>Nacelle Component</u>	<u>Assumed Substructure and Material</u>	<u>Remarks</u>
<p>Fan duct and core cowl (D-duct construction assumed)</p> 	<p>Outer fairing: Graphite/Kevlar with nonmetallic HRP core Outer fan duct walls and bifurcations: aluminum sandwich Dyna-Rohr panels Inner fan duct walls: titanium sandwich BUMPER blocks, rings and longerons: aluminum built-up structures</p>	<p>Outer surface weight was reduced 25% to account for composites. Relative to total fan-duct and core cowl weight, this is about 5.5% reduction. Design complexities need further investigation.</p>
<p>Fan Reverser</p> 	<p>Cascades: chopped carbon-epoxy Blocker doors: Dyna-Rohr structural acoustic panels Cascade supports: aluminum frame Linkages: aluminum Actuators: ball-screw Reverser drive: pneumatic motor</p>	<p>GE data showed reverser cascades to be the only area of advanced technology. Cascade weight saving of 15% due to use of composites is about 2.5% of total fan reverser weight. Combined fan-reverser and fan-duct weight reduction factor is 4.6%.</p>
		<p>Fan-reverser design needs refinement to be acceptable.</p>

Table A-XXIII. Boeing Weight Analysis Summary (Concluded)

<u>Nacelle Component</u>	<u>Assumed Substructure and Material</u>	<u>Remarks</u>
Mixer, plug and tailpipe	<p>Mixer lobes: single-thickness titanium</p> <p>Lobe support struts and ring: Inconel</p> <p>Lobe fairing: aluminum</p> <p>Plug: Inconel, thickness as required by minimum welding gage criteria.</p> <p>Tailpipe: Inconel</p>	<p>Data base for mixer includes experimental work on daisy-lobe mixers and previous Boeing analytical studies.</p> <p>CE gave minimum design definition. Insufficient structural depth for frames and for nozzle to fan duct attachment were Boeing concerns.</p> <p>Difference in design philosophy in this area accounts for significant part of weight difference.</p>



7.0 CONCLUSIONS AND RECOMMENDATIONS

1. NASA's stated fuel consumption goal is a 12% reduction of cruise TSFC. For the Boeing study, this was interpreted to mean a 12% reduction of airplane BLKF. Under this interpretation, the ATE as installed in the Boeing Model 768-868 would surpass the design mission fuel consumption goal by over 6% if it could be developed as assumed.
2. Boeing's evaluation being more conservative than GE's indicated the ATE nacelle to be over 1000 lb. heavier than the GE weight estimate. A weight increase of 1000 lb/nacelle (i.e., 2000 lb. total) increases fuel burned by about 1%; however, DOC increases only 0.3%.
3. The NASA goal of 5% DOC reduction is bettered by 1% using GE supplied engine performance, weight, and economic data. However, Boeing considers the engine price quoted by GE unrealistically high for E³ technology levels. When the 20% lower Boeing price estimate is applied, the DOC improvement increases from 6.4 to 7.5%. The DOC improvement with the higher Boeing weight and lower price is about 7.2%.
4. Engine noise estimates based on a preliminary engine noise treatment show that FAR 36 amendment 8 could met. Since no attempt was made to refine the nacelle treatment for lowest noise levels, it was concluded that current and near-future noise treatment technology could attain the 3 EPNdB margin Boeing generally considers acceptable for assuring certifiable noise levels.
5. To ensure that the E³ program results in an engine configuration that meets program goals and that can be installed in a nacelle acceptable to the airframer and airlines, the airframer should be actively involved in the installation design and evaluation. It is therefore recommended that the balance of the E³ program include continuing active participation by the airframe contractors.

REFERENCES

1. EEE Component Development and Integration Program, General Electric Purchase Order No. 200-4XX-14N43049.
2. EEE Component Development and Integration Program, General Electric Purchase Order No. 200-4XX-14K40096.
3. Study data for Advanced Technology and Reference engines. NASA Energy Efficient Engine Program, General Electric Co. Aircraft Engine Group, May 5, 1978.
4. Energy Efficient Engine and Integration Studies for General Electric Company, D6-44690, December 6, 1977.
5. Aerodynamic Analysis of GE E³ Model Scale Nacelle Simulator (Unnumbered report submitted to GE by letter August 9, 1978).
6. General Electric Drawing No. 4013237-857.
7. General Electric Drawing No. 4013267-002.
8. General Electric Drawing No. 4013267-810.
9. General Electric Presentation "E³ Mount Configuration".

APPENDIX B

Appendix B is a reproduction of report LR 28933 supplied by Lockheed-California Company as their contribution to aircraft integration. The format and printing have been altered to coordinate with this publication.

PRECEDING PAGE BLANK NOT FILMED

FINAL REPORT

ENERGY EFFICIENT ENGINE

COMPONENT DEVELOPMENT

AND

INTEGRATION STUDY

Purchase Order 200-4XX-14N43062

Prepared for: GENERAL ELECTRIC COMPANY
AIRCRAFT ENGINE GROUP
Cincinnati, Ohio

LOCKHEED-CALIFORNIA COMPANY • BURBANK
A DIVISION OF LOCKHEED CORPORATION

PRECEDING PAGE BLANK NOT FILMED

APPENDIX B
TABLE OF CONTENTS

<u>Section</u>		<u>Page</u>
1.0	INTRODUCTION AND SUMMARY	172
2.0	STUDY EFFORT	183
2.1	Aircraft and Mission Definition	183
2.2	Aircraft Performance and Mission Sensitivity	183
	2.2.1 Sensitivity Analysis	183
	2.2.2 Performance Retention	190
2.3	Aircraft/Engine Integration	190
	2.3.1 Nacelle Configuration	190
	2.3.2 Nacelle - Wing Interference	193
	2.3.3 Accessory Location	193
	2.3.4 Access Provisions	193
	2.3.5 Thrust Reverser	199
	2.3.6 Center Engine Installation	199
	2.3.7 Engine Bleed Requirements and Power Extraction	199
	2.3.8 Engine Fire Protection	199
2.4	Performance and Economic Comparisons	202
3.0	CONCLUSIONS AND RECOMMENDATIONS	206
	SUPPLEMENT A	207
	SUPPLEMENT B	224

APPENDIX B
LIST OF ILLUSTRATIONS

<u>Figure</u>		<u>Page</u>
B-1.	Three-View Drawing of Domestic Aircraft With E ³ Engine.	177
B-2.	Three-View Drawing of Intercontinental Aircraft With E ³ Engine.	178
B-3.	Wing Engine Installation Layout With E ³ Engine.	179
B-4.	Center Engine Installation Layout With E ³ Engine.	180
B-5.	Wing Engine Location - E ³ Engine.	181
B-6.	Three-View Drawing of Domestic Aircraft With CF6-50C Engine.	185
B-7.	Three-View Drawing of Intercontinental Aircraft With CF6-50C Engine.	186
B-8.	ASSET Synthesis Cycle.	187
B-9.	Fail-Safe Design Concepts E ³ Engine Mount System.	195
B-10.	Pylon-Mounted Aircraft Accessories - E ³ Wing Engine Installation.	196
B-11.	E ³ Engine With Fan Case-Mounted Accessories.	197
B-12.	Thrust Reverser Flow Directivity.	200
B-13.	Layout of Fire Zones for E ³ Engine.	201
B-14.	Block Fuel Savings With E ³ Engine.	203
B-15.	DOC Savings With E ³ Engine.	204
B-16.	Aircraft Size Advantage With E ³ Engine.	205

APPENDIX B
LIST OF TABLES

<u>Table</u>		<u>Page</u>
B-I.	Reference Aircraft Design and Performance Characteristics.	174
B-II.	E ³ Aircraft Design and Performance Characteristics.	175
B-III.	Design and Technology Features - 1990's Transport Aircraft.	184
B-IV.	Aircraft Block Fuel and DOC.	188
B-V.	Airframe Noise Estimates (E ³ Engine).	189
B-VI.	Sensitivity Factors - Domestic Aircraft - E ³ Engine.	191
B-VII.	Sensitivity Factors - Intercontinental Aircraft - E ³ Engine.	191
B-VIII.	Intercontinental Aircraft Performance Characteristics.	192
B-IX.	Domestic Aircraft Performance Characteristics.	192
B-X.	E ³ Accessory Location.	194

1.0 INTRODUCTION AND SUMMARY

This study was accomplished by the Commercial Advanced Design Division of the Lockheed-California Company for the General Electric Company in support of their "Energy Efficient Engine component Development and Integration" Program with NASA-Lewis Research Center. The effort required was in accordance with General Electric Company Purchase Order 200-4XX-14N43062 and consisted of the following Tasks:

- TASK 1 - Aircraft and Mission Definition
- TASK 2 - Aircraft Performance and Mission Sensitivity
- TASK 3 - Aircraft/Engine Integration
- TASK 4 - Reporting

This evaluation is an update or follow-on to the previous Lockheed study effort in support of the "Energy Efficient Engine Preliminary Design and Integration Study", General Electric Purchase Order number 200-4XX-14K43170, which included:

- Definition of airplane design and technology features
- Aircraft and mission definition
- Aircraft performance and mission sensitivities
- Aircraft - engine integration evaluation

During the previous study effort, Lockheed Report LR 28377, two aircraft configurations were developed; one for a domestic mission and one for an intercontinental mission. These domestic and intercontinental aircraft, using the CF6-50C turbofan engine, were characterized for the following technology features and mission criteria:

- Technology Features
 - Supercritical wing
 - Active controls
 - Advanced Composite structure
- Mission Criteria

	<u>Domestic</u>	<u>Intercontinental</u>
Design Range (n.mi.)	3,000	6,500
No. Passengers	400	400
Cruise Speed	M 0.8	M 0.8
Typical Range (n.mi.)	1,400	3,000
Configuration	3 Engine Wide Body	4 Engine Wide Body

At the start of this study effort, a re-evaluation of aircraft technology features and mission criteria was accomplished. This resulted in retention of the previously selected criteria, except that the payload capacity of 100,000 pounds (500 passengers) was incorporated in lieu of 80,000 pounds (400 passengers) previously used. This change resulted from review by

Lockheed's Marketing Development Division relative to potential market demand in the 1990's time frame. Reference aircraft design and performance characteristics consistent with the increased payload capacity are included in Table B-I. These configurations were established as baseline aircraft to be used for comparison with aircraft incorporating the Energy Efficient Engine.

The Energy Efficient Engine cycle selected by General Electric for installation on the domestic and intercontinental aircraft is a mixed flow, direct drive high-bypass turbofan with the following characteristics, as compared to the current CF6-50C engine:

	<u>CF6-50C</u>	<u>E³</u>
Technology Level	Current	1990's
Fan Drive	Direct	Direct
Exhaust	Separate	Mixed
Bypass Ratio	4.2	6.8
Overall Ratio	32	38
Turbine Inlet Temp.	2445°F	2450°F

Table B-II is a tabulation of the aircraft design and performance characteristics of the domestic and intercontinental aircraft with the E³ engine. Comparison of this data with the reference aircraft (CF6-50C engine) indicates mission fuel and direct operating cost (DOC) savings with the E³ engine as follows:

	<u>Fuel Savings</u>		<u>DOC Savings</u>	
	<u>Design</u>	<u>Typical</u>	<u>Design</u>	<u>Typical</u>
Domestic	18.3%	17.3%	8%	6.8%
Intercontinental	22.9%	21.2%	12%	10.5%

General arrangement drawings, depicting the domestic and intercontinental aircraft, with the E³ engine, are included as Figures B-1 and B-2. The size of the E³ engine, as supplied by General Electric, is well matched (thrust-both takeoff and cruise, reverse thrust level, and power extraction) with the Lockheed specified mission/payload characteristics for the 1990's aircraft.

Installation layout drawings of the E³ engine on the domestic aircraft (wing and center mounted engine) are included as Figures B-3 through B-5, and depict location of the aircraft accessories in the engine core as well as placement of the nacelle with respect to the wing consistent with minimization of interference drag penalties.

The results of this study are as follows:

- The NASA defined goals for minimum fuel and DOC savings of 12% and 5%, respectively, are attained with the E³ engine
- Nacelle aerodynamic and mechanical characteristics (inlet, nacelle contour, and mount systems) are acceptable for aircraft installation

Table B-I. Reference Aircraft Design and Performance Characteristics

	Domestic	Intercontinental
<u>Mission Characteristics</u>		
Design Range (n.mi.)	3000	6500
Typical Range (n.mi.)	1400	3000
Cruise Speed	MO.8	MO.8
No. Passengers	500	500
Init. Cruise Altitude (ft)	37,000	32,000
Field Length (ft)	6837	9369
Approach Speed (kt)	135	133
<u>Design Characteristics</u>		
Configuration	3 Engine-Trijet	4 Engine-Quadjet
Power Plant	CF6-50C	CF6-50C
Sweep (.25C)	30°	30°
W/S (lb/ft ²)	118	145
T/W	0.274	0.248
AR	10	10
t/c (%)	13	13
TOGW (lb)	478,622	709,664
OEW (lb)	261,795	303,963
Wing Span (ft)	201.4	221.2
Body Length (ft)	228.3	229.5
Body Diameter (ft)	19.6	19.6
<u>Performance Characteristics</u>		
Thrust/Eng. (SLS, lb)	43,714	43,999
Block Fuel - Design (lb)	98,116	266,136
Block Fuel - Typ. (lb)	42,629	103,425
DOC - Design (¢/ASM)	1.262	1.449
DOC - Typ. (¢/ASM)	1.360	1.435

Table B-II. E³ AIRCRAFT AND PERFORMANCE CHARACTERISTICS

	Domestic	Intercontinental
<u>Mission Characteristics</u>		
Design Range (n.mi.)	3000	6500
Typical Range (n.mi.)	1400	3000
Cruise Speed	MO.8	MO.8
No. Passengers	500	500
Init. Cruise Altitude (ft)	37,000	32,000
Field Length (ft)	6837	9369
Approach Speed (kt)	135	133
<u>Design Characteristics</u>		
Configuration	3 Engine-Trijet	4 Engine-Quadjet
Power Plant	E ³	E ³
Sweep (.25C)	30°	30°
W/S (lb/ft ²)	113	135
T/W	0.270	0.241
AR	10	10
t/c (%)	13	13
TOGW (lb)	453,652	624,577
OEW (lb)	256,767	283,672
Wing Span (ft)	200.2	215.6
Body Length (ft)	228.3	229.5
Body Diameter (ft)	19.6	19.6
<u>Performance Characteristics</u>		
Thrust/Eng. (SLS, lb)	40,832	37,631
Block Fuel - Design (lb)	80,158	205,221
Block Fuel - Typ. (lb)	35,254	81,504
DOC - Design (¢/ASM)	1.161	1.290
DOC - Typ. (¢/ASM)	1.269	1.299

CHARACTERISTICS	MMSC	MMSC	HORIZONTAL TAIL	VERTICAL TAIL
AREA - SQ. FT.	370.24 (1087.61)	394.33 (1182.93)	52.38 (1582.23)	1.8
ASPECT RATIO	14	15	16	1.8
SPAN	61.92 (1887.19)	61.92 (1887.19)	61.92 (1887.19)	61.92 (1887.19)
WING AREA - SQ. FT.	370.24 (1087.61)	370.24 (1087.61)	370.24 (1087.61)	370.24 (1087.61)
WING AREA - SQ. METERS	34.22 (1037.61)	34.22 (1037.61)	34.22 (1037.61)	34.22 (1037.61)
T/C TIP	8	8	8	8
T/C ROOT	15.9	15.9	15.9	15.9
T/C TIP	8	8	8	8
T/C ROOT	15.9	15.9	15.9	15.9

GROSS WEIGHT - 205416 KG. (452857 LB.)

POWER PLANT (3) G.E. E³ TURBOFAN

INSTALLED THRUST - 381287 N (40757 LB.)

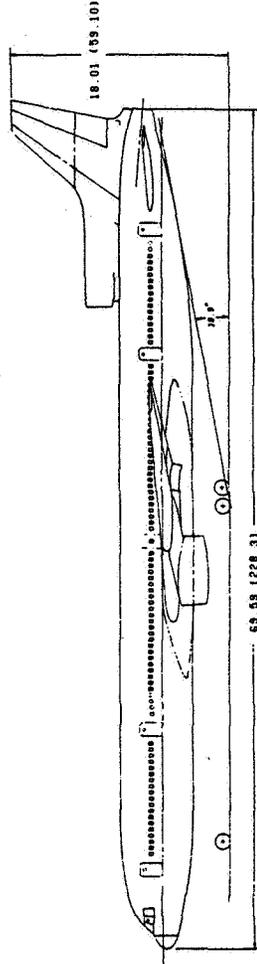
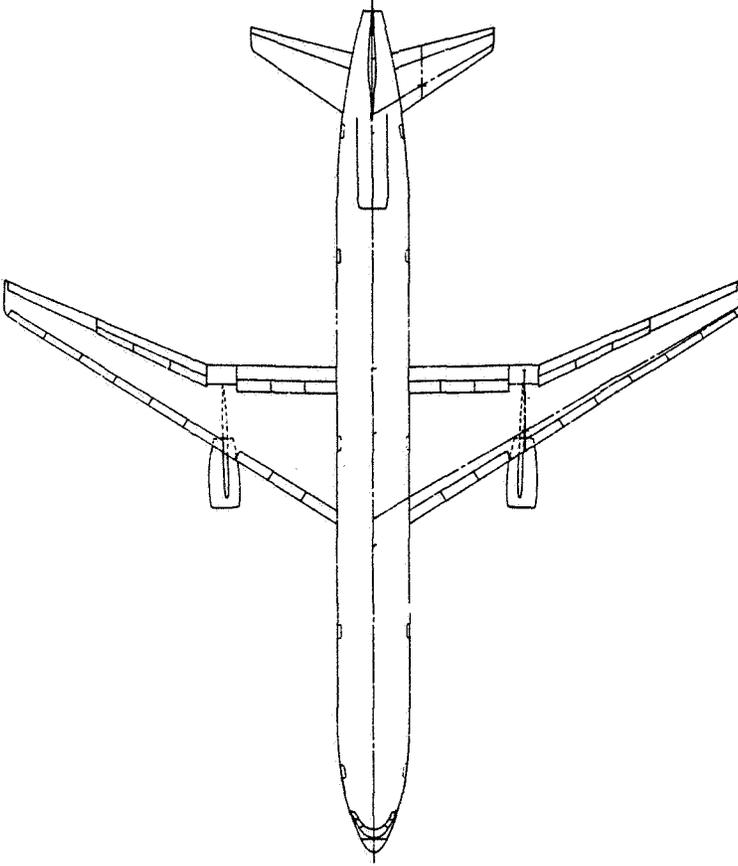
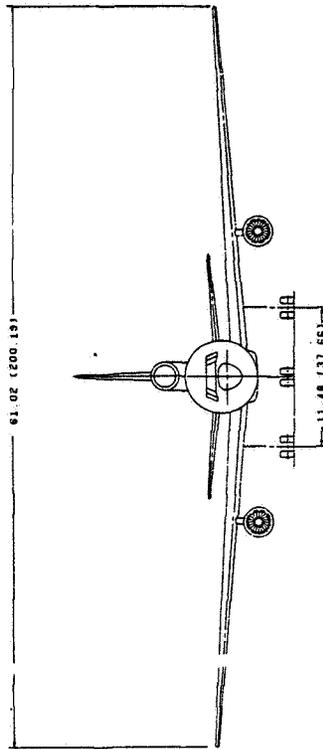
PASSENGERS - 489

RANGE - 3,000 N.M.

2. DIMENSIONS IN METRES (FEET), OR NOTED

3. CADAM REF. DMC CL1333-11-1.1.2.3

NOTES:



PRECEDING PAGE BLANK NOT FILMED

FOLDED FRAME

Figure B-1. Three-View Drawing of Domestic Aircraft with E3 Engine.

FOLDED FRAME

CHARACTERISTICS	RUSSIAN	INTERCONTINENTAL TAIL	VERTICAL TAIL
AREA - SQ. FT. (SQ. M.)	432.82 (40090.27)	421.31 (3921.83)	488.28 (4536.64)
ASPECT RATIO	10	8	10.9
SPAN - FT. (M.)	69.32 (2020.04)	69.32 (2020.04)	69.32 (2020.04)
ROOT CHORD - FT. (M.)	6.38 (1944.31)	6.38 (1944.31)	6.38 (1944.31)
TIP CHORD - FT. (M.)	6.98 (2137.22)	6.98 (2137.22)	6.98 (2137.22)
MEAN CHORD - FT. (M.)	10.34 (3150.02)	10.34 (3150.02)	10.34 (3150.02)
TAPER RATIO	0.92	0.92	0.92
WING AREA - SQ. FT. (SQ. M.)	7.31 (2136.33)	4.43 (1310.40)	6.43 (1892.83)
WING TIP - FT. (M.)	0.815 (248.1)	0.815 (248.1)	0.815 (248.1)
T/C ROOT - FT. (M.)	10.9	10	10
T/C TIP - FT. (M.)	10.9	10	10

GROSS HEIGHT - 284225 KC (626841 LB)
 POWER PLANT (4) G. E. E³ TURBOFAN
 INSTALLED THRUST - 167900 N (37767 LB.)
 PASSENGERS - 476
 RANGE - 6,800 M.N.

2. DIMENSIONS IN METRES (FEET), OR BOTH
 3. CADAN REF DMC. CL1333-12-1.1.2.3
 NOTES:

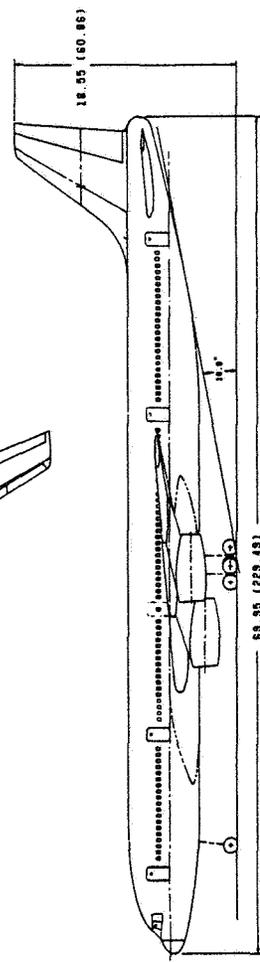
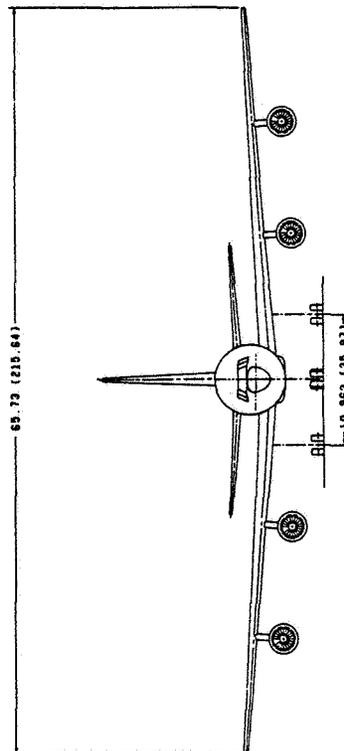
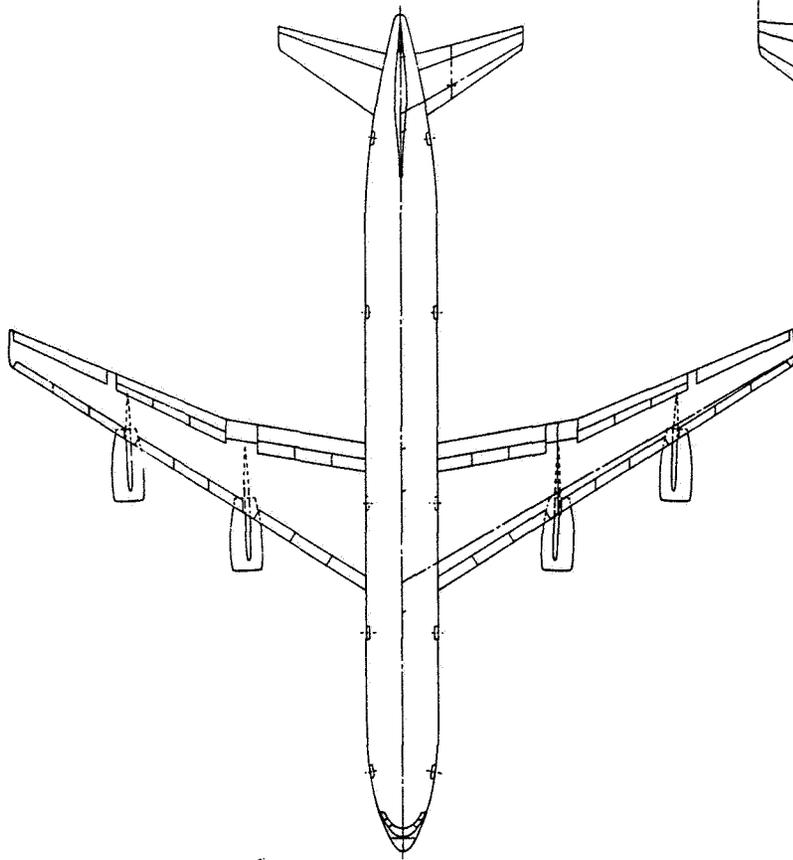


Figure B-2. Three-View Drawing of Intercontinental Aircraft with E³ Engine.

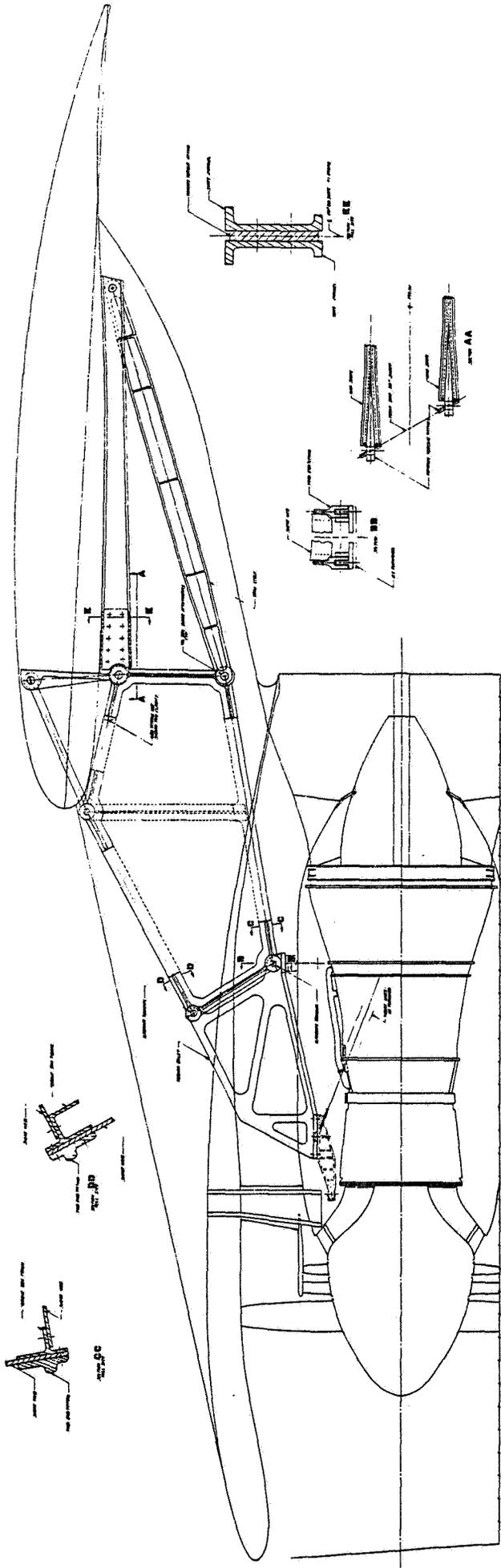


Figure B-3. Wing Engine Installation Layout with E3 Engine.

FOLDOUR FRAME

FOLDOUR FRAME

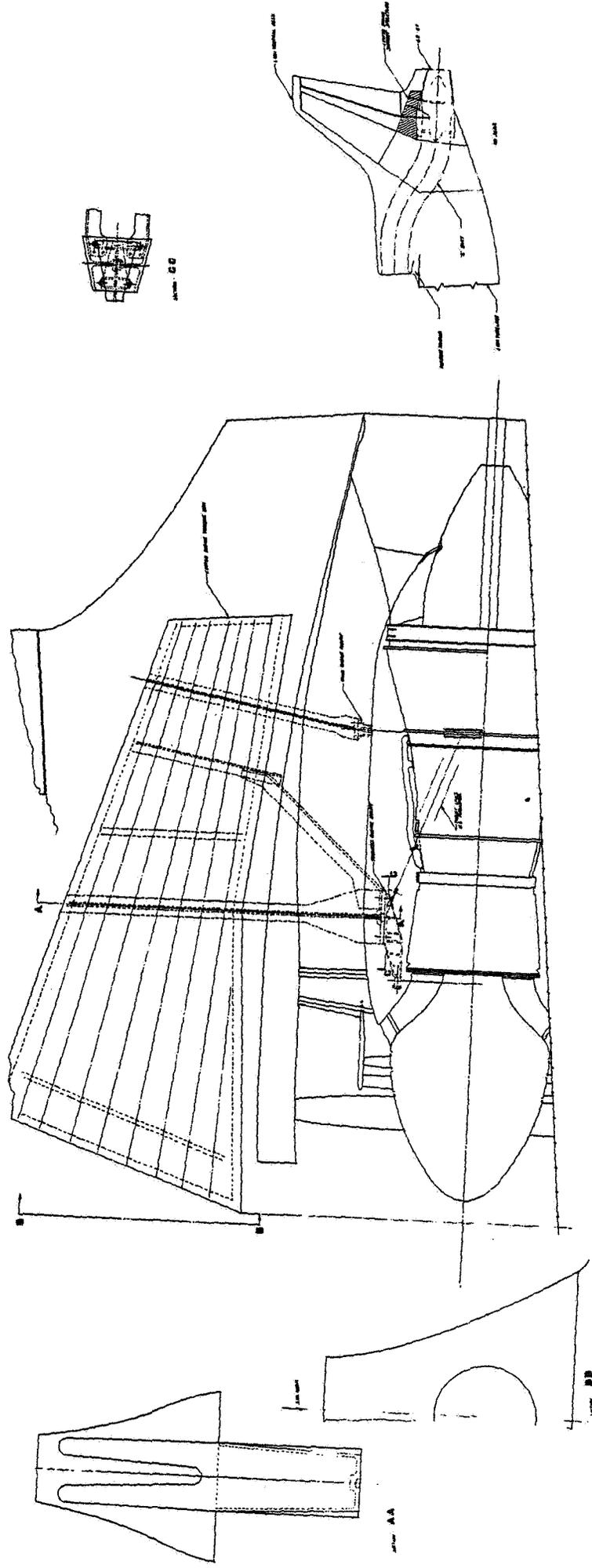


Figure B-4. Center Engine Installation Layout with E³ Engine.

W/OUT FRAME

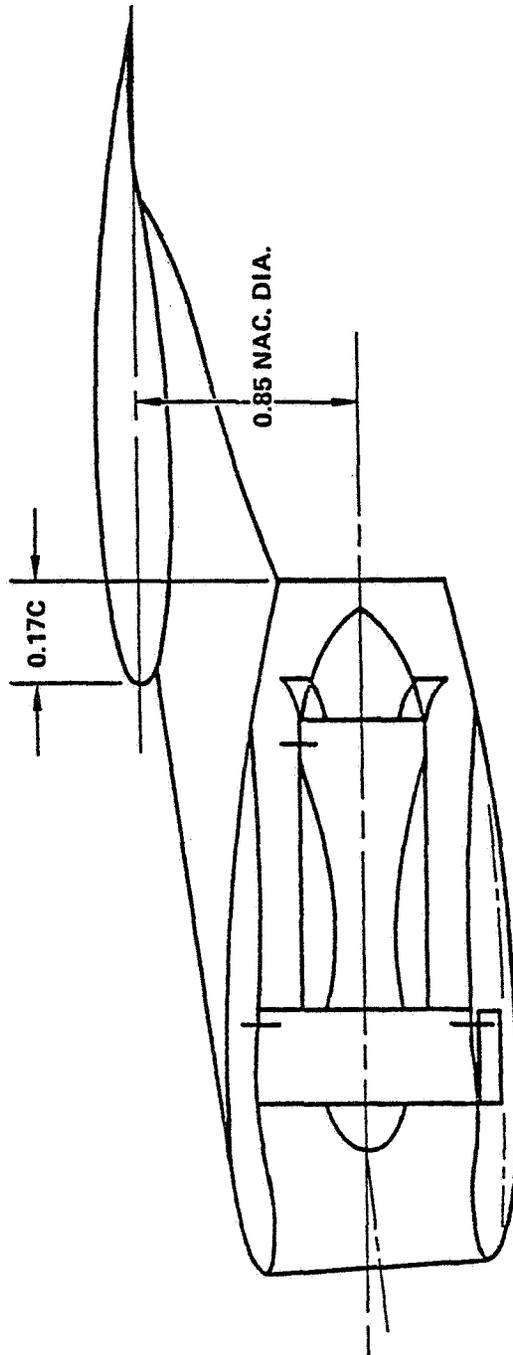


Figure B-5. Wing Engine Location - E³ Engine

- Installation of the E³ engine with mixed exhaust appears feasible without a penalty for interference drag
- The thrust characteristics of the E³ engine, supplied by General Electric, are compatible with 1990's commercial aircraft.
- Incorporation of the E³ engine results in aircraft configuration, sized for long range and large payload capacity, which are compatible with existing airport facilities (field length, wing span, body length, and gross weight).

2.0 STUDY EFFORT

The study effort accomplished by Lockheed in support of General Electric companys Energy Efficient Engine Component Development and Integration program consisted of the following major tasks:

- Task 1 - Aircraft and Mission Definition
- Task 2 - Aircraft Performance and Mission Sensitivity
- Task 3 - Aircraft/Engine Integration

2.1 AIRCRAFT AND MISSION DEFINITION

Mission and design definitions, along with applicable advanced technology features, were established for both the domestic and intercontinental aircraft during the previous study effort (Lockheed Report LR 28377). On initiation of this effort, those definitions were reviewed, and updated where applicable, for the purpose of establishing reference (baseline) configurations and performance characteristics for comparison of those aircraft with the E³ engine. Definition of the domestic and intercontinental aircraft mission characteristics and technology levels is included as Table B-III. General arrangement drawings are included as Figures B-6 and B-7, and the procedures for calculating DOC are included as Supplement B.

2.2 AIRCRAFT PERFORMANCE AND MISSION SENSITIVITY

Performance, weight, and pertinent installation data for both the current CF6-50C engine and the advanced technology E³ engine was supplied by General Electric for incorporation into the reference aircraft. Each aircraft was sized for minimum mission fuel and DOC using the Lockheed Parametric Analysis (ASSET) program, depicted in Figure B-8. The ASSET Analysis Program is a Lockheed Proprietary synthesis model to size parametrically and determine the weight, performance, and cost of aircraft sized to meet given mission profiles, payload capacity, and structural criteria using a pre-selected optimization criteria. Aircraft fuel usage, and DOC for both the design and average missions, along with estimates of the airframe noise for the FAR 36 measuring points is included in Tables B-IV and B-V. Supplement A includes the computer printouts for the domestic and intercontinental aircraft with the E³ engine.

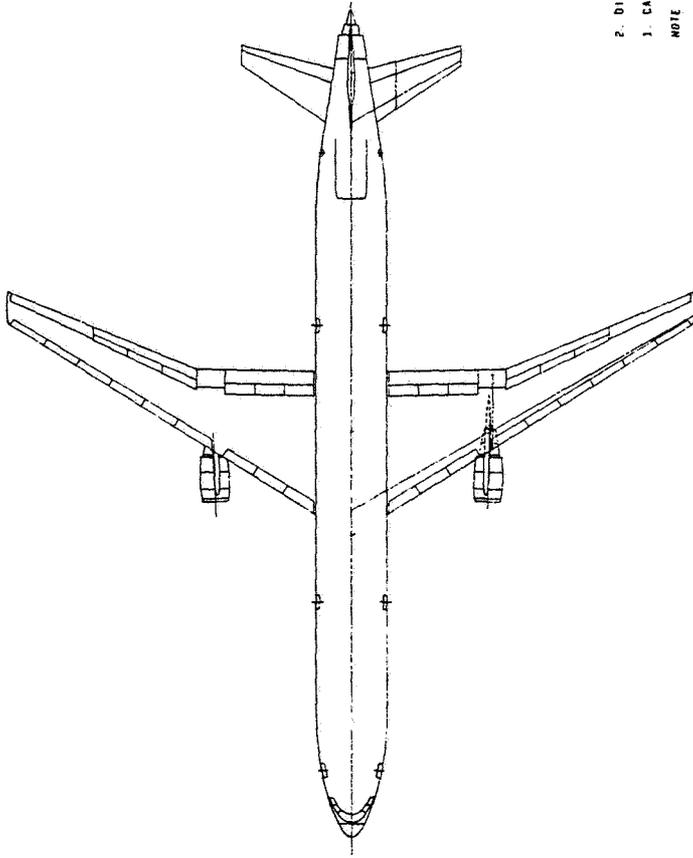
2.2.1 Sensitivity Analysis

Sensitivity factors were calculated for each aircraft (domestic and intercontinental) with the E³ engine to assess the effects of changes in SFC, engine weight, engine intial price, and engine maintenance cost on aircraft performance (TOGW, fuel usage, and DOC). The following sensitivity factors were calculated:

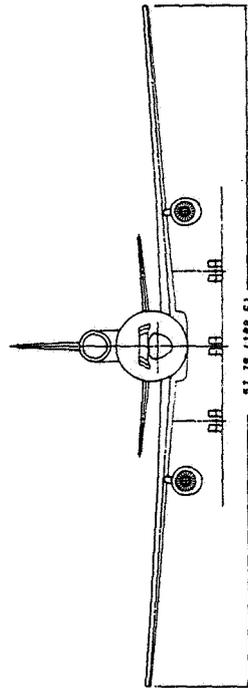
	<u>+5% SFC</u>	<u>+1000 lb</u>	<u>+*250K</u>	<u>+20%</u>	
TOGW	X	X			
Fuel Wt	X	X			
DOC	X	X	X	X	

Table B-III. DESIGN AND TECHNOLOGY FEATURES-1990's TRANSPORT AIRCRAFT

	Domestic	Intercontinental
Aircraft Type	Wide body trijet 235 in. fuse. dia. 9 abreast seating	Wide body quadjet 235 in. fuse. dia. 9 abreast seating
No. Engines and Location	2-wing mounted 1-center mounted	4-wing mounted
Payload Capacity (lb)	100,000 (500 pax)	100,000 (500 pax)
TOGW Class (lb)	500,000	750,000
Engine Thrust (lb)	45,000	46,000
Mission Characteristics		
Design Range (n.mi.)	3,000	6,500
Typical Range (n.mi.)	1,400	3,000
Typ. Range L.F.	0.55	0.55
Cruise Speed	MO.8	MO.8
Cruise Alt. (ft)	35,000	35,000
TOFL (ft)	7,000	10,000
App. Speed (kt)	135	135
<u>Advanced Technology</u>		
Supercrit. Wing	~3% reduction of wing wt - increased thickness of airfoil <ul style="list-style-type: none"> • AR = 10 • t/c = 13% • Sweep = 30° 	~3% reduction of wing wt - increased thickness of airfoil <ul style="list-style-type: none"> • AR = 10 • t/c = 13% • Sweep = 30°
Active Controls <ul style="list-style-type: none"> • Load Relief • Relaxed Stability 	-5.5% wing wt. -1% body wt. -28% tail size	-5.5% wing wt. -1% body wt. -28% tail size
Advanced Composites <ul style="list-style-type: none"> • Primary Struct. • Secondary Struct. 	-8.7% M.E.W.	-9.2% M.E.W.



