NASA’s In Space Manufacturing Initiative and Additive Manufacturing Development and Quality Standards Approach for Rocket Engine Space Flight Hardware

Additive Manufacturing for Defense and Aerospace 2016 Summit
March 29-30, 2016
London, United Kingdom
Agenda

•" NASA’s Journey to Mars – Where will Additive Manufacturing Contribute?
•" In Space Manufacturing Initiative (ISM)
  –" 3D Printer International Space Station Technology Demonstration Initial Results
  –" ISM Elements
  –" Additive Construction with Mobile Emplacement (ACME) and Additive Construction for Expeditionary Structures (ACES)
  –" External In-Space Manufacturing and Assembly Projects
  –" ISM Roadmap
•" Additive Manufacturing of Liquid Rocket Engine Components
  –" Additive Manufacturing Demonstrator: Liquid Propulsion System
  –" Proposed Engineering and Quality Standard for Additively Manufactured Spaceflight Hardware
  –" Additive Manufacturing Structural Integrity Initiative (AMSII)
•" Summary
Additive Manufacturing Path to Exploration

**EARTH RELIANT**

- Earth-Based Platform
  - Certification & Inspection Process
  - Design Properties Database
  - Additive Manufacturing Automation
  - In-space Recycling Technology Development
  - External In-space Manufacturing and Repair
  - AM Rocket Engine Development, Test, and Certification
  - AM for Support Systems (e.g., ECLSS) Design, Development, Test

**PROVING GROUND**

- Space-Based Platform
  - 3D Print Tech Demo
  - Additive Manufacturing Facility
  - On-demand Parts Catalogue
  - Recycling Demo
  - Printable Electronics Demo
  - In-space Metals Demo
  - AM Propulsion Systems
    - RS-25
    - Upper Stage Engine
  - Habitat Systems

**EARTH INDEPENDENT**

- Planetary Surfaces Platform
  - Additive Construction Technologies
  - Regolith Materials - Feedstock
  - AM In Space Propulsion Systems
    - Upper Stage
    - Orbiters
    - Landers
  - Habitat Systems
Additive Manufacturing

at Marshall Space Flight Center

In Space Manufacturing Initiative
A total of 21 parts were printed on ISS, including the uplinked ratchet handle. Inspection and testing of all articles included: Structured light scannings, X-ray and CT scan, microscopy, density, mechanical testing. Mechanical property differences observed between flight and ground samples. Additional ISS prints in Spring 2016 will enable additional mechanical properties data and support hypotheses evaluation. Lessons Learned have been incorporated into the next generation 3D Printer for ISS – Additive Manufacturing Facility (AMF) by Made In Space.
In-Space Manufacturing Elements

Material Characterization Database Development

- Objectives: Characterize and document any microgravity effects on printed parts and resulting mechanical properties
- Develop design-level database for microgravity applications
- Additional on-orbit prints of engineering test articles are planned with ISS (3D Printer and AMF)
- All datasets will be available through the MSFC Materials and Processes Technical Information System (MAPTIS)

On-demand ISM Utilization Catalogue Development

- Objective: Develop a catalogue of approved parts for in-space manufacturing and utilization
- Joint effort between MSFC AM M&P experts, space system designers, and JSC ISS Crew Tools Office
- Documenting on-orbit printing process with users and ISS Program (safety, human factors, etc.)
- Developing V&V/Quality Control/Certification process and process for Candidate Part inclusion in catalogue
### AMF - Additive Manufacturing Facility (SBIR Phase II-Enhancement) with Made In Space

- Commercial printer for use on ISS
- Incorporates lessons learned from 3D Printer ISS Tech Demo
- Expanded materials capabilities: ABS, ULTEM, PEEK
- Anticipated launch in Spring 2016

### In-space Recycler ISS Tech Demonstration Development (SBIR 2014)

- Objective: Recycle 3D printed parts into feedstock to help close logistics loop
- Phase I recycler developments completed by Made In Space and Tethers Unlimited
- Phase II SBIR (2014) awarded to Tethers Unlimited for the In-space Recycler for proposed ISS Technology Demonstration in FY2017

### Launch Packaging Recycling Phase I SBIR (2015)

- Objective: Recycle launch packaging materials into feedstock to help close logistics loop (3 proposals selected for award)

### In-space Printable Electronics Technology Development

- Collaborating with Xerox Palo Alto Research Center (PARC), NASA Ames Research Center, and AMRDEC
- Roadmap developed targeting ISS technology demonstration
- Printing a Radio Frequency Identification (RFID) antenna for assessment on the RFID Enabled Autonomous Logistics Management Tech Demo
- Additive ultracapacitors have been developed, tested, & patented utilizing MSFC Innovation Funds

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**Additive Manufacturing Facility**

**Tethers Unlimited SBIR to Develop ISS Recycler Tech Demo**

**3D Printed RFID Antenna, layers**

**Printed/ packaged ultracap device**
Additive Construction with Mobile Emplacement (ACME)

**Shared Vision:** Capability to print custom-designed expeditionary structures on-demand, in the field, using locally available materials.

