

**SUPEROXIDE CONFIGURATIONS FOR
ATMOSPHERE CONTROL SYSTEMS**

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FOREWORD

This program was initiated by the Life Support Division, Biomedical Laboratory, Aerospace Medical Research Laboratories, Wright-Patterson Air Force Base, Ohio. The effort was conducted by MSA Research Corporation, a Division of Mine Safety Appliances Company, Evans City, Pennsylvania 16033, under Contract No. AF 33(615)-2792, in support of project 6373, "Equipment for Life Support in Aerospace," task 637302, "Respiratory Support Equipment." The effort sponsored by this contract started in April 1965 and was completed in June 1966. Mr. Clemens M. Meyer of the Biotechnology Branch, Life Support Division, Aerospace Medical Research Laboratories, was the contract monitor.

This technical report has been reviewed and is approved.

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ABSTRACT

Solid superoxide forms were studied to evolve optimized configuration designs for life support of one man on 2-, 4-, 8-, 24-, and 48-hour space missions. Suitable designs were developed to generate O₂ for these missions, but CO₂ control becomes progressively more difficult as mission time decreases. Optimization for short mission configurations was gained by dynamic flow designs, preheating inlet flow streams, and use of a catalyzing agent. The evolution of available O₂ was as high as 85% for 4-hour mission configurations and as high as 98% for 24-hour missions. The superoxide configurations that have been developed are in plate form as opposed to discs since the former have more efficient O₂ generation and CO₂ absorption characteristics. This was the effect of flow orientation rather than specific shape, per se. The configurations feature rippled superoxide plates, which, when packaged, achieve a 20% increase in bulk density over granules, and a lower pressure drop, thereby minimizing fan power. Heat generated by the superoxide reaction was utilized in the following manner: the inlet flow stream was preheated by refluxing a part of the outlet flow stream with it. This technique increased performance of the inlet portion of the superoxide bed. Mass transfer correlations were developed to describe the mechanics of the reactions. Effects of humidity, reduced pressure, O₂/N₂ balance and densification of solid forms on the mass transfer behavior of the superoxide configurations are described.

Contrails

TABLE OF CONTENTS

Section No.		Page No.
I	INTRODUCTION	1
II	EXPERIMENTAL	2
III	TESTING	6
	Superoxide Forms	6
	Twenty-Four-Hour Configurations	6
	Tests With Discs	14
	Tests With Plates	15
	Eight-Hour Configurations	18
	Tests With Discs	18
	Tests With Plates	19
	Four-Hour Configurations	24
	Tests With Additives	24
	Inlet Flow Stream Preheating	27
	Two-Hour Configurations	29
	Forty-Eight-Hour Configurations	31
	Man Tests	32
	Tests With Granules	32
	Structural Tests	33
IV	DESIGN PHASE	35
	Design Coefficients	35
	Results and Correlations	38
	Applications of the Equations	50
	Configuration Recommendations	55
	Configuration Samples	58
V	CONCLUSIONS AND RECOMMENDATIONS	60
	Recommendations	61
	APPENDIX - CONFIGURATION TEST DATA	63

LIST OF FIGURES

Figure No.		Page No.
1	Flow Schematic for Configuration Tests	4
2	Disc Configuration With Circumferential Hubs	7
3	Disc Configuration With Circumferential Hubs	8
4	Disc Configuration With Circumferential Hubs	9
5	Disc Configuration With Waffle Pattern	10
6	Corrugated Plate Configurations	11
7	Rippled Plate Configurations	12
8	Diagonal Rippled Superoxide Plate Configuration	13
9	Reflux Manifold	17
10	O ₂ Generation Coefficients With KO ₂ Plates	39
11	CO ₂ Absorption Coefficients for KO ₂ Plates	40
12	O ₂ Generation Coefficients for Discs	41
13	CO ₂ Absorption Coefficients for Discs	42
14	O ₂ Generation Resistances in KO ₂ Plates	44
15	CO ₂ Absorption Resistance in KO ₂ Plate Configurations	45
16	HTU for O ₂ Generation with KO ₂ Configurations	47
17	HTU for CO ₂ Absorption With KO ₂ Configurations	48
18	Reflux Manifold	56
19	Two-Hour and Four-Hour Configuration Designs	57
20	Eight-Hour and Twenty-four-Hour Configuration Designs	59