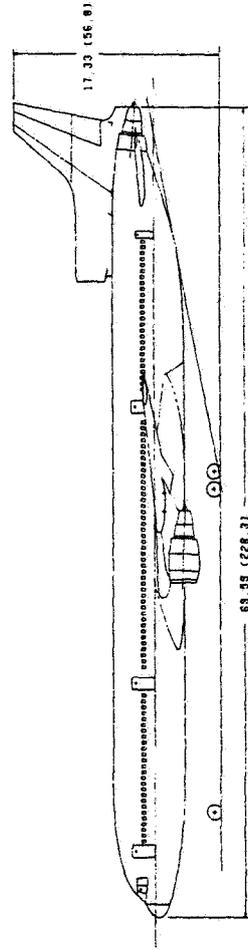
FOLDOUT FRAMES



57.75 (180.5)

2. DIMENSIONS IN METRES (FEET), OR NOTED
 3. CADAM REF. DMS C1333-1-1.1.2.3

NOTE

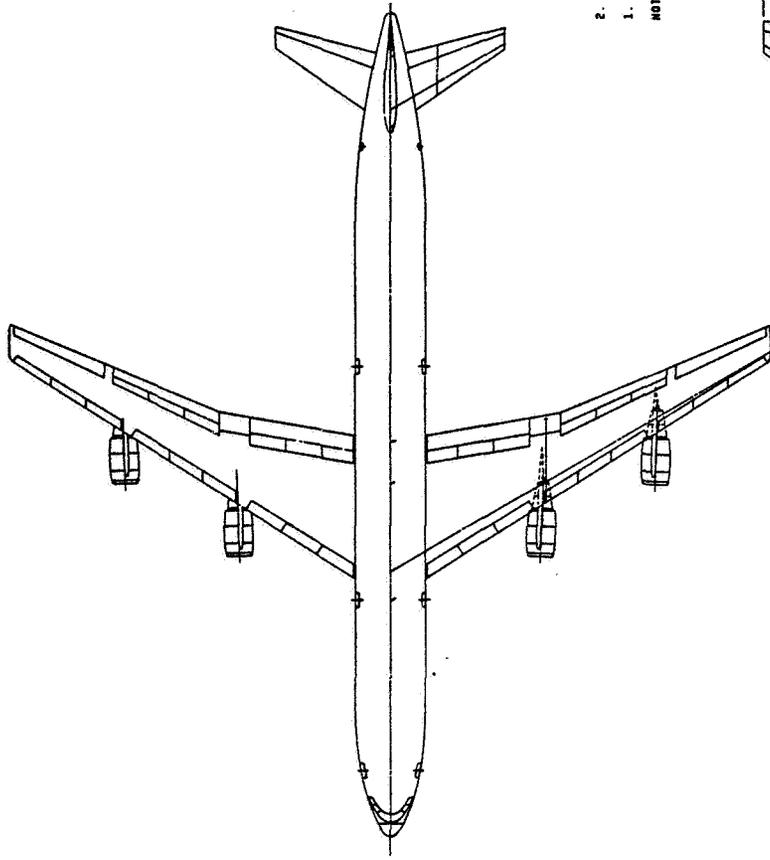


17.32 (56.8)

63.55 (208.7)

Figure B-6. Three-View Drawing of Domestic Aircraft with CF6-50C Engine.

63



2. DIMENSIONS IN METRES (FEET), OR NOTED
 1. CADAM REF. DMS. CL1333-2-1.1.2.3
 NOTE

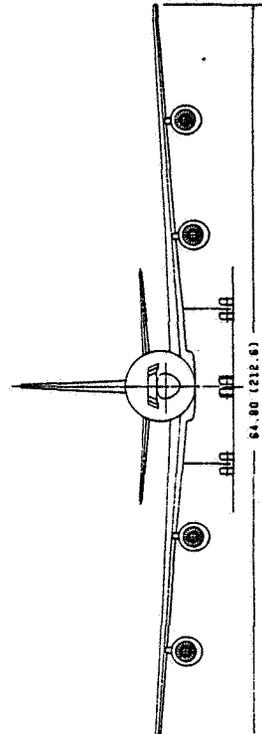
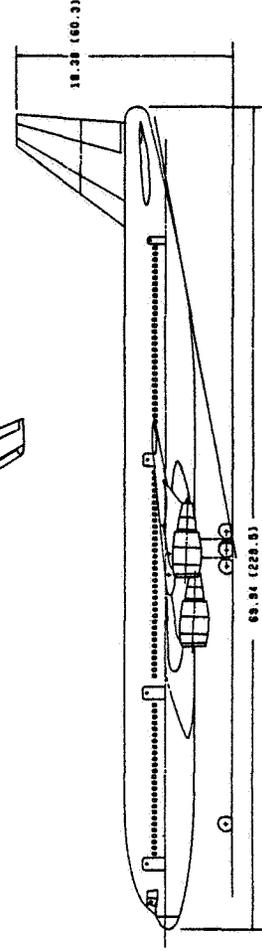


Figure B-7. Three-View Drawing of Intercontinental Aircraft with CF6-50C Engine.

FOLDOUT FRAME

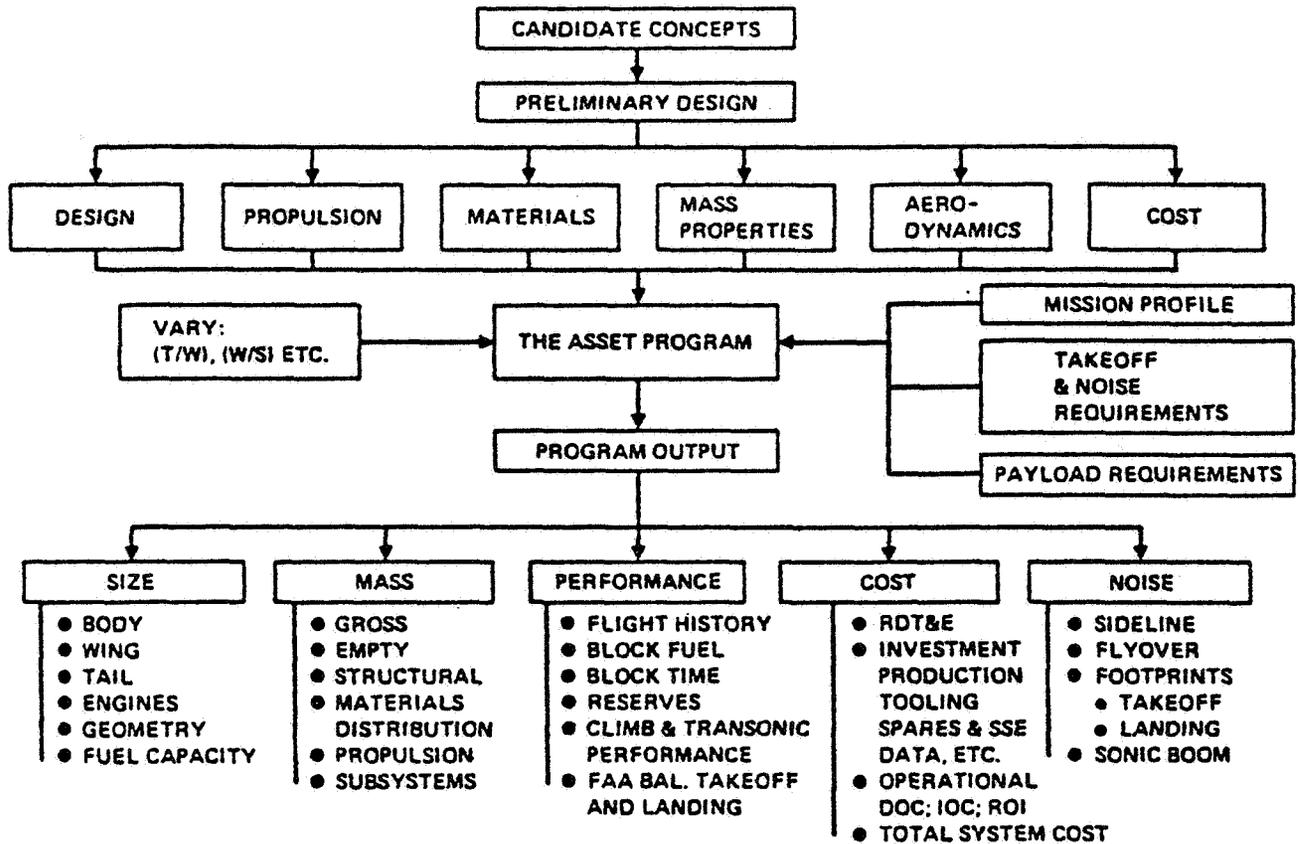


Figure B-8. ASSET Synthesis Cycle

Table B-IV. Aircraft Block Fuel and DOC

Fuel - Design Range (100% L.F.)

Segment	Domestic		Intercontinental	
	CF6-50C	E ³	CF6-50C	E ³
Takeoff	1089	776	1462	959
Climb	14520	11417	19185	15514
Cruise	81228	66610	243746	186963
Decent	675	845	917	1055
Land	600	510	825	730
Total	98112	80158	266135	204221

Fuel - Typical Range (55% L.F.)

Segment	Domestic		Intercontinental	
	CF6-50C	E ³	CF6-50C	E ³
Takeoff	1089	776	1462	959
Climb	10818	8350	11709	9529
Cruise	29529	24886	88584	69315
Decent	651	801	879	1001
Land	540	441	791	700
Total	42627	35254	103425	81504

Aircraft D.O.C. (/ASM)

	Domestic		Intercontinental	
	CF6-50C	E ³	CF6-50C	E ³
DOC - Design	1.262	1.161	1.449	1.290
DOC - Typical	1.360	1.269	1.435	1.299

Table B-V. AIRFRAME NOISE ESTIMATES (E³ ENGINE)

Condition	Domestic	Intercontinental
<u>Approach (42° Flap, Gear down, 3° Glide)</u>		
Landing Weight (lb)	371,635	418,209
Approach Speed (knots)	135	133
Altitude (ft)	394	394
Airframe Noise (EPNdB)	95.9	96
<u>Takeoff (25° Flap, Gear up)</u>		
Climb Angle	5.96°	4.66°
TOGW (lb)	452,857	626,841
Altitude (ft)	1668	1128
Distance (n.mi.)	3.5	3.5
Speed (knots)	150.55	160.6
Airframe Noise (EPNdB)	84.1	89.6
<u>Sideline Point</u>		
Airframe Noise (EPNdB)	80.0	83.2

Table B-VI and B-VII depict the sensitivity factors for the E³ aircraft (with advanced technology engine).

2.2.2 Performance Retention

As specified by NASA, one of the major goals for the E³ program is to incorporate those design features into the advanced technology engine which will ensure that deterioration of SFC characteristics with time (engine cycles) will be less than 50 percent of that currently experienced on the CF6-50C engine. This improvement was assessed to provide an additional 1% in SFC reduction, effectively over the service life of the engine.

An assessment of the impact on aircraft performance characteristics of the E³ engine, with and without credit for improved performance retention characteristics, was accomplished using the engine SFC and weight characteristics supplied by General Electric. Table B-VIII and B-IX depict the results of this assessment. These results indicate an additional increase in aircraft fuel savings of approximately 1% is attained with performance retention incorporated. The fuel savings included in this report are those values obtained with performance retention incorporated into the E³ engine.

2.3 AIRCRAFT/ENGINE INTEGRATION

2.3.1 Nacelle Configuration

The nacelle dimensions and weight for the E³ engine were supplied by General Electric. The E³ engine uses a mixed flow exhaust which requires a full length nacelle.

Use of the full length nacelle requires consideration of the following installation items:

- Potential of interference drag penalty particularly for wing mounted engine.
- Increased in wetted area of the nacelle and subsequent increase in drag.
- Potential of increased nacelle weight due to full length cowl.
- Access to engine hot section and to engine and aircraft accessories.

As part of this study effort, an assessment was made of the nacelle design, supplied by General Electric, for acceptability of aerodynamic and mechanical characteristics. This assessment included nacelle contour and envelope dimensions (both interior and exterior), inlet geometry, engine mount system, nacelle structural arrangement and materials, and nacelle weight. The results of this evaluation were supplied to General Electric for consideration during their preliminary design phase of the E³ flight propulsion system. Assessment of the flight propulsion system design used as the baseline for the NASA/GE Preliminary Design Review (PDR), November 1978, results in the following conclusions:

- Nacelle contours provide acceptable aerodynamic characteristics for incorporation into the E³ aircraft.

Table B-VI. Sensitivity Factors - Domestic Aircraft - E³ Engine.

<u>Base</u>	1.161/1.269	453,652	80,158/35,254	
	<u>ΔDOC</u> <u>(¢/ASM)</u>	<u>ΔTOGW</u> <u>(lb)</u>	<u>ΔFuel</u> <u>(lb)</u>	
ΔSFC				
+5%	+0.021/+0.0181%	+ 8526	+ 5114	6.38%
0	0	0	0	---
-5%	-0.021/-0.0181%	- 8337	- 4994	6.23%
ΔEngine Weight at 40,000 lb/F _N				
+1000 lb	+0.006/+0.052%	+ 5677	+ 876	---
0	0	0	0	---
-1000 lb	-0.006/-0.052%	- 5514	- 851	---
ΔEngine Cost				
+ \$250K	+0.021/+0.0181%	NA	NA	
0	0			
- \$250K	-0.021/-0.0181%			
ΔEngine Maint.				
+20%	+0.023/+0.0190%			
0	0			
-20%	-0.024/-0.0207%			

Table B-VII. Sensitivity Factors - Intercontinental Aircraft - E³ Engine.

<u>Base</u>	1.290/1.299	624,577	205,221/81,504	
	<u>ΔDOC</u> <u>(¢/ASM)</u>	<u>ΔTOGW</u> <u>(lb)</u>	<u>ΔFuel</u> <u>(lb)</u>	
ΔSFC				
+5%	+0.042/+0.033%	+25419	+16505	8.04%
0	0	0	0	---
-5%	-0.042/-0.033%	-24321	-15732	7.67%
ΔEngine Weight at 37,600 lb/F _N				
+1000 lb	+0.009/+0.007%	+ 8952	+ 2643	---
0	0	0	0	---
-1000 lb	-0.009/-0.007%	- 8395	- 2476	---
ΔEngine Cost				
+ \$250K	+0.024	NA	NA	
0	0			
- \$250K	-0.025			
ΔEngine Maint.				
+20%	+0.027			
0	0			
-20%	-0.028			

Table B-VIII. INTERCONTINENTAL AIRCRAFT PERFORMANCE CHARACTERISTICS

	CF6-50C Engine	E3 Engine Without Improved Performance Retention	E3 Engine With Improved Performance Retention
No. Pax	500	500	500
Design Range (n.mi.)	6,500	6,500	6,500
Gross Wt. (lb)	709,664	629,443	624,577
Empty Wt. (lb)	303,963	285,767	283,672
Engine Thrust (lb)	43,999	37,925	37,631
Design Fuel (lb)	266,136	208,378	205,221
Typical Fuel (lb)	103,425	82,731	81,504
Des. Fuel Savings	-	21.7%	22.9%
Typ. Fuel Savings	-	20.1%	21.2%

Table B-IX. DOMESTIC AIRCRAFT PERFORMANCE CHARACTERISTICS

	CF6-50C Engine	E3 Engine Without Improved Performance Retention	E3 Engine With Improved Performance Retention
No. Pax	500	500	500
Design Range (n.mi.)	3,000	3,000	3,000
Gross Wt. (lb)	478,622	455,319	453,652
Empty Wt. (lb)	261,796	257,710	256,767
Engine Thrust (lb)	43,714	40,978	40,832
Design Fuel (lb)	98,113	81,157	80,158
Typical Fuel (lb)	42,629	35,684	35,254
Des. Fuel Savings	-	17.3%	18.3%
Typ. Fuel Savings	-	16.3%	17.3%

- Inlet geometry is acceptable and is consistent with our previous experience with this size of engine on the L-1011 commercial aircraft
- The engine mount system is structurally adequate and compatible with pylon mounting to the aircraft. Evaluation of the mount system, with respect to fail-safe capabilities, and the design approach necessary, are included in Figure B-9
- Nacelle structural arrangement, structural materials, and weight estimates made by General Electric appear to be reasonable and acceptable.

Use of composite materials in the nacelle results in a weight savings of approximately 15 percent as compared to an all metal nacelle. This estimate, supplied by General Electric, is consistent with Lockheed's efforts for Advanced Acoustic Composite Nacelles, NASA Report CR 132649.

2.3.2 Nacelle - Wing Interference

Figure B-5 depicts installation of the E³ engine to the wing of the domestic aircraft. Placement of the engine with respect to the wing is consistent with Lockheed experience on the L-1011 for elimination or minimization of interference drag penalties. Aerodynamic assessments of this installation indicate no drag penalty imposed by wing/nacelle interference. Development testing (wind tunnel tests) and tailoring will be required prior to actual installation of the E³ mixed flow engine on the aircraft. For the aircraft performance analysis, zero interference drag was used, which is compatible with experience on the L-1011 commercial aircraft.

2.3.3 Accessory Location

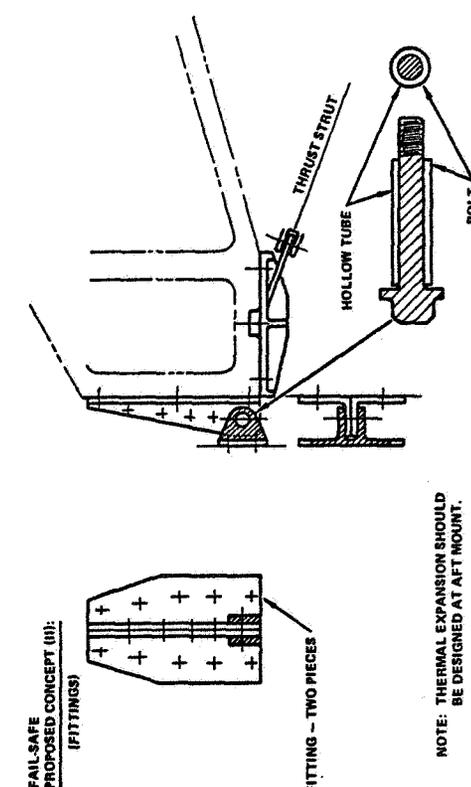
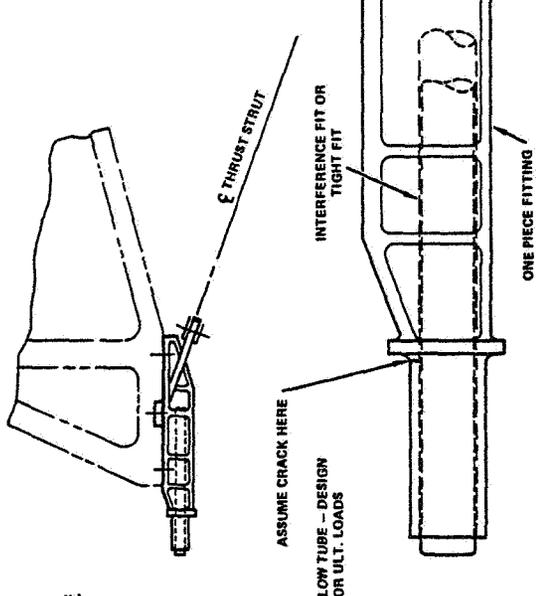
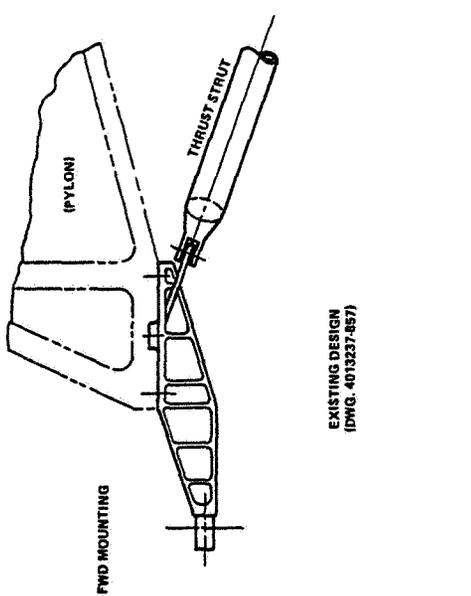
During this study, various aircraft accessory locations were considered. Table B-X presents a qualitative assessment of the advantages and disadvantages of each location. Figure B-10 depicts location of aircraft accessories for the wing mounted engines in the pylon. Locating the aircraft accessories in the engine pylon is desirable for minimization of nacelle drag and improved maintainability/reliability due to the improved environment (lower temperature). Attempts to pylon mount all accessories (both engine and aircraft), for best nacelle aerodynamic shape, requires an increase in pylon size and probable adverse effect on interference drag. Figure B-11 depicts the other accessory locations subjected to design layouts during this study. These design layouts show that accessories located in the engine core or external to the fan case are practical for the E³ engine. Since location of engine and aircraft accessories will ultimately depend on the desires of the E³ engine user, it is important to provide an engine/nacelle configuration which is adaptable to the user requirements. The E³ engines, as configured, accomplishes this goal. Accessories can be core mounted, fan case mounted, or pylon mounted without requiring changes to the basic engine design.

2.3.4 Access Provisions

The E³ engine/nacelle configuration selected as the baseline for the flight propulsion system PDR uses core mounted accessories (both engine and aircraft). This configuration requires access to the engine core which will be provided by hinging the thrust reverser and interior (core) cowl. In the event that pylon mounted aircraft accessories are incorporated in future

Table B-X. E³ Accessory Location

Aircraft Accessories	Engine Accessories	Advantage	Disadvantage
Pylon Mount	Pylon Mount	<ul style="list-style-type: none"> • Best aero shape nacelle • Improved component environment • Access to engine not req. for component maint. • Utilize integral gearbox 	<ul style="list-style-type: none"> • Large Pylon • High speed shaft from engine to pylon • Possible effect on interference drag • Requires additional work stands
Pylon Mount	Cowl Mount	<ul style="list-style-type: none"> • Good aero shape nacelle • Improved component environment • Engine access not req. for aircraft accessories 	<ul style="list-style-type: none"> • Large pylon • Requires added gearbox, high speed shaft, etc. • Requires additional work stands
Pylon Mount	Core Mount	<ul style="list-style-type: none"> • Good aero shape nacelle • Improved component environment - aircraft accessories • Engine access not req. for aircraft accessories 	<ul style="list-style-type: none"> • Aircraft and engine components in separate locations • Large pylon • Requires added gearbox, high speed shaft, etc.
Cowl Mount	Cowl Mount	<ul style="list-style-type: none"> • Improved component environment • Utilize integral gearbox • Enhance accessibility to components • Small pylon • Utilize integral gearbox • Small pylon • Rigid mount for all components 	<ul style="list-style-type: none"> • Hot environment for engine components • Aircraft and engine components in separate locations • Large nacelle • Revision to nacelle structure and thrust reverser
Core Mount	Core Mount	<ul style="list-style-type: none"> • Utilize integral gearbox • Enhance accessibility to components • Small pylon • Utilize integral gearbox • Small pylon • Rigid mount for all components 	<ul style="list-style-type: none"> • Requires access to engine hot section for maint. of engine components • Hot environment for engine components • Aircraft and engine components in separate locations • Large nacelle • Revision to nacelle structure and thrust reverser



NOTE: THERMAL EXPANSION SHOULD BE DESIGNED AT AFT MOUNT.

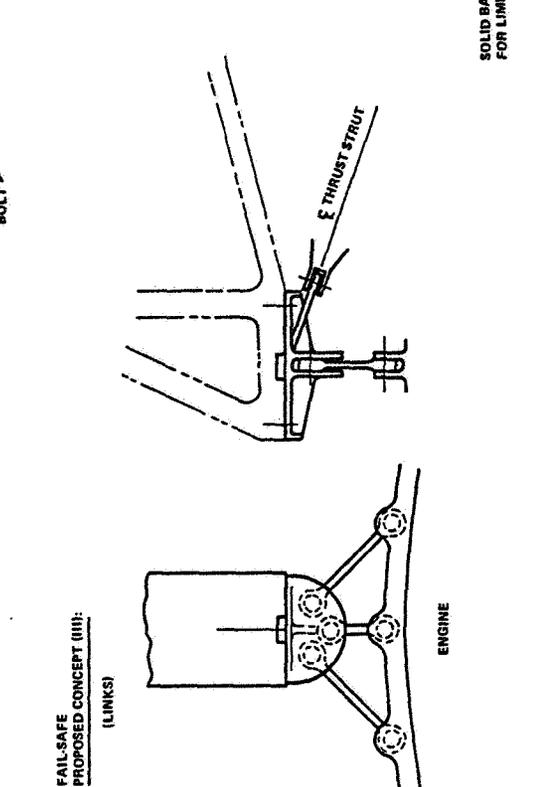


Figure B-9, Fail-Safe Design Concepts E³ Engine Mount System.

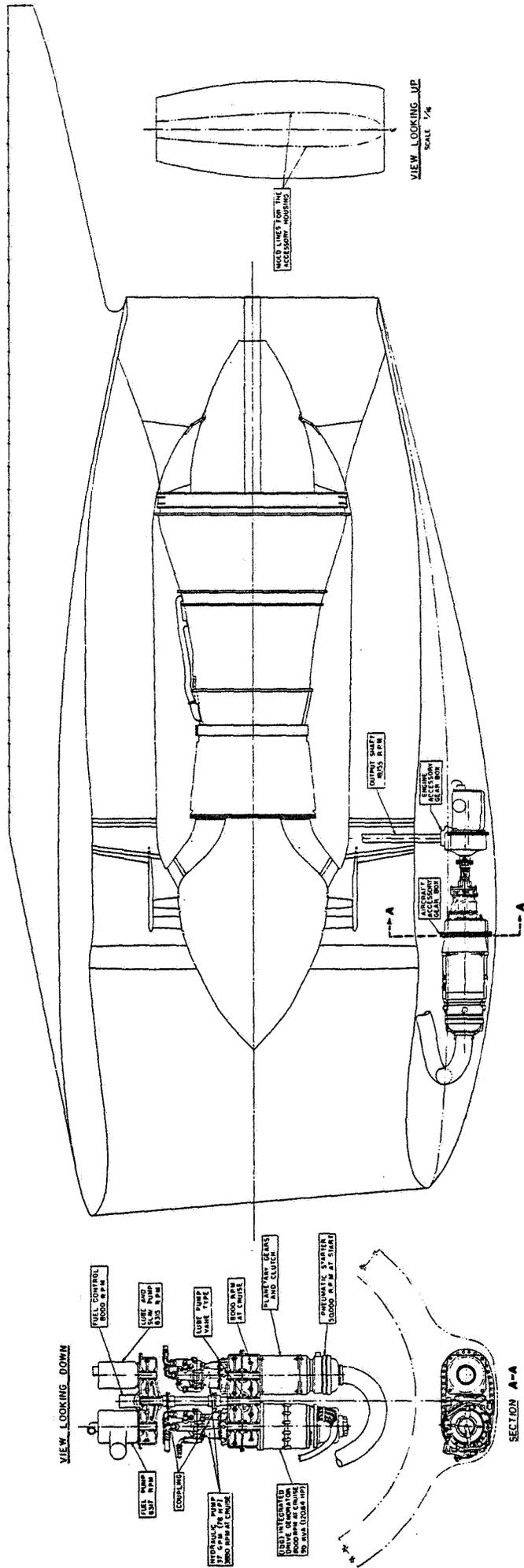


Figure B-11. E³ Engine with Fan Case-Mounted Accessories.

PROJECT FEEDBACK

engines, access would be provided by removing the top of the pylon to provide ready access to components. Since the pylon skin is subjected to aerodynamic loads only, with the pylon structural arrangement shown in Figure B-10, removal of panels for access can be accomplished with non-structural, quick turn type of fasteners. An additional work stand similar to that currently required for the center engine on the L-1011 will also be required for pylon mounted accessories.

2.3.5 Thrust Reverser

Reverse thrust is provided by a set of cascades, located in the engine fan stream, which are uncovered by a translating cowl during the reverse thrust operating mode. Required levels of reverse thrust for the E³ aircraft are approximately 35 percent of engine forward thrust. As currently sized, the E³ engine will provide reverse thrust static effectiveness of 34 percent of forward thrust, which is slightly less than the CF6-50C with both the fan and turbine reverser. The level of reverse thrust estimated for the E³ engine is considered acceptable for both the domestic and intercontinental aircraft designs. Flow directivity of the thrust reverser is required to minimize impingement on the aircraft control surfaces and to minimize reingestion into the engine. A schematic of the expected flow directivity requirements is shown in Figure B-12.

2.3.6 Center Engine Installation

Primary concern for installation of the mixed flow nacelle in the center engine location is the nacelle overall length and the potential effect on interference and possible scrape of the nacelle during takeoff rotation. For the domestic aircraft design the E³ center engine was located such that ground clearance of the aft end during takeoff rotation was consistent with the current L-1011 installation. Also, the "S" duct inlet configuration of the L-1011 was retained. As is the case with the wing engine installation, future aerodynamic development testing and possible tailoring will be required to minimize interference effects. For this study effort, zero interference drag penalty, which is consistent with L-1011 experience, was used for the center engine installation.

2.3.7 Engine Bleed Requirements and Power Extraction

For this study effort, engine bleed and power extraction requirements were included in the engine performance data supplied by General Electric. Estimates of the bleed and power extraction requirements for a 500 passenger aircraft for the early 1990's are:

- Bleed air - 9 lb/sec for ECS and anti-icing (Total for all engines)
- Power extraction - 370 hp for hydraulic pumps and generator (Total for all engines)

2.3.8 Engine Fire Protection

Figure B-13 depicts the applicable fire zones established by Lockheed for the E³ engine. The following criteria was used to establish the E³ engine fire protection criteria:

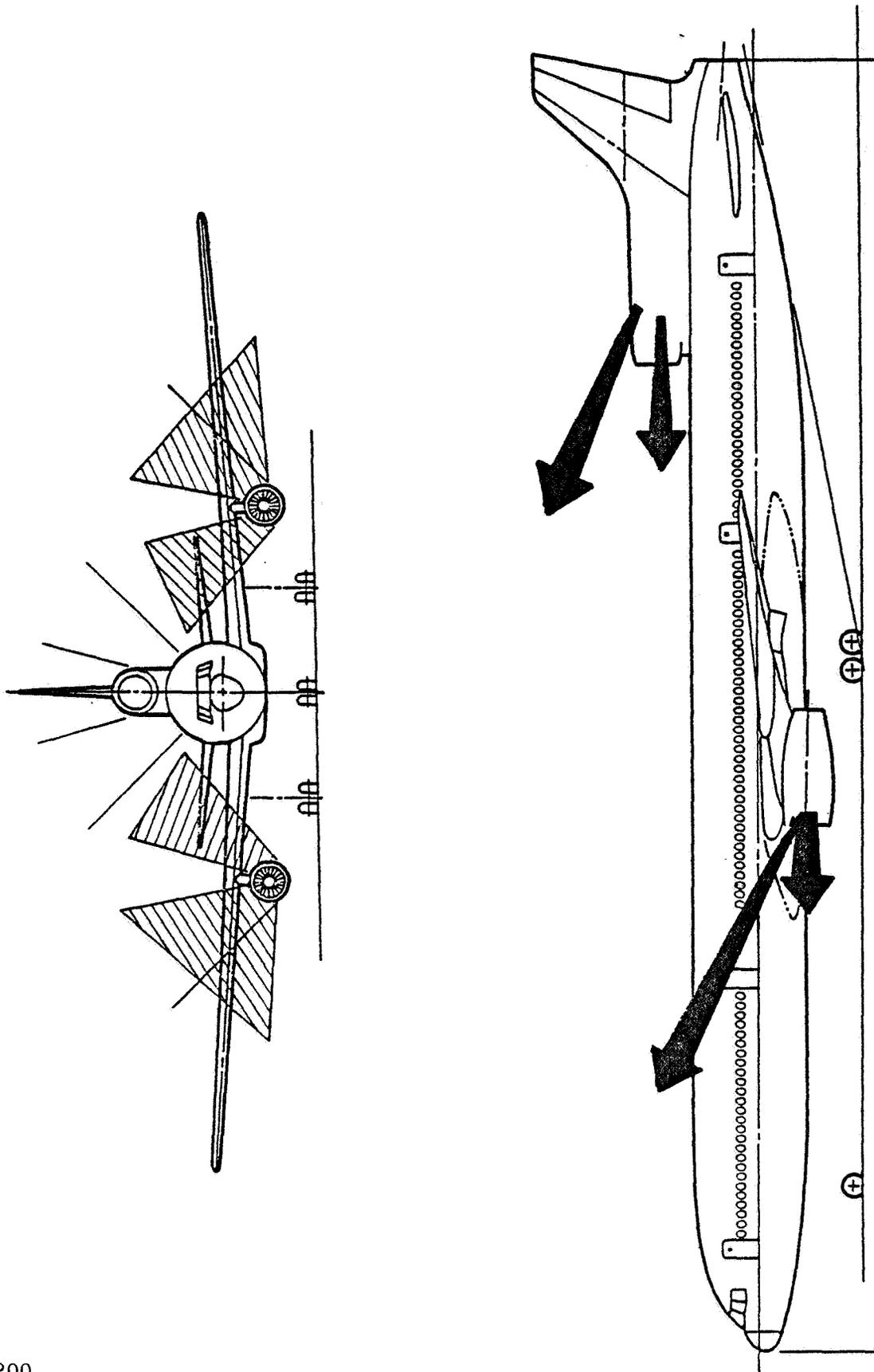
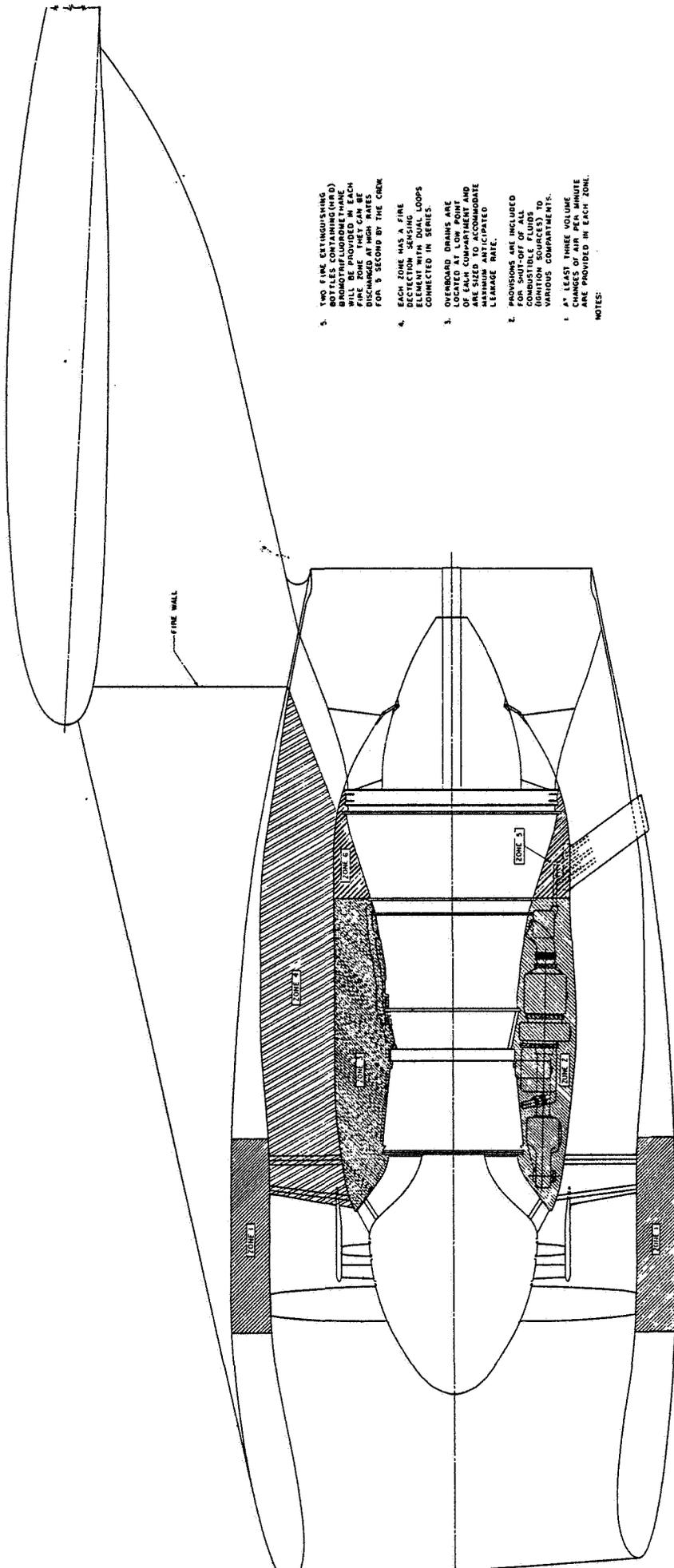


Figure B-12. Thrust Reverser Flow Directivity



3. TWO FIRE EXTINGUISHING BOTTLES CONTAINING (MFD) BROMOCHLORODIFLUOROMETHANE WILL BE PROVIDED IN EACH COMPARTMENT. THESE BOTTLES WILL BE DISCHARGED AT HIGH RATES FOR 5 SECONDS BY THE CREW.
4. EACH ZONE HAS A FIRE EXTINGUISHING ELEMENT WITH DUAL LOOPS CONNECTED IN SERIES.
5. OVERBOARD DRAINS ARE LOCATED AT LOW POINT OF EACH COMPARTMENT AND ARE BELIEVED TO ACCUMULATE LEAKAGE RATE.
6. PROVISIONS ARE INCLUDED FOR SHUT-OFF OF ALL COMBUSTIBLE FLUIDS (EXCEPT SOURCES) TO VARIOUS COMPARTMENTS.
7. AT LEAST THREE VOLUME REDUCING DEVICES ARE PROVIDED IN EACH ZONE.

