EFFECTS OF COMPRESSION, STAGING, AND BRAID ANGLE ON BRAIDED ROPE SEAL PERFORMANCE

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Background

- High temperature flexible packings have origins in several programs
  - Space Shuttle Thermal Protection System (TPS)
  - National Aerospace Plane (NASP) engine seals

Rope Seal Benefits

- High temperature operation (1500-2000 °F)
  - 500-1000 °F hotter than graphite seals
- Low leakage
- Flexible: Seals & conforms to complex geometries
  - O-ring-like flexibility
- Resilient
- Allows relative thermal growth between primary/support structures
- Field joint capability
- Hybrid design resists abrasion

CD-97-75256
High Temperature (1500 °F)

Rope Seal Test Fixture
Comparison of Hybrid Seal Braid Architecture

58° Braid Angle Hybrid

46° Braid Angle Hybrid

Core: Nextel 550
Sheath: Haynes 188
4 wires/bundle

Core: Nextel 550
Sheath: Haynes 188
10 wires/bundle
Residual Interference After Compression Cycling

![Bar chart showing residual interference for different materials](chart.png)

- All-Ceramic
- 46° Hybrid
- 58° Hybrid

All ceramic seals exhibit more residual interference
Effect of Compression, Braid, and Staging on Seal Flow
($\Delta p = 10$ psid; $T = 1300$ °F; After Scrubbing)

Hybrid Seals (1/16")

- High braid angle hybrid seal exhibited 1/2 - 1/3 the leakage of low braid angle hybrid for same linear crush, but had 6x unit pressure
- Two stage seals leaked less than single stage seals
  High braid angle/high stiffness hybrid: 30+% less
Effect of Compression, Braid, and Staging on Seal Flow

$(\Delta p = 10 \text{ psid}; T = 1300 \, {^\circ}\text{F}; \text{After Scrubbing})$

- Multiple stage seals leaked less than single stage seals
- Two stage seals: 60% less
- Three stage seals: 70% less

All Ceramic Seals (1/16"")

Linear crush, in.

Flow, SCFM/in.²
Effect of Staging on Seal Pressure Drop
Multiple Stage Seals, After Scrubbing

All Ceramic: 2 Seals
.018" Linear Crush

All Ceramic: 3 Seals
.018" Linear Crush
Three Stage Seal Durability

After Hot Scrubbing

10 cycles x 0.13" Stroke at 1300°F

Static Pressure Taps 3 Places

Seals survived accelerated seal durability cycle at temperature
P&W Turbine Vane Seal Requirements

- Operate hot
  Seal/metal temperature: 1200 °F
  Gas stream temperature: last stage vane

- Exhibit low leakage – minimize cooling requirements

- Permit relative vane-to-shroud thermal growths

- Seal complex turbine airfoil geometries

- Resist abrasion in high acoustic environment

- Maintain structural integrity
Next Generation Fighter F-22
P&W F119 Engines
Summary and Conclusions

- Increasing hybrid seal braid angle and core coverage reduced leakage 1/2 -1/3rd that of conventional hybrid for same compression but increased stiffness and unit preload

- Using multiple seals, the last stage seal always resists the largest percentage of the inlet pressure
  + Two stage seals: 1st stage resists 25%
    2nd stage resists 75%
  + Three stage seals: 1st stage resists 20%
    2nd stage resists 30%
    3rd stage resists 50%

- Multiple stage seals reduced leakage considerably
  + Hybrid seals 2 stage: 30+% reduction
  + Ceramic seals 2 stage: 60+% reduction
    3 stage: 70+% reduction

Braided Rope Seals are meeting an important need arising from increased engine cycle temperature, performance, and efficiency requirements