LIST OF TABLES

Table No.		Page No.
I	Summary of Individual Plates	25
II	Data on Individual Compositions	26
III	Strength of Superoxide Forms	33

Contrails

Section I

INTRODUCTION

A potassium superoxide atmosphere control unit was developed at MSAR and has been reported in AMRL-TR-65-44*. This was a 24-hour unit which provided O₂ and absorbed CO₂ for one man. It employed solid disc-shaped superoxide forms which achieved an increase in bulk density, lower pressure drop, and less water sensitivity than traditional granular beds. This departure from the use of conventional granular-type chemicals for atmosphere control gave a new perspective on the application of these chemicals for life support.

The present work was undertaken to further encompass the performance analysis and investigation of various geometrical configurations using high density forms of sodium and potassium superoxide. The product of this work was to yield information on performance studies of configurations which would best fit a designated mission.

Tests were made and optimum configurations were selected for 2-, 4-, 8-, 24-, and 48-hour missions. Solid, non-granular forms were evaluated, granular forms being specified as not to be a part of this effort. Two modules of solid superoxide form were delivered to AMRL for subsequent evaluation.

Mechanics of control were studied. Coefficients for O₂ generation and CO₂ absorption were devised. Mass transfer numbers were calculated from experimental data generated from tests. These relations integrated with performance of the solid superoxide forms help explain configuration behavior.

The data thus generated in this program can be applied in life support design application for superoxide atmosphere control systems.

*McGoff, M.J., Potassium Superoxide Atmosphere Control Unit, AMRL-TR-65-44 (AD 624 556), Aerospace Medical Research Laboratories, Wright-Patterson AFB, Ohio, September 1965.

Section II

EXPERIMENTAL

The following criteria were followed in the development of superoxide configurations for atmosphere control of manned space chambers.

Type of System	One man chemical oxygen back up emergency life support
Mission Time	2-, 4-, 8-, 24-, and 48-hours
Metabolic Requirements	
O ₂ consumption range	22.7 to 45.4 g/hr
CO ₂ production range	22.7 to 50 g/hr
H ₂ O production range	22.7 to 45.4 g/hr
Space Assembly Atmosphere	
Total pressure	380-760 mm Hg
Atmosphere	Pure O ₂ to air O ₂ /N ₂ ratio
CO ₂ level	3.8 to 7.6 mm Hg
Temperature	24 ± 6°C
Relative humidity	50%
Others	
Weight, volume and power	Minimum
Dusting	Minimum

Other requirements were to determine influence of humidity on performance, effects of reduced pressure, O₂/N₂ ratio, water uptake and determination of the period of time that elapsed before the O₂ level is sufficient to maintain man's metabolic requirements. This latter requirement pertained to rate measurements and required that monitoring instrumentation be installed in testing each configuration.

Contrails

Configurations were tested in a sealed 3680 liter (130 cu ft) space chamber or in a sealed 212 liter (7.5 cu ft) chamber. Simulation was done with an MSAR Metabolog (man simulator). A schematic of the 3680 liter chamber and test equipment is shown in figure 1. The 212 liter chamber, not shown, was placed inside the 3680 liter chamber and was looped in stream with the simulator through the cooler and back to the simulator. The simulator uses a fuel, (acetylene) that is catalytically combusted to produce an RQ of 0.8 (RQ - volume CO₂/volume O₂). The catalytic combustion of acetylene does not generate the total water production requirement and water was added as required. Gases from the simulator were enriched with moisture by fuel consumption and water makeup. These warm gases passed through a cooler where the temperature was lowered and some water was removed to maintain humidity. The simulator consumed O₂ at the specified rate of 45 g/hr or 31.7 liters/hr (STP) and produced CO₂ at the constant rate of 50 g/hr or 25.3 liters/hr (STP). All configurations were tested at the upper specified rates, 45.4 g/hr O₂ and 50 g/hr CO₂; no simulation was done at the lower level of 22.7 g/hr O₂ and CO₂.