NOTES:

Handwritten note: 2

Figure B-13. Layout of Fire Zones for E³ Engine.

FOR OUT BOARD

- Fire Prevention: Compartmentation used for containment and to provide maximum separation between combustibles and ignition sources. Fireproof bulkheads should be provided in the more critical areas. Flameproof bulkheads should be provided in the more critical areas. Flameproof barriers are required to protect primary structure and engine support structure. Fire zones will require ventilation and overboard drains located at low points. Ventilation of the compartments should be a minimum of three volume changes per minute and can be provided by fan air or ram air during in-flight conditions.
- Fire Detection: Fire detection is provided by audio and visual indication at the flight station for engine compartments as well as the APU and main wheel wells. Thermistor type, continuous sensing elements are used as the sensors to activate appropriate warning indicators on flight station control panels. Each fire zone contains its own sensors and control loops.
- Fire Extinguishing System: High rate of discharge (HRD) system is normally provided for engine accessory compartment and APU compartment. On the L-1011 aircraft, the fire extinguishing material is Bromo-trifluoromethane and two fire extinguisher bottles are provided for each engine fire zone. Bottles are operated (discharged) from controls located in the flight station.

2.4 PERFORMANCE AND ECONOMIC COMPARISONS

The previously stated objectives for the Energy Efficient Engine Program with regards to fuel and operating cost savings are:

- Reduction in specific fuel consumption of 12 percent minimum.
- Reduction in direct operating costs of 5 percent minimum.

Figures B-14 and B-15 show the savings in block fuel and DOC, of the domestic and intercontinental aircraft with the E³ engine when compared to the reference aircraft (CF6-50C engine). The results show significant savings for the E³ engine as follows:

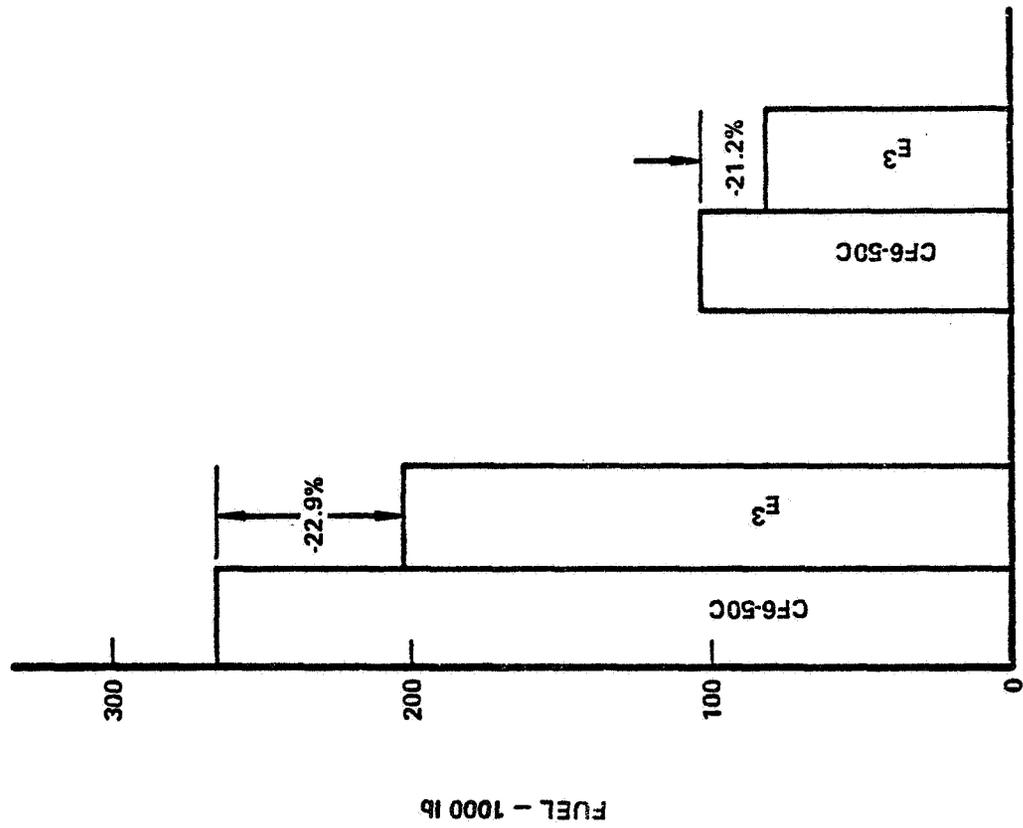
	Domestic		Intercontinental	
	Des. Range	Typ. Range	Des. Range	Typ. Range
Block Fuel	18.3%	17.3%	22.9%	21.2%
DOC	8.0%	6.8%	12.0%	10.5%

Figure B-16 depicts the advantages in aircraft size when the E³ engine is used. Incorporation of the energy efficient engine provides an aircraft design, for large payload capacity and long range capability, which is well within the capabilities of current airport facilities and also provides significant future growth capability.

INTERCONTINENTAL

TYPICAL

DESIGN



DOMESTIC

TYPICAL

DESIGN

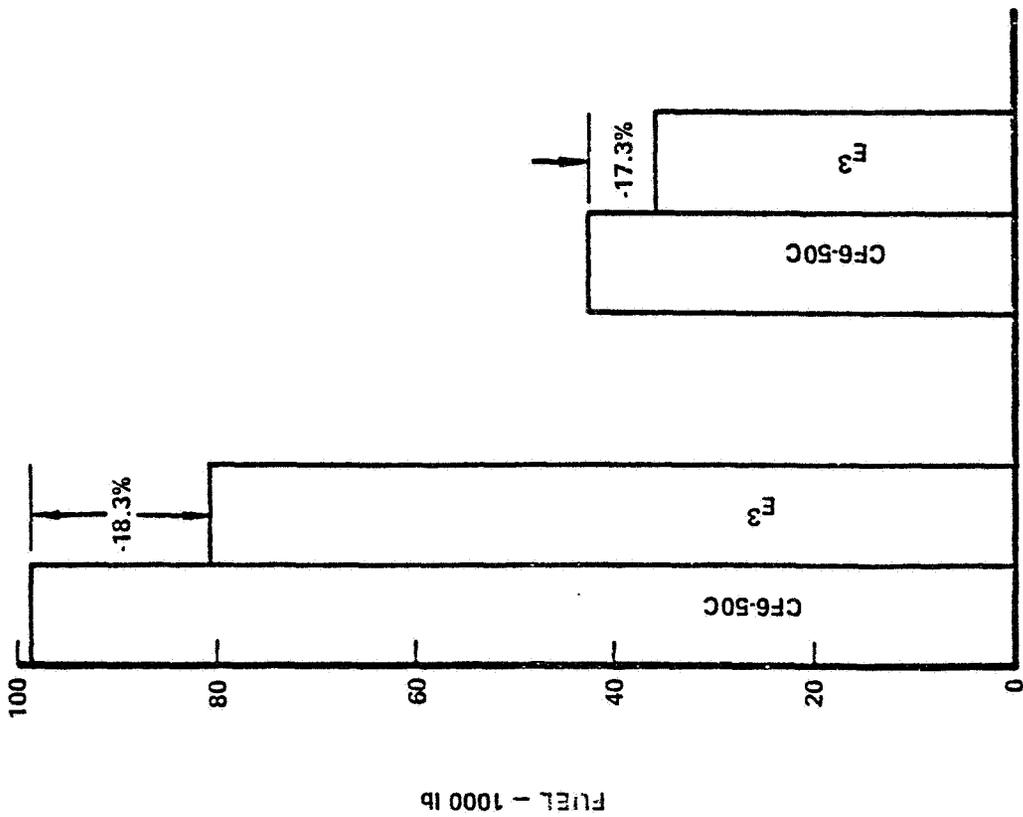


Figure B-14. Block Fuel Savings with E³ Engine

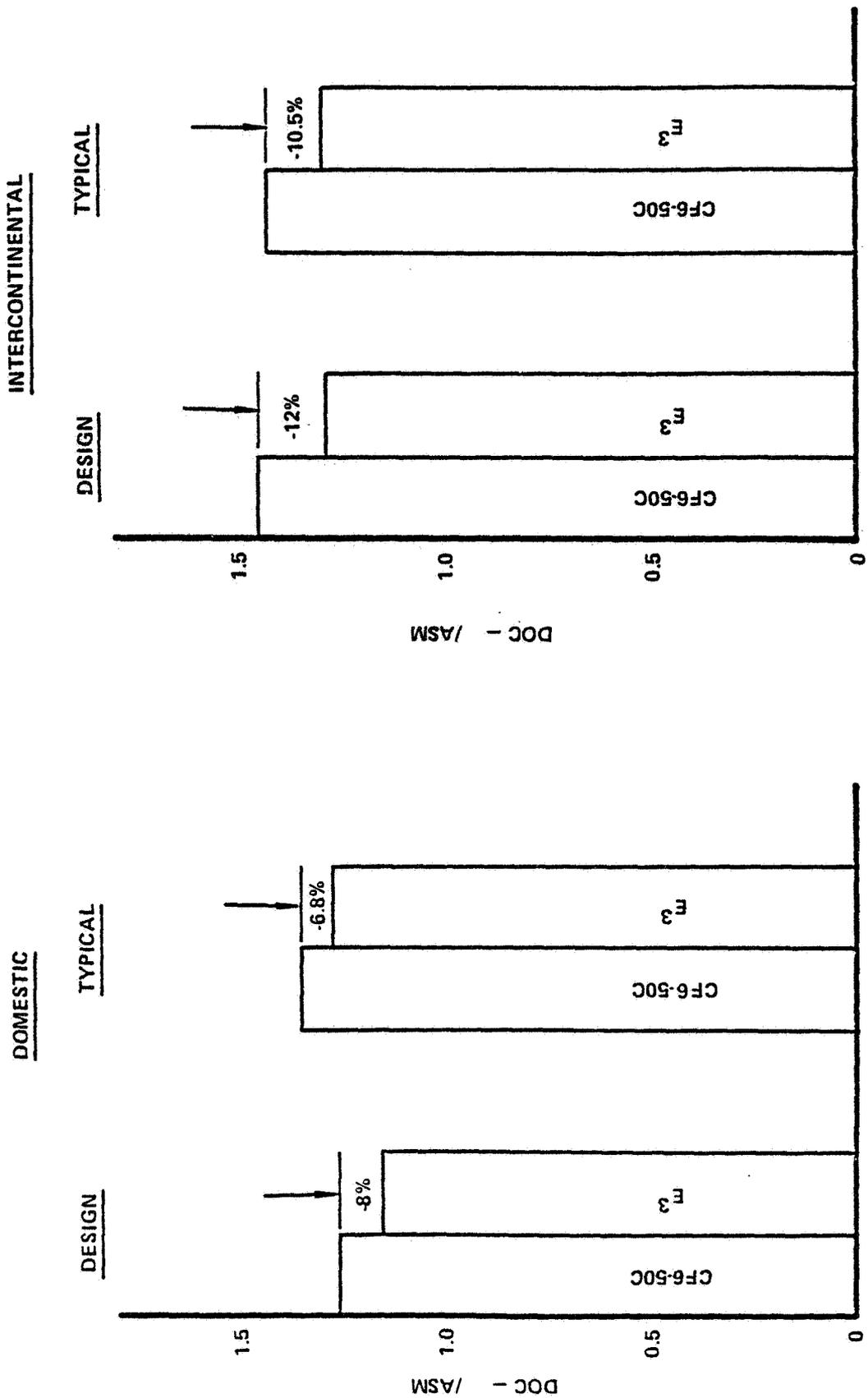
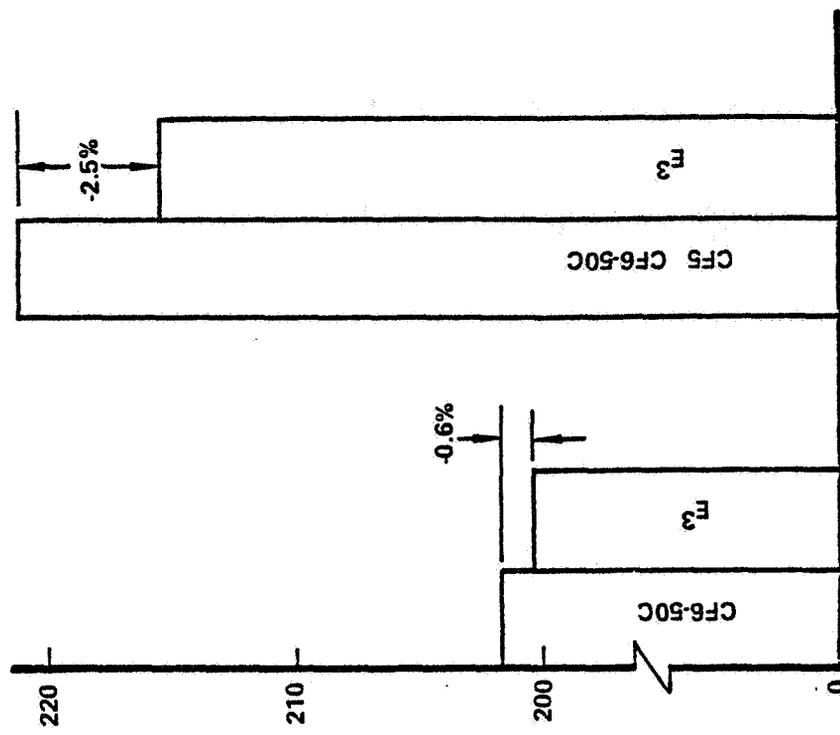


Figure B-15. DOC Savings with E³ Engine

WING SPAN

INTERCONT.

DOMESTIC



GROSS WT.

INTERCONT.

DOMESTIC

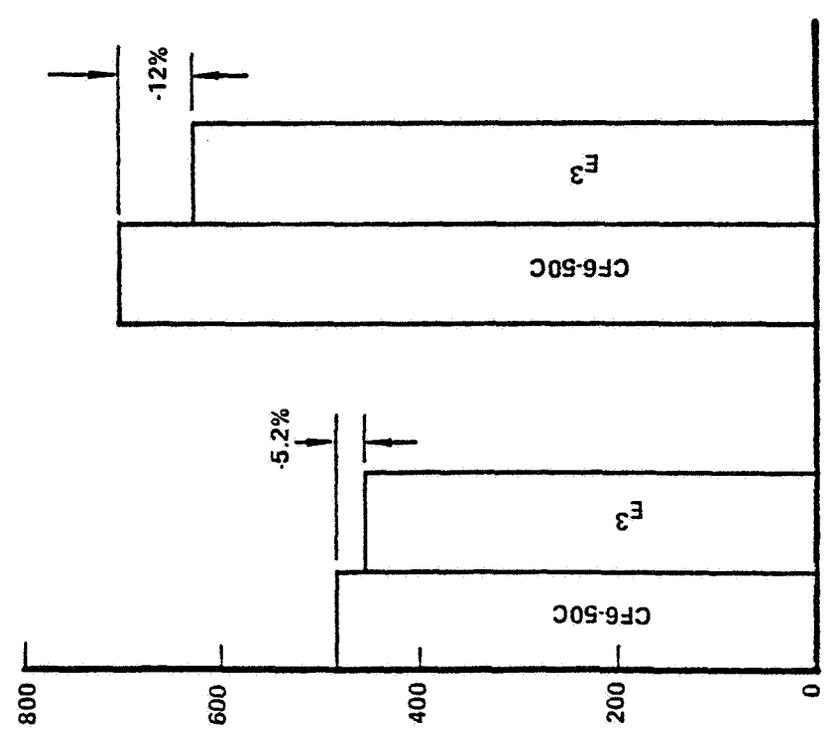


Figure B-16. Aircraft Size Advantage with E³ Engine

3.0 CONCLUSIONS AND RECOMMENDATIONS

The results of this study, accomplished with the advanced technology, direct drive, mixed flow E³ engine, with the design and performance characteristics supplied by General Electric, show that:

- The NASA specified goals for minimum fuel and DOC savings are exceeded with the E³ engine
- Nacelle aerodynamic and mechanical characteristics are acceptable for aircraft installation
- Installation of the mixed exhaust E³ engine on both the domestic and intercontinental aircraft appears feasible without a penalty for interference drag
- Thrust characteristics of the E³ engine are compatible with the 1990's commercial aircraft selected by Lockheed
- Incorporation of the E³ engine results in aircraft configurations, sized for long range and large payload capacity, which are compatible with existing airport facilities.

SUPPLEMENT A

- Asset Computer Printout - Domestic Aircraft with E³ Engine
- Asset Computer Printout - Intercontinental Aircraft with E³ Engine

E003 AIRCRAFT / 500 PASS / 3000 N MI / M = .80 MISS

T/C AR W/S T/W
13.00 10.00 113.0 0.270

C O N F I G U R A T I O N G E O M E T R Y

BASIC WING--	AREA(SQ FT)	SPAN(FT)	TAPER RATIO	C/4 SWEEP	L.E. SWEEP	MAC(FT)
	4007.6	200.19	0.300	30.000	32.260	21.95
WING PANELS--	AREA(SQ FT)	EXP. AREA	AVG T/C	L.E. SWEEP	SFLE(SQ FT)	REF L(FT)
	2562.0	1815.2	13.00	32.260	0.0	29.52
	1938.8	1838.8	13.00	32.260	0.0	16.46
TOTAL WING--	AREA(SQ FT)	EFF AR	AVG T/C	CR(FT)	CT(FT)	MAC(FT)
	4400.8	0.11	13.00	40.32	9.24	25.53
FUSELAGE--	LENGTH(FT)	S WET(SQ FT)	BW(FT)	EQUIV O(FT)	SPI(SQ FT)	L(FT)
	228.33	12707.9	19.58	19.58	300.95	72.42
	RW(FT)	RH(FT)	SBW(SQ FT)			
	19.58	19.58	11599.00			
HORZ. TAIL 1--	SHT1(SQ FT)	SMX1(SQ FT)	REF L1(FT)	L HT1(FT)	HT1 VOL COEF	
	927.82	702.90	13.40	87.11	0.9186	
HORZ. TAIL 2--	SHT2(SQ FT)	SMX2(SQ FT)	REF L2(FT)	L HT2(FT)	HT2 VOL COEF	
	0.0	0.0	0.0	228.33	0.0	
VERT. TAIL 1--	SVT1(SQ FT)	SVX1(SQ FT)	REF L1(FT)	L VT1(FT)	VT1 VOL COEF	
	577.94	577.94	20.84	91.66	0.0660	
VERT. TAIL 2--	SVT2(SQ FT)	SVX2(SQ FT)	REF L2(FT)	L VT2(FT)	VT2 VOL COEF	
	0.0	0.0	0.0	228.33	0.0	
PROPULSION--	ENG L(FT)	ENG D(FT)	POD L(FT)	POD D(FT)	POD S WET	NO. PODS
	11.37	7.38	19.67	7.83	967.12	2.
						INLET L(FT)
						30.08
FUEL TANKS--	WING(CU FT)	BOX(CU FT)	FUS(CU FT)			
	4662.21	1340.60	9999.00			
WETTED VOLUMES--	BODY	WING	TAILS	PODS	POLONS	PONTOONS
	53501.06	5449.88	1085.65	1892.19	0.0	0.0
						TOTAL
						61928.78

DOMESTIC AIRCRAFT (E3 ENGINE)

E33 AIRCRAFT / 500 PASS / 3000 N MI / M F .80 MISS

T/C AR W/S T/W
 17.00 10.00 113.0 0.270

W E I G H T S T A T E M E N T

	WEIGHT (POUNDS)	WEIGHT FRACTION	(PERCENT)
CROSS WEIGHT	(452857.)		
FUEL AVAILABLE	97270.	FUEL	21.48
EXTERNAL	0.		
INTERNAL	35587.		
ZERO FUEL WEIGHT	100000.	PAYLOAD	22.08
PAYLOAD	85000.		
PASSENGERS	0.		
PACKAGE	15000.		
CARGO	0.		
STORES	0.		
OPERATIONAL EMPTY WEIGHT	255987.	OPERATIONAL ITEMS	4.77
OPERATIONAL ITEMS	16193.		
STANDARD ITEMS	5406.		
EMPTY WEIGHT	239988.	STRUCTURE	29.85
STRUCTURE	135192.		
WING	48514.		
ROTOR	0.		
TAIL	5876.		
BODY	56519.		
ALIGHTING GEAR	18781.		
ENGINE SECTION AND NACELLE	5503.		
PROPULSION	29119.	PROPULSION	6.43
CRUISE ENGINES	22180.		
LIFT ENGINES	0.		
THRUST REVERSER	4709.		
EXHAUST SYSTEM	0.		
ENGINE CONTROL	208.		
STARTING SYSTEM	532.		
PROPELLERS	0.		
LUBRICATING SYSTEM	0.		
FUEL SYSTEM	1491.		
DRIVE SYSTEM (POWER TRANS)	0.		
SYSTEMS	69677.	SYSTEMS	15.39
FLIGHT CONTROLS	4407.		
AUXILIARY POWER PLANT	1116.		
INSTRUMENTS	923.		
HYDRAULIC AND PNEUMATIC	2673.		
ELECTRICAL	5967.		
AVIONICS	2200.		
ARMAMENT	0.		
FURNISHINGS AND EQUIPMENT	44293.		
AIR CONDITIONING	7682.		
ANTI-ICING	416.		
PHOTOGRAPHIC	0.		
LOAD AND HANDLING	0.	TOTAL	(100.)

DOMESTIC AIRCRAFT (E3 ENGINE)

M I S S I O N S U M M A R Y
/ 500 PASS / 3000 N MI / M = .80 MISS

SEGMENT	INIT ALTITUDE (FT)	INIT MACH NO	INIT WEIGHT (LBS)	SEGT FUEL (LBS)	TOTAL FUEL (LBS)	SEGT DIST (N MI)	TOTAL DIST (N MI)	SEGT TIME (MIN)	TOTAL TIME (MIN)	EXTERN STORE TAB ID	ENGINE THRUST TAB ID	EXTERN F TANK TAB ID	AVG L/D RATIO	AVG SFC (FF/T)	WTK OYER PRES
TAKOFF POWER 1	0	0.0	452857	0	0	0	0	0.0	0.0	0	429501	0	0.0	0.297	0.09
POWER 2	0	0.0	452857	776	776	0	0	1.3	1.3	0	429501	0	0.0	0.297	0.00
CLIMB	0	0.378	452081	7614	8390	109	109	19.5	20.9	0	429201	0	19.97	0.500	0.09
ACCEL	30000	0.692	444467	827	9217	20	130	2.8	23.7	0	429201	0	19.16	0.557	0.00
CLIMB	30000	0.800	443640	2976	12193	85	215	11.0	34.7	0	429201	0	19.29	0.568	0.09
CRUISE	37000	0.800	440664	64687	76880	2535	2750	331.5	366.2	0	429101	0	19.72	0.567	0.00
DESCENT	40000	0.800	375977	70	76950	25	2774	3.2	369.4	0	203301	0	18.41	-0.393	0.00
DECL	30000	0.800	375907	21	76971	6	2781	0.9	370.2	0	203301	0	17.99	-0.405	0.00
DESCENT	30000	0.692	375885	744	77726	94	2874	17.8	388.0	0	203301	0	19.35	-1.118	0.00
CRUISE	40000	0.800	375131	2986	80712	126	3000	16.4	404.4	0	429101	0	19.56	0.571	0.00
LOITER	1500	0.315	372145	510	81222	0	3000	3.0	407.4	0	429101	0	19.01	0.523	0.00
RFSET	0	0.0	371635	0	81222	-3000	0	0.0	407.4	0	0	0	0.0	0.0	0.00
RESET	0	0.0	371635	0	81222	0	0	0.0	407.4	0	0	0	0.0	0.0	0.00
CLIMB	0	0.378	371635	1658	82880	15	15	3.3	410.7	0	429201	0	19.26	0.468	0.00
ACCEL	10000	0.456	369977	0	82880	0	15	0.0	410.7	0	429201	0	19.27	0.477	0.00
CLIMB	10000	0.456	369977	3821	86701	62	77	10.6	421.3	0	429201	0	19.18	0.508	0.00
CRUISE	30000	0.725	366155	350	87051	13	90	1.9	423.1	0	429101	0	18.24	0.579	0.00
DESCENT	30000	0.692	365806	397	87448	64	154	11.3	434.4	0	203301	0	19.15	-0.727	0.00
DECL	10000	0.456	365408	0	87448	0	154	0.0	434.4	0	203301	0	19.19	-1.183	0.00
DESCENT	10000	0.456	365408	325	87773	27	181	5.9	440.3	0	203301	0	19.19	-1.762	0.00
CRUISE	30000	0.725	365084	518	88290	19	200	2.7	443.0	0	429101	0	18.22	0.579	0.00
CRUISE	1500	0.378	364564	388	88679	0	200	2.0	445.0	0	429101	0	19.47	0.623	0.00
CRUISE	30000	0.725	364177	8597	97266	0	200	45.0	490.0	0	429101	0	18.21	0.579	0.00

WTK = 452857.1 FUEL A = 97270.3 FUEL R = 97265.6

DOMESTIC AIRCRAFT (E³ ENGINE)

A L T E R N A T E M I S S I O N N O. I S U M M A R Y

/ 55(LF / 1400 N MI / M.F. 90 MISS

SEGMENT	INIT ALTITUDE (FT)	INIT MACH	INIT WEIGHT (LB)	SEGMT FUEL (LB)	TOTAL FUEL (LB)	SEGMT DIST (N MI)	TOTAL DIST (N MI)	SEGMT TIME (MIN)	TOTAL TIME (MIN)	EXTERN STORE TAB ID	ENGINE THRUST TAB ID	EXTERN F TANK TAB ID	Avg L/D RATIO	Avg SFC (FF/T)	FIRE OVER PAGES
TAKOFF POWER 1	0.	0.0	360350.	0.	0.	0.	0.	0.0	0.0	0.	429501.	0.	0.0	0.297	0.00
POWER 2	0.	0.0	360359.	776.	776.	0.	0.	1.3	1.3	0.	429501.	0.	0.0	0.297	0.00
CLIMB	0.	0.379	359583.	5224.	6000.	73.	73.	13.3	14.6	0.	429201.	0.	18.96	0.498	0.00
ACCEL	30000.	0.692	354359.	504.	6504.	12.	86.	1.7	16.3	0.	429201.	0.	17.37	0.557	0.00
CLIMB	30000.	0.800	353855.	2622.	9126.	81.	167.	10.5	26.8	0.	429201.	0.	18.10	0.569	0.00
CRUISE	41000.	0.800	351231.	21813.	30939.	983.	1150.	128.6	155.4	0.	429101.	0.	19.29	0.577	0.00
DESCENT	41000.	0.800	329420.	72.	31011.	25.	1175.	3.3	158.7	0.	203301.	0.	17.48	-0.399	0.00
DESCENT	20000.	0.800	229348.	20.	31031.	6.	1181.	0.8	159.5	0.	203301.	0.	16.82	-0.406	0.00
DESCENT	30000.	0.692	329328.	709.	31740.	88.	1269.	16.7	176.2	0.	203301.	0.	18.36	-1.120	0.00
CRUISE	41000.	0.800	328619.	2821.	34561.	131.	1400.	17.1	193.3	0.	429101.	0.	19.09	0.577	0.00
LOITER	15000.	0.290	325798.	441.	35002.	0.	1400.	3.0	196.3	0.	429101.	0.	18.66	0.507	0.00
RESET	0.	0.0	325357.	0.	35002.	-1400.	0.	0.0	196.3	0.	0.	0.	0.0	0.0	0.00
RESET	0.	0.0	325357.	0.	35002.	0.	0.	0.0	196.3	0.	0.	0.	0.0	0.0	0.00
CLIMB	0.	0.378	325357.	1405.	26408.	13.	13.	2.8	199.1	0.	429201.	0.	18.21	0.468	0.00
ACCEL	10000.	0.456	323951.	0.	36409.	0.	13.	0.0	199.1	0.	429201.	0.	18.26	0.477	0.00
CLIMB	10000.	0.456	323951.	3146.	39553.	51.	64.	8.7	207.8	0.	429201.	0.	18.15	0.507	0.00
CRUISE	30000.	0.705	320806.	674.	40277.	26.	90.	3.8	211.6	0.	429101.	0.	17.63	0.583	0.00
DESCENT	30000.	0.692	320131.	372.	40599.	60.	150.	10.5	222.1	0.	203301.	0.	18.11	-0.728	0.00
DESCENT	10000.	0.456	319759.	0.	40599.	0.	150.	0.0	222.1	0.	203301.	0.	18.15	-1.183	0.00
DESCENT	10000.	0.456	319759.	305.	40904.	25.	175.	5.5	227.7	0.	203301.	0.	18.15	-1.763	0.00
CRUISE	20000.	0.705	319455.	633.	41537.	25.	200.	3.6	231.3	0.	429101.	0.	17.59	0.584	0.00
CRUISE	15000.	0.379	318821.	371.	41908.	0.	200.	2.0	233.3	0.	429101.	0.	18.51	0.646	0.00
CRUISE	20000.	0.705	318451.	7900.	49909.	0.	200.	45.0	278.3	0.	429101.	0.	17.46	0.585	0.00

DOMESTIC AIRCRAFT (E³ ENGINE)

C O S T S U M M A R Y

ROT AND F		PRODUCTION		PROCUREMENT	
DEVELOPMENT - NONRECURRING	TOTAL *	MATERIAL	LABOR	TOTAL PER PROD A/C**	PER PROD A/C**
ENGINEERING	942.18	4142.50	13208.30	17350.78	41779.12
TOOLING	536.94	1880.62	2750.84	4631.46	
TEST ARTICLES	72.51	0.0	0.0	0.0	
DATA	0.0	189.10	432.73	621.83	30.65
SYSTEMS ENGMT/NGMT	0.0	1249.92	9176.09	10425.00	
CRUISE ENGINE	0.0	612.11	31.58	643.69	10.42
LIFT ENGINE	0.0	211.76	817.07	1028.82	360.60
FAN	0.0	0.0	0.0	0.0	
AVIONICS	0.0	148.65	722.04	870.69	40.93
OTHER SYSTEMS	0.0	63.10	95.03	158.13	
FACILITIES	0.0				
TOTAL AIR VEHICLE	1451.64	118.05	123.24	201.30	0.0
INTEGR LOGISTICS SUPPORT	10.03	0.0	28.95	28.95	20.89
PLANNING	3.41	0.0	6.15	6.15	
TRAINING	19.14	0.0	0.0	0.0	751.07
HANDBOOKS	6.91	3.58	5.73	9.31	1214.64
SSE	17.53	53.32	10.05	63.36	
TOTAL ILS		0.0	0.0	0.0	
TOTAL DVLPMNT-NONREC	1569.18	61.16	72.37	133.53	5682.21
INITIAL SPARES COST		0.0	0.0	0.0	
PRODUCTION DEVELOPMENT					
ENGINEERING	317.55	2733.85	7565.96	10299.82	
TOOLING	-120.76	478.15	360.39	838.54	
ENGINES	0.0	125.23	22.78	148.01	
TOTAL PROD DEV	196.80	66.51	64.86	131.37	
AIR VEHICLE SPARES	694.39	132.91	360.26	493.17	0.0
TOTAL DVLPMNT-SECUR	873.61	410.11	1168.01	1578.12	
GOVNMNT DVLPMNT COST	0.0	29.45	329.67	359.11	
TOTAL DVLPMNT COST	2442.80	0.0	0.0	0.0	48872.75
SYSTEMS INTEGR		505.12	588.96	1094.08	
TOTAL COST		7699.52	21486.40	28985.92	
TOTAL REC **		769.20	769.20	769.20	
ENG CHANGE ORDERS				953.37	
SUSTAINING ENG COST				1786.19	
PROD TOOLING COST				1559.78	
QUALITY ASSURANCE				2894.43	
MISCELLANEOUS ***				1000.32	
TOTAL AIRFRAME COST				37179.96	
ENGINE COST				4107.86	
AVIONICS COST				267.19	
TOTAL MANUFACTURING COST				41555.01	
WARRANTY				224.13	
TOTAL PRODUCTION COST				41779.12	

* - MILLIONS OF DOLLARS
 ** - 1000 OF DOLLARS OR HOURS PER PROD A/C
 *** - INCLUDES PROD DATA, SYSTEMS ENGR AND OTHER SYSTEMS

DOMESTIC AIRCRAFT (E³ ENGINE)

OPERATIONAL COSTS				MISC. DATA			
DIRECT OPERATIONAL COST (DOC)		INDIRECT OPERATIONAL COST (IOC)					
C/SM***	PERCENT	C/SM***	PERCENT				
FLIGHT CREW	0.18986	16.35699	SYSTEM	0.02131	2.07120	RANGE (N. MI.)	2999.96
FUEL AND OIL	0.32060	21.26940	LOCAL	0.05896	5.72997	BLOCK SPEED (MPH)	418.21
INSURANCE	0.02007	1.72878	AIRCRAFT CONTROL	0.00159	0.15439	BLOCK TIME (HRS)	7.17
DEPRECIATION	0.44088	27.98386	CABIN ATTENDANT	0.21039	20.44603	FLIGHT TIME (HRS)	7.17
MAINTENANCE	0.26304	22.66199	FOOD AND BEVERAGE	0.13520	13.13899	AVG STAGE LENGTH (N. MI.)	1144.00
TOTAL DOC	1.23440	100.000	PASSFNGR HANDLING	0.12880	12.51637	AVG CARGO PER FLIGHT	17413.00
			CARGO HANDLING	0.05700	5.53917	UTILIZATION (HRS PER YR)	3636.00
			OTHER PASSENGER EXPENSE	0.32984	32.05363	FLIGHTS PER A/C PER YEAR	506.88
			OTHER CARGO EXPENSE	0.00583	0.56622	FARE (\$)	268.80
			GENERAL + ADMINISTRATION	0.08010	7.78404		
			TOTAL IOC	1.02902	100.000		

*** - CENTS PER SEAT N. MILE

RATE OF RETURN ON INVESTMENT										
YR	AVG NO AIRCRAFT DURING YEAR	AIRCRAFT ADDED DURING YEAR	AVERAGE INVESTMENT DURING YEAR	CUMULATIVE DEPRECIATION	AVERAGE BOOK VALUE OF FLEET	REVENUE	INTEREST EXPENSE	OPERATING EXPENSE	CASH FLOW	ROI PERCENT
			\$M	\$M	\$M	\$M	\$M	\$M	\$M	PERCENT
1	6.3	10.0	356.76	21.41	335.36	261.70	34.25	104.05	-76.73	28.61
2	16.3	10.0	927.58	77.06	850.52	680.42	83.57	270.54	13.32	29.01
3	20.0	0.0	1141.64	145.56	996.08	837.44	93.16	332.97	182.82	30.00
4	20.0	0.0	1141.64	214.06	927.58	837.44	82.20	332.97	188.30	31.62
5	20.0	0.0	1141.64	282.56	859.09	837.44	71.24	332.97	193.78	33.51
6	20.0	0.0	1141.64	351.05	790.59	837.44	60.28	332.97	199.26	35.72
7	20.0	0.0	1141.64	419.55	722.09	837.44	49.32	332.97	204.74	38.35
8	20.0	0.0	1141.64	488.05	653.59	837.44	38.36	332.97	210.22	41.53
9	20.0	0.0	1141.64	556.55	585.09	837.44	27.40	332.97	215.70	45.45
10	20.0	0.0	1141.64	625.05	516.59	837.44	16.44	332.97	221.18	50.42

AVG ROI OVER THE 10 YEAR PERIOD = 35.65 PERCENT

DOMESTIC AIRCRAFT (E³ ENGINE)

OPERATIONAL COSTS				MISC. DATA	
DIRCT OPERATIONAL COST (DOC)	INDIRECT OPERATIONAL COST (IOC)	C/SH*** PERCENT		RANGE (N. MI.)	
C/54*** PERCENT	SYSTEM	LOCAL	AIRCRAFT CONTROL	BLOCK SPEED (MPH)	
FLIGHT CREW	0.20727	16.32909	0.02688	1.96712	1399.95
FUFL AND OIL	0.29610	17.96275	0.12635	9.24694	363.08
INSURANCE	0.02191	1.72583	0.00340	0.24915	3.65
DEPRECIATION	0.48131	37.91907	0.22969	16.80977	3.65
MAINTENANCE	0.33082	26.06329	0.14760	10.80227	1144.00
TOTAL DOC	1.33790	100.000	0.27600	20.19872	17413.00
			0.12214	8.93902	3636.00
			0.32984	24.13913	994.95
			0.00583	0.42641	125.44
			0.09868	7.22150	
TOTAL IOC	1.36641	100.000			

RATE OF RETURN ON INVESTMENT										
YEAR	AVG NO AIRCRAFT DURING YEAR	AIRCRAFT ADDFC DURING YEAR	AVERAGE INVESTMENT DURING YEAR	CUMULATIVE DEPRECIATION	AVERAGE BOOK VALUE OF FLEET	REVENUE	INTEREST EXPENSE	OPERATING EXPENSE	CASH FLOW	ROI PERCENT
			\$M	\$M	\$M	\$M	\$M	\$M	\$M	PERCENT
1	6.3	10.0	356.76	21.43	335.36	239.72	34.25	114.73	-93.05	23.74
2	16.3	10.0	927.58	77.06	850.52	623.26	83.57	298.29	-29.14	24.02
3	20.0	0.0	1141.64	145.56	996.08	767.09	93.16	367.12	130.57	24.75
4	20.0	0.0	1141.64	214.06	927.58	767.09	82.20	367.12	136.05	25.99
5	20.0	0.0	1141.64	282.56	859.09	767.09	71.24	367.12	141.53	27.42
6	20.0	0.0	1141.64	351.05	790.59	767.09	60.28	367.12	147.01	29.11
7	20.0	0.0	1141.64	419.55	722.09	767.09	49.32	367.12	152.49	31.11
8	20.0	0.0	1141.64	488.05	653.59	767.09	38.36	367.12	157.97	33.53
9	20.0	0.0	1141.64	556.55	585.09	767.09	27.40	367.12	163.45	36.52
10	20.0	0.0	1141.64	625.05	516.59	767.09	16.44	367.12	168.93	40.30

AVG ROI OVER THE 10 YEAR PERIOD = 29.06 PERCENT

DOMESTIC AIRCRAFT (E³ ENGINE)