Automated Construction of Expeditionary Structures (ACES)
Automated Construction of Expeditionary Structures (ACES)

Additive Construction with Mobile Emplacement (ACME)

Planetary Regolith-based Concrete

Candidate Binder Materials
- "Sorel-type cement (Mg0-based)
- "Sulfur cement
- "Polymers / trash
- "Portland cement

Continuous Delivery and Mixing System
- COTS Mixer
- COTS Concrete Pump
- Accumulator

Manual feed

Gantry

Materials

Dry Good Feed

Liquid Storage

Storage Subsystems

ACME 2 Nozzles

Subscale Optimized Planetary Structure

Portland Cement

Candidate Binder Materials

ACME 3 Nozzles

ACES 3 Nozzle

Guard Shack (6’ x 6’ x 8’)

Print Trials

Automated Construction of Expeditionary Structures (ACES)

Synergistic technologies for planetary and terrestrial use
Space Technology Mission Directorate’s Tipping Point Projects – Robotic In-Space Manufacturing and Assembly of Spacecraft and Space Structures

• Dragonfly: On-Orbit Robotic Installation and Reconfiguration of Large Solid RF Reflectors
  Space Systems Loral of Palo Alto, California
  Project provides the next generation of performance advancements in GEO ComSats: more apertures for greater geographic coverage variation, reconfigurable apertures for mission/fleet versatility, larger apertures for greater throughput, and mission enabling unique optics.

• Public-Private Partnership for Robotic In-Space Manufacturing and Assembly of Spacecraft and Space Structures
  Orbital ATK of Dulles, Virginia
  Project will perform an integrated ground demonstration including robotically deployed rigid backbone and welding using precision alignment.

• Versatile In-Space Robotic Precision Manufacturing and Assembly System - Made in Space, Inc. of Moffett Field, California

External In-Space Manufacturing (EISM) is a joint program between the Defense Advanced Research Projects Agency (DARPA) Tactical Technology Office and the NASA Advanced Exploration Systems (AES) Office

  Broad Area Announcement solicitation to be released in Spring 2016
# In-space Manufacturing Exploration Technology Development Roadmap

<table>
<thead>
<tr>
<th>Earth-based</th>
<th>Demos: Ground &amp; ISS</th>
<th>Exploration</th>
</tr>
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<tr>
<td>• &quot;Multiple FDM Zero-G parabolic flights (1999-2013)&quot;</td>
<td>• &quot;In-space:3D Print: First Plastic Printer on ISS Tech Demo&quot;</td>
<td>• &quot;3D Print Demo ABS Ops&quot;</td>
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<tr>
<td>• &quot;System Studies &amp; ground Tests for Multiple Materials &amp; Technologies&quot;</td>
<td>• &quot;NIAC Contour Crafting&quot;</td>
<td>• &quot;Add. Mfctr. Facility Ultem Ops (AMF)&quot;</td>
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<tr>
<td>• &quot;Verification &amp; Cert. Process development&quot;</td>
<td>• &quot;NIAC Printable Spacecraft&quot;</td>
<td>• &quot;In-space Utilization Catalogue Part Cert &amp; Testing&quot;</td>
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<tr>
<td>• &quot;Material &amp; Printer Characterization Database&quot;</td>
<td>• &quot;Small Sat in a Day&quot;</td>
<td>• &quot;Recycler Demo&quot;</td>
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<tr>
<td>• &quot;Autonomous Process Dev.&quot;</td>
<td>• &quot;AF/NASA Space-based Additive NRC Study&quot;</td>
<td>• &quot;NASA/DARPA External In-space BAA Demo&quot;</td>
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<td>• &quot;Additive Construction: Simulant Dev. &amp; Ground Demos&quot;</td>
<td>• &quot;Multiple FDM Zero-G parabolic flights (1999-2013)&quot;</td>
<td>• &quot;In-space Material Database&quot;</td>
</tr>
<tr>
<td></td>
<td>• System Studies &amp; ground Tests for Multiple Materials &amp; Technologies</td>
<td>• &quot;Future Engineer STEM Challenge(s)&quot;</td>
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* Green text indicates ISM/ISRU collaboration