The space chamber was monitored by instruments to record O₂, CO₂ and humidity. These were MSA O₂ and CO₂ LIRA. Serdex and an Aminco humidity meter were used for moisture measurement. The instruments were calibrated and checked regularly to assure accurate readings. These instruments were manifolded and used to read gas concentrations in the chamber and the canister inlet and outlet streams.

Thermocouples to measure chemical bed temperatures and electrical power leads to operate fans were introduced into the space chamber through hermetically sealed plugs. Power supply for fans was available from a 28-v, dc source or a 100 watt, 115-v ac, 400-cycle inverter.

The space chamber was checked for leaks and sealed tight by a screw-type door closure before beginning the tests. Sampling lines and instrumentation were checked for leak tightness.

Most of the testing was conducted at sea level. Some of the tests were made at a reduced pressure of 1/2 atmosphere. Reduced pressure was accomplished by evacuating the chamber with a Nash vacuum pump.

Testing was confined to solid KO₂ and NaO₂ forms, although granules were used in one of the tests to characterize the properties of the KO₂. All tests were made at forced circulation conditions: no static, passive testing was done.

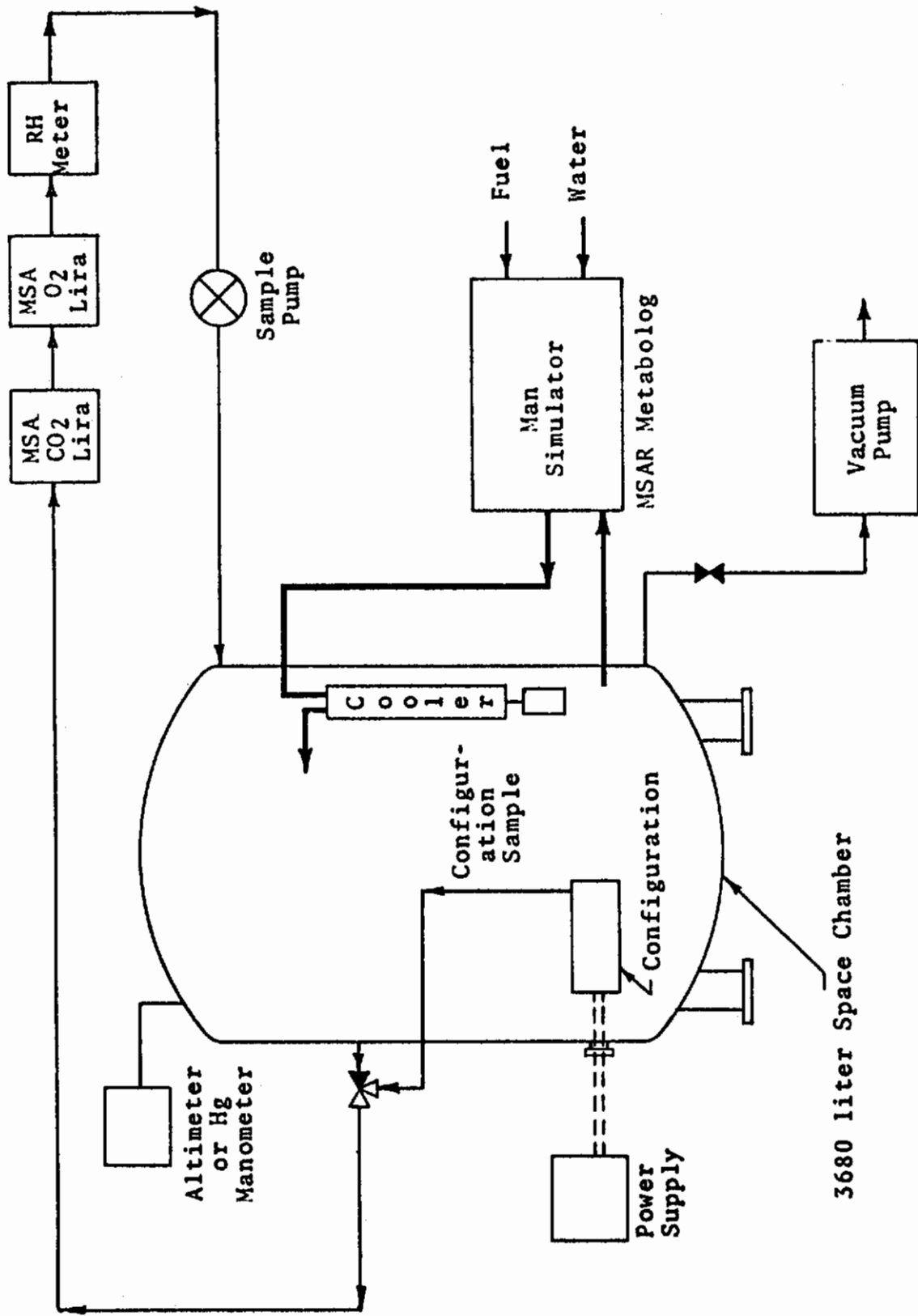


FIG. 1 - FLOW SCHEMATIC FOR CONFIGURATION TESTS

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The rates of O₂ generation and CO₂ absorption were calculated by monitoring the chamber conditions to obtain mass balances. The simulator operated at a fixed level and variations in the chamber gas concentrations reflected configuration performance. These chamber gas measurements also gave inlet conditions for the configurations since the fan drew the flow stream directly from the chamber. As mentioned previously, samples of the flow stream passing out of the configuration were analyzed and these further defined performance and moisture removing capacity of the particular designs.