Basic AIRCRAFT / 500 PASS / 6500 N MI / M = .80 MISS

T/C AK W/S T/M
13.60 10.00 134.0 0.241

C O N F I G U R A T I O N G E O M E T R Y

BASIC WING---	AREA(SQ FT)	SPAN(FT)	TAPER RATIO	C/4 SWEEP	L.E. SWEEP	MAC(FT)
	4050.2	215.04	0.300	30.000	32.260	23.65
WING PANELS---	AREA(SQ FT)	EXP. AREA	AVG T/C	L.E. SWEEP	SFLE(SQ FT)	REF L(FT)
	2489.3	2169.6	13.00	32.260	0.0	32.06
	2133.7	2133.7	13.00	32.260	0.0	17.73
TOTAL WING---	AREA(SQ FT)	EFF AK	AVG T/C	CR(FT)	CI(FT)	MAC(FT)
	5113.9	9.69	13.00	43.61	9.95	27.57
FUSELAGE---	LENGTH(FT)	S WET(SQ FT)	BMW(FT)	EQUIV D(FT)	SPI(SQ FT)	L(FT)
	224.44	1140.00	19.58	19.58	300.95	78.01
	HW(FT)	BH(FT)	SBW(SQ FT)			
	19.58	19.58	11940.60			
HORIZ. TAIL 1---	SH1(SQ FT)	SMX1(SQ FT)	REF L1(FT)	L HT1(FT)	HT1 VOL COEF	
	444.26	717.11	13.54	106.52	0.9195	
HORIZ. TAIL 2---	SH2(SQ FT)	SMX2(SQ FT)	REF L2(FT)	L HT2(FT)	HT2 VOL COEF	
	0.0	0.0	0.0	229.49	0.0	
VERT. TAIL 1---	SV1(SQ FT)	SMX1(SQ FT)	REF L1(FT)	L VT1(FT)	VT1 VOL COEF	
	225.16	225.15	21.68	105.96	0.0661	
VERT. TAIL 2---	SV2(SQ FT)	SMX2(SQ FT)	REF L2(FT)	L VT2(FT)	VT2 VOL COEF	
	0.0	0.0	0.0	229.49	0.0	
PROPULSION---	WING LIFT	ENG D(FT)	POD L(FT)	POD D(FT)	POD S WET	NO. PODS
	10.99	7.11	19.00	7.53	1799.18	4.
FUEL TANKS---	WING(CU FT)	BOX(CU FT)	FUS(CU FT)			INLET L(FT)
	5974.55	1593.57	9999.00			0.0
WETTED VOLUME---	BODY	WINGS	TAILS	PODS	PYLONS	PONTOONS
	51025.04	6460.34	1178.14	3388.57	0.0	0.0
						TOTAL
						63372.09

INTERCONTINENTAL AIRCRAFT (E³ ENGINE)

H I S T O R Y S U M M A R Y

FORM AIRCRAFT		/ 500 MASS / 6500 MI / H - 60 - MISS												
SEGMENT	TRAT ALTITUDE (FT)	INIT MACH	INIT WGT (LB)	TOTL FUEL (LB)	SEGMENT FUEL (LB)	TOTL FUEL (LB)	SEGMENT TIME (MIN)	TOTL TIME (MIN)	EXTERN STORE TAB ID	ENGINE THRUST TAB ID	EXTERN F TANK TAB ID	AVG L/D RATIO	AVG SFC (FF/TT)	MAX OVER PRES
TAKEOFF														
POWER 1	0	0.0	620000	0	0	0	0.0	0.0	0	429101	0	0.0	0.297	0.0
POWER 2	0	0.0	620000	0	0	0	1.3	1.3	0	429101	0	0.0	0.297	0.0
CLIMB	0	0.379	620000	11430	11430	11430	25.0	26.4	0	429201	0	20.10	0.501	0.0
ACCEL	30000	0.642	613000	1330	14190	14190	3.5	29.9	0	429201	0	20.42	0.557	0.0
CLIMB	30000	0.800	616000	2270	16470	16470	6.4	36.4	0	429201	0	20.52	0.571	0.0
CRUISE	34000	0.800	613000	16700	26550	26550	67.5	83.9	0	-429101	0	20.39	0.568	0.0
DESCENT	43000	0.800	625000	20360	20360	20360	3.2	87.1	0	203301	0	18.80	-0.393	0.0
DECEL	30000	0.805	623000	27036	27036	27036	0.9	88.0	0	203301	0	18.38	-0.405	0.0
DESCENT	30000	0.642	623000	41040	20410	20410	17.4	105.4	0	203301	0	19.80	-1.120	0.0
CRUISE	43000	0.600	623000	5280	20700	12500	16.3	121.7	0	-429101	0	20.11	0.578	0.0
LOITER	1500	0.400	611000	730	20630	20630	3.0	124.7	0	-429101	0	19.41	0.677	0.0
RESET	0	0.0	610000	0	20630	20630	0.0	124.7	0	0	0	0.0	0.0	0.0
RESET	0	0.0	610000	0	20630	20630	0.0	124.7	0	0	0	0.0	0.0	0.0
CRUISE	41000	0.870	618000	17130	22570	22570	16.5	141.2	0	-429101	0	20.03	0.580	0.0
TAKEOFF														
POWER 1	0	0.0	601000	0	22570	22570	0.0	141.2	0	429101	0	0.0	0.297	0.0
POWER 2	0	0.0	601000	0	22600	22600	1.3	142.5	0	429101	0	0.0	0.297	0.0
CLIMB	0	0.578	591000	1600	22330	22330	2.7	145.2	0	429201	0	19.35	0.469	0.0
ACCEL	10000	0.470	590000	0	22330	22330	0.0	145.2	0	429201	0	19.40	0.477	0.0
CLIMB	10000	0.450	590000	3710	23000	23000	8.3	153.5	0	429201	0	19.29	0.508	0.0
CRUISE	30000	0.730	594000	991	22970	22970	4.1	157.6	0	-429101	0	18.15	0.602	0.0
DESCENT	30000	0.672	593000	400	23370	23370	11.1	168.7	0	203301	0	19.26	-0.728	0.0
DECEL	10000	0.450	593000	0	23340	23340	0.0	168.7	0	203301	0	19.30	-1.183	0.0
DESCENT	10000	0.450	593000	340	23680	23680	5.9	174.6	0	203301	0	19.30	-1.763	0.0
CRUISE	30000	0.730	594000	610	23470	23470	2.8	177.4	0	-429101	0	18.11	0.602	0.0
CRUISE	1500	0.370	592000	0	24100	24100	30.0	207.4	0	-429101	0	19.56	0.667	0.0

INTERCONTINENTAL AIRCRAFT (E³ ENGINE)

ALTERNATE MISSION NO. 1 SUMMARY

1443 AIRCRAFT / 552 LB / 3000 Y MI / M = 86 MISS

SEGMENT	INIT ALTITUDE (FT)	INIT MACH NO	INIT WLGHT (LB)	TOTAL FUEL (LB)	SLIGHT FUEL (LB)	TOTAL FUEL (LB)	SLIGHT FUEL (LB)	SEGMT TIME (MIN)	TOTAL TIME (MIN)	EXTRN STORE TAB ID	ENGINE THRUST TAB ID	EXTRN F TANK TAB ID	AVG L/D RATIO	AVG SFC (FF/7)	MAX OVER PRES
TAKEOFF POWER 1	0.	0.0	444194.	0.	0.	0.	0.	0.0	0.0	0.	429501.	0.	0.0	0.297	0.0
POWER 2	0.	0.0	444194.	959.	959.	0.	0.	1.3	1.3	0.	429501.	0.	0.0	0.297	0.0
CLIMB	0.	0.378	442234.	6216.	7167.	70.	70.	12.7	14.1	0.	429201.	0.	20.03	0.498	0.0
ACCEL	3000.	0.642	437032.	557.	7726.	11.	81.	1.5	15.6	0.	429201.	0.	18.56	0.537	0.0
CLIMB	3000.	0.800	430475.	2744.	10488.	64.	150.	8.9	24.5	0.	429201.	0.	19.19	0.569	0.0
CRUISE	4000.	0.800	433710.	66136.	76624.	2600.	2750.	340.0	364.5	0.	-029101.	0.	19.96	0.583	0.0
DESCENT	4000.	0.800	367574.	97.	76722.	26.	2778.	3.7	368.1	0.	203301.	0.	17.92	-0.404	0.0
DECEL	3000.	0.800	367476.	24.	76744.	6.	2784.	0.8	368.4	0.	203301.	0.	17.08	-0.404	0.0
DESCENT	3000.	0.692	367452.	240.	77620.	88.	2872.	16.7	385.6	0.	203301.	0.	18.70	-1.121	0.0
CRUISE	4000.	0.800	366573.	306.	8068.	128.	3060.	16.7	402.4	0.	-429101.	0.	19.46	0.583	0.0
LITTER	1500.	0.400	362312.	700.	81366.	0.	3000.	3.0	405.4	0.	-429101.	0.	18.22	0.703	0.0
RESET	0.	0.0	362812.	0.	81386.	-3000.	0.	0.0	405.4	0.	0.	0.	0.0	0.0	0.0
RESET	0.	0.0	362812.	0.	81386.	0.	0.	0.0	405.4	0.	0.	0.	0.0	0.0	0.0
CRUISE	4000.	0.800	362812.	1543.	88724.	0.	0.	40.5	445.9	0.	-429101.	0.	19.35	0.536	0.0
TAKEOFF POWER 1	0.	0.0	355404.	0.	86724.	0.	0.	0.0	445.9	0.	429501.	0.	0.0	0.297	0.0
POWER 2	0.	0.0	355404.	959.	89684.	0.	0.	1.3	447.3	0.	429501.	0.	0.0	0.297	0.0
CLIMB	0.	0.370	354511.	1463.	91141.	10.	10.	2.4	449.6	0.	429201.	0.	18.31	0.468	0.0
ACCEL	1000.	0.456	353046.	0.	91151.	0.	10.	0.0	449.6	0.	429201.	0.	18.39	0.477	0.0
CLIMB	1000.	0.456	353047.	3140.	94296.	41.	52.	7.0	456.7	0.	429201.	0.	18.27	0.507	0.0
CRUISE	3000.	0.700	349900.	1104.	95445.	36.	90.	5.5	462.2	0.	-429101.	0.	17.74	0.612	0.0
DESCENT	3000.	0.652	341744.	403.	95884.	29.	144.	10.4	472.6	0.	203301.	0.	18.23	-0.728	0.0
DECEL	1000.	0.456	340334.	0.	95894.	0.	144.	0.0	472.6	0.	203301.	0.	18.27	-1.183	0.0
DESCENT	1000.	0.456	340334.	314.	96233.	25.	174.	5.5	471.1	0.	203301.	0.	18.28	-1.763	0.0
CRUISE	1000.	0.700	347444.	744.	94444.	26.	200.	3.7	481.3	0.	-429101.	0.	17.70	0.612	0.0
CRUISE	1500.	0.570	344444.	637.	10337.	0.	200.	30.0	511.8	0.	-429101.	0.	18.58	0.690	0.0

INTERCONTINENTAL AIRCRAFT (E³ ENGINE)

C O S T S U M M A R Y

DEVELOPMENT - WORKLOADING	TOTAL \$	STRUCTURE	MATERIAL	LABOR	TOTAL PER PHOD A/C**	PROCUREMENT PER PHOD \$/C**
ENGINEERING	1106.32	WING	2792.13	13946.31	18736.43	TOTAL PRODUCTION 48117.74
TOOLING	582.84	NOSE	2309.14	3361.71	5670.85	INTEGR LOGISTICS SUPPORT 33.48
TEST ARTICLES	77.69	TAIL	0.0	0.0	0.0	PLANNING
DATA	0.0	RODY	146.36	447.23	643.59	TRAINING 11.38
SYSTEMS ENH/ANAL	0.0	ALIGNING GEAR	1215.91	891.26	10107.18	TRAINERS 360.48
CRUISE ENGINE	0.0	FRG S/LT + MACELLE	492.70	40.78	833.40	'HANDBOOKS 50.16
LIFT ENGINE	0.0	LRG SECTION	275.98	1705.40	1481.36	FACILITIES 0.0
FAN	0.0	MACELLE	0.0	0.0	0.0	SSE - CFE 23.06
AVIONICS	0.0	AIR INDUCTION	237.39	1147.60	1364.99	SSE - GFE 751.07
OTHER SYSTEMS	0.0	PROPULSION	38.57	57.81	46.37	TOTAL ILS 1229.03
FACILITIES	0.0	ENGINE INSTALL	145.94	146.17	292.11	INITIAL SPARES COST 6385.56
TOTAL AIR VEHICLE	1764.24	THROST REVERSER	0.0	35.00	35.00	PRODUCTION DEVELOPMENT ENGINEERING 350.19
INTEGR LOGISTICS SUPPORT	33.48	EXHAUST SYSTEM	0.0	7.73	7.73	TOOLING -159.85
PLANNING	0.0	ENGINE CONTROLS	0.0	0.0	0.0	ENGINES 0.0
TRAINING	11.38	STARTING SYSTEM	4.42	7.04	11.45	TOTAL PHOD DEV 190.34
HANDING WS	27.03	PROPELLER INSTALL	70.98	13.31	84.29	TOTAL PROCUREMENT 53923.45
SSE	5.50	COMMUNICATING SYSTEM	0.0	0.0	0.0	* - MILLIONS OF DOLLARS
TOTAL ILS	47.18	FUEL SYSTEM	0.0	0.0	0.0	** -1000 OF DOLLARS OR HOURS PER PHOD A/C
TOTAL DVLPMNT-MINIK	1812.02	DRIVE SYSTEM (H)	70.54	83.08	153.62	*** - INCLUDES PHOD DATA, SYSTEMS ENGR AND OTHER SYSTEMS
DEVELOPMENT - RECUR(PROTOTYPES)	0.0	SYSTEMS	0.0	0.0	0.0	
AIR VEHICLE	150.28	FLIGHT CONTROLS	496.69	7962.44	11809.13	
SPARES	192.23	AUX POWER PLAN	429.64	394.31	919.96	
TOTAL DVLPMNT-RECUR	342.51	INSTRUMENTS	125.09	22.64	147.68	
GOVMT DVLPMNT COST	0.0	HYDRAULIC + PNEUM	11.42	79.02	160.45	
TOTAL DVLPMNT COST	2750.63	ELECTRICAL	178.35	481.13	659.48	
		AVIONIC INSTALL	47.71	1325.75	1793.46	
		ARMAMENT	30.75	431.83	470.59	
		FURN AND FOOTIP	1.02	4685.34	5730.91	
		AIR CONDITIONING	41.89	532.72	434.61	
		ANTI-ICING	22.37	24.65	52.01	
		PHOTOGRAPHIC	0.0	0.0	0.0	
		LOAD AND HANDLING	0.0	0.0	0.0	
		SYSTEMS INTECH	561.26	651.32	1212.58	
		TOTAL COST	8464.00	22706.19	31110.19	
		TOTAL HRS **		812.87	812.87	
		ENG CHANGE ORDERS			1021.86	
		SUSTAINING ENG COST			2005.61	
		PHOD TOOLING COST			1648.32	
		QUALITY ASSURANCE			3058.75	
		MISCELLANEOUS ***			1057.11	
		TOTAL AIRFRAME COST			39899.82	
		ENGINE COST			5224.60	
		AVIONICS COST			751.60	
		TOTAL MANUFACTURING COST			45875.41	
		WARRANTY			242.30	
		TOTAL PRODUCTION COST			46117.74	

INTERCONTINENTAL AIRCRAFT (E3 ENGINE)

OPERATIONAL COSTS				MISC. DATA			
DIRECT OPERATIONAL COST (DMC)	INDIRECT OPERATIONAL COST (IOC)	C/SM***	PERCENT	RANGE (N. MI.)	BLOCK SPEED (MPH)	BLOCK TIME (HRS)	FLIGHT TIME (HRS)
FLIGHT CREW	6,21679	10,61200	SYSTEM	J.02323	1.89938		
FUEL AND OIL	0.43100	28.70396	LOCAL	0.09343	1.64021		
INSURANCE	0.01859	1.44175	AIRCRAFT CONTROL	0.00208	0.17039		
DEPRECIATION	0.40416	31.72466	CABIN ATTENDANT	0.25277	20.67020		
MAINTENANCE	0.27431	21.27208	FLOOD AND REFRIGER	0.07891	6.45245		
TOTAL DMC	1.34990	100.000	PASSENGER HANDLING	0.13403	10.96017		
			CARGO HANDLING	0.04262	3.48555		
			OTHER PASSENGER EXPENSE	0.48400	39.57838		
			OTHER CARGO EXPENSE	0.00595	0.48663		
			GENERAL + ADMINISTRATION	0.10586	8.65665		
			TOTAL IOC	1.22289	100.000		

*** - CENTS PER SEAT N. MILE

RATE OF RETURN ON INVESTMENT										
YEAR	AV. NO. AIRCRAFT DURING YEAR	AIRCRAFT ADDED DURING YEAR	AVERAGE INVESTMENT DURING YEAR	CUMULATIVE DEPRECIATION	AVERAGE HOUR VALUE OF FLEET	REVENUE	INTEREST EXPENSE	OPERATING EXPENSE	CASH FLOW	ROI PERCENT
1	6.3	10.0	394.45	23.67	370.78	253.58	37.87	142.49	-116.44	20.09
2	16.3	10.0	1,250.57	85.25	440.37	659.32	92.40	370.48	-67.45	20.27
3	20.0	0.0	1,262.24	160.94	1161.31	811.47	103.00	455.98	101.00	20.82
4	20.0	0.0	1,262.24	236.67	1025.57	811.47	90.88	455.98	107.06	21.76
5	20.0	0.0	1,262.24	312.41	949.84	811.47	78.76	455.98	113.12	22.86
6	20.0	0.0	1,262.24	388.14	874.10	811.47	66.65	455.98	119.18	24.15
7	20.0	0.0	1,262.24	463.87	798.37	811.47	54.53	455.98	125.23	25.68
8	20.0	0.0	1,262.24	539.61	722.64	811.47	42.41	455.98	131.29	27.53
9	20.0	0.0	1,262.24	615.34	646.90	811.47	30.29	455.98	137.35	29.82
10	20.0	0.0	1,262.24	691.08	571.17	811.47	18.18	455.98	143.41	32.71

AVG ROI OVER THE 10 YEAR PERIOD = 24.11 PERCENT

INTERCONTINENTAL AIRCRAFT (E³ ENGINE)

OPERATIONAL COSTS

DIRECT OPERATIONAL COST (DOC)	INDIRECT OPERATIONAL COST (IOC)	MISC. DATA
C/\$M ⁰⁰⁰	PERCENT	

FLIGHT CREW	0.22657	17.44775	SYSTEM	0.02644	1.67800	RANGE (N. MI.)	3000.00
FUEL AND OIL	0.36439	24.12785	LICEL	0.20243	12.84574	BLOCK SPEED (MPH)	420.18
INSURANCE	0.01943	1.44627	AIRCRAFT CONTROL	0.00451	0.28648	BLOCK TIME (HRS)	7.14
DEPRECIATION	0.42761	32.92553	CABIN ATTENDANT	0.26417	16.76337	FLIGHT TIME (HRS)	7.14
MAINTENANCE	0.31162	23.99727	FOOD AND BEVERAGE	0.08246	5.23288	AVG STAGE LENGTH (N. MI.)	2547.00
TOTAL DOC	1.34960	100.000	PASSENGER HANDLING	0.29040	18.42770	AVG CARGO PER FLIGHT	18386.00
			CARGO HANDLING	0.09235	5.86037	UTILIZATION (HRS PER YR)	4133.00
			OTHER PASSENGER EXPENSE	0.48400	30.71284	FLIGHTS PER A/C PER YEAR	578.87
			OTHER CARGO EXPENSE	0.00595	0.37762	FARE (S)	232.80
			GENERAL + ADMINISTRATION	0.12315	7.81496		
			TOTAL IOC	1.57589	100.000		

*** - CENTS PER SEAT N. MILE

RATE OF RETURN ON INVESTMENT

YEAR	AVG. NO. AIRCRAFT DURING YEAR	AIRCRAFT ADDED DURING YEAR	AVERAGE INVESTMENT DURING YEAR	CUMULATIVE DEPRECIATION	AVERAGE VALUE OF FLEET	REVENUE	INTEREST EXPENSE	OPERATING EXPENSE	CASH FLOW	ROI PERCENT
			\$M	\$M	\$M	\$M	\$M	\$M	\$M	PERCENT
1	6.3	10.0	394.75	23.47	370.78	242.64	37.87	155.99	-128.66	16.79
2	16.3	16.0	1025.57	85.20	940.37	630.87	92.40	405.58	-99.22	16.89
3	20.0	0.0	1262.24	160.94	1101.31	776.46	103.00	499.18	61.89	17.26
4	20.0	0.0	1262.24	236.67	1225.57	776.46	90.88	499.18	67.95	17.95
5	20.0	0.0	1262.24	312.41	449.84	776.46	78.76	499.18	74.01	18.74
6	20.0	0.0	1262.24	388.14	874.10	776.46	66.65	499.18	80.07	19.67
7	20.0	0.0	1262.24	463.87	798.37	776.46	54.53	499.18	86.13	20.78
8	20.0	0.0	1262.24	539.61	722.64	776.46	42.41	499.18	92.19	22.12
9	20.0	0.0	1262.24	615.34	646.90	776.46	30.29	499.18	98.25	23.77
10	20.0	0.0	1262.24	691.08	571.17	776.46	18.18	499.18	104.31	25.86

AVG. ROI OVER THE 10 YEAR PERIOD = 19.65 PERCENT

INTERCONTINENTAL AIRCRAFT (E³ ENGINE)

SUPPLEMENT B

DIRECT OPERATING COST (DOC) CALCULATIONS - E³ AIRCRAFT

The following factors and formulas were used in calculating Direct Operating Cost (DOC) for the E³ aircraft. All costs are in January 1976 dollars:

	<u>3-Engine Domestic</u>	<u>4-Engine Intercont.</u>
Crew Cost	\$397/blk-hr	\$476/blk-hr
Fuel Cost		
Cost of Fuel	\$0.308/gal	\$0.387/gal
Cost of Oil	\$1.00/lb	\$1.00/lb
Non Revenue Flying Factor	1.0123	1.0123
Salvage Value (SV)	4%	4%
Life	16 YRS	16 YRS
Insurance Rate (IR)	0.304%	0.304%
Labor Rate (LR)	\$9.00/hr	\$9.00/hr
Maint. Burden Factor (MBF)	2.23	2.23
Airframe Labor/Cycle (AFLC)	0.52	0.52
Airframe Labor/Flt-Hr (AFLH)	0.52	0.52
Airframe Matl/Cycle (AFMC)	0.68	0.68
Airframe Matl/Flt-Hr (AFMH)	0.68	0.68
Engine Labor/Cycle (ELC)	0.62	0.62
Engine Labor/Flt-Hr (ELH)	0.62	0.62
Engine Matl/Cycle (ELC)	1.31	1.31
Engine Matl/Flt-Hr (EMH)	1.31	1.31

FORMULAS - DOC CALCULATIONS

Fuel Cost (FC)	=	(Cost Fuel x Blk Fuel/Blk Time) + (No. Engines x 0.135 Cost of Oil) x (Non Revenue Flying Factor)
Unit Air Vehicle Cost (UAVC)	=	Airframe + Engine + Avonics + RDT&E/No. of Aircraft
Depreciation Cost (DC)	=	(UAVC + Spares - SV)/Life
Insurance Cost (IC)	=	(UAVC x IR)
Airframe Weight (AFW)	=	(MEW - Engine and Thrust Reverser)/10 ³
Airframe Cost (AFC)	=	(UAVC - Engine and Thrust Reverser)/10 ⁶
Thrust (T)	=	Total Max. SLS, Uninstalled - Std Day (Sum of All Engines)/10 ³
Engine Price (EP)	=	Total constant Price Including Thrust Reverser (Sum of all Engines)/10 ⁵
No. Of Engines (NENG)		
Flight Time (FT)	=	[(0.05 x AFW) + 6 - 630/(120 + AFW)] x LR x AFLC
AF Labor/Cycle	=	[(0.05 x AFW) + 6 - 630/(120 + AFW)] x 0.59 x FT x LP x AFLH
AF Labor/Flt-Hr	=	6.24 x AFC x AFMC
AF Matl/Cycle	=	3.08 x AFC x FT x AFMH
AF Matl/Flt-Hr	=	(0.3 x NENG + 0.03 x T) x LR x ELC
Eng. Labor/Cycle	=	(0.6 x NENG + 0.27 x T) x LR x FT x ELH
Eng. Labor/Flt-Hr	=	2 x NENG x EP x EMC
Eng. Matl.Cycle	=	2.5 x NENG x EP x FT x EML
Eng. Matl/Flt-Hr	=	(Total AF Labor + Total Eng Labor) x MBF
Maintenance Burden	=	Sum of all Airframe and Engine Maintenance + Burden
Total Maintenance	=	

APPENDIX C

Appendix C is a reproduction of report ACEE-15-FR-9735 A supplied by Douglas Aircraft Company as their contribution to aircraft integration. The format and printing have been altered to coordinate with this publication. A preliminary report was the instrument used by General Electric Company for aircraft integration analysis. The preliminary report extended through Section 4.3, the final complete report is presented here.

PRECEDING PAGE BLANK NOT REPRODUCED

SEPTEMBER 1979

**FINAL REPORT ON STUDY TRANSPORTS
POWERED BY G.E. ENERGY EFFICIENT ENGINES**

GENERAL ELECTRIC PURCHASE ORDER 200-4XX-14N44386

PRECEDING PAGE BLANK NOT FILMED

**DOUGLAS AIRCRAFT COMPANY
MCDONNELL DOUGLAS CORPORATION**

FINAL REPORT ON
STUDY TRANSPORTS POWERED
BY G.E. ENERGY EFFICIENT ENGINES

This final report summarizes work done under General Electric Purchase Order 200-4XX-14N44386 as part of General Electric's prime contract Energy Efficient Engine (E³) Component Development and Integration Program with the NASA Lewis Research Center.

This report completes submittal of final report inputs for Task 1, 2 and 3 in compliance with the Task 4 Reporting requirements.

PREFACE

This report presents results of a study conducted by the Douglas Aircraft Company as a subcontractor to General Electric to investigate applications of engines based on use of NASA supported Energy Efficient Engine (E³) Technology. This work was done under Purchase Order 200-4XX-14N44386 as a part of the General Electric prime contract from the NASA Lewis Research Center on Energy Efficient Engine Component Development and Integration program.

The studies reported herein were conducted to identify commercial transport aircraft which could possibly use engines based on technology from the NASA sponsored E³ program, provide descriptions and characteristics of such aircraft and investigate airframe/propulsion integration.

The study results presented herein were conducted from May 1978 through August 1979.

APPENDIX C
TABLE OF CONTENTS

<u>Section</u>		<u>Page</u>
1.0	INTRODUCTION	235
2.0	ADVANCED TECHNOLOGY FEATURES	238
2.1	Aerodynamics	238
2.1.1	Advanced Wing Design	238
2.1.2	Advanced High-Lift System	240
2.2	Materials	240
2.2.1	Advanced Composites	242
2.2.2	Metals	242
2.3	Systems	242
2.3.1	Longitudinal Stability Augmentation System (α LSAS)	242
2.3.2	Wing Load Alleviation	243
2.3.3	Other	243
3.0	AIRCRAFT DESCRIPTIONS	244
3.1	Aircraft Characteristics	244
3.2	Direct Operating Costs	244
3.3	Drag	249
3.4	Weight	249
3.5	Sensitivity Factors	249
3.6	Noise	249
3.7	Secondary Power	249
4.0	AIRFRAME/PROPULSION SYSTEM INTEGRATION	266
4.1	Nacelle Placement	266
4.2	Preliminary 1990 Propulsion System Requirements	266
4.2.1	Maintenance	266
4.2.2	Thrust Reversers	266
4.2.3	Ozone	269
4.2.4	Bleed Air Cleanliness	269
4.2.5	Bleed Port Locations	269
4.2.6	Containment	270
4.3	Installation Studies	270
4.3.1	Final Study Configurations	281
4.3.1.1	Core Mounted Accessory Configuration	282
4.3.1.2	Fan Case Mounted Accessory Configuration	283
4.3.2	Maintenance Cost Comparison	283

APPENDIX C
TABLE OF CONTENTS (Concluded)

<u>Section</u>	<u>Page</u>
4.4 Regenerative Fuel Heat System Study	292
4.4.1 Design Philosophy	292
4.4.2 Aircraft Configuration Studied	295
4.4.3 Fuel Temperature Characteristics	295
4.4.3.1 Descent and Start of Cruise	295
4.4.3.2 Regenerative System Operation at Cruise	295
4.4.3.3 Engine Throttling Effects	295
4.4.4 Cruise SFC Savings Calculations	300
4.4.5 Regenerative Fuel Heat Study Conclusions	301

APPENDIX C
LIST OF ILLUSTRATIONS

<u>Figure</u>		<u>Page</u>
C-1.	Energy Efficient Transport.	236
C-2.	Aircraft Design Concept.	237
C-3.	Advanced Features - Aerodynamics.	239
C-4.	Advanced Features - Materials.	241
C-5.	Domestic Aircraft.	247
C-6.	Compressibility Drag Rise Characteristics.	254
C-7.	High-Lift Polars Gear-Up.	255
C-8.	Aircraft Compressor Bleed Air Required.	264
C-9.	Nacelle/Wing Relationship.	267
C-10.	DAC Layouts for GE E ³ Study.	271
C-11.	Study Layout for GE E ³ Engine Wing Installation.	273
C-12.	Study Layout for GE E ³ Engine Wing Installation Aft of Wing.	274
C-13.	Study Layout for GE E ³ Engine Installation, Fan Case-Mounted Accessories.	275
C-14.	Study Layout for GE E ³ Engine Installation, Core-Mounted Accessories, 0% Chord Exhaust Position.	276
C-15.	Study Layout for GE E ³ Engine Installation, Fan Case-Mounted Accessories, 0% Chord Exhaust Position.	277
C-16.	Study Layout for GE E ³ Engine Installation, Core-Mounted Accessories, 15% Chord Exhaust Position.	278
C-17.	Study Layout for GE E ³ Engine Installation, Core-Mounted Accessories, 105-Inch-Diameter Nacelle.	279
C-18.	Study Layout for GE E ³ Engine Installation, Fan Case-Mounted Accessories, 102-Inch-Diameter Nacelle.	280
C-19.	Overall Fuel Heating System Schematic.	293
C-20.	Preliminary Fuel Heating System Schematic.	294
C-21.	Fuel/Engine Oil Temperature Profile.	296
C-22.	Effect of Throttling Back on Fuel Flow.	298
C-23.	Effect of Throttling Back on Fuel Temperature.	299

APPENDIX C
LIST OF TABLES

<u>Table</u>		<u>Page</u>
C-I.	Aircraft Design Requirements.	245
C-II.	Aircraft Characteristics.	246
C-III.	Direct Operating Costs Transcontinental Range Domestic Trijets.	250
C-IV.	DAC DOC Method for GE E ³ Study.	251
C-V.	Aircraft Drag.	253
C-VI.	Aircraft Weight Breakdowns.	256
C-VII.	Sensitivity Factors.	257
C-VIII.	Airframe Generated Noise.	258
C-IX.	Nonpropulsive Noise Study.	259
C-X.	Accessory Gearbox Power Requirements.	263
C-XI.	Installation Elapsed Time Goals.	268
C-XII.	Replacement Labor Study for Core-Mounted Engine Accessories.	284
C-XIII.	Replacement Labor Study for Fan Core-Mounted Engine Accessories.	287
C-XIV.	Unscheduled Removals for Fan Case-Mounted Accessories Versus Core Mounted Accessories.	291
C-XV.	Performance Summary for Regenerative Fuel Heating System on DAC Candidate E ³ Engine Transport.	297

1.0 INTRODUCTION

This study is based on an airplane which is an advanced technology derivative of the DC-10 as illustrated in Figure C-1. This selection was arrived at from a solicitation of the views of Douglas marketing and engineering personnel on a logical and likely new airframe.

Taking into consideration traffic growth forecasts, airline fleet compositions and technology development activities, the logical transports to utilize engines based on NASA E³ technology in the early 1990 time period appeared to be aircraft with increased seating capacity relative to the DC-10 and design emphasis on reduced fuel consumption. The need to minimize new development costs resulted in the selection of stretched DC-10's employing advanced technologies. A domestic version incorporating a 65-foot fuselage stretch with a wing area compatible with an international version was configured. This aircraft growth would follow an initial stretch in the early 1980's as indicated in Figure C-2.

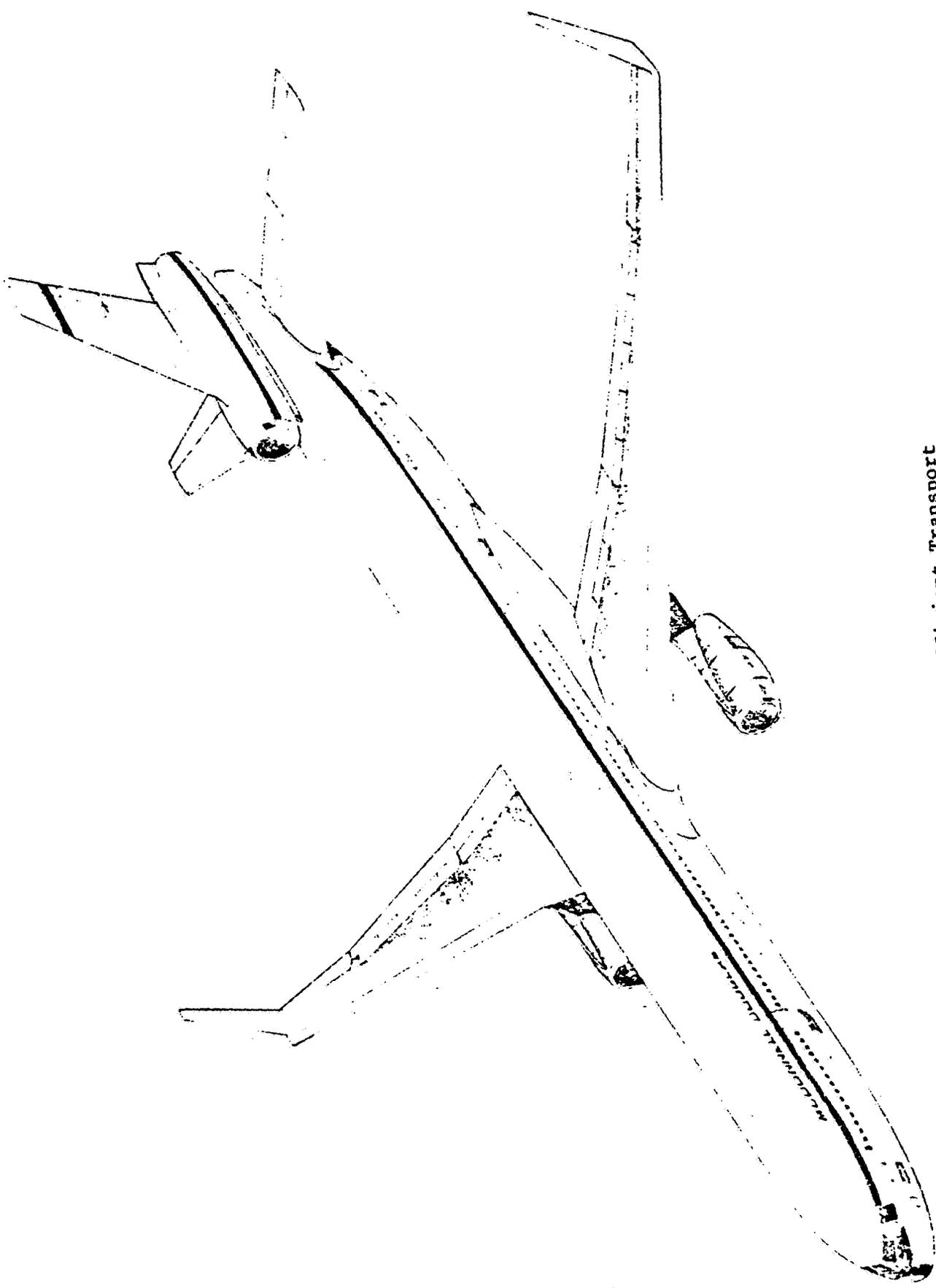


Figure C-1 Energy-Efficient Transport

ORIGINAL PAGE IS
OF POOR QUALITY



- COMBINE COST-EFFECTIVE ADVANCED TECHNOLOGY AND DC-10 COMMONALITY TO PRODUCE AIRCRAFT WITH BEST OPERATING ECONOMICS
- SELECT COMMON WING SIZE TO PROVIDE BOTH DOMESTIC TRANSCONTINENTAL RANGE AND INTERCONTINENTAL RANGE VERSIONS TO CAPTURE LARGE MARKET BASE

Figure C-2 Aircraft Design Concept

2.0 ADVANCED TECHNOLOGY FEATURES

The selection of advanced technology features was based on results from recent studies and on-going technology development programs including the NASA Aircraft Energy Efficiency program activities on Composites and the Energy Efficient Transport.

2.1 AERODYNAMICS

Advancements in aerodynamics provide a major improvement in aircraft efficiency. Figure C-3 lists the major elements.

2.1.1 Advanced Wing Design

One of the prominent features of the advanced airplane is the new high aspect ratio wing using supercritical airfoil sections and winglets. Fundamentally, the supercritical airfoil generates greater amounts of lift for a given thickness and drag than a conventional airfoil. The distinguishing geometric characteristics are a slightly blunter nose, a flatter upper surface and a highly cambered thin trailing edge relative to a conventional airfoil.

The benefits provided by the supercritical airfoil for wing design can be utilized in several ways. From purely aerodynamic considerations, the cruise speed and lifting capability (buffet boundary) could be increased for the same wing sweep and thickness. Because of the emphasis on fuel efficiency, the application of supercritical airfoil technology to the E³ aircraft has been to increase wing thickness while still achieving some benefits in buffet boundary. The increased wing thickness provides a structural weight advantage as well as an increase in takeoff and landing C_{Lmax} . The increased C_{Lmax} , improved buffet boundary and weight reduction due to the thickness increase, result in a reduction in wing area (and thus further weight reduction). Part of this weight reduction has been utilized to increase the wing aspect ratio to reduce induced drag. Winglets in conjunction with the moderately high wing aspect ratio will provide a large induced drag reduction without the excessive wing span and the consequent large airport gate space requirements that result from the use of very high aspect ratios.

The wing design incorporates airfoil shape and thickness variations cross the span to counteract wing-fuselage interference and other three-dimensional planform effects and to maintain as much of the two-dimensional drag-divergence Mach number capability of the advanced airfoils as possible. The wing twist and taper ratio are selected to produce minimum induced drag, considering the tradeoffs in wing weight and stalling characteristics.