**ISS Serves as a Key Exploration Test-bed for the Required Technology Maturation & Demonstrations**
Additive Manufacturing

at Marshall Space Flight Center

Advanced Manufacturing Demonstrator:
Liquid Propulsion System
Project Objectives

- Reduce the cost and schedule required for new engine development and demonstrate it through a complete development cycle.
  - Prototype an engine in less than 2.5 years.
  - Use additive manufacturing to reduce part cost, fabrication time, and overall part count.
  - Adopt Lean Development approach.
    - Focus on fundamental/quick turn analysis to reduce labor time and cost and move to first development unit
    - Get hardware into test fast so that test data can be used to influence/refine the design
- Advance the TRL of additive manufactured parts through component and engine testing.
- Develop a cost-effective prototype engine whose basic design can be used as the first development unit for an in-space propulsion class engine.
Strategic Vision for Future AM Engine Systems

**Defining the Development Philosophy of the Future**

- Integrating Design with Manufacturing
- 3D Design Models and Simulations Increase Producibility
- Transforming Manual to Automated Manufacturing
- Dramatic Reduction in Design Development, Test and Evaluation (DDT&E) Cycles

**Building Foundational Industrial Base**

- Bridging the gap between the present and future projects that are coming

**Building Experience “Smart Buyer” to enable Commercial Partners**

**Enabling & Developing Revolutionary Technology**

**Transferring “Open Rights” SLM Material Property Data & Technology to U.S. Industry**
## Game-Changing Aspects of Prototype Additive Engine

<table>
<thead>
<tr>
<th><strong>State of the Art for Typical Engine Developments</strong></th>
<th><strong>Prototype Additive Engine</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>DDT&amp;E Time</strong></td>
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</tr>
<tr>
<td>– 7-10 years</td>
<td>– 2-4 years</td>
</tr>
<tr>
<td><strong>Hardware Lead Times</strong></td>
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</tr>
<tr>
<td>– 3-6 Years</td>
<td>– 6 Months</td>
</tr>
<tr>
<td><strong>Testing</strong></td>
<td><strong>Testing</strong></td>
</tr>
<tr>
<td>– Late in the DDT&amp;E cycle</td>
<td>– Testing occurs early in the DDT&amp;E cycle</td>
</tr>
<tr>
<td><strong>Engine Cost</strong></td>
<td><strong>Prototype Cost</strong></td>
</tr>
<tr>
<td>– $20 - $50 Million</td>
<td>– $3-5 Million</td>
</tr>
<tr>
<td><strong>Applicability</strong></td>
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</tr>
<tr>
<td>– Design for particular mission by a particular contractor</td>
<td>– Provide relevant data to multiple customers (SLS, Commercial partners, other government agencies)</td>
</tr>
<tr>
<td>– Often proprietary</td>
<td>– Flexible test bed configuration can accommodate other’s hardware / design concepts</td>
</tr>
</tbody>
</table>
Reduction in Parts Count for Major Hardware

- **MOV!**
  Part Count (Approx): 1 vs. 6!

- **FTP!**
  Part Count (Approx): 22 vs. 40!

- **MCC!**

- **Injector!**
  Part Count (Approx): 6 vs. 255!

- **MFV (Hidden)!**
  Part Count (Approx): 1 vs. 5!

- **Mixer (Hidden)!**
  Part Count: 2 vs. 8!

- **OTP!**
  Part Count (Approx): 41 vs. 80!

- **OTBV!**
  Part Count (Approx): 1 vs. 5!

- **Regen Nozzle!**

- **Turbine!**

- **Discharge!**

- **Duct!**

Note: Part counts examples are for major piece parts and do not include bolts, nuts, washers, etc.
Future Outlook

Fundamental Additive Manufacturing M&P Development

- Material Properties & NDE
- Standards & Specs
- Certification Rationale

Lean & Aggressive Development Philosophy

Building Foundational Additive Manufacturing Industrial Base

Parallel & Congruent Activities

- Push
- Pull

Relevant Environment Testing

- Methane Prop. Systems
- Nuclear Propulsion
- Payloads & Satellites
- RP Engine
- MPS Components
- Upper Stage Engine
- RS-25
- CCP
- LPS Prototype Engine

RS-25

LPS Prototype Engine

Methane Prop. Systems

Nuclear Propulsion

Payloads & Satellites

RP Engine

MPS Components

Upper Stage Engine

RS-25

CCP

LPS Prototype Engine
Proposed Certification Approach for Additively Manufactured Rocket Engine Spaceflight Hardware
AM in the Human Exploration and Operations Portfolio

Exploration Systems Development
ORION and SLS

Commercial Crew Program
DRAGON V2

Requirement choices dictate how we embrace, foster, and protect the technology and its opportunities
Managing Opportunity and Risk