Chemical and physical methods of enhancing performance were studied. Chemical methods included affects of catalyzing agents, peroxide blending with superoxides, blending of sodium and potassium superoxides, addition of CO₂ absorbing chemicals to the superoxide and water spray treatment to precondition the superoxide with a hydroxide surface. An eutectic NaO₂-KO₂ was prepared, but could not be tested in solid shapes since forming qualities were poor. Physical preparations encompassed four disc sizes and four plate designs. Molding of asbestos fibers with the superoxide to increase porosity was evaluated. Effects of flow rate, densification, geometry, and influence of temperature were primary aspects of physical investigations. Consideration was given in all designs to obtain self-supporting characteristics.

A cursory test was made on the strength of superoxide forms as a function of formation pressure. Dusting and material compatibility tests were not made since fabrication of actual atmosphere control systems was not a part of this effort. Dusting and material compatibility of superoxides was reported in AMRL-TR-65-44.

Section III

TESTING

The superoxide configurations were constructed with two basic shapes - plates and discs. Various geometries were assembled to study influences of length and flow velocities. A single configuration consisted of individual styles of plates or discs; hybrid combinations within a single package were not examined.

Superoxide Forms

Four disc sizes and three styles of plates were examined. Molds were fabricated to form fluff-type superoxide into the various shapes.

Figures 2, 3, 4, and 5 show 7 cm, 9.5 cm, 14.5 cm and 38 cm diameter size discs which were examined. The thickness of the discs was approximately 0.48 cm with the exception of the 38 cm disc, which was pressed to a thickness of 2.2 cm. A self-supporting superoxide structure was made by 1/4 in. deep saw cuts. This represented a configuration that had, in effect, cubical superoxide granules supported by a superoxide disc. The surface areas and weights for each disc are given for these designs.