NASA has done exploratory development of these advanced airfoils including flight testing on an F-8 research airplane. Douglas has designed, developed and flight tested supercritical airfoils on two different wings on the YC-15 AMST prototype aircraft. Results from recent Douglas/EET wind tunnel programs have substantiated that these advanced airfoils will provide the desired characteristics for a high aspect ratio wing application.

WING

- SUPERCRITICAL AIRFOILS - REDUCED WEIGHT AND DRAG, INCREASED LIFT CAPABILITY
- HIGH ASPECT RATIO - REDUCED INDUCED DRAG DECREASES BOTH FUEL BURNED AND THRUST REQUIRED
- WINGLETS - REDUCED INDUCED DRAG DECREASES FUEL BURNED WHILE MINIMIZING SPAN AND WEIGHT INCREASE

HIGH-LIFT SYSTEM

- VARIABLE CAMBER KRUEGER - HIGH MAXIMUM LIFT CAPABILITY WITH MODEST FLAP DEFLECTIONS
- TWO-SEGMENT FLAP - HIGH LIFT-TO DRAG WITH LIMITED FLAP DEFLECTION MINIMIZES THRUST REQUIRED AND APPROACH NOISE

The winglet concept as well as the supercritical wing were wind tunnel tested by Dr. Whitcomb of NASA Langley, and have been under study for a number of aircraft applications. A recently completed Douglas/EET task generated an optimized high aspect ratio supercritical wing which considered the winglet as part of the original design. A joint USAF/NASA program is currently pursuing winglet installation on a KC-135A aircraft. In preparation for this activity, extensive wind tunnel testing at cruise speed and low-speed high-lift conditions has been conducted.

A winglet development program for potential application to the Douglas DC-10 is currently active. The winglet design has taken into account the experimental results of Dr. Whitcomb. This design, in various forms according to the specific model of DC-10, was successfully wind tunnel tested at cruise speed in the NASA Langley eight-foot wind tunnel in 1978 as part of the NASA ACEE program, and demonstrated the performance potential compared to wing tip extensions. The program will continue development through 1979 in the low-speed high-lift regime and will evaluate the stability and control characteristics. Other concurrent work at Douglas is investigating the structural and other facets of the winglet installation. Continuation of on-going efforts forms the basis for the advanced wing design in the E³ airplanes.

2.1.2 Advanced High-Lift System

The high lift system features two-segment trailing edge flaps in conjunction with a variable camber Krueger leading edge. The two-segment flap provides high extension capability and the large chord forward segment and smaller chord auxiliary flap provide an optimum camber distribution. The flap is continuous from the side of the fuselage to 80 percent of the wing span, avoiding the high-speed (inboard) aileron cutout and the associated loss of lift and increase in drag. The full-span leading edge Krueger flap will allow for tailoring to provide good stall characteristics and control stall progress in across the span.

This high-lift system design will provide excellent C_{Lmax} capability and very high lift-to-drag ratios allowing the use of small wing area and engine thrust size. Maximum flap deflection is limited to 30 degrees to reduce approach noise by minimizing both approach thrust and airframe generated noise. An additional benefit is reduced fuel consumption.

Development work on this high-lift system design is proceeding, leading to application in the next generation Douglas transport aircraft. Extensive two dimensional wind tunnel testing and analytical configuration studies have been conducted in the last few years. An extensive wind tunnel program which as part of the Douglas/EET effort was recently completed using a full span high aspect ratio supercritical wing with several combinations of high lift system.

2.2 MATERIALS

Material improvements expected are shown in Figure C-4. Improvements in metal alloys and structure fabrication techniques as well as the major use of advanced composites are visualized. The application of advanced composites to primary structure is dependent on major technology development sponsored by NASA.

COMPOSITES

- WING AND EMPENNAGE PRIMARY AND SECONDARY STRUCTURE
- CONTROL SURFACES
- FLOOR BEAMS
- LANDING GEAR DOORS
- FAIRINGS
- ENGINE NACELLES
- CARBON BRAKES

LESS WEIGHT

METALS

- BONDED STRUCTURE
- IMPROVED ALLOYS

LESS WEIGHT

Figure C-4 Advanced Features - Materials

2.2.1 Advanced Composites

Major advanced composite technology development activities have been underway for several years. Douglas composite programs, with major funding support from NASA, are leading to widespread application of composites in future transport aircraft. Current NASA sponsored advanced composite programs at Douglas include development of the DC-10 rudder, vertical tail and a wing study.

Expected application areas for composite materials in the next generation of transport aircraft include control surfaces, floor beams, fairings, landing gear doors and carbon brakes. If emphasis is placed on continued composite technology development, by the early 1990's, design, fabrication and repair techniques should have advanced to the point that application areas may be expanded to include wing and empennage primary structure. Use of composites in primary structures for the E³ study aircraft is assumed. The fuselage pressure shell will still be of metal construction and will not have changed noticeably from current DC-10 designs except for the increased use of bonded metal structure and improved alloys. Composite advantages include significant structural weight reduction, and with the falling price of composite materials relative to metals, minimum price escalation due to inflation.

2.2.2 Metals

Improved alloys are expected as well as the use of bonded structures resulting from the PABST program presently being conducted under Air Force sponsorship.

The forward fuselage section of a C-15 airframe has been fabricated using bonded structure and testing has been underway.

2.3 SYSTEMS

2.3.1 Longitudinal Stability Augmentation System (α LSAS)

The proposed E³ aircraft configurations include a static stability augmentation system that allows operation at a center-of-gravity range aft of that of an unaugmented aircraft. The α LSAS system provides angle-of-attack stability characteristics similar to those of the DC-10. The more aft center-of-gravity location reduces the aerodynamic balancing down load carried by the horizontal tail. This results in lower trim drag and a weight savings due to the smaller horizontal tail and wing required. The α LSAS system provides positive stability for all flight conditions, ensuring the proper feel for control column motions and forces required for maneuvering the aircraft. The system employs pitch rate, pitch attitude and normal acceleration as feedback parameters to independent augmentation computers which provide control inputs in series with pilot commands to the four elevator segments and the horizontal stabilizer.

In order to explore thoroughly the requirements and interrelationships of aircraft configuration, flying qualities, safety and reliability, control system design and economics, Douglas has embarked on a study utilizing an advanced derivative of the DC-10 transport. A substantial portion of this task is proceeding under the ACEE program. During 1977 an extensive piloted

simulation, to explore aircraft flying qualities on the Douglas six-degree of motion simulator, was conducted. This study was expanded in 1978 to include the effect of control system characteristics including failure cases and transient phenomena.

2.3.2 Wing Load Alleviation

The use of control surface movement to regulate the net load and its distribution on the wing structure can be used to reduce bending moments and therefore reduce weight.

An additional advantage is that ride quality will be improved. Principally, the application of these functions will be applied to the control of maneuver loads and gust loads.

The use of active systems for flutter suppression, which alters the apparent mass or stiffness, or aerodynamic damping, is expected to be employed to provide appropriate flutter speed margins. Even in the extremely unlikely event of complete system failure, the aircraft will not be flutter critical within the normal operating envelope.

The use of control devices to limit load is not uncommon. However, the full application of wing load alleviation in a transport aircraft involves careful consideration not only of the technical factors, but also the regulatory requirements and operating factors such as dispatch reliability. Advanced techniques to improve the design processes are under development, for example, by NASA in the ACEE program. In this program, large-scale drones, using a high aspect ratio supercritical wing with active controls, will be tested to correlate design techniques. A number of other applications are also under study or development. In the transport field, a significant interest has developed into applications for current transports or their derivatives. The Lockheed L-1011 experimental development, conducted partly under the ACEE program, is now flying. At Douglas, design is proceeding for a system related to the DC-10. Activity in this field is also to be pursued in combination with the ACEE program.

2.3.3 Other

Improvements in other aircraft systems are expected. Some of these are:

- Digital avionics - reduced weight and improved reliability and capability.
- Flight performance management - reduced aircraft operational fuel consumption.
- Air conditioning - reduced engine bleed requirements.
- APU - reduced weight and fuel consumption.
- Advanced cockpit displays - reduced weight and improved performance.

These improvements, relative to current aircraft systems, can be incorporated into future aircraft designs and are assumed to be utilized in the E³ aircraft.

3.0 AIRCRAFT DESCRIPTIONS

Using the advanced technologies described with results from on-going studies and technology development programs, aircraft sizing studies were conducted using Douglas computer programs. The design requirements for the aircraft include the selection of a common wing size to satisfy the needs of both a domestic transcontinental and intercontinental range version. The requirements shown on Table C-I are based to a great extent on the DC-10-10 transcontinental and the DC-10-30 intercontinental range aircraft. Design cruise Mach number was reduced from the DC-10 levels to reduce fuel consumption. The domestic aircraft is shown in Figure C-5. An intercontinental range version would require additional thrust and a four-wheel centerline main landing gear assembly to accommodate the higher gross weight.

3.1 AIRCRAFT CHARACTERISTICS

The aircraft characteristics are shown in Table C-II compared to those which would result from the use of scaled CF6 engines. The aircraft incorporates a DC-10 fuselage stretched 65 feet, a new high aspect ratio wing with supercritical airfoils and winglets, a new empennage and advanced aircraft systems. The basic mixed class seating capacity is 458 passengers in the domestic version with lower deck galley. Oversize cargo doors permit the accommodation of pallets in both the forward and center cargo compartments. The aft bulk cargo compartment is the same size as in the DC-10-30. The flight crew consists of a three man cockpit crew and 15 cabin attendants.

The wing area was set by the requirement for a 31,000 foot initial cruise altitude capability for an intercontinental range version. The wing design incorporates the results of the latest wind tunnel tests and analytical studies. Lateral control is provided by spoilers and the all-speed outboard aileron. This allows the flap to extend from the side of the body to 80 percent span without interruption, and with the limited flap deflection of 30 degrees, results in lower required thrust levels and less noise. Wing load alleviation consisting of maneuver and gust load alleviation is used to reduce wing weight.

Horizontal tail aspect ratio has been increased compared to the current DC-10 to reduce trim drag.

The wing, horizontal tail and vertical tail utilize composites in primary and secondary structures to minimize weight.

The scaled thrust size of the G.E. study engine was set by the thrust limited initial cruise altitude requirement of 33,000 ft. The resulting takeoff field length is 7400 ft. compared to the requirement of not to exceed 8000 ft., indicating a reasonable match between airframe and engine characteristics.

3.2 DIRECT OPERATING COST

The direct operating cost for the advanced airplane was determined using engine costs supplied by G.E. For comparative purposes, the direct operating cost was also determined for the same airframe technology but

Table C-I. Aircraft Design Requirements

	<u>Domestic</u>	<u>International</u>
MIXED CLASS SEATS	450	450
RANGE (N MI)	3,000	5,500
CRUISE MACH NO.	0.80	0.80
TAKEOFF FIELD LENGTH (FT) MTOW, SL, 84°F	8,000	11,000
APPROACH SPEED (KEAS) PASSENGERS, BAGGAGE, RESERVES	130	135
INITIAL CRUISE ALTITUDE (FT)	33,000	31,000

Table C-II. GE E³ Aircraft Characteristics

Domestic Transcontinental Range

<u>Engine</u>	<u>Scaled CF6-50C</u>	<u>Advanced</u>
Mixed Class Seats	458	458
Design Range (Nautical Miles)	3,000	3,000
Engine Thrust Size (LB/Engine)	44,630	41,360
Adjusted Wing Area (SQ FT)	5,190	4,680
Weights:		
Maximum Takeoff (LB)	539,000	499,000
Maximum Landing (LB)	475,000	459,000
Operator's Empty (LB)	303,240	289,950
Performance:		
Cruise Mach Number	0.80	0.80
Takeoff Field Length, MTOGW, SL 84°F (FT)	6,900	7,400
Approach Speeds, Passengers, Bags, Reserves (KEAS)	120	124
Thrust Limited Initial Cruise Altitude (FT)	33,000	33,000
Buffet Limited Initial Cruise Altitude (FT)	37,100	36,500
Fuel Burned At Design Range (LB) (100% Passenger Load Factor)	123,060	98,650
Typical Stage Length (Nautical Miles)	2,000	1,000
Fuel Burned At Typical Range (LB)	39,940	32,630
(60% Passenger } (30% Cargo } Load Factors)		

scaled CF6 engines. The comparison is shown in Table C-III and the DOC calculation method in Table C-IV.

3.3 DRAG

The airplane parasite and induced drag are shown in Table C-V. Nacelle drag is included in the engine data. The compressibility drag increment is shown in Figure C-6. The takeoff and landing drag polars are presented in Figure C-7.

3.4 WEIGHT

Airframe weight breakdowns are shown in Table C-VI. The weights are based on technology advancements including the widespread use of advanced composites.

3.5 SENSITIVITY FACTORS

Sensitivity factors were generated and are shown in Table C-VII. These factors provide a means to assess the impact of perturbations in specific fuel consumption, engine weight and nacelle drag on aircraft weights, engine size, and fuel burned for the study missions.

3.6 NOISE

The airframe or non-propulsive noise with flight conditions and engine power settings at the FAR noise measuring points are shown in Table C-VIII. Sound pressure levels by frequency band and direction at these conditions are shown in Table C-IX.

3.7 SECONDARY POWER

The secondary power requirements have been estimated and the mechanical power requirements are shown in Table C-X. For hydraulic power, the time average cruise requirement in still air (without turbulence) is 31 horsepower per engine. This is based on hydraulic pumps in average condition with nominal aircraft hydraulic system leakage. The maximum or sizing requirement for hydraulic power is for two pumps per engine operating at full capacity. One hundred seventy five horsepower per engine is required for pumps that have had considerable usage.

The time average accessory gearbox power required by the generators is 75 horsepower per engine. This is based on a survey made on power usage in the DC-10. The DC-10 average power usage was scaled up to provide for the increase in number of passengers in this study. The maximum or sizing requirement is 257 horsepower per engine.

The average pneumatic power required in the form of compressor bleed is shown in Figure C-8.

The maximum bleed case is for one pneumatic system out and an engine out, under icing conditions. For this case, at a 15,000 foot hold condition, it is estimated that one engine must provide 0.7 pounds/second inlet cowl anti-ice bleed with a temperature greater than 500°F plus 5 pounds/second

Table C-III. Direct Operating Costs Transcontinental Range Domestic Trijets

	<u>Scaled CF6-50C</u>	<u>Advanced Engine</u>
Aircraft Study Price (1978 \$M)	46.43	47.44
Stage Length (n mi)	1000	3000
Block Fuel (lb)	38300	32630
Block Time (hr)	2.54	2.55
DOC (1978 \$/trip)	6.84	6.87
Cockpit Crew	1126	1100
Depreciation	2385	2455
Insurance	290	297
Landing Fees	404	374
Airframe Maintenance	802	786
Engine Maintenance	582	426
Fuel	2980	2435
TOTAL DOC	8569	7873
Relative DOC	0	-8.1%

Table C-IV. DAC DOC Method For GE E³ Study

Direct operating costs for the GE domestic E³ aircraft are in 1978 dollars and consist of the following components:

Cockpit Crew (3 man crew)

$$\$/\text{flight} = t_b \times (280 + 30.3 \times \frac{\text{TOW}}{100000})$$

where: t_b = block time (hours)

TOW = maximum takeoff weight (lb)

Airframe Depreciation

$$\$/\text{flight} = (1-R) \times C_A \times (1 + S_A) \times D/D_A/P$$

where: R = residual value ratio = 0.10

C_A = aircraft price less bare engine price (1978 \$)

S_A = airframe spares ratio = 0.08

D = trip distance (nautical miles)

D_A = depreciation period = 16 years

P = annual productivity = 1200000 nautical miles/year

Engine Depreciation

$$\$/\text{flight} = (1-R) \times C_e \times N_e \times (1 + S_E) \times D/D_A/P$$

where: C_e = price of one bare engine (1978 \$)

N_e = number of engines = 3

S_e = engine spares ration = 0.25

Insurance

$$\$/\text{flight} = I \times (C_A + N_e \times C_e) \times D/P$$

where: I = annual insurance rate = 0.0075

Landing Fees

$$\$/\text{flight} = L \times \text{TOW}/1000$$

where: L = landing fee rate per 1000 lb of maximum takeoff weight = 0.75 \$/1000 lb

Table C-IV. DAC DOC Method For GE E³ Study (Concluded).

Fuel

$$$/flight = C_f \times F_B / 6.7$$

where: C_f = fuel price = 0.50 \$/gallon

F_B = block fuel

Airframe Maintenance

$$$/flight = t_F \times [162 \times 334 \times 10^{-6} \times (W_A - 240000.)] \\ + 400 + 40 \times 10^{-5} \times (W_A - 240000.)$$

where: t_F = flight time (hr) = $t_B - 0.167$

W_A = airframe weight (lb)

= manufacturer's empty weight - bare engine weight

Engine Maintenance

$$$/flight = 223 \times t_F \times \sqrt{E_x} \text{ for advanced engine}$$

$$= 260 \times t_F \times \sqrt{E_x} \text{ for CF6-50C}$$

where: E_x = engine thrust scale factor

Table C-V. Aircraft Drag

Aircraft With Advanced Engines

Reference Area:

Trapezoidal Wing Area = 4,231 ft²

Parasite Drag:

f = 67.86 ft² (excludes nacelles)

Induced Drag:

AR_{trapezoidal} = 10.85

e = 0.953 (includes winglet effects)

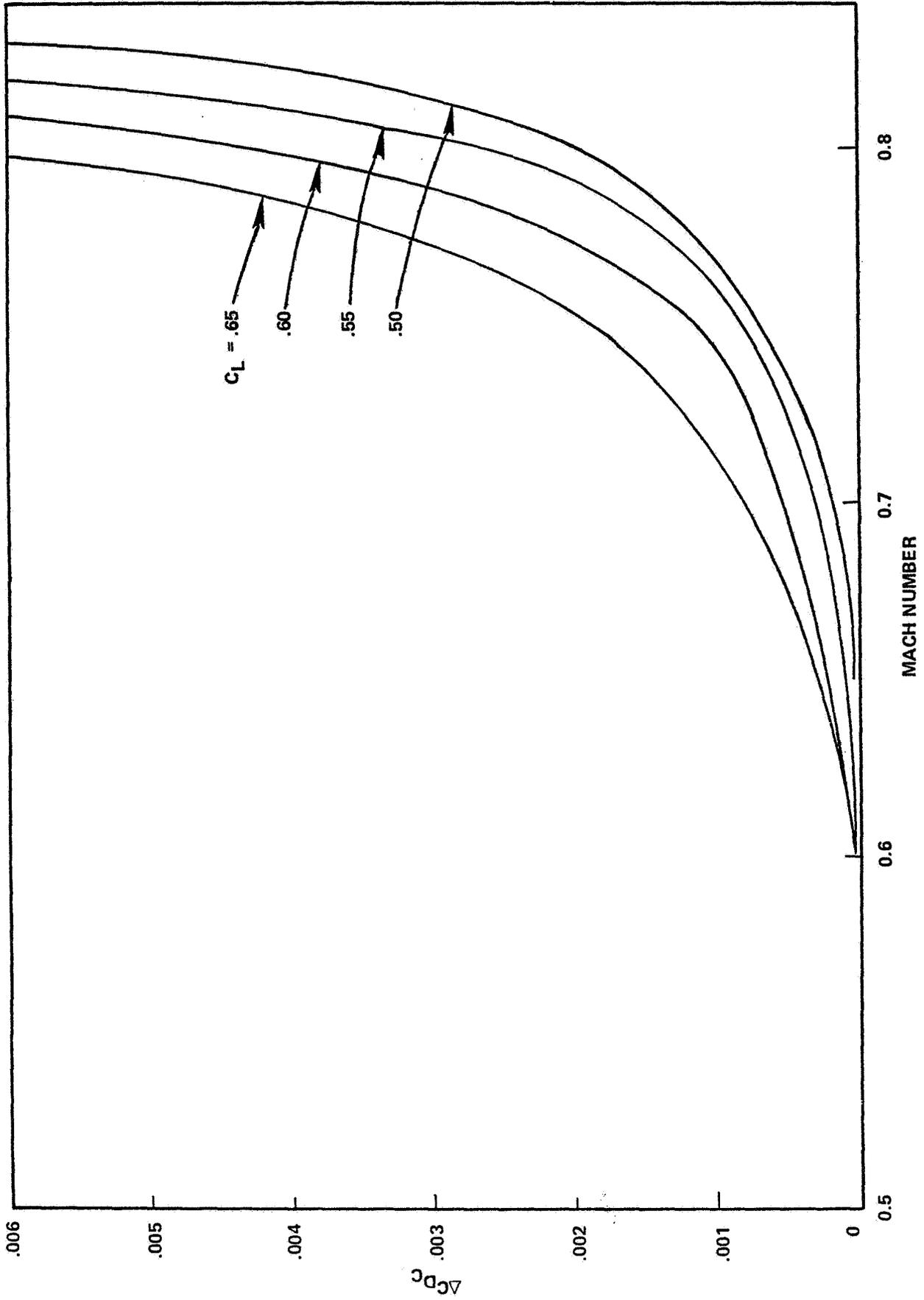


Figure C-6. Compressibility Drag Rise Characteristics

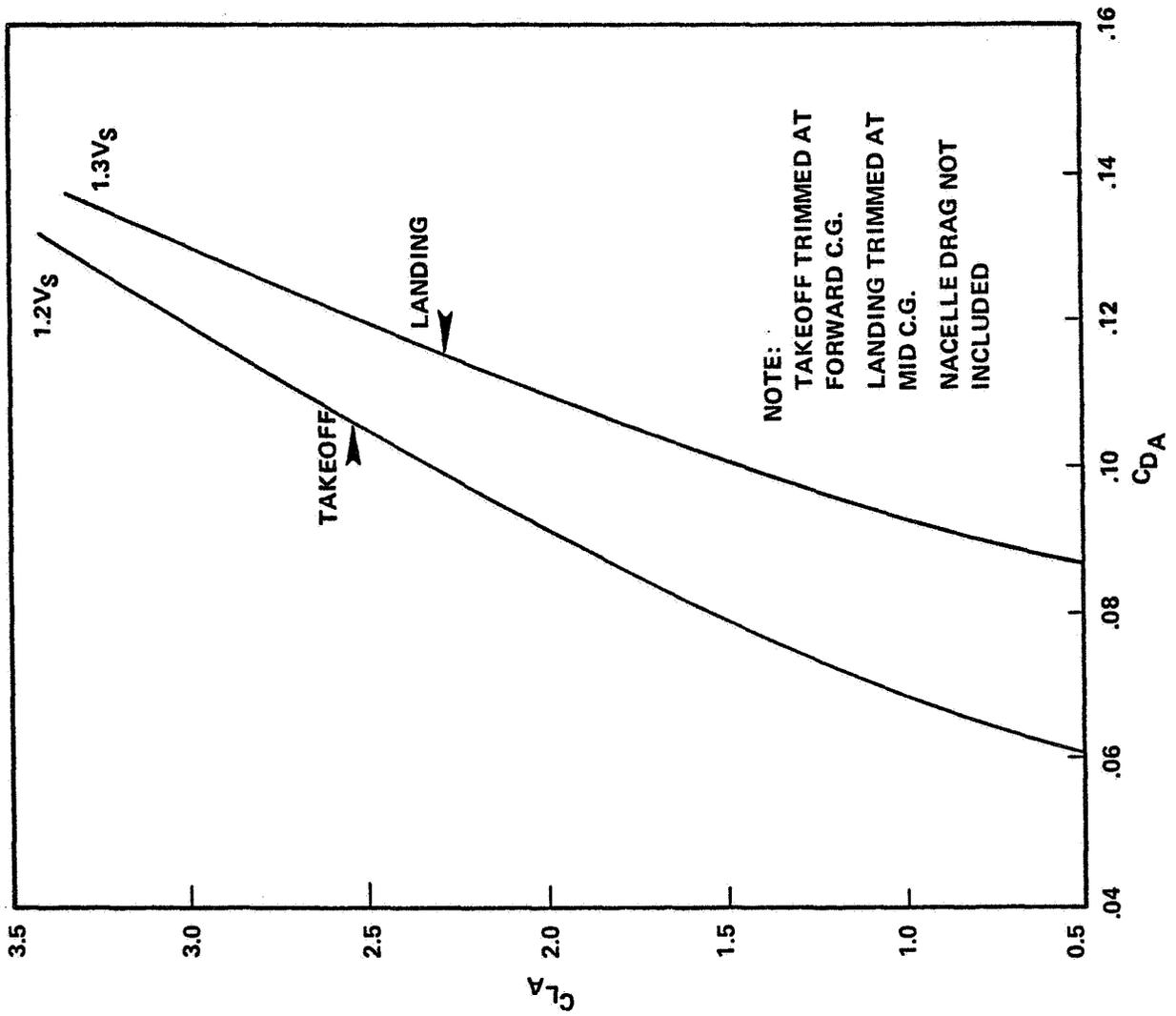


Figure C-7. High-Lift Polars Gear-Up

Table C-VI. Aircraft Weight Breakdowns

Domestic Transcontinental Range Trijets

<u>Weights (lb)</u>	<u>Scaled CF6-50 Engines</u>	<u>Advanced Engines</u>
Wing	61,260	55,250
Horizontal Tail	4,980	4,250
Vertical Tail	2,320	1,990
Fuselage	62,720	61,950
Landing Gear	22,120	20,360
Propulsion*	38,640	36,480
APU	1,435	1,435
Fuel System	2,240	2,130
Flight Controls and Hydraulic System	11,880	10,540
Instruments	1,750	1,750
Air Conditioning and Pneumatics	4,965	4,965
Electrical	6,460	6,460
Avionics	2,700	2,700
Furnishings	53,290	53,290
Ice Protection	730	650
Handling Gear	60	60
Manufacturer's Empty Weight	277,550	264,260
Operator's Items	25,690	25,690
Operator's Empty Weight	303,240	289,950

*Includes lower vertical tail

Table C-VII. Sensitivity Factors

Domestic Trijet With GE Advanced Engines

A CHANGE IN OF	SFC	Engine Weight	Engine Price	Engine Maintenance
WILL CAUSE				
	+5%	+1000 lb each	+10%	+10%
Δ Maximum Takeoff Weight	+2.5%	+1.2%	0	0
Δ Operator's Empty Weight	+1.7%	+1.7%	0	0
Δ Adjusted Wing Area	+4.6%	+1.6%	0	0
Δ Engine Thrust Size	2.1%	+0.9%	0	0
Δ Fuel Burned at Design Range	+6.8%	+0.9%	0	0
Δ Fuel Burned at 1000 n mi	+6.3%	+0.9%	0	0
Δ DOC at Design Range	+3.0%	+0.9%	+0.6	+0.6
Δ DOC at 100 n mi	+2.7%	+0.9%	+0.6	+0.5

Table C-VIII. Airframe Generated Noise at FAR-36 Measuring Points

Condition	Trijet With GE Advanced Engines			
	Sideline	Takeoff	Cutback	Approach
Aircraft Weight (LB)	497000	497000	497000	457000
Geometric Altitude (FT)	850	1638	1545	394
Aircraft Pitch Angle (Deg)	+15	+15	+12	+3
Climb Gradient (%)	10.9	10.6	5.2	-5.2
Installed Thrust Per Engine				
- (LB)	30190	29690	20340	5430
- (% Of Takeoff)	100	100	68	18
True Airspeed (Knots)	147	148	148	146
Flap Deflection (Degrees)	20	20	20	30
Airframe Noise (EPNdB)	76.6	77.2	77.7	92.3

NOTE: Thrust Size = 41230 LB/Engine

Table C-IX. Nonpropulsive Noise Study.

NONPROPULSIVE NOISE STUDY E3 DOMESTIC ADVANCED G.F. VERSION	H5TI	DATE	02/15/79	NON-PROPULSIVE											
				MACH NO. = 0.219											
				FLAP AREA = 255.2 SQ FT											
				FLAP POS = 20.0 DEG											
SIDELINE CAN5 00M															
PHYS N1 = 5000.0 RPM															
R50. FOOT ALTITUDE * 1477. FOOT SIDELINE DISTANCE SOUND PRESSURE LEVELS, DB															
ANGLE FROM INLET CENTERLINE (DEGREES)															
BRAND	20.0	30.0	40.0	50.0	60.0	70.0	80.0	90.0	100.0	110.0	120.0	130.0	140.0	150.0	160.0
50	48.1	52.0	54.3	55.8	56.8	57.2	57.3	57.0	56.4	55.4	54.1	52.5	50.3	47.6	43.8
63	48.5	52.2	54.4	55.9	56.8	57.3	57.4	57.2	56.7	55.8	54.6	53.1	51.1	48.4	44.7
80	48.5	52.0	54.0	55.4	56.4	57.1	57.5	57.5	57.3	56.7	55.7	54.2	52.3	49.7	45.9
100	49.5	52.6	54.2	55.4	56.4	57.2	57.8	58.1	58.1	57.7	56.9	55.6	53.8	51.3	47.5
125	49.6	52.7	54.5	55.8	56.7	57.1	58.1	59.1	59.1	58.6	57.8	56.5	54.6	52.0	48.0
160	47.9	51.3	53.4	55.1	56.4	57.5	58.2	58.5	58.4	57.9	56.9	55.5	53.5	50.7	46.6
200	46.8	51.1	54.0	56.2	57.7	58.7	59.2	59.3	58.9	58.1	56.9	55.2	52.9	49.8	45.4
250	44.5	50.5	54.6	57.4	59.2	60.3	60.8	60.7	60.2	59.2	57.7	55.7	53.0	49.3	44.0
315	45.1	51.1	55.2	59.0	61.0	61.0	61.5	61.5	61.0	60.0	58.6	56.6	53.9	50.2	44.9
400	44.0	49.6	53.7	58.7	60.2	60.8	60.8	61.0	60.6	59.8	58.5	56.6	54.0	50.4	45.1
500	44.0	48.8	52.1	56.7	58.1	58.9	59.3	59.1	58.5	58.5	57.3	55.6	53.3	49.9	44.7
630	44.8	49.6	52.1	56.8	58.2	58.9	59.1	59.3	58.4	57.4	56.1	54.6	52.4	49.3	44.2
800	43.6	49.5	52.5	56.3	57.7	58.3	58.7	58.8	58.6	57.9	56.6	54.9	53.3	49.6	42.3
1000	40.6	47.4	51.0	54.7	56.0	56.5	56.7	56.9	56.6	55.8	53.5	51.7	49.1	45.4	39.6
1250	37.9	45.4	49.0	51.2	52.7	53.6	54.2	54.3	54.0	53.4	52.2	50.5	47.9	44.0	37.7
1600	33.5	42.2	46.6	49.2	50.9	52.1	52.7	52.9	52.7	51.9	50.7	48.7	45.9	41.6	34.3
2000	30.2	40.2	45.0	47.7	49.4	50.6	51.4	51.7	51.5	50.8	49.6	47.7	44.7	40.0	32.0
2500	25.2	37.0	42.2	45.0	46.7	47.9	48.8	49.2	49.2	48.7	47.5	45.6	42.4	37.3	28.1
3150	13.4	29.3	36.3	39.0	42.1	43.6	44.7	45.4	45.5	44.9	43.6	41.2	37.4	31.0	19.2
4000	0.0	17.4	26.6	31.9	35.8	38.8	40.8	41.9	42.1	41.4	39.7	36.6	31.6	23.2	7.5
5000	0.0	8.7	18.9	24.7	29.4	33.4	36.1	37.7	38.2	37.5	35.6	32.2	26.5	16.9	0.0
6300	0.0	0.0	9.1	16.4	21.9	25.7	28.1	29.3	29.3	28.1	25.6	21.3	14.2	2.3	0.0
8000	0.0	0.0	0.0	6.2	11.2	15.7	18.4	19.6	19.5	17.9	14.7	9.3	0.4	0.0	0.0
10000	0.0	0.0	0.0	0.0	0.0	0.5	4.3	6.1	6.1	4.2	0.2	0.0	0.0	0.0	0.0
PNT	59.4	65.5	69.4	72.1	74.1	75.4	76.1	76.1	76.1	75.4	74.1	72.1	69.3	65.4	59.4
PMLT	59.4	65.5	69.4	72.1	74.1	75.4	76.1	76.1	76.1	75.4	74.1	72.1	69.3	65.4	59.4
A WTD	50.2	55.1	58.6	61.9	63.6	64.7	65.3	65.5	65.2	64.5	63.3	61.5	59.0	55.4	49.9
PLASPL	58.2	62.6	65.4	67.5	68.5	69.0	70.5	70.6	70.3	69.6	68.4	66.8	64.5	61.3	56.8
ARC RMS	542E	3460	2599	2135	1972	1713	1639	1618	1648	1750	1875	2108	2483	3127	4409

Table C-IX. Nonpropulsive Noise Study (Continued).

NONPROPULSIVE NOISE STUDY #3	DOMESTIC ADVANCED G.E. VERSION	H5T1	DATE 02/15/79	NON-PROPULSIVE	MACH NO. = 0.222	FLAP AREA = 255.2 SQ FT	FLAP POS = 20.0 DEG	1638. FOOT ALTITUDE * 0. FOOT SIDELINE DISTANCE SOUND PRESSURE LEVELS, DB									
								A N G L E F R O M I N L F T C E N T E R L I N E (D E G R E E S)									
								20.0	30.0	40.0	50.0	60.0	70.0	80.0	90.0	100.0	110.0
50	47.4	51.7	54.3	56.0	57.1	57.7	57.9	57.6	57.1	56.1	54.8	53.2	51.1	48.4	45.0		
63	47.8	52.0	54.5	56.1	57.2	57.7	58.0	57.8	57.3	56.5	55.3	53.8	51.8	49.2	45.8		
90	47.7	51.6	54.0	55.6	56.8	57.6	58.1	58.2	57.9	57.3	56.3	54.9	53.0	50.5	47.0		
100	48.7	52.2	54.1	55.5	56.6	57.6	58.3	58.7	58.7	58.3	57.6	56.3	54.6	52.1	48.6		
125	48.9	52.5	54.5	56.1	57.5	58.6	59.4	59.8	59.8	59.4	58.6	57.3	55.5	52.9	49.3		
150	47.2	51.0	53.3	55.2	56.7	57.9	58.7	59.1	59.1	58.6	57.7	56.3	54.4	51.7	48.0		
200	46.0	50.8	54.0	56.3	58.0	59.1	59.7	59.9	59.6	58.8	57.7	56.0	53.8	50.8	46.7		
250	43.4	50.0	54.4	57.4	59.5	60.7	61.3	60.8	60.8	59.9	58.4	56.4	53.7	50.2	45.3		
315	44.1	50.8	55.2	58.3	60.3	61.6	62.2	62.2	61.8	60.8	59.4	57.4	54.7	51.1	46.2		
400	42.8	49.2	53.7	57.0	59.3	60.7	61.5	61.7	61.4	60.6	59.3	57.4	54.9	51.4	46.6		
500	42.6	48.3	52.0	55.9	57.1	58.7	59.6	60.0	59.9	59.3	58.1	56.5	54.1	50.9	46.2		
630	43.3	49.0	51.9	55.5	58.2	60.8	61.8	62.2	62.2	61.8	60.8	59.4	57.4	54.4	45.9		
800	42.0	48.9	52.3	56.4	59.6	61.8	62.8	63.2	63.2	62.8	61.8	60.4	58.4	55.4	51.4		
1000	38.7	46.7	50.7	53.3	55.0	56.0	56.6	56.7	56.4	55.6	54.4	52.6	50.1	46.6	41.4		
1250	35.7	44.6	48.9	51.4	53.1	54.2	54.9	55.1	54.9	54.3	53.1	51.4	49.0	45.4	39.8		
1600	30.7	41.2	46.2	49.2	51.2	52.6	53.4	53.7	53.5	52.9	51.6	49.7	47.0	43.0	36.6		
2000	26.5	38.5	44.5	47.7	49.8	51.2	52.1	52.5	52.4	51.8	50.6	48.7	45.9	41.6	34.5		
2500	21.3	35.4	41.6	45.0	47.1	48.6	49.6	50.2	50.3	49.8	48.7	46.8	43.8	39.1	31.2		
3150	8.0	27.3	35.5	39.8	42.4	44.2	45.5	46.3	46.5	46.1	44.8	42.6	39.0	33.2	23.0		
4000	0.0	14.5	25.4	31.7	36.2	39.5	41.8	43.1	43.5	42.9	41.2	38.3	33.5	25.9	12.5		
5000	0.0	5.3	17.5	24.3	29.7	34.1	37.3	39.1	39.8	39.2	37.5	34.3	28.9	20.2	4.6		
6300	0.0	0.0	6.1	15.8	22.1	26.5	29.3	30.8	31.0	30.1	27.7	23.6	17.0	6.2	0.0		
8000	0.0	0.0	0.0	8.5	11.5	16.7	19.9	21.5	21.6	20.3	17.2	12.1	3.8	0.0	0.0		
10000	0.0	0.0	0.0	0.0	0.0	6.1	8.1	8.3	8.6	7.0	3.3	0.0	0.0	0.0	0.0		
PNL	64.8	69.2	74.4	77.3	77.2	76.8	77.0	77.0	77.0	76.3	75.0	73.1	70.4	66.6	61.1		
PNLT	57.9	64.8	70.2	74.4	74.8	75.9	76.8	77.2	77.2	76.3	75.0	73.1	70.4	66.6	61.1		
A WTD	54.5	59.5	64.1	68.9	69.3	69.6	70.0	70.0	70.0	69.4	68.2	66.3	63.5	60.0	55.5		
CASPL	48.7	53.3	58.3	62.6	63.3	63.6	64.0	64.0	64.0	63.4	62.2	60.3	57.5	54.0	50.0		
ACRNG	6171	2774	2772	2240	1943	1765	1670	1636	1655	1726	1857	2069	2408	2974	4035		

Table C-IX. Nonpropulsive Noise Study (Concluded).