•" Opportunity
  –" Additive Manufacturing (AM) offers revolutionary opportunities in mechanical design innovation, cost savings, and schedule reduction

•" Risks
  –" Lack of governing requirements (M&P)
  –" Process control – how to ensure AM process is repeatable, reliable, and in control (M&P, PM)
  –" Process sensitivity :: unknown failure modes (M&P, PM)
  –" Inspection and acceptance testing (PM)
  –" Rapidly evolving technology(M&P, PM)
  –" Too easy, too cheap = ubiquitous, lack of rigor (M&P)
  –" AM related failure tarnishes the technology (M&P)

M&P = Materials and Processes Engineers  PM = Project Management
Engineering and Quality Standard for AM Spaceflight Hardware

- Tailoring
- Governing standards
- AM Design
- Part Classification
- Structural Assessment
- Fracture Control
- Qualification Testing
- Part Development Plans
- Process Controls
- Material Properties
- Finishing, Cleaning, Repair Allowances
- Part Inspection and Acceptance
Available standards will not mitigate AM part risk to a level equivalent to other processes for some time to come!

Known Unknowns needing investment:
- Unknown failure modes :: limited process history
- Open loop process, needs closure or meaningful feedback
- Feedstock specifications and controls
- Thermal processing
- Process parameter sensitivity
- Mechanical properties
- Part Cleaning
- Welding of AM materials
- AM Surface improvement strategies
- NDE of complex AM parts
- Electronic model data controls
- Equipment faults, modes of failure
- Machine calibration / maintenance
- Vendor quality approvals

Knowledge gaps exist in the basic understanding of AM Materials and Processes, creating potential for risk to certification of critical AM Hardware.
Additive Manufacturing Structural Integrity Initiative

(AMSII) Project Overview

•" Goal for Certification of AM flight hardware at NASA
  –" Implement a unified, data-driven, cross-program approach to the certification of structural AM
  spaceflight hardware.

•" AMSII Project Objectives
  –" Provide the foundational knowledge required to qualify the Selective Laser Melting (SLM)
  process for structural hardware in spaceflight applications.
  –" Validate the qualification and certification methodology presented in the MSFC draft, *Engineering
  and Quality Standard for Additively Manufactured Spaceflight Hardware*.

•" Participants
  –" ARC, GRC, LaRC, MSFC, NASA NDE Working Group (NNWG)

•" Tasks
  1." Establish feedstock controls and maximum recycle limits for Alloy 718 powder. Identify powder
  control metrics for inclusion in standard.
  2." Apply statistical process controls to powder fusion systems. Evaluate methodology at
  commercial vendors having mature SLM alloy 718 processes
  3." Derive statistically-based design allowables for SLM alloy 718 and compare with traditional A-
  basis methodology. Publish design allowables for SLM alloy 718 based on a minimum five
  powder lots.
  4." Design and build analogue engine articles to evaluate platform-to-platform variability; establish
  “first article” inspection methodology; and interrogate critical features.
  5." Characterize defect structures of SLM alloy 718 material built within and at the limits of the
  process window. Provide test articles to NNWG for NDE studies. Evaluate in-situ process
  monitoring methods to detect defects and/or build anomalies.
In-Space Manufacturing Summary

"In-space manufacturing is a critical capability needed to support NASA’s deep space exploration missions

- Increase in reliability
- Reduction in logistics burden (make it or take it)
- Recycling capabilities
- Flexibility in design

"NASA has taken the first step towards in-space manufacturing capability by successfully demonstrating 3D print technology on ISS

"The journey through development and proving ground trials is a long one

- Foundational technologies are yet to be demonstrated
- Design for repair culture needs to be embraced
- Applications need to be validated

"Additive construction offers significant potential for expeditionary structures for the Army and NASA and, in addition, commercial, humanitarian assistance and disaster relief possibilities. Excellent opportunity for demonstration of public/private partnerships."
Additive Manufacturing of Rocket Engines for Human Space Exploration Summary

"AMD-LPS is catalyst for culture change
  – "Demonstrated game changing aspects of cost and schedule reduction
  – "Dramatic reduction in Design, Development, Test and Evaluation (DDT&E) cycle time
  – "Established technology testbed for future developments

"Certification approach for additively manufactured rocket engine components developed by MSFC
  – "Center-level AM requirements released for broad review in July 2015
  – "Requirements allow innovation while managing risk
  – "Defines the expectations for engineering and quality control in developing critical AM parts

"Additive Manufacturing Structural Integrity Initiative (AMSII) is an Agency level cooperative effort designed to address foundational knowledge gaps in certification requirements to better manage AM risk