BAND	NONPROPULSIVE NOISE STUDY E3 DOMESTIC ADVANCED G.F. VERSION										MACH NO. = 0.217	FLAP POS = 30.0 DEG			
	APPROACH CAN5 30M		394. FOOT ALTITUDE * 0. FOOT SIDELINE DISTANCE SOUND PRESSURE LEVELS, DB										FLAP POS = 30.0 DEG		
	PHYS NL = 5000.0 RPM	ANGLE	FRDM	INLF	TLF	CE	N	PL	INE	(DEGR)				EFFS	
20.0	30.0	40.0	50.0	60.0	70.0	80.0	90.0	100.0	110.0	120.0	130.0	140.0	150.0	160.0	
50	56.3	63.3	66.9	69.4	71.1	72.3	73.0	73.3	73.2	72.7	71.8	70.5	68.6	66.2	63.2
63	57.8	64.5	67.8	70.1	71.7	72.8	73.5	73.9	73.9	73.5	72.8	71.6	70.0	67.8	64.9
80	58.1	64.3	67.2	69.2	70.8	72.1	73.2	73.8	74.1	74.1	73.6	72.6	71.2	69.1	66.2
100	57.6	64.4	66.7	69.4	70.0	71.6	73.0	74.0	74.6	74.8	74.5	73.7	72.3	70.3	67.5
125	58.3	64.2	66.3	68.7	70.5	72.2	73.5	74.5	75.0	75.1	74.7	73.8	72.4	70.3	67.4
160	58.9	65.2	68.0	69.7	71.2	72.5	73.5	74.3	74.7	74.7	74.3	73.4	72.1	70.1	67.3
200	56.4	63.7	67.7	70.5	72.5	74.0	74.6	75.4	75.5	75.1	74.3	72.9	71.1	68.6	65.3
250	55.3	64.0	68.8	72.0	74.1	75.6	76.4	76.7	76.6	75.9	74.8	73.2	70.9	68.0	64.1
315	56.0	64.5	69.1	72.2	74.4	75.8	76.7	77.0	76.9	76.3	75.3	73.7	71.6	68.7	65.1
400	55.3	63.4	67.8	70.9	73.2	74.8	75.9	76.4	76.5	76.1	75.2	73.9	71.9	69.3	65.8
500	56.5	63.9	67.3	69.6	71.5	73.1	74.2	74.9	75.3	75.2	74.6	73.6	72.0	69.8	66.8
630	57.1	65.0	68.2	70.4	71.9	73.0	73.9	74.4	74.7	74.6	74.1	73.2	71.7	69.6	66.7
800	55.9	64.4	68.0	70.2	71.8	73.0	73.9	74.5	74.7	74.5	74.0	73.0	71.4	69.3	66.3
1000	54.9	64.0	67.8	70.2	71.8	73.0	73.9	74.4	74.6	74.4	73.8	72.8	71.3	69.0	65.9
1250	54.2	63.8	67.5	69.6	71.0	72.0	72.8	73.4	73.7	73.7	73.4	72.6	71.2	69.2	66.1
1600	53.0	63.6	67.4	69.4	70.3	70.9	71.5	72.0	72.5	72.8	72.7	72.1	71.0	69.0	66.0
2000	49.7	61.5	65.6	67.8	69.2	70.3	71.2	72.0	72.6	72.9	72.7	72.0	70.7	68.5	65.2
2500	44.9	58.3	63.0	66.0	67.8	69.3	70.5	71.4	71.9	72.1	71.7	70.8	69.2	68.8	63.0
3150	37.5	54.6	60.6	64.3	66.7	68.4	69.8	70.7	71.1	71.1	70.6	69.5	67.7	64.9	60.8
4000	27.8	49.3	56.6	61.2	64.5	67.0	68.9	70.1	70.8	70.8	70.3	69.0	66.9	63.7	58.9
5000	21.0	45.7	53.6	58.5	62.1	64.9	67.0	68.5	69.3	69.5	69.0	67.8	65.6	62.3	57.0
6300	10.0	33.0	41.7	47.1	50.2	52.2	53.6	54.6	55.3	55.5	55.1	53.9	51.9	48.5	42.9
8000	0.0	33.1	45.1	51.9	56.0	58.7	60.6	62.1	63.9	63.2	62.7	61.3	58.8	54.8	48.0
10000	0.0	13.0	34.0	43.3	49.3	53.6	55.7	58.8	60.0	60.3	59.6	57.8	54.6	49.4	40.8
PWL	73.5	84.1	88.5	91.4	93.4	95.0	96.3	97.1	97.5	97.5	97.0	96.0	94.2	91.7	87.9
PNLT	73.5	84.1	88.5	91.4	93.4	95.0	96.3	97.1	97.5	97.5	97.0	96.0	94.2	91.7	87.9
A-WTD	68.8	76.8	80.1	82.2	83.9	85.2	86.2	87.3	87.6	87.6	86.8	85.7	84.1	81.8	78.6
CASPL	68.8	76.8	80.1	82.2	83.9	85.2	86.2	87.3	87.6	87.6	86.8	85.7	84.1	81.8	78.6
ACN PWG	2865	1229	783	517	486	435	411	406	414	435	469	516	565	690	864

Table C-X. Accessory Gearbox Power Requirements

<u>TYPE</u>	<u>SOURCE</u>	<u>TIME AVERAGE CRUISE POWER IN STILL AIR</u>	<u>SIZING REQUIREMENT</u>
Hydraulic Power	Two 35 GPM Pumps per Engine	31 HP/Engine	175 HP/Engine
Electric Power	One 120 KVA Generator per Engine	75 HP/Engine	257 HP/Engine

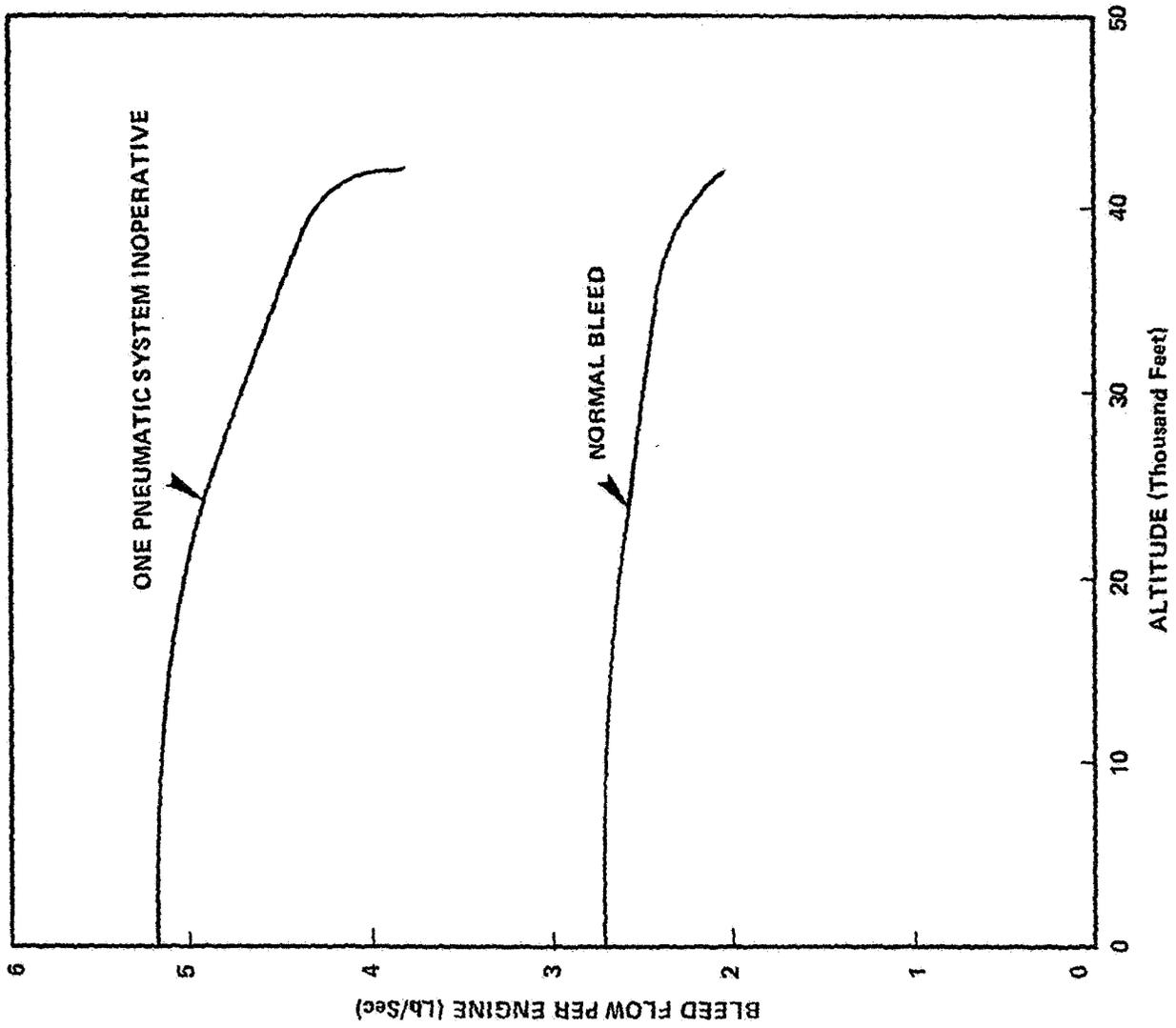


Figure C-8. Aircraft Compressor Bleed Air Required

wing anti-ice flow at a temperature greater than 400°F plus 2.7 pounds/second to provide air to drive one air conditioning pack. The sizing case therefore requires a total of 8.4 pounds/second with the engine at 40 to 60% of climb thrust.

The above values reflect preliminary analyses of a current test program to reduce bleed flow requirements for wing anti-icing.

Further evaluations may result in requirements to revise the wing anti-icing flow requirements. In addition, potential means to reduce bleed flow requirements have been identified but sufficient work has not been done to reflect these reductions in this study.

4.0 AIRFRAME/PROPULSION SYSTEM INTEGRATION

Preliminary propulsion system integration requirements have been investigated. Study engine installations provided by General Electric have been reviewed; Douglas conducted nacelle/aircraft integration studies and requirements for engine installation in the E³ study aircraft have been determined. Results of these studies are reported below.

4.1 NACELLE PLACEMENT

The nacelle/pylon/wing relationship must be established to minimize interference drag. Wind tunnel tests are required to establish this relationship. Such tests have been underway as a part of Douglas activities on the NASA Langley Energy Efficient Transport Program. Further development is required. Figure C-9 shows the current relation between nacelle/ pylon/wing reflecting the best estimate to date. Test results to date indicate a more aft location would have excessive interference drag. Further, studies of the flow efflux pattern during reverse thrust shows a more aft location would have a problem from impingement on the inboard section of the variable camber Kreuger leading edge device on a swept wing.

4.2 PRELIMINARY 1990 PROPULSION SYSTEM REQUIREMENTS

New engines are introduced because they result in a major improvement in economics, provide the thrust requirement for a new airplane size, or both. In the 1990's, a new engine based on E³ technology will be expected to improve economics because the thrust sizes of interest are expected to be available from current and derivative versions of CF6, CFM56, JT8D refan, JT9D, JT10D, and RB211 engines. Since the E³ goal is to reduce specific fuel consumption by 12% and DOC by 5%, other cost components cannot increase, and may have to decrease to provide sufficient incentive for development of a new engine. It is therefore expected that other costs should improve, or at worse, remain the same. This needs to be accomplished while meeting more stringent regulations and requirements.

4.2.1 Maintenance

The installation maintainability goals should be comparable to today's standards. This requires access to all borescope ports without removal of any component. Elapsed time goals are shown in Table C-XI.

4.2.2 Thrust Reversers

Thrust reversers should be improved compared to current designs. Specific needs are listed below.

1. Fan thrust reversers with efflux directivity that minimizes debris kickup while enabling routine use down to zero speed are desired. Directivity tailoring capability must exist to match airframe requirements to maintain airplane control and drag.
2. The overall reverser effectiveness goal is 40% for the primary plus fan on wing engines. Tail engine reversing effectiveness can be lower to prevent aircraft pitchup.

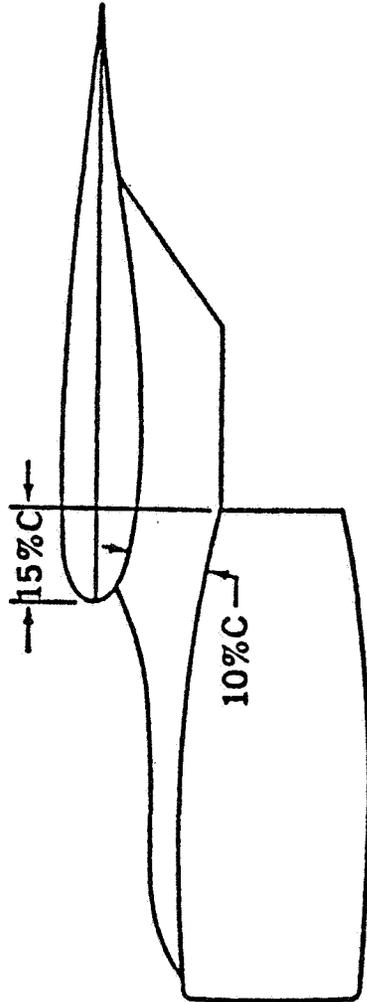


Figure C-9. Nacelle/Wing Relationship

Table C-XI. Installation Elapsed Time Goals

<u>DESCRIPTION</u>	<u>ELAPSED TIME</u> <u>(Minutes)</u>
Engine	
Build Up Neutral QEC from Basic Engine	2000
Build Up Neutral QEC to Wing QEC	45
Build Up Neutral QEC to Tail QEC	30
Convert Wing QEC to Tail QEC	45
Convert Tail QEC to Wing QEC	45
Change Wing Engine	60
(Including Access Time and GSE)	
Change Tail Engine	90
Components/Accessories	
	Remove and Replace
Integrated Drive Generator	35
Hydraulic Pump	15
Fire Detector	15
Main Fuel Control	25
Fuel Pump	60
Fuel Heater	30
Primary Nozzle	90
Exhaust Plug with Primary Nozzle Removed	10
Exhaust Plug with Primary Nozzle Installed	15
Fuel Heater Air Shutoff Solenoid Valve	10
Anti-Icing Air Shutoff Actuator Valve	20
Differential Pressure Switch	6
Nose Cowl Anti-Icing Pressure Regulator and Shutoff Valve	7
Starter	20
Starter Shutoff Valve	5
Hydraulic Filters	5
Fuel Flow Transmitter	11
Ignition Exciter	7
Ignition Plugs	7
Pressure Ratio Bleed Control	8
Compressor Stator Control	23
Fan Air Case Cooling Shutoff Valves	7
Bleed (Air/Fuel) Converter Valve	12
Bleed Control Valves	7
Pneumatic Pressure Regulating Valves	7
Bleed Check Valves	4

3. Current fail-safe design practice for ground only reversing will be maintained. The reversers will maintain their position in the event of an actuation system failure.
4. A hydraulic actuation system is preferred with reverser hydraulic fluid isolated from other airframe hydraulic fluid.

4.2.3 Ozone

Consideration should be given to providing bleed air for cabin air conditioning that has an ozone concentration of less than 0.1 ppm. Since elevating the temperature of air conditioning ozone will destroy the ozone, heating and cooling the bleed air may be a viable way to reduce the ozone concentration in the cabin. Cabin air recirculation will reduce ozone contamination.

4.2.4 Bleed Air Cleanliness

Bleed ports must be designed to prevent the ingestion of solid particles that enter the engine inlet, or liquids (such as might be generated within the engine by fluid leakage), without unnecessarily sacrificing total pressure recovery.

Because an engine compressor acts as a centrifugal separator, clean air may be extracted at the compressor inside diameter without significant loss of ram pressure. The associated disadvantages are the cost of making hollow stator vanes suitable for conducting this air to the outside diameter of the engine, and the pressure drop of the flow traversing these relatively small passages.

Outside diameter ports that are protected by locating them in a shadow zone sacrifice ram pressure but may be designed to provide clean air as long as the engine is running. When the engine is stopped, fluids can draw into such openings if they occur at a low point.

4.2.5 Bleed Port Locations

Bleed air must be available from the engine at flight idle power to supply the aircraft pneumatic system.

For economy reasons, bleed must be available at the lowest stage that will satisfy air conditioning system pressure requirements at maximum altitude with the lowest engine power useful for cruise. If the maximum altitude for the baseline airplane is 39,000 feet, a bleed pressure of 20 psig would permit using DC-10 type components. Pressures as low as 15 psig could be considered if the associated economy improvement would justify the development of new and possibly more complicated air conditioning components.

An additional, lower stage port located so that the discharge temperature closely approached but did not exceed 450°F on a hot day at sea level with takeoff thrust would eliminate the need for precooling. Complete elimination of precooling could only be justified by a thorough investigation. Changing from DC-10 to DC-9 pneumatic system concepts for providing suitable ice protection bleed temperatures would probably be required. The investment would have to include a study of the pressure suitability of the next lower

stage pressure whenever high stage bleed exceeds 450°F at idle power on a hot day. Any pressure above 25 psig at this lower stage would be satisfactory.

A completely independent port for engine inlet ice protection air supply is desired, located at compressor discharge, or preferably a lower stage if it would provide 400°F at engine idle power with ambient temperatures at the low limit of the FAA icing envelope.

4.2.6 Containment

In addition to rotor blade containment requirements of FAR Part 33, any blade fragment exiting from the engine shall not have sufficient energy to penetrate nacelle structure or systems.

4.3 INSTALLATION STUDIES

Installation studies were made reviewing the G.E. installation for airframe compatibility. A listing of the layouts made is shown in Figure C-10 with a brief description. The eight layouts listed in Figure C-10 are shown as Figures C-11 through C-18.

Various fore and aft placement of the nacelle relative to the wing were studied including location on the trailing edge of the wing. The current study location with the nozzle trailing edge at 15% of the wing chord is judged to offer the best promise of attaining a design which has no fan reverser impingement on wing high lift device surfaces without incurring the high risks of nacelle to wing interference drag penalties for aft mounted nacelles or wing flutter penalties which are expected for more forward nacelle positions.

The reference base G.E. installation design utilizes a core mounted accessory arrangement in order to retain a circular nacelle cross section which would produce a minimum frontal and wetted skin area with consequent minimum performance loss due to nacelle external drag. This approach, however, results in reduced accessibility to engine mounted components and a more compact and difficult to maintain accessory arrangement. Performance versus maintenance cost trades, including the effects on dispatch delay and cancellation rates are needed. As a part of evaluation/accessory arrangement, three different layout studies were made from which the drag penalties associated with fan case mounted accessories could be assessed relative to equivalent nacelles designed for core mounted accessories. The first two of these studies were made using very preliminary estimates of accessory package configurations and were later found to be very optimistic in regard to accessory package volume requirements. As greater design detail concerning the core mounted accessory package was received from G.E., it was observed that earlier studies pertaining to engine fan case and overall diameters did not provide realistic core compartment volumes to house core mounted accessories without imposing unacceptable flow restrictions in the fan exhaust ducts (DAC layout PP-SK-GEE3-006) shown as Figure C-16. Since this problem did not impact the fan case mounted accessory design, different engine case and nacelle basic diameters are shown in the final study layouts for the core mounted and fan case mounted accessory arrangements (Ref. PP-SK-GEE-007 and PP-SK-GEE3-008 shown as Figures C-17 and C-18 respectively).

DAC LAYOUT NUMBER	G.E. INPUT DATA	LAYOUT DESCRIPTION	LAYOUT PURPOSE	CONCLUSIONS
PP-SK-GEE3-001	G.E. DWG 4013237-857 DTD 5-5-78	WING MOUNTED NACELLE, 46900 LB THRUST, EXHAUST PLANE AT 29°C., CORE MTD. ACCESSORIES	INITIAL DAC ASSESSMENT OF G.E. E ³ FLIGHT INSTALLATION DESIGN	<ul style="list-style-type: none"> FAN REVERSE EXHAUST IMPINGES ON WING L.E. HIGH LIFT DEVICES.
PP-SK-GEE3-002 8-25-78	G.E. DWG 4013237-857 DTD 5-5-78	WING MOUNTED NACELLE, 46900 LB THRUST, AFT OF WING NACELLE, CORE MTD. ACCESSORIES	EVALUATE AFT OF WING LOCATION AS MEANS OF AVOIDING REVERSED THRUST EXHAUST INTERFERENCE WITH WING	<ul style="list-style-type: none"> HAS MAJOR WING FLUTTER PENALTIES INCREASES TRIM DRAG THIS APPROACH WAS ABANDONED FOR E³ STUDIES.
PP-SK-GEE3-003 9-14-78	G.E. DWG 4013237-857 DTD 5-5-78	WING MOUNTED NACELLE, 46900 LB THRUST, EXHAUST PLANE AT 29°C., FAN CASE MTD. ACCESSORIES WITH THIN METAL FAN CASE.	EVALUATE FAN CASE MOUNTED ACCESSORIES RELATIVE TO DESIGN SHOWN IN PP-SK-GEE3-001	<ul style="list-style-type: none"> INCREASES AIRPLANE DRAG (FOR 3 ENGINE A/P) 0.3% RELATIVE REFERENCE BASE CONFIGURATION
PP-SK-GEE3-004A 10-25-78	G.E. DWG 4013267-011 DTD 8-24-78	WING MOUNTED NACELLE, 46900 LB THRUST, EXHAUST PLANE AT 0°C., CORE MTD. ACCESSORIES	UPDATE DAC STUDY CONFIGURATION TO LATEST G.E. DIMENSIONS & DAC ENGINE SIZE REQ'TS-EVALUATE EXTREME FWD NACELLE TO WING POSITION	<ul style="list-style-type: none"> EXCESSIVE PYLON STRUCTURAL WEIGHT & HIGH POTENTIAL FOR WING FLUTTER PROBLEM PREDICTED FOR THIS CONFIGURATION
PP-SK-GEE3-005 10-27-78	G.E. DWG 4013267-011 DTD 8-24-78	WING MOUNTED NACELLE, 40000 LB THRUST, EXHAUST PLANE AT 0°C., FAN CASE MTD ACCESSORIES WITH THICK COMPOSITE FAN CASE	EVALUATE FAN CASE MOUNTED ACCESSORY ARRANGEMENT WITH THICK WALLED COMPOSITE FAN CASE	<ul style="list-style-type: none"> INCREASES AIRPLANE DRAG (FOR 3 ENGINE A/P) 0.7% RELATIVE TO PP-SK-GEE3-004 CONFIGURATION
PP-SK-GEE3-006 12-21-78	G.E. DWG 4013267-011 DTD 8-24-78 MODIFIED BY GE/NASA PDR OF NOV. 20 & 21	WING MOUNTED NACELLE, 40000 LB THRUST, EXHAUST PLANE AT 15°C., CORE MTD ACCESSORIES	UPDATE DAC STUDY CONFIGURATION TO LATEST G.E. ENGINE DIMENSIONS AND ACCESSORY CONFIGURATION. INTENDED AS BASELINE FOR MAINTAINABILITY STUDIES.	<ul style="list-style-type: none"> BULGE IN FAN DUCT INNER WALL REQUIRED TO CLEAR CORE MOUNTED ACCESSORIES RESULTS IN SEVERE FLOW RESTRICTION IN FAN EXHAUST DUCT
PP-SK-GEE3-007 1-23-79	G.E. DWG 4013267-011 DTD 8-24-78 MODIFIED BY GE/NASA PDR OF NOV 20 & 21	WING MOUNTED NACELLE, 40000 LB THRUST, EXHAUST PLANE AT 15°C., CORE MTD ACCESSORIES, ENLARGED FAN CASE	EVALUATE ENGINE AND NACELLE DIAMETER INCREASE REQUIRED TO PERMIT UNRESTRICTED FAN EXHAUST FLOW PAST CORE MTD ACCESSORY ARRANGEMENT SHOWN ON PP-SK-GEE3-006.	<ul style="list-style-type: none"> REQUIRES 3.2% INCREASE IN MAX. NACELLE DIA. (RELATIVE TO PP-SK-GEE3-006) TO ACCOMMODATE DESIRED FAN EXHAUST DUCT AREAS. PRESUMES AVAILABILITY OF COMBINED VSCF/ELECTRIC STARTER-LARGER NACELLE DIA. WILL BE REQUIRED IF THIS PRESUMPTION IS INVALID.
PP-SK-GEE3-008 1-31-79	G.E. DWG 4013267-011 DTD. 8-24-78 MODIFIED BY GE/NASA PDR OF NOV 20 & 21	WING MOUNTED NACELLE, 40000 LB THRUST, EXHAUST PLANE AT 15°C., FAN CASE MTD ACCESSORIES THICK COMPOSITE FAN CASE	EVALUATE FAN CASE MTD ACCESSORY ARRANGEMENT WITH MINIMUM DIAMETER FAN CASE RELATIVE TO INSTL. SHOWN ON PP-SK-GEE3-007	<ul style="list-style-type: none"> USES FAN CASE DIA (MAX NACELLE DIA) 3.24% SMALLER THAN PP-SK-GEE3-007. REQUIRES 11.0 INCH BULGE ON BOTTOM & FOR ACCESSORY PACKAGE.

Figure C-10. DAC Layouts For G.E. E³ Study

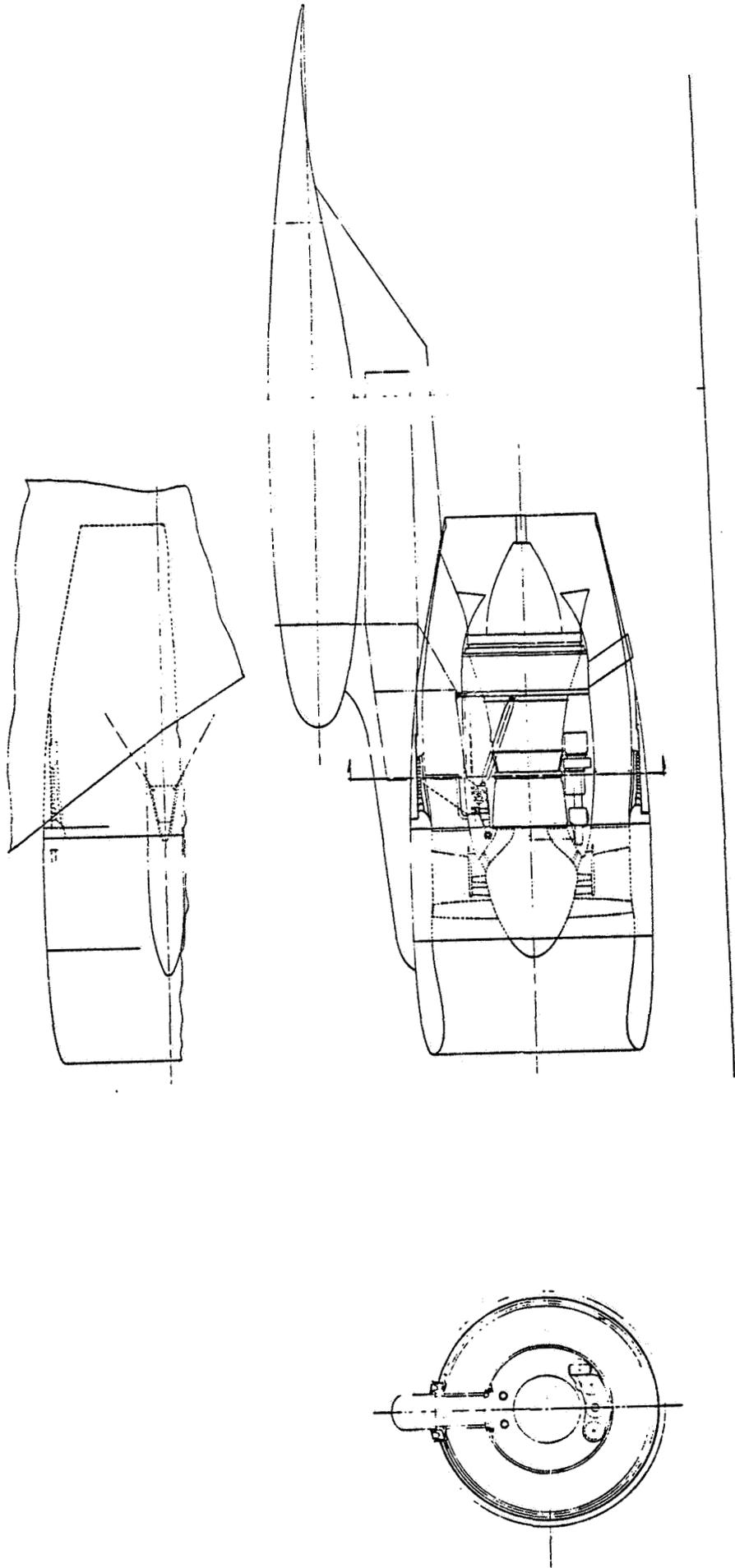


Figure C-11. Study Layout for GE E³ Engine Wing Installation.

PRECEDING PAGE BLANK NOT FILMED

FOLDDOUT FRAME

FOLDDOUT FRAME 2

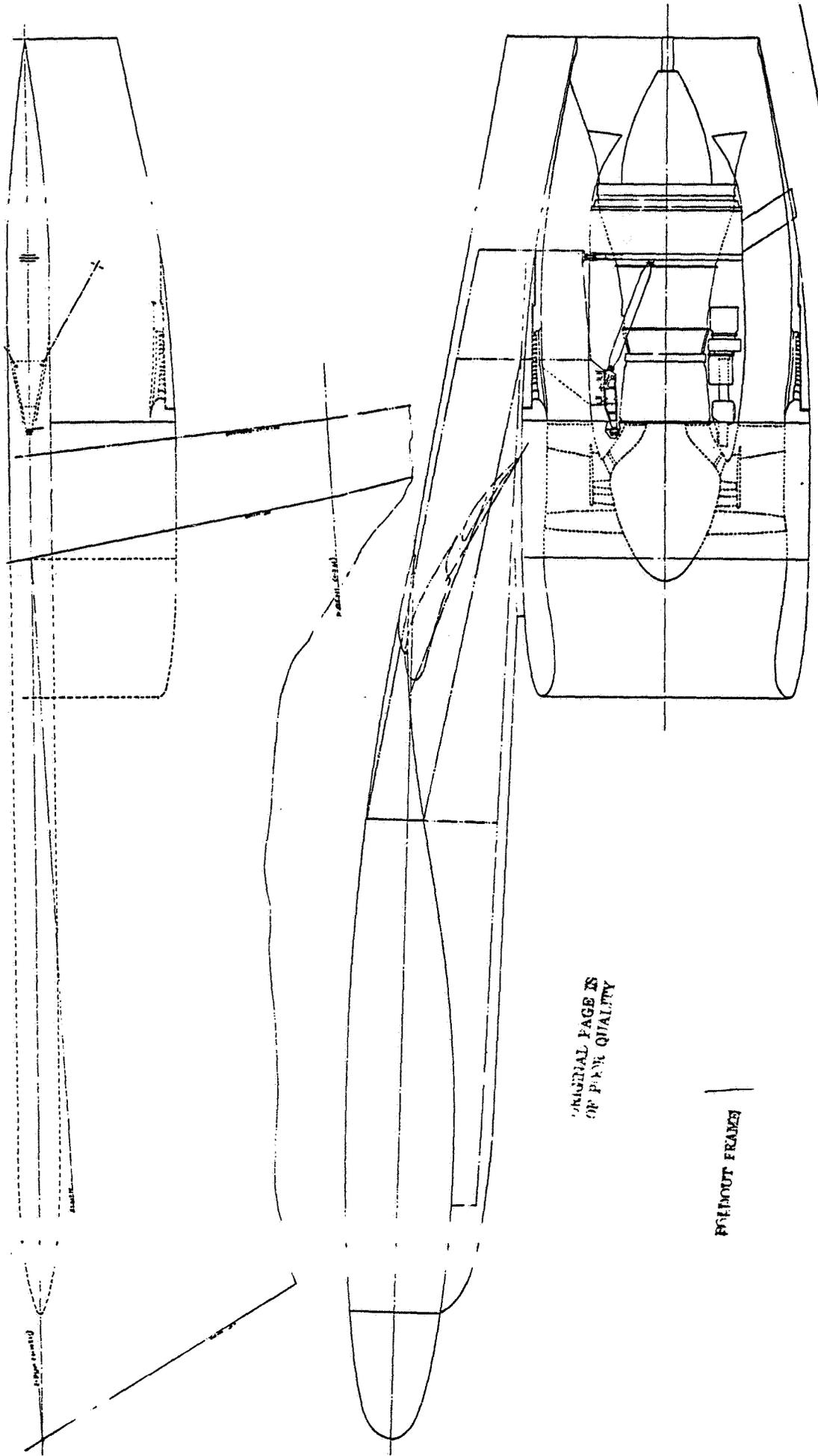


Figure C-12. Study Layout for GE E³ Engine Installation Aft of Wing Location.

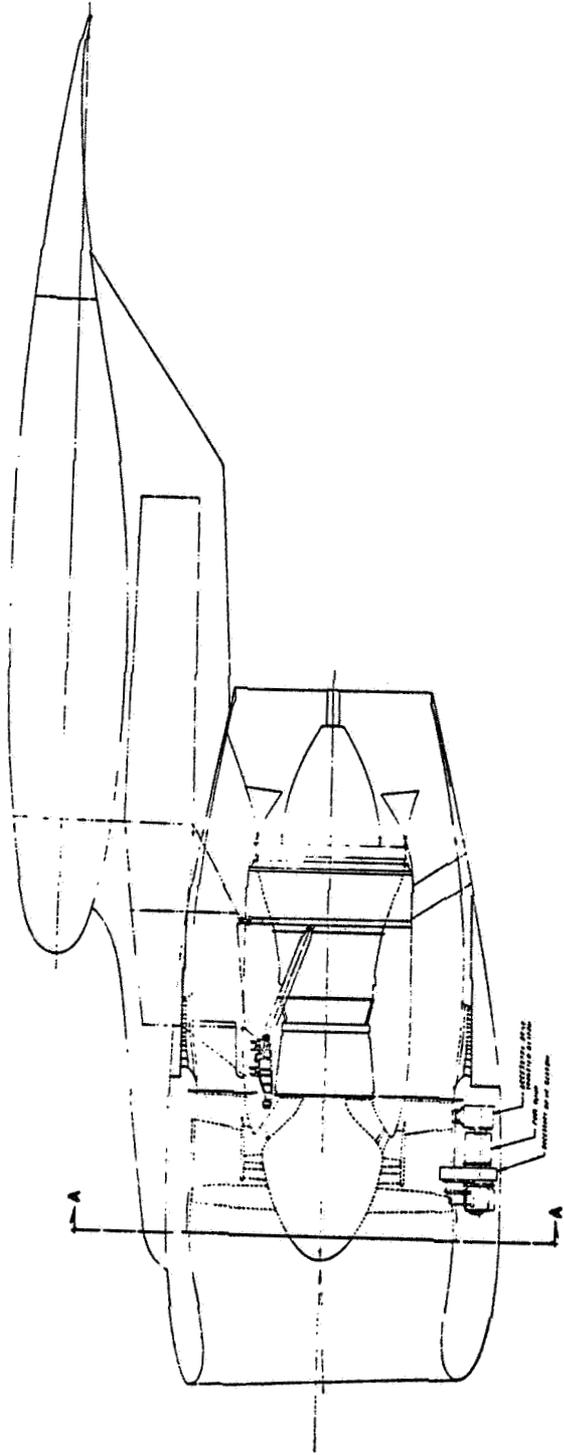
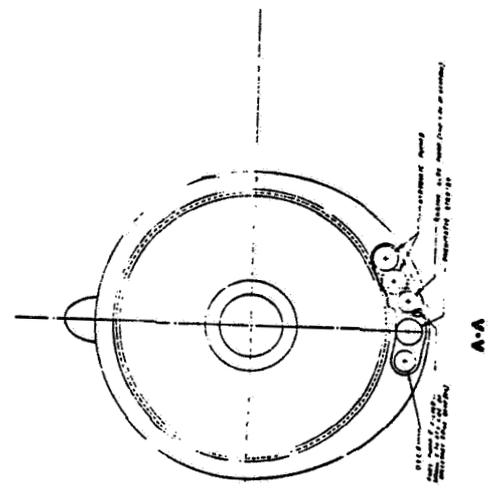


Figure C-13. Study Layout for GE E³ Engine Installation, Fan Case-Mounted Accessories.



FOLDOUT FRAME

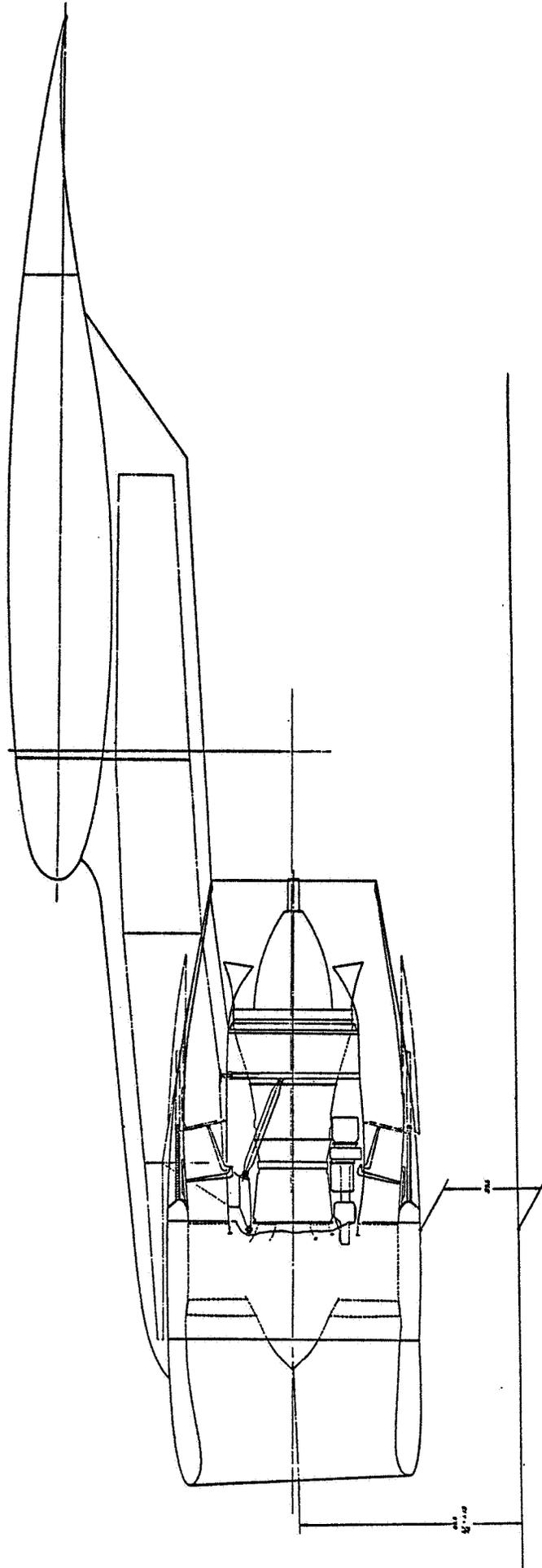


Figure C-14. Study Layout for GE E³ Engine Installation, Core-Mounted Accessories,
0% Chord Exhaust Position.

FOLDOUT FRAME 17

FOLDOUT FRAME

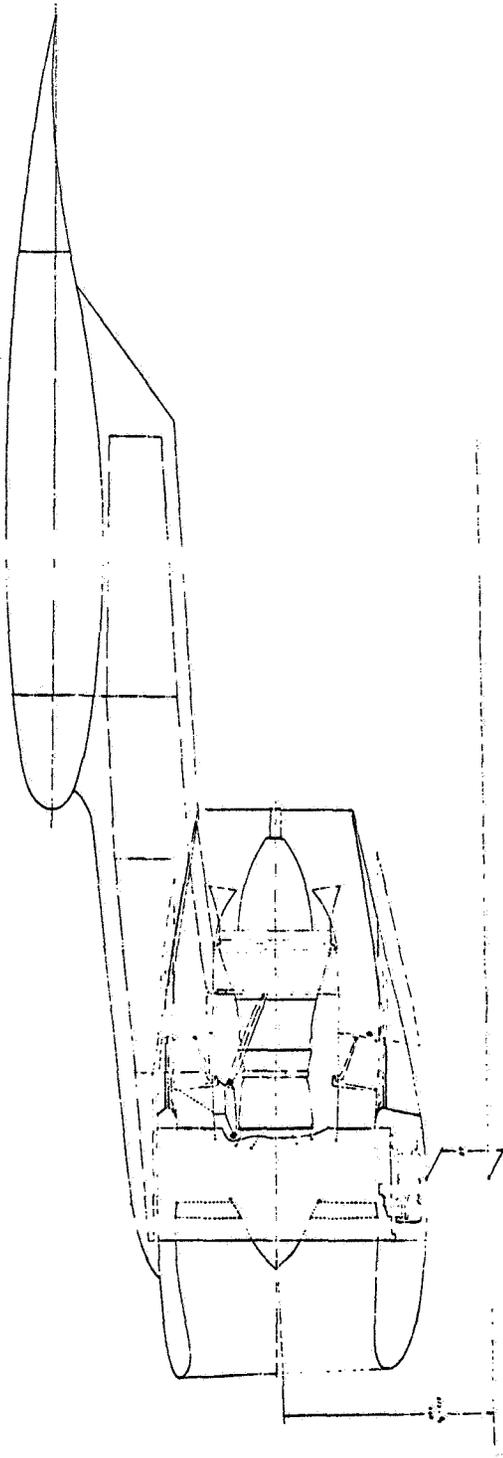
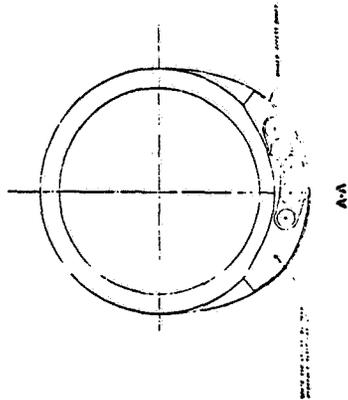


Figure C-15. Study Layout for GE E³ Engine Installation, Fan Case-Mounted Accessories, 0% Chord Exhaust Position.



ORIGINAL PAGE IS
OF POOR QUALITY

ENGINE INSTALLATION

ENGINE INSTALLATION

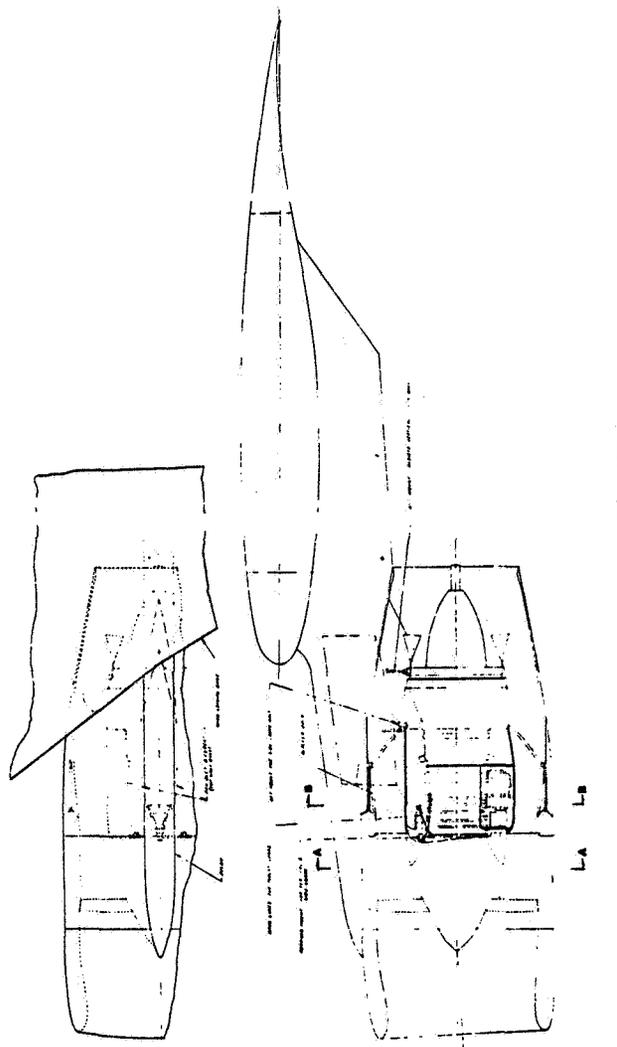
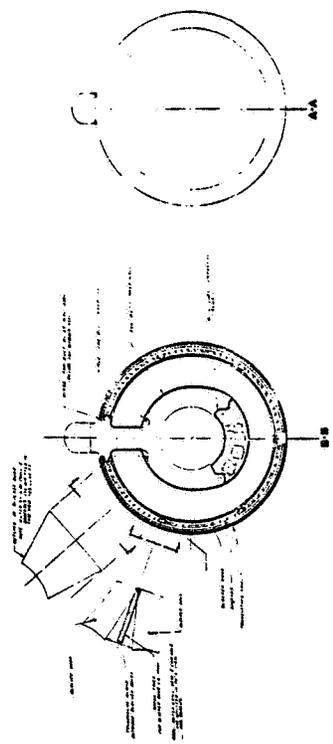
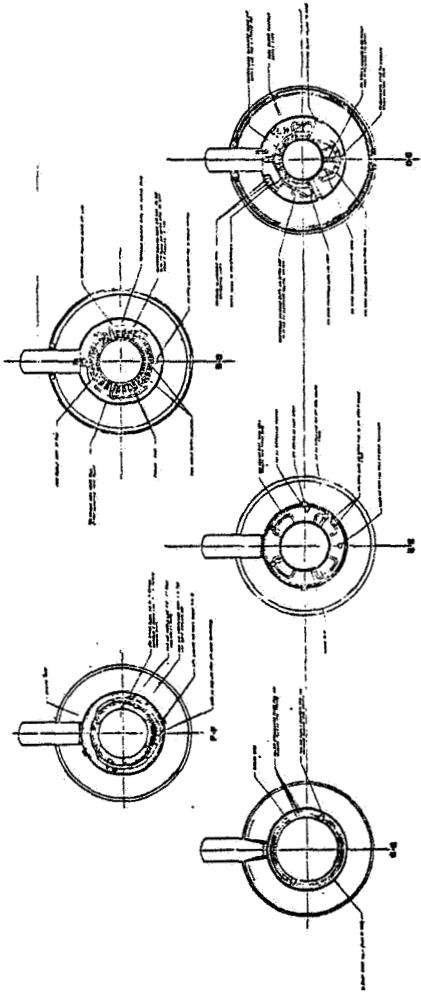
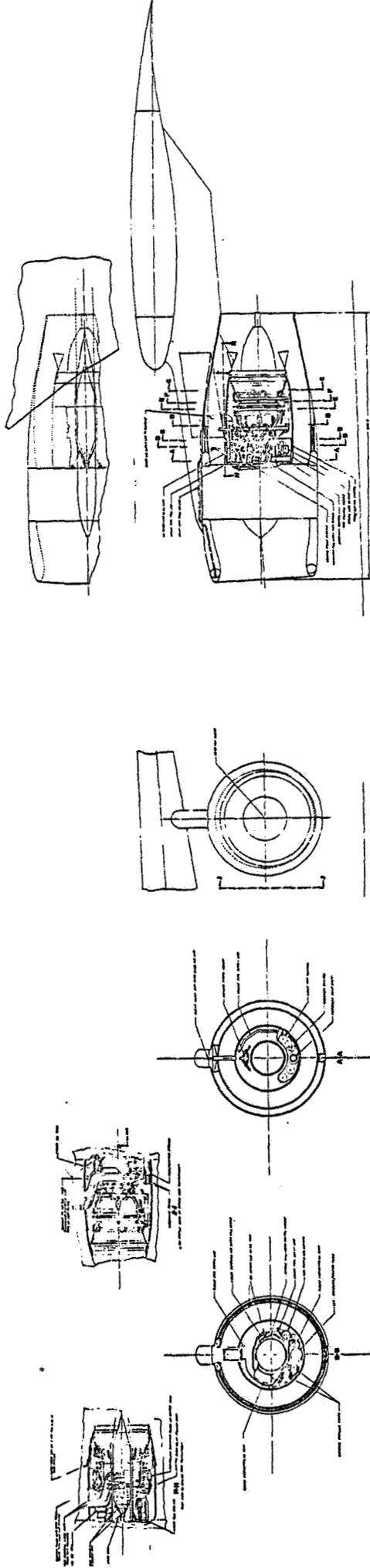


Figure C-16. Study Layout for GE F3 Engine Installation, Core-Mounted Accessories, 15% Chord Exhaust Position.



ENGINE DRAWING 2

ENGINE DRAWING 1



FOLDDOUT FRAME 2

Figure C-17. Study Layout for GE E³ Engine Installation, Core-Mounted Accessories, 108-Inch-Diameter Nacelle.

REVISED DRAWING

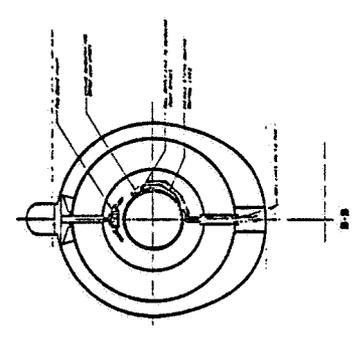
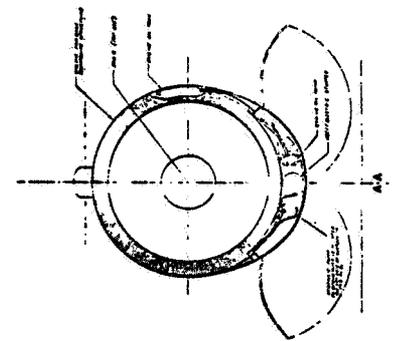
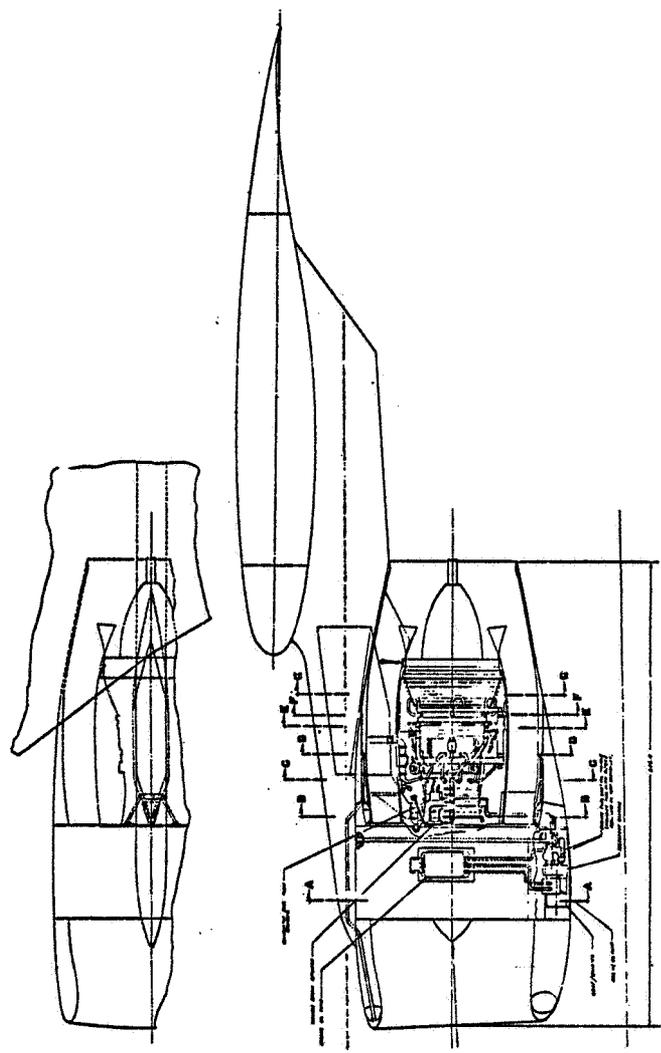


Figure C-18. Study Layout for GE F³ Engine Installation, Fan Case-Mounted Accessories, 102-Inch-Diameter Nacelle.

FOLDOUT FRAME 2

FOLDOUT FRAME

4.3.1 Final Study Configurations

The two final engine installation study layouts (Ref. PP-SK-GEE-007 and PP-SK-GEE-008) were prepared with the primary purpose of comparing the core mounted accessory design with a fan case mounted accessory arrangement. Both layouts were sufficiently detailed in regard to engine accessories and associated plumbing systems so that assessments could be made with respect to nacelle space allocations and maintainability. To serve this purpose, sufficient detail of engine and accessory plumbing and wiring runs has been shown to permit an assessment of the removal-replacement times for those engine installation components which historically have required the most frequent replacements. Since it would be impossible, within the present budget and schedule, to show all such plumbing and wiring, discretion has to be used in deciding which runs were to be shown. The rationale used, has been to show all those large diameter plumbing or cable runs which, because of their size and limited choice of location, could force the use of designs with severe penalties in accessibility to adjacent engine and accessory components. Small diameter piping and wire bundles of approximately one-half inch diameter or less can be designed with a wide latitude concerning their location and so have not been shown on the subject drawings since they should have a relatively small impact on nacelle component maintainability.

The inlet duct flow lines, primary exhaust duct flow lines and engine core configurations on both engine layouts are identical and are based on the configurations shown on G.E. drawing #4013267-011, dtd 8-24-78, scaled to 40,000 lb. thrust. For the core mounted accessory design the fan case exit diameter, the fan exhaust duct diameters and nacelle maximum outer surface diameters are greater than the corresponding values used for the fan case mounted accessory configuration. As outlined in the DAC interim E³ report (ACEE-15-TR-9735 dtd March 1979) this diametral difference was required to accommodate realistic core compartment volumes to house the accessory package without imposing unacceptable flow restrictions in the fan exhaust ducts. This difference has the net result of both study nacelles having approximately identical wetted surface area values even though the fan case mounted accessory configuration requires an accommodating bulge to the nacelle along the bottom center-line.

The plumbing systems that directly service the engine core (i.e. combustion chamber fuel supply, variable stator servo power and active tip clearance control air supply) are also essentially identical for both study layouts and are derived from information supplied in the GE/NASA PDR of Nov. 1978 and in G.E. drawing #4013270-191 dtd 2-16-79 which depicts the ICLS configuration for customer and engine service bleed air piping.

One 120 KVA electrical generator and two 35 GPM hydraulic pumps are required on each engine on the DAC E³ transport. In addition to these airframe accessories, the accessory gearbox must provide shaft power interfaces for engine oil pumping, engine fuel controls and engine starting functions. In the case of the core mounted accessory design, reasonable nacelle diameters could be maintained only by combining the airframe electric power generation and engine starting functions into one component in the form of a VSCF/electric starter unit. This is primarily due to the increased bleed air plumbing for the active tip clearance control systems and starter bleed valves which limit the accessory envelope to the core length between

the fan case support frame and the 5th stage of the high pressure compressor. With this length restriction the elimination of the air ducting to a pneumatic starter becomes one of the major advantages of the VSCF/electric starter design approach.

4.3.1.1 Core Mounted Accessory Configuration

The accessory gearbox for the core mounted accessory arrangement is shown (on drawing #PP-SK-GEE-007) smile shaped and located just aft of the fan case support bulkhead with all accessories mounted on the aft face of the gearbox. From left to right (looking aft) the accessories are mounted in the following order: fuel control module (including fuel pump and fuel/oil heat exchanger), engine oil pump, VSCF/electric starter (on engine bottom centerline in line with the gearbox input drive shaft), first hydraulic pump and second hydraulic pump. A separate N₃ tach generator is not listed above since a reading of this engine performance parameter is available from the "wild" frequency A.C. output from the VSCF. If an independent indication of N₂ speed is desired a separate Tach generator can be incorporated into the above arrangement without any notable impact on the results of this nacelle design study.

Since information regarding the required operating temperatures and heat rejection rates for the still to be designed fuel control and VSCF/electric starter units were not available, no provisions for accessory temperature controls have been shown on the subject layouts. Compartmentization of the engine accessory zone separate from the rest of the engine core compartment for ventilation purposes would force the design to a choice of either a larger nacelle diameter (with a complete rearrangement of the gearbox and component locations) or a major reduction in accessibility to both the accessories and engine core plumbing components. A more attractive approach, from the viewpoint of maximum accessibility at minimum system weight, would be to use local heat shielding to protect individual accessories from radiant heat from the engine core or bleed air ducts while directing cooling air flow onto these components from air supply ducts mounted to the inner surface of the hinged fan duct assembly. Although a quantitative assessment can not be made for this type of system without specific values for component cooling characteristics, the impact of its employment upon the nacelle lines shown on the subject layout should be minor.

A major access problem disclosed by the subject layout is at the engine core-to-pylon interface where all the engine to airframe system connections are made. Due to the G.E. nacelle concept wherein the aft edge of the hinged portion of the fan duct inner wall is 38 inches forward of the rear flange of the core case, only a 23 inch long portion of the pylon lower bulkhead is common to the engine core compartment. As shown on the layout (drawing #PP-SK-GEE3-007) considerable congestion results in this area due to the presence of the airframe-to-accessory package connections (i.e. fuel feedline, hydraulic supply lines and airframe electrical power lines) as well as the engine bleed air supply ducts to the airframe. With this arrangement, it is anticipated that a significant increase in engine removal and replacement time will result relative to the present DC-10.

4.3.1.2 Fan Case Mounted Accessory Configuration

The accessory gearbox for the fan case mounted accessory arrangement is shown (drawing #PP-SK-GEE3-008) centered below and supported by the bottom of the engine fan case. A two inch deep depression above the accessory compartment has been scalloped out of the 7 inch thick composite fan case shell to minimize the external bulge in the nacelle loft lines required to house the accessory package. Two doors, hinged to the composite fan case at the 3:30 and the 7:30 o'clock positions, and latched together along the bottom centerline form the bulged external nacelle line around the accessory compartment. The accessory gearbox is smile shaped in a manner similar to the design used for the core mounted accessory arrangement but in this case both the forward as well as the aft faces of the gearbox are employed to provide drive pads for the accessories. The engine oil pump, the VSCF/ electric starter and the No. 1 hydraulic pump are mounted to the forward face of the gearbox while the No. 2 hydraulic pump and the engine fuel control module are mounted to the aft side of the gearbox alongside of the gearbox input drive shaft. This arrangement is similar to those in use on current commercial transports and provides the minimum bulge to the basic circular nacelle cross section formed by the engine composite fan case. A second scalloped-out well in the composite fan case structure is provided on the horizontal center line on the right hand side of the engine in which is housed the engine oil tank. A metal lined trough between this well and the accessory compartment on the bottom must be provided in order to provide for the oil plumbing between the tank and the engine oil pump. The metal lining would be for the purposes of fire zoning. Similar metal lined troughs must be provided between the engine accessory compartment and the top of the fan case in order to provide fire protected routes from accessory compartment and the pylon for the engine fuel feed line and for airframe hydraulic and electric power supply connections. As shown on the study drawing, the fuel feed line would be routed on the opposite side of the fan case from the other airframe connections.

Except for the absence of the accessory package, the engine core section for this configuration has been kept identical to that for the core mounted accessory configuration. Thus, differences in maintainability costs should be strictly due to the differences in accessory package location.

4.3.2 Maintenance Cost Comparison

To compare the two engine configurations for their relative maintenance costs a review of each configuration was conducted to identify those engine installation components which were uncommon in their method of installation or accessibility. The major components so identified were: the VSCF/electric starter, the two engine driven hydraulic pumps, the engine fuel control module (includes engine fuel pump), the engine oil tank, the engine combustor fuel flow divider and the variable stator actuator. Each of these components was evaluated with respect to the manpower and elapsed time required for a removal/replacement cycle for each of the two engine configurations as shown in Tables C-XII and C-XIII. The labor requirements detailed in Table C-XII and C-XIII are broken down for each component into three categories: the labor involved in gaining access to the nacelle/engine compartment area in which the component is located (see column 2), the labor involved in any

Table C-XII. Replacement Labor Study For Core Mounted Engine Accessories

COMPONENT	ACCESS PROCEDURE	SYSTEM IMPACT DUE TO COMPONENT REMOVAL	ACCESSIBILITY COMPLICATIONS	COMPONENT TO AIRPLANE INTERFACE BREAKDOWN	COMPONENT TO REPLACEMENT LABOR SUMMARY		
					ELAPSED TIME (MIN)	NUMBER OF MEN REQUIRED	MAN HOURS
VSCF/STARTER	REQUIRES OPENING OUTER AND INNER FAN DUCT DOORS (L.H. & R.H. SIDES) LABOR: 2 MEN, 20 MIN, .67 MIN-HR	1) VSCF TO ENGINE GEARBOX OIL LEAK CHECK REQUIRED 2) ELECTRICAL SYSTEM CONTINUITY CHECK REQ'D.	UNIT IS ON BOTTOM & OF ENGINE CORE AND SHOULD BE CAPABLE OF REMOVAL OF ANY OTHER COMPONENTS.	1) VSCF IS SUPPORTED FROM GEARBOX BY QUICK DISCONNECT CLAMP OR EQUIV. 2) 4 TO 7 POWER CABLES ARE ATTACHED TO THREADED TERMINAL POSTS ON VSCF 3) SMALLER WIRE CONNECTIONS FOR HIGH TEMP. WARNING AND N ₂ SPEED SENSING ARE BY MEANS OF 1 OR 2 MULTI-PIN CONNECTORS. LABOR: 2 MEN, 12 MIN, .4 MIN-HR	32	2	1.07
NO. 1 HYDRAULIC PUMP	REQUIRES OPENING OUTER AND INNER FAN DUCT DOORS (R.H. SIDE ONLY) LABOR: 2 MEN, 18 MIN, .67 MIN-HR	1) LEAK CHECK AFTER REINSTALLATION	PUMP MODULE CAN BE REMOVED WITHOUT REMOVAL OF OTHER COMPONENTS	1) REMOVEABLE PUMP MODULE IS HELD TO FIXED BASE BY QUICK DISCONNECT CLAMP. FLUID CONNECTIONS TO AIRFRAME ARE MADE TO FIXED PART OF PUMP SO THAT PUMP MODULE MAY BE REPLACED WITHOUT BREAKING FLUID CONNECTIONS LABOR: 1 MAN, 4 MIN, .07 MIN-HR	22	2	0.74
NO. 2 HYDRAULIC PUMP	IDENTICAL TO NO. 1 HYD. PUMP REQUIRES OPENING OUTER AND INNER FAN DUCT DOORS (L.H. SIDE)	1) DRAIN FUEL IN LINE FROM PYLON SHUT OFF VALVE TO FUEL CONTROL & LINES FROM ENGINE CORE TO FUEL CONTROL. 2) LEAK CHECK AFTER REPLACEMENT. LABOR: 1 MAN, 5 MIN, .05 MIN-HR	ACCESS IS UNLIMITED BY OTHER ENGINE SYSTEMS. REQUIRES ADJUSTABLE HEIGHT. DOLLY TO SUPPORT COMPONENT WEIGHT DURING REMOVAL.	IDENTICAL TO NO. 1 HYD. PUMP 1) MODULE IS SUPPORTED FROM GEARBOX PAD BY QUICK DISCONNECT CLAMP. 2) APPROX. 6 FUEL LINES MUST BE DISCONNECTED. 3) 2 OIL LINES MUST BE DISCONNECTED FROM FUEL-OIL HEAT EXCHANGER 4) ONE OR MORE ELECTRICAL MULTI-PIN CONNECTORS MUST BE REMOVED LABOR: 2 MEN, 45 MIN, .80 MIN-HR	22	2	0.74
ENGINE FUEL CONTROL MODULE	REQUIRES OPENING OUTER AND INNER FAN DUCT DOORS (L.H. SIDE) LABOR: 2 MEN, 18 MIN, .67 MIN-HR				68	2	1.65

Table C-XII. Replacement Labor Study For Core Mounted Engine Accessories (Cont'd)

COMPONENT	ACCESS PROCEDURE	SYSTEM IMPACT DUE TO COMPONENT REMOVAL	ACCESSIBILITY COMPLICATIONS	COMPONENT TO AIRPLANE INTERFACE BREAKDOWN	COMPONENT REPLACEMENT LABOR SUMMARY		
					ELAPSED TIME (MIN)	NUMBER OF MEN	MAN HOURS
ENGINE OIL PUMP	REQUIRES OPENING OUTER AND INNER FAN DUCT DOORS (L.H. SIDE) LABOR: 2 MEN, 18 MIN, .67 MIN-HR	1) DRAIN OIL LINES TO PUMP 2) LEAK CHECK AFTER PUMP REPLACEMENT LABOR: 1 MAN, 5 MIN, .05 MIN-HR	PUMP CAN BE REMOVED WITHOUT DISTURBING OTHER SYSTEMS. ACCESS TO PUMP PLUMBING CONNECTIONS ARE LIMITED DUE TO PROXIMITY TO FUEL CONTROL AND ITS PLUMBING.	1) PUMP MOUNTS TO CEAR-BOX BY MEANS OF QUICK DISCONNECT CLAMP 2) 6 EXTERNAL LINES TO PUMP MUST BE DISCONNECTED LABOR: 1 MAN, 18 MIN, .30 MIN-HR	41	2	1.02
FUEL-OIL HEAT	ACCESS REQUIRES OPENING AND INNER FAN DUCT DOORS (BOTH SIDES) LABOR: 2 MEN, 20 MIN, .67 MIN-HR	1) FUEL CONTROL AND FUEL FEED LINE MUST BE DRAINED 2) OIL LINE TO OIL TANK MUST BE DRAINED. 3) INSTL. MUST BE LEAK CHECKED AFTER REINSTALLATION. LABOR: 1 MAN, 5 MIN .08 MIN-HR	ACCESS IS GOOD BUT CLEARANCE WITH 5TH STAGE BLEED DUCT IS LIMITED. ACCESS TO OIL LINE BETWEEN OIL PUMP AND HEAT EXCHANGER IS LIMITED.	1) HEAT EXCHANGER TO FUEL CONTROL IS BOLTED CONNECTION. 2) TWO OIL LINES (4 CONNECTIONS) REQUIRE REMOVAL. LABOR: 1 MAN, 13 MIN, .21 MIN-HR	38	2	.96
OIL TANK	REQUIRES OPENING OUTER AND INNER FAN DUCT DOORS (BOTH SIDES) LABOR: 2 MEN, 20 MIN, .67 MIN-HR	1) DRAIN OIL TANK 2) DRAIN OIL LINES TO TANK 3) LEAK CHECK AFTER REINSTALLATION LABOR: 1 MAN, 6 MIN, 0.1 MIN-HR	WORK STAND REQUIRED AS OIL TANK IS 9 FT ABOVE GROUND ON WING NACELLE. ACCESS IS LIMITED BY PROXIMITY OF HYDRAULIC FEED LINES AND ELECTRIC POWER CABLES.	1) TANK IS SUPPORTED FROM ENGINE CORE AT 4 ANCHOR POINTS (BOLTED CONNECTIONS) 2) 3 FLUID LINES MUST BE DISCONNECTED LABOR: 2 MEN, 10 MIN, .33 MIN-HR	34	2	1.10
COMBUSTOR FUEL SUPPLY FLOW DIVIDER	REQUIRES OPENING OUTER AND INNER FAN DUCT DOORS ON L.H. SIDE OF NACELLE LABOR: 2 MEN, 18 MIN, .60 MIN-HR	1) LEAK CHECK AFTER REINSTALLATION LABOR: 1 MAN, 5 MIN, .08 MIN-HR	REQUIRES LADDER FOR ACCESS (UNIT IS APPROX. 8 FT. ABOVE GROUND ON WING NACELLE). ACCESS TO CONNECTIONS IS MORE LIMITED THAN FOR FAN CASE MOUNTED ACCESSORY CONFIGURATION	1) UNIT IS SUPPORTED BY MOUNTING BRACKET ATTACHED TO CORE WITH THREADED ATTACHMENTS 2) 3 SHROUDED FUEL LINES CONNECTED TO UNIT. 3) ONE (OR MORE) MULTI-PIN ELEC. CONNECTORS MUST DISCONNECT AT UNIT. LABOR: 1 MAN, 18 MIN, .3 MIN-HR	41	2	0.98

Table C-XII. Replacement Labor Study For Core Mounted Engine Accessories (Concluded).

COMPONENT	ACCESS PROCEDURE	SYSTEM IMPACT DUE TO COMPONENT REMOVAL	ACCESSIBILITY COMPLICATIONS	COMPONENT TO AIRPLANE INTERFACE BREAKDOWN	COMPONENT REPLACEMENT LABOR SUMMARY		
					ELAPSED TIME (MIN)	NUMBER OF MEN	MAN HOURS
VARIABLE STATOR ACTUATOR	REQUIRES OPENING OUTER AND INNER FAN DUCT DOORS ON ONE SIDE OF NACELLE LABOR: 2 MEN, 18 MIN, .60 MIN-HR	1) LEAK CHECK AFTER REINSTALLATION	REQUIRES LADDER FOR ACCESS (UNIT IS 8 FT ABOVE GROUND ON WING NACELLE). ACCESS TO FUEL LINE CONNECTIONS IS MORE RESTRICTED THAN FOR FAN MOUNTED ACCESSORY CONFIGURATION.	1) UNIT IS ATTACHED TO MOUNTING BRACKET ON CORE WITH THREADED FASTENERS. 2) TWO SHROUDED FUEL LINES MUST BE DISCONNECTED FROM UNIT. 3) ACTUATOR ROD CONNECTED TO LINK WITH BOLTED ATTACHMENT. LABOR: 1 MAN, 10 MIN, 0.17 MIN-HR	28	2	0.77

NOTE: MAN-HOUR (MN-HR) VALUES SHOWN DO NOT NECESSARILY MATCH THE PRODUCT OF MANPOWER LOAD (NO. OF MEN REQUIRED) AND THE ELAPSED TIME VALUES SINCE MANPOWER LOAD VALUES IN EXCESS OF ONE INDICATE THE MAXIMUM NUMBER OF MEN REQUIRED AT ANY TIME DURING A TASK AND ARE NOT NECESSARILY CONTINUOUS VALUES FOR THE ENTIRE ELAPSED TIME TO ACCOMPLISH A TASK.

Table C-XIII. Replacement Labor Study For Core Mounted Engine Accessories

COMPONENT	ACCESS PROCEDURE	SYSTEM IMPACT DUE TO COMPONENT REMOVAL	ACCESSIBILITY COMPLICATIONS	COMPONENT TO AIRPLANE INTERFACE BREAKDOWN	COMPONENT TO REPLACEMENT LABOR SUMMARY		
					ELAPSED TIME (MIN)	NUMBER OF MEN	MAN HOURS
VSCF/STARTER	OPEN ACCESSORY COMPARTMENT DOORS ON BOTTOM OF FAN COWL LABOR: 2 MEN, 5 MIN, .13 MIN-HR	1) VSCF TO ENGINE GEARBOX OIL LEAK CHECK REQUIRED 2) ELECTRICAL SYSTEM CONTINUITY CHECK	UNIT IS ON BOTTOM & OF ENGINE CORE AND SHOULD BE CAPABLE OF REMOVAL WITH REMOVAL OF ANY OTHER COMPONENTS.	1) VSCF IS SUPPORTED FROM GEARBOX BY QUICK DISCONNECT CLAMP OR EQUIV. 2) 4 TO 7 POWER CABLES ARE ATTACHED TO THREADED TERMINAL POSTS. 3) SMALLER WIRE CONNECTIONS FOR HIGH TEMP. WARNING AND N ₂ SPEED SENSING ARE BY MEANS OF 1 OR 2 MULTI-PIN CONNECTORS. LABOR: 2 MEN, 12 MIN, .4 MIN-HR	17	2	0.53
NO. 1 HYDRAULIC PUMP	REQUIRES OPENING ACCESSORY COMPARTMENT DOORS ON BOTTOM OF FAN COWL LABOR: 2 MEN, 5 MIN, .13 MIN-HR	1) LEAK CHECK AFTER REINSTALLATION	PUMP MODULE CAN BE REMOVED WITHOUT REMOVAL OF OTHER COMPONENTS	1) REMOVEABLE PUMP MODULE IS HELD TO FIXED BASE BY QUICK DISCONNECT CLAMP. FLUID CONNECTIONS TO AIRFRAME ARE WITH SELF SEALING QUICK DISCONNECT COUPLINGS THAT ARE INTEGRAL WITH MECHANICAL CONNECTION OF PUMP MODULE LABOR: 1 MAN, 4 MIN, .07 MIN-HR	9	2	0.20
NO. 2 HYDRAULIC PUMP	IDENTICAL TO NO. 1 HYD. PUMP			IDENTICAL TO NO. 1 HYD. PUMP	9	2	0.20
ENGINE FUEL CONTROL MODULE	REQUIRES OPENING ACCESSORY COMPARTMENT DOORS ON BOTTOM OF FAN COWL LABOR: 2 MEN, 5 MIN, .13 MIN-HR	1) DRAIN FUEL IN LINE FROM PYLON SHUT OFF VALVE TO FUEL CONTROL & LINES FROM ENGINE CORE TO FUEL CONTROL. 2) LEAK CHECK AFTER REINSTALLATION LABOR: 1 MAN, 5 MIN, .08 MIN-HR	ACCESS IS UNRESTRICTED. REQUIRES ADJUSTABLE HEIGHT DOLLY TO SUPPORT COMPONENT WEIGHT DURING REMOVAL	1) MODULE IS SUPPORTED FROM GEARBOX BY QUICK DISCONNECT CLAMP. 2) APPROX. 6 FUEL LINES MUST BE DISCONNECTED. 3) 2 OIL LINES MUST BE DISCONNECTED AT FUEL-OIL HEAT EXCHANGER 4) ONE OR MORE MULTI-PIN ELECTRICAL CONNECTORS MUST BE REMOVED LABOR: 2 MEN, 45 MIN, .9 MIN-HR	55	2	1.11

Table C-XIII. Replacement Labor Study For Core Mounted Engine Accessories (Cont'd)

COMPONENT	ACCESS PROCEDURE	SYSTEM IMPACT DUE TO COMPONENT REMOVAL	ACCESSIBILITY COMPLICATIONS	COMPONENT TO AIRPLANE INTERFACE BREAKDOWN	COMPONENT REPLACEMENT LABOR SUMMARY		
					ELAPSED TIME (MIN)	NUMBER OF MEN	MAN HOURS
ENGINE OIL PUMP	REQUIRES OPENING ACCESSORY COMPARTMENT DOORS ON BOTTOM OF FAN COWL LABOR: 2 MEN, 5 MIN, .13 MIN-HR	1) DRAIN OIL LINES TO PUMP 2) LEAK CHECK AFTER PUMP REPLACEMENT LABOR: 1 MAN, 5 MIN, .08 MIN-HR	ACCESS IS UNRESTRICTED	1) PUMP MOUNTS TO GEARBOX BY MEANS OF QUICK DISCONNECT CLAMP 2) 6 EXTERNAL LINES TO PUMP MUST BE DISCONNECTED LABOR: 1 MAN, 15 MIN, .25 MIN-HR	25	2	.46
FUEL-OIL HEAT EXCHANGER	REQUIRES OPENING ACCESSORY COMPARTMENT DOORS ON BOTTOM OF FAN COWL LABOR: 2 MEN, 5 MIN, .13 MIN-HR	1) FUEL FEED LINE MUST BE DRAINED 2) OIL LINE TO OIL TANK MUST BE DRAINED. 3) INSTL. MUST BE CHECKED AFTER REINSTALLATION LABOR: 1 MAN, 5 MIN, .08 MIN-HR	ACCESS IS UNRESTRICTED	1) HEAT EXCHANGER TO FUEL CONTROL IS BOLTED CONNECTION. 2) TWO OIL LINES (4 CONNECTIONS) REQUIRE REMOVAL. LABOR: 1 MAN, 12 MIN, .20 MIN-HR	22	2	.41
OIL TANK	REQUIRES REMOVAL OF BOLTED ON DOOR ON SIDE OF FAN CASE LABOR: 1 MAN, 5 MIN, .08 MIN-HR	1) DRAIN OIL TANK 2) REFILL OIL LINES 3) LEAK CHECK AFTER REINSTALLATION LABOR: 1 MAN, 5 MIN, 0.8 MIN-HR	REQUIRES WORKSTAND OR LADDER FOR ACCESS	1) TANK IS SUPPORTED FROM FAN CASE BY THREADED ATTACHMENTS 2) 3 FLUID LINES MUST BE DISCONNECTED LABOR: 1 MAN, 10 MIN, .16 MIN-HR	19	2	.32
COMBUSTOR FUEL SUPPLY FLOW DIVIDER	REQUIRES OPENING OUTER AND INNER FAN DUCT DOORS ON L.H. SIDE OF NACELLE LABOR: 2 MEN, 18 MIN, .60 MIN-HR	1) LEAK CHECK AFTER REINSTALLATION LABOR: 1 MAN, 5 MIN, .08 MIN-HR	REQUIRES LADDER FOR ACCESS (UNIT IS APPROX. 8 FT. ABOVE GROUND ON WING NACELLE).	1) UNIT IS SUPPORTED BY MOUNTING BRACKET ON ENGINE CORE WITH THREADED FASTENERS 2) 3 SHROUDED FUEL LINES CONNECTED TO UNIT. 3) ONE (OR MORE) MULTIPIN ELEC. CONNECTORS UNIT. LABOR: 1 MAN, 16 MIN, .27 MIN-HR	39	2	0.95

Table C-XIII. Replacement Labor Study For Core Mounted Engine Accessories (Concluded).

COMPONENT	ACCESS PROCEDURE	SYSTEM IMPACT DUE TO COMPONENT REMOVAL	ACCESSIBILITY COMPLICATIONS	COMPONENT TO AIRPLANE INTERFACE BREAKDOWN	COMPONENT REPLACEMENT LABOR SUMMARY		
					ELAPSED TIME (MIN)	NUMBER OF MEN	MAN HOURS
VARIABLE STATOR ACTUATOR	REQUIRES OPENING OUTER AND INNER FAN DUCT DOORS ON ONE SIDE OF NACELLE LABOR: 2 MEN, 18 MIN, .60 MIN-HR	1) LEAK CHECK AFTER REINSTALLATION	REQUIRES LADDER FOR ACCESS (UNIT IS 8 FT ABOVE GROUND ON WING NACELLE).	1) UNIT IS ATTACHED TO MOUNTING BRACKET ON CORE WITH THREADED FASTENERS. 2) TWO SHROUDED FUEL LINES MUST BE DISCONNECTED FROM UNIT. 3) ACTUATOR ROD CONNECTED TO LINK WITH BOLTED ATTACHMENT. LABOR: 1 MAN, 8 MIN, 0.13 MIN-HR	26	2	0.73

NOTE: MAN-HOUR (MN-HR) VALUES SHOWN DO NOT NECESSARILY MATCH THE PRODUCT OF MANPOWER LOAD (NO. OF MEN REQUIRED) AND THE ELAPSED TIME VALUES SINCE MANPOWER LOAD VALUES IN EXCESS OF ONE INDICATE THE MAXIMUM NUMBER OF MEN REQUIRED AT ANY TIME DURING A TASK AND ARE NOT NECESSARILY CONTINUOUS VALUES FOR THE ENTIRE ELAPSED TIME TO ACCOMPLISH A TASK.

system preparation for component removal or post replacement system checkouts (see column 3), and the labor involved in physically dismounting/remounting each component to the engine (see column 5). A summary of the column 2, 3 and 5 labor factors for each component is tabulated in column 6 on each table. These totals represent the non-routine maintenance labor performed in replacing a listed component if it is suspected of being failed.

An estimate of the maintenance cost impact of the core located accessories versus the fan case location for unscheduled removals can be obtained by using the labor values in Tables C-XII and C-XIII to calculate estimated costs due to unscheduled component removals as summarized in Table C-XIV.

The labor (man hours) and elapsed time values shown in Table C-XIV are taken from Tables C-I and C-II. The labor costs were calculated by using a labor cost rate of \$11.00 per man hour to which is added a maintenance burden cost equal to 1.8 times the labor cost. The cost due to dispatch delay is taken from the costs shown in NASA Report CR-12113, Vol. II, dtd March 1973 ("An Airline Study of Advanced Technology Requirements For Advanced High Speed Commercial Transport Engines," by G. Phillip Sallee) for the DC-10 and factored by 1.4429 to adjust the amounts for inflationary effects for the 1973 to 1979 time period. This factor is based on the U.S. Department of Commerce Index for government and industry costs. The component unscheduled replacement rates are based on data accumulated by the Douglas Aircraft Company Reliability Engineering Group for similar engine installed components of the DC 10-30 aircraft for the years of 1976 and 1977. In the cases of the VSCF/electric starter and the engine combustor fuel flow divider in which there were no previous experience to go by, estimates were made on experience with engine components of similar mechanical complexity. For the core mounted accessories that are not uncommon to both engine configurations, two sets of replacement rates are shown; one set which is identical to the set supplied to cost calculations for the fan mounted accessory configuration and a second set which is 10% greater than comparable values in the first set. This second set of unscheduled replacement rates was used along with the first set in order to evaluate sensitivity in costs to the shorter life that could occur due to locating accessories in the more severe temperature environment found in the engine compartment. As shown in Table X-III, a comparison of costs for the fan mounted accessory configuration with the costs (at the accelerated replacement rate) for the core mounted accessory configuration show the later to be \$.045 greater per engine flight hour. This value is only for eight listed components and as such is probably indicative of only half of the resulting cost difference if all the affected components were to be assessed in the choice between accessory package locations. An examination of the Table C-XIV cost breakdown shows that the "cost due to dispatch delay" is the major contributor to the replacement cost total for each component. This cost is an account of increased crew wages and passenger rescheduling expenses, etc. resulting from equipment delays and is not typically counted-in as line maintenance cost in standard DOC calculations. As a result of this study, a \$0.90 per engine flight hour cost difference for the core mounted accessory location relative to the fan case location is indicated as an order of magnitude cost difference estimate for the shop and line maintenance cost due to unscheduled removals only.

Table C-XIV. Cost Comparison of Maintenance Labor Costs for Unscheduled Removals for Fan Case-Mounted Accessories Vs. Core-Mounted Accessories, General Electric E3 Engine Installation.

COMPONENT	ACCESS'Y CONFIG.	ELAPSED TIME (MINUTES)	MAN-HOURS	LABOR COST (WITH BURDEN)	COST DUE TO DISPATCH DELAY	COST OF COMPONENT REMOVAL	COMPONENT UNSCHEDULED REMOVAL RATE (NO./1000 FT-HRS)	REMOVAL COST PER 1000 FLT-HRS		
								ACCESSORY CONFIGURATION		
								FAN MTD	CORE MTD	CORE MTD ASSEY REMOVED
VSCF	FAN CORE	17	0.53	16.32	202.01	218.33	.1436	31.35	77.26	85.86
		32	1.07	32.96	505.03	537.99	.1436 .1596			
HYDRAULIC PUMP	FAN CORE	9	0.20	6.16	202.01	208.17	.2755	57.35	61.93	68.79
		22	0.74	22.79	202.01	224.80	.2755 .3060			
FUEL CONTROL	FAN CORE	55	1.11	34.19	505.03	539.22	.1536	82.82	325.85	362.13
		68	1.65	50.82	2070.63	2121.45	.1536 .1707			
OIL PUMP	FAN CORE	25	0.46	14.17	202.01	216.18	.1400	30.27	75.10	83.47
		41	1.02	31.42	505.03	536.45	.1400 .1556			
FUEL/OIL HEAT EXCHANGER	FAN CORE	22	0.41	12.63	202.01	214.64	.0059	1.27	3.15	3.53
		38	0.96	29.57	505.03	534.60	.0059 .0066			
OIL TANK	FAN CORE	19	0.32	9.86	202.01	211.87	.0801	16.97	43.17	47.96
		34	1.10	33.88	505.03	538.91	.0801 .0890			
COMBUSTOR FUEL FLOW DIVIDER	FAN CORE	39	0.95	29.26	505.03	534.29	.1500	80.14	80.28	89.22
		41	0.98	30.18	505.03	535.21	.1500 .1667			
VARIABLE STATOR CONTROL ACTUATOR	FAN CORE	26	0.73	22.48	202.01	224.49	.1500	33.67	33.86	37.63
		28	0.77	23.72	202.01	225.73	.1500 .1667			
Unscheduled Replacement Cost Total Per 1000 Ft-Hr/Eng.								\$333.84	\$700.60	\$778.59
Unscheduled Replacement Cost Total Per Ft-Hr/Eng.								\$ 0.33	\$ 0.70	\$ 0.78

ΔCost for Core Accessories vs. Fan Case Accessories (Equal Repl. Rate) = \$0.37 Per Ft. Hr. Per Engine
 ΔCost for Core Accessories (Accelerated Repl. Rate) vs. Fan Case Accessories = \$0.45 Per Ft. Hr. Per Engine

In addition to scheduled maintenance cost differences, some other considerations related to accessory location that have not been qualified are:

- 1: Effect on accessory component life.
- 2: Higher initial costs when a new nacelle/engine is introduced since the above are based on a mature installation.
- 3: Effect on engine maintenance cost because of increased teardown and build up costs
- 4: Installation cost
- 5: Installation development cost.

It is concluded that an accessory location option should be maintained pending more in depth studies.

4.4 REGENERATIVE FUEL HEAT SYSTEM STUDY

The principle incentive for a regenerative fuel heating system is to transfer unwanted heat from the bleed air supply for the airframe environmental control system to the fuel being supplied to the engine with the prospect of improving (decreasing) the engine SFC values at cruise. In addition, elimination of the fan air bleed that would otherwise be needed at cruise, should also result in an SFC reduction. A study of these potential SFC improvements on the E³ candidate airplane was conducted using the following design constraints:

1. The heat transfer loop between the bleed air and the fuel system should be through an intermediate, non toxic fluid such as water to minimize the chance of air conditioning contamination with fuel vapor.
2. Fuel temperature should not exceed 275°F.
3. Air pressure loss in water/air heat exchanger < 0.5 psi.
4. Engine bleed at entry to the environmental control system (ECS) is not to be less than 300°F. This temperature is called the ECS Set Point (ECSSP).

A schematic of the G.E. candidate system is shown in Figure C-19.

4.4.1 Design Philosophy

Figure C-19 shows an overall system schematic while a preliminary control system logic schematic is shown in Figure C-20. The system is designed to be optional. It has been found that the regenerative system can not be operated at idle descent as fuel temperatures are already close to 275°F with a conventional system due to the heat rejection from the engine oil cooler. The ECS Set Point (ECSSP) temperature is usually 440°F to facilitate hot air wing anti-icing. Without wing anti-icing, the ECSSP temperature has been chosen at 300°F. The lower the ECSSP, the greater the heat available to the regenerative system for heat transfer into the fuel supplied to the engine. The conventional system of switching from the IP bleed to engine HP compressor delivery bleed at low throttle settings is retained since the problem of ECS operation at low bleed pressures and temperatures still exist. The low throttle settings are coincident with high fuel temperatures, therefore, the regenerative system only operates with I.P. bleed air. Bypasses around the bleed/air/water and the fuel/water heat exchangers are included for those operational modes when the regenerative system is not in operation.

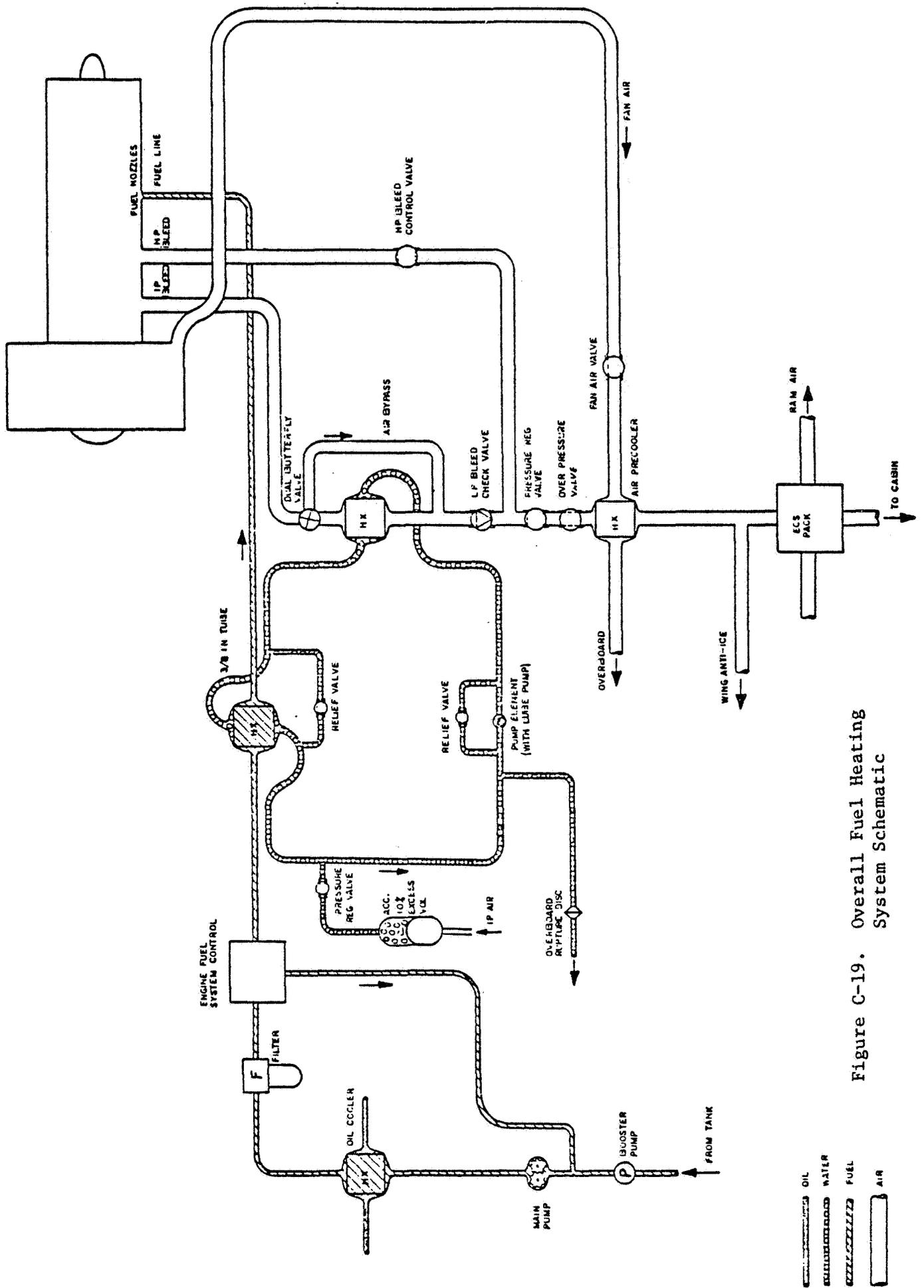


Figure C-19. Overall Fuel Heating System Schematic

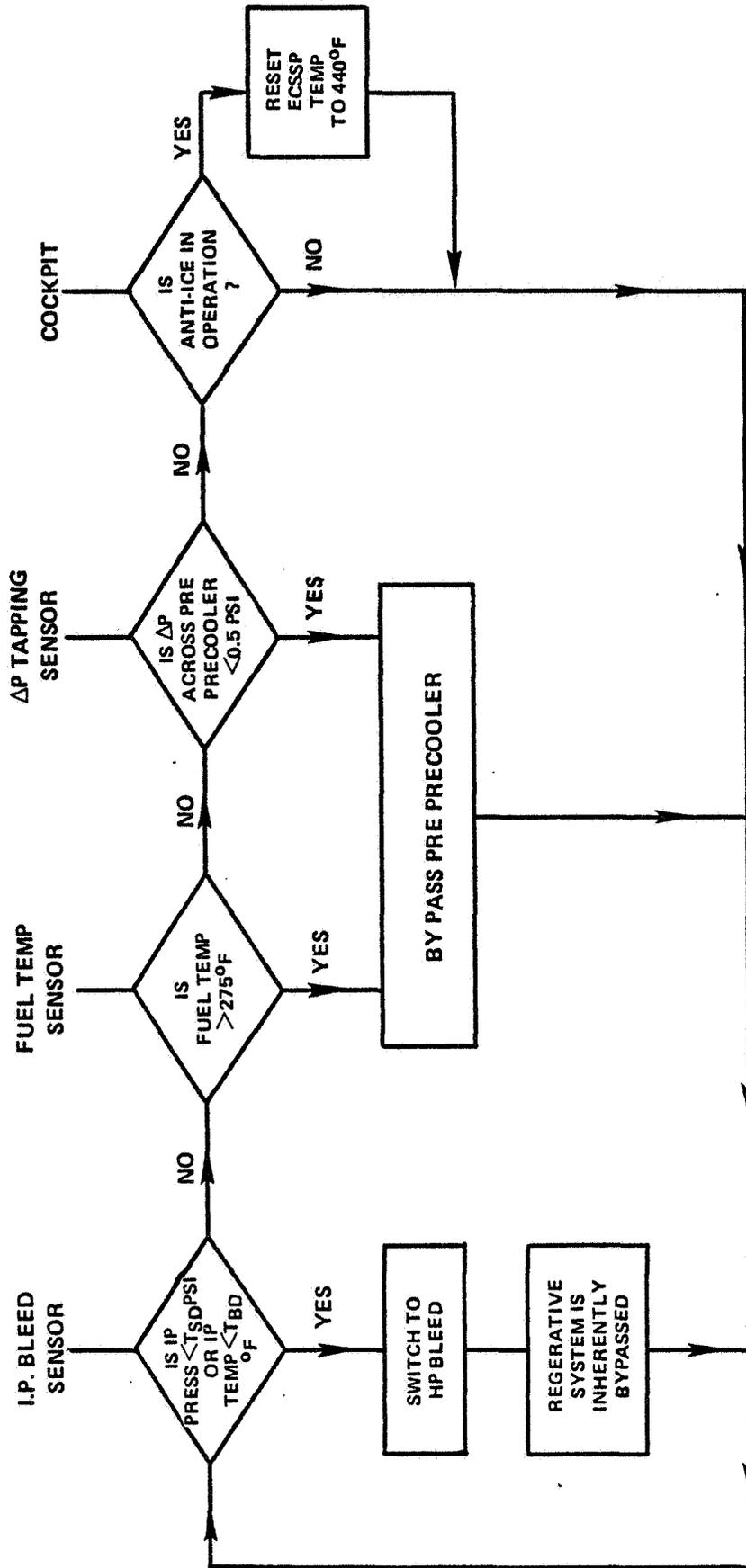


Figure C-20. Preliminary Fuel Heating System Schematic

4.4.2 Aircraft Configuration Studied

The study was concentrated on the E³ candidate aircraft sized to a minimum takeoff weight of 499,000 lb. which has 3 engines in a DC10-30 arrangement. E³ bleed quantities were estimated in proportion to the number of passengers with a recirculating ECS system designed for 55% recirculation. It was assumed that cabin bleed flows remained constant throughout a flight, and that the aircraft had one air conditioning pack per engine in operation.

4.4.3 Fuel Temperature Characteristics

Estimates for the E³ airplane oil cooler fuel outlet temperatures were made from DC10 test data. These temperatures varied according to flight condition, engine power setting, fuel tank temperature and ambient temperature. With the regenerative system operating, the permissible fuel temperature rise would be 275°F minus FOCO, where FOCO is the oil cooler fuel outlet temperature.

4.4.3.1 Descent and Start of Cruise

Engine oil cooler temperature data for a typical DC10 flight profile for a standard plus 18°F day with an initial fuel tank temperature of 120°F is shown on Figure C-21. According to this data, the oil cooler fuel outlet temperature at cruise initiation would be 218°F, while an Idle Descent condition would produce an oil outlet fuel temperature of 275°F. With this Idle Descent temperature, the regenerative system would have to be shut off to avoid exceeding the maximum fuel temperature limit (275°F). Test data for Standard Day conditions indicate that the FOCO temperature at start of cruise would be 153°F which would allow a 122°F fuel temperature rise due to regenerative system heating.

4.4.3.2 Regenerative System Operation At Cruise

Table C-XV shows the fuel temperature rise for the various options, cruise at M=0.8, 35,000 ft; ISA with a preheat FOCO of 153°F. Where the resultant fuel temperature is less than 275°F, the regenerative system would be operating continuously; to obtain optimum benefit from regenerative heating, the design aim should be to achieve 275°F fuel temperature in the cruise mode since cruise constitutes the greatest proportion of the flight profile. DC10 flight test data indicate that 6°F decrease in FOCO temperature can be expected over the duration of cruise due to cooling of the wing tank fuel temperatures. For the E³ candidate aircraft with 55% ECS recirculation, the regenerative system could be operated without interruption throughout cruise with a maximum experienced fuel temperature of 271°F.

4.4.3.3 Engine Throttling Effects

As the aircraft gets lighter during prolonged cruise, the engines are throttled back. The effect of partial cruise thrust settings on engine fuel flow and regenerative system heat input is shown in Figure C-22 while Figure C-23 shows the resultant fuel temperature as a function of % max cruise thrust. A reduction of 5% fuel flow corresponds to a 5% reduction of cruise thrust and a 40°F increase in regenerative heating fuel temperature rise will in turn be offset by the lower FOCO temperature due to wing tank cooling

STD + 18°F DAY
 +120°F INITIAL FUEL TANK TEMP

REF: DAC/GE ENGG COORD MEMO
 No. 73-40-1 DTD 3/19/70

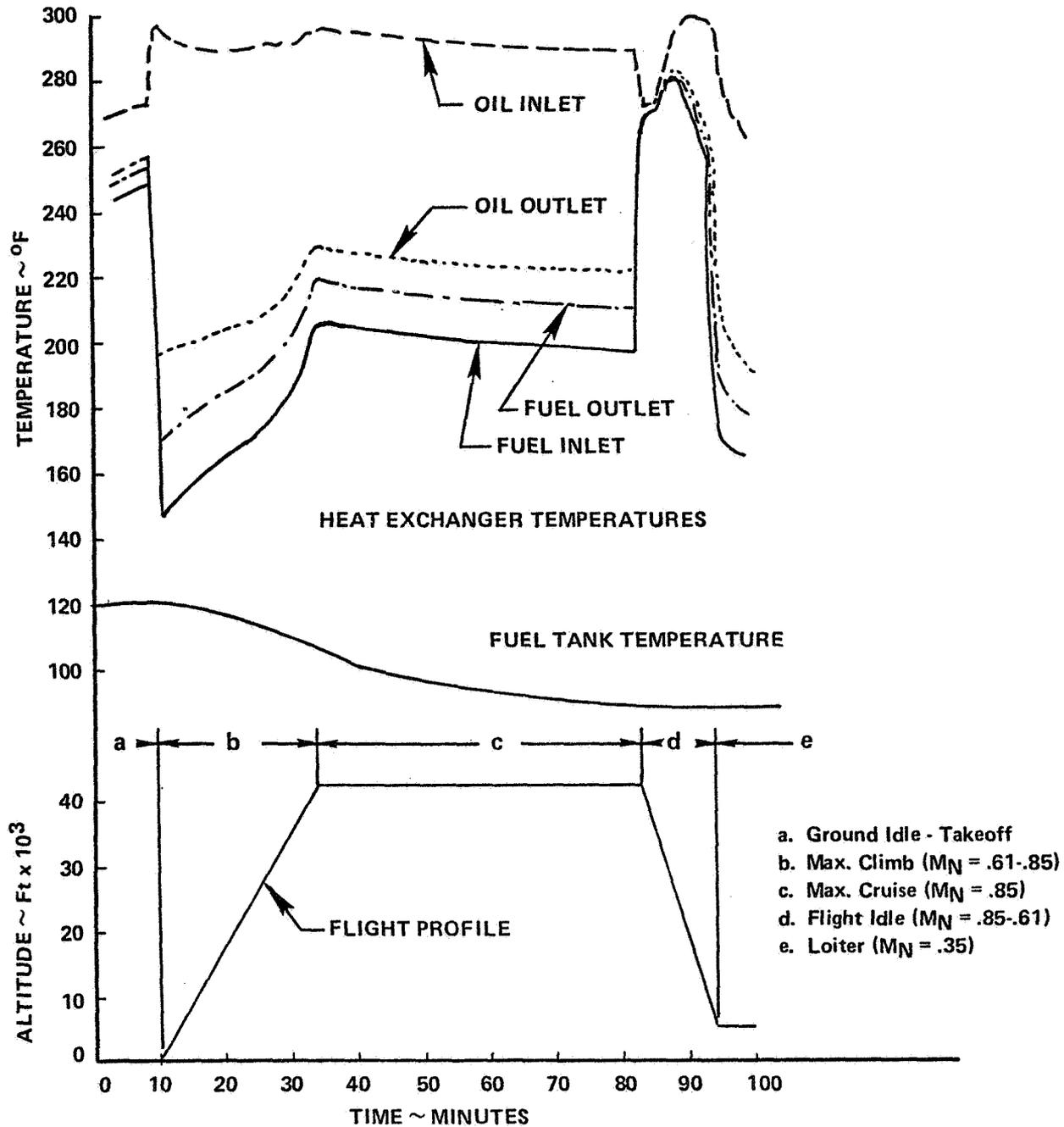
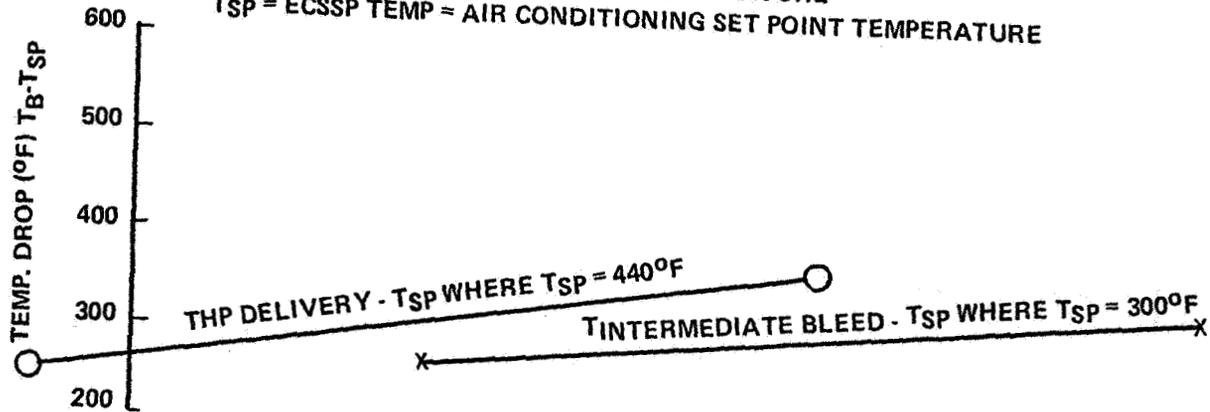


Figure C-21. Fuel/Engine Oil Temperature Profile

Table C-XV. Performance Summary For Regenerative Fuel Heating System
On DAC Candidate E³ Engine Transport

RATED TAKEOFF THRUST LB (PER ENGINE)	41360			
MAX. TAKEOFF WEIGHT LB	499000			
MAX. CRUISE FUEL FLOW PER ENG. FOR M ₀ = 0.8, 35K ALT. LB/HR	4814			
I.P. BLEED TEMP. °F	534			
H.P. BLEED TEMP. °F	860			
H.P. DELIVERY PRESS. PSIA	151			
TYPE OF AIR CONDITIONING	100% NORMAL		55% RE-CIRCULATE	
BLEED AIR FLOW PPS	3.15		1.41	
ENVIRONMENTAL CONTROL SET POINT (ECSSP TEMP) °F	440	300	440	300
FUEL TEMP. RISE DUE TO REGENERATIVE HEATING °F	151	264	68	118
ESTIMATED FUEL TEMP. AFTER PRE-HEATING °F	304	417	221	271

MTOGW = 499,000 LB
 TAKE OFF THRUST/ENGINE = 41,360 LB
 T_B = BLEED AIR TEMPERATURE
 T_{SP} = ECSSP TEMP = AIR CONDITIONING SET POINT TEMPERATURE



NOTE: IT IS ASSUMED IN THIS CALCULATION THAT CABIN BLEED FLOW REQUIREMENTS DO NOT VARY WITH THROTTLE SETTINGS

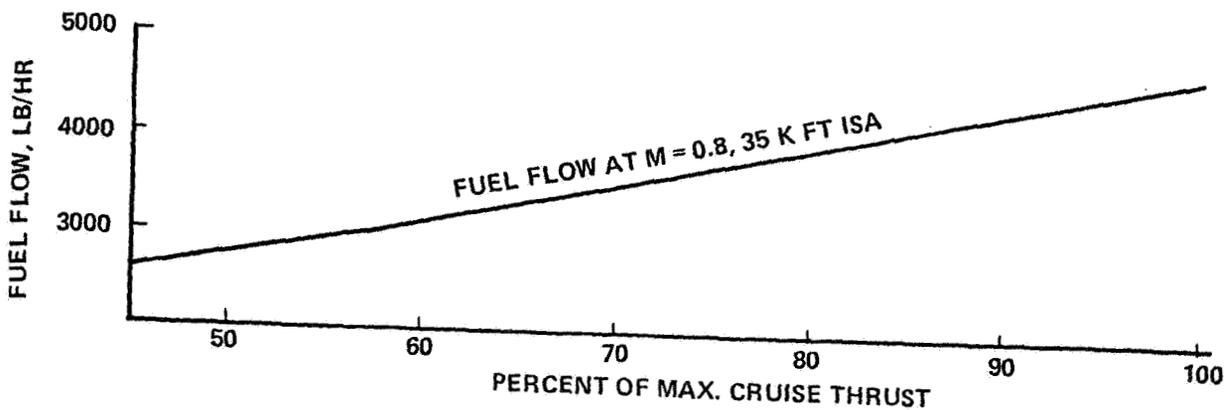
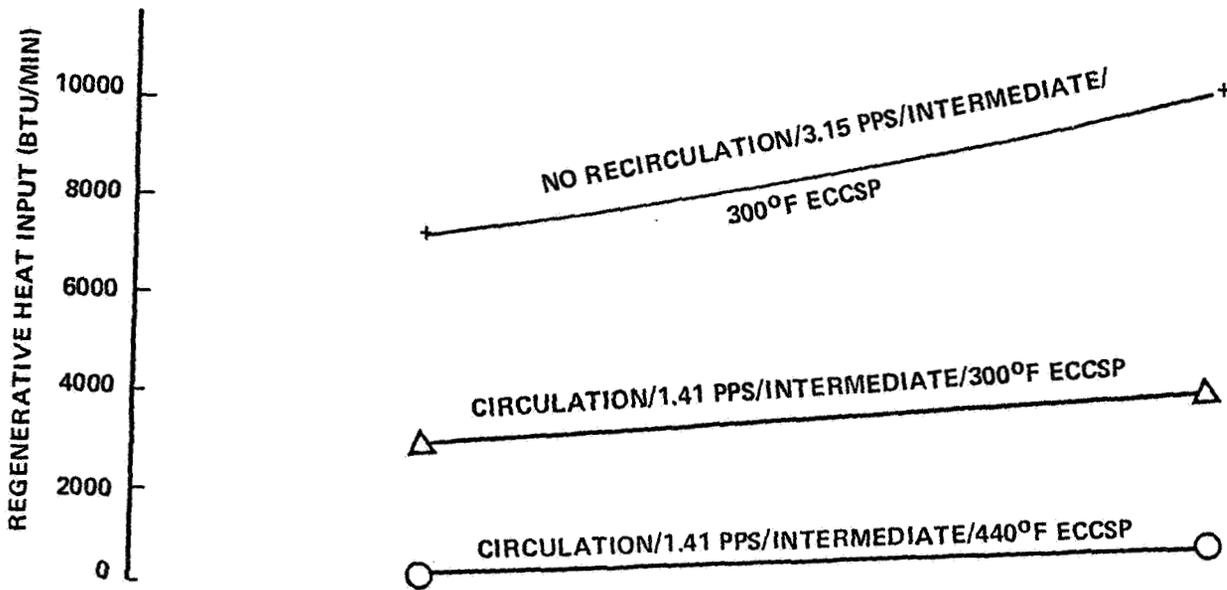
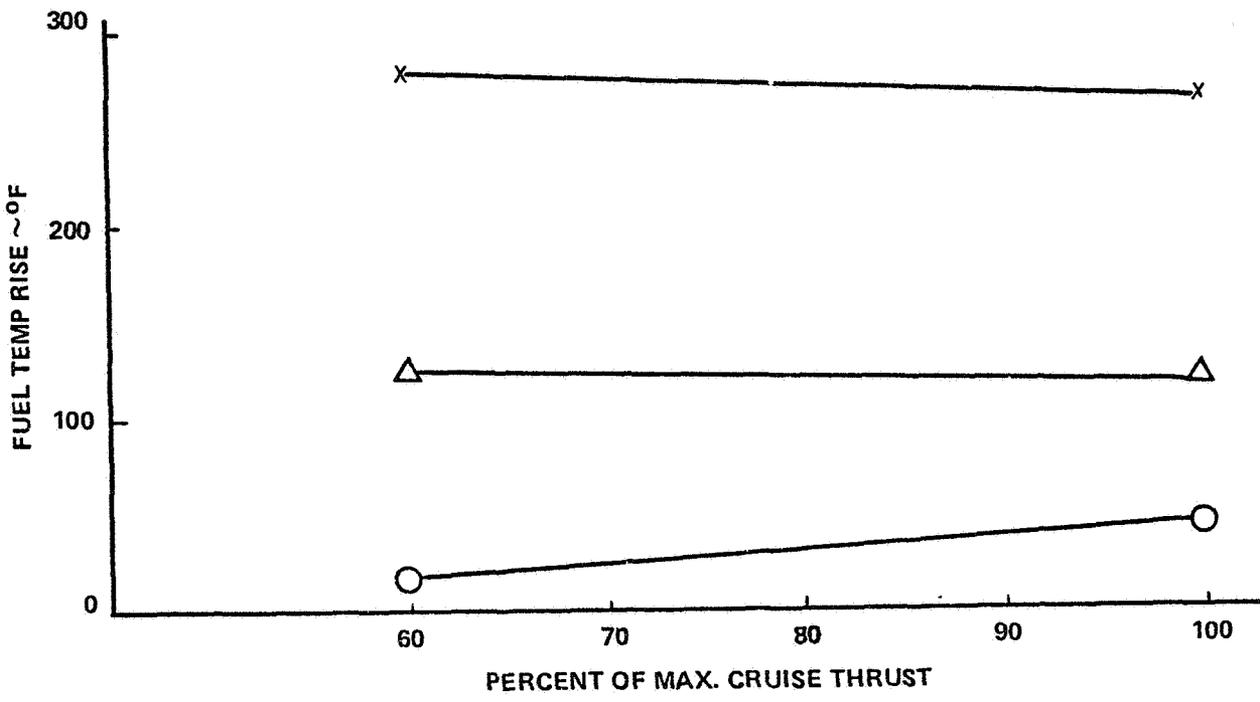
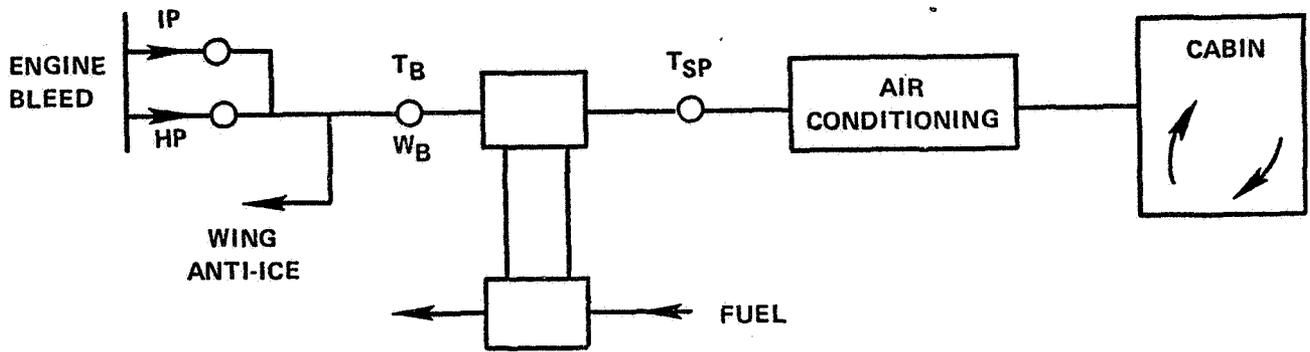


Figure C-22. Effect of Throttling Back on Fuel Flow

MTOGW = 499,000 LB
 TAKE OFF THRUST/ENGINE = 41,360 LB
 T_B = BLEED AIR TEMPERATURE
 T_{SP} = ECSSP TEMP = AIR CONDITIONING SET POINT TEMPERATURE
 W_B = ENGINE BLEED NOT INCLUDING ANTI-ICE



$$\text{FUEL TEMP RISE (°F)} = \frac{\text{HEAT INPUT (BTU/MIN)}}{\text{FUEL FLOW (LB/HR)}} \times \frac{60}{0.5}$$

Figure C-23. Effect of Throttling Back on Fuel Temperature

(described in Para. 4.4.3.2) so that the absolute value of the fuel temperature at the regenerative heater outlet will substantially remain constant over the entire range of cruise thrust settings with no change in potential SFC savings as cruise progresses.

4.4.4 Cruise SFC Savings Calculations

% SFC Saving purely due to fuel pre-heating

$$\frac{WF \times \Delta T_F \times C_{pf}}{WF \times EHV} = \frac{WB \times (T_B - T_{ECSSP}) \times C_{pb}}{WF \times EHV} - (1)$$

WB	-	Bleed Flow	LB/MIN
WF	-	Fuel Flow	LB/MIN
ΔT_F	-	Pre Heat Fuel Temp Rise	Degree F
C_{pf}	-	Specific Heat of Fuel	BTU/LB/ Degree F
C_{pb}	-	Specific Heat of Bleed Air	BTU/LB/ Degree F
EHV	-	Effective Heating Value of Fuel	BTU/LB
T_B	-	Bleed Temperature	Degree F
T_{ECSSP}	-	Environmental Control System Set Point	Degree F

FROM (1)

$$\Delta T_F = \frac{WB}{WF} \times \frac{(T_B - T_{ECSSP}) \times C_{pb}}{C_{pf}} \quad (2)$$

Examining Table 1

It must be remembered that for the E³ engine, SFC savings are possible due to three reasons:

1) DIRECTLY DUE TO IMPROVED TECHNOLOGY

A basic initial SFC improvement due to a more economical engine.

2) DIRECTLY DUE TO RECIRCULATION

Recirculation reduces cabin bleed by 55% which

- (a) reduces SFC due to reduced cabin bleed
- (b) reduces SFC due to the associated reduction in fan precooler bleed as a consequence of the reduction in intermediate bleed flow.

3) DIRECTLY DUE TO REGENERATOR

- a) the preheating fuel temp rise is greater since the fuel flow to receiver each BTU of bleed heat is reduced.
- b) the SFC reduction due to the elimination of fan precooler bleed when the regenerator operates.

This report is concerned only with the savings due to reason 3).

4.4.4 CRUISE SFC SAVINGS CALCULATIONS (Continued)

CALCULATION OF SFC SAVINGS

Savings directly due to fuel pre-heating have been estimated by ratioing the pre-heat of the fuel to a fuel effective heating value, thrust is assumed constant and a specific heat of 0.5 for the fuel was assumed, i.e. from (1)

$$\% \text{ SFC saving} = \frac{\Delta T_F \times C_{pf}}{EHV}$$

QUOTED BELOW ARE SFC SAVINGS FOR REASON (3):

(A) WITH CABIN RECIRCULATION ECSSP TEMP = 300 DEGREE F
MAX CRUISE RATING

SFC SAVING DIRECTLY DUE TO FUEL PREHEATING $\frac{118 \times 0.5}{18525} = 0.32\%$

SFC SAVING DUE TO REDUCTION IN PRECOOLER FAN BLEED WITH REGENERATOR 0.06%

IN OPERATION TOTAL SFC REDUCTION DIRECTLY DUE TO REGENERATOR 0.38%

(B) THE MAXIMUM SFC SAVING DIRECTLY DUE TO THE REGENERAOR

Assuming a FOCO of 153 degree F and a fuel temperature after the regenerator of 275 degree F, the maximum SFC saving directly due to the regenerator is:

$$\frac{122 \times 0.5}{18525} = 0.33\%$$

and 1 degree F in fuel temperture rise reduces the SFC by:

$$\frac{0.33}{122} = 0.0027\%$$

4.4.5 Regenerative Fuel Heat Study Conclusions

An SFC improvement can be gained by incorporation of the subject system on the order of 0.3% to 0.5%. The use of such a system would not permit the elimination, or reduction in size, of the bleed air precooler used in current airframe designs to limit bleed air temperatures for environmental control system use. A more detailed definition of Regenerative Fuel Heating System complexity weight and cost, referenced to specific airframe designs, is required before a final conclusion can be made regarding the desirability of such a system.