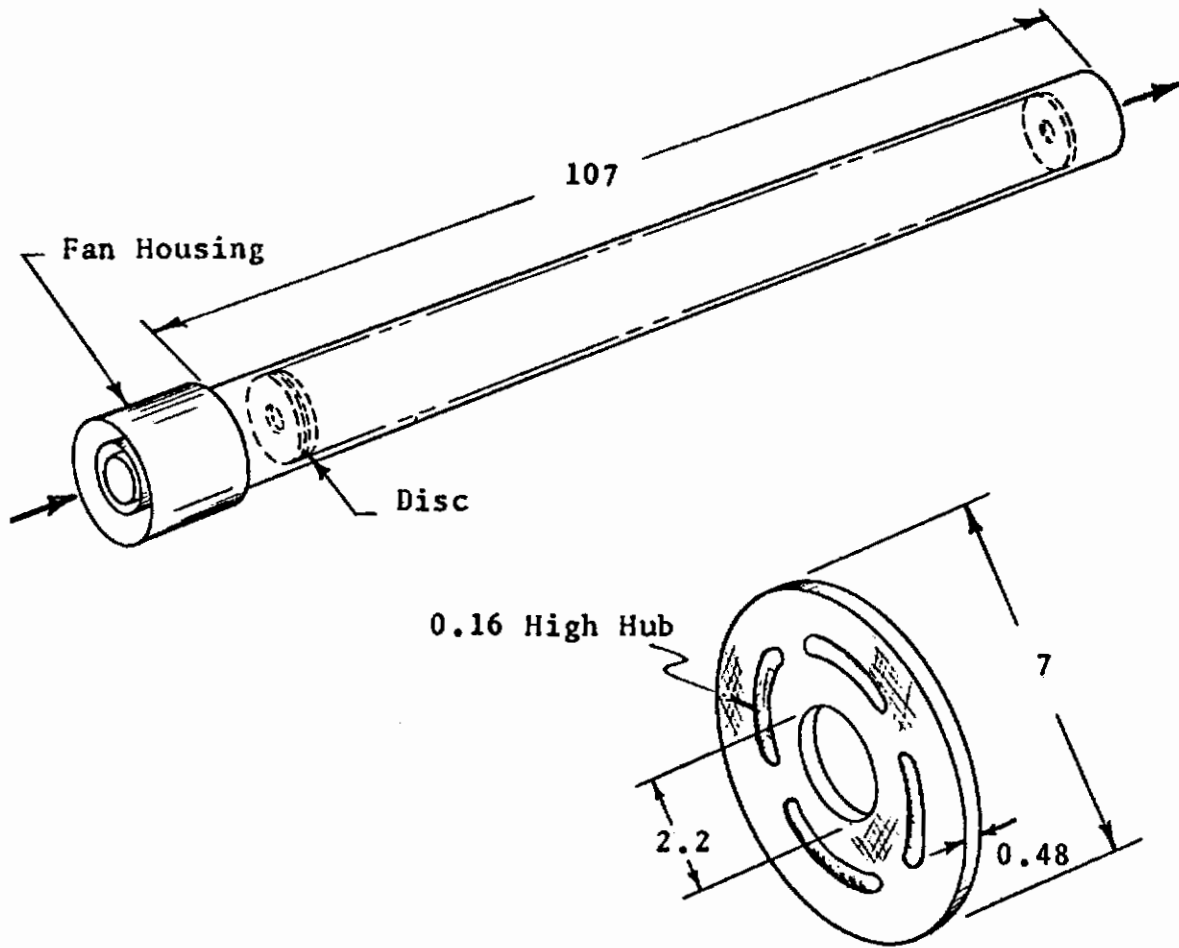
Figures 6, 7, and 8 show plate designs. Figure 6 is a corrugated pattern across the 11.4 cm length. These plates did not have uniform thickness and considerable unreacted superoxide was left within the corrugated pattern.

Figures 7 and 8 show plate configurations having uniform thicknesses. Figure 7 is a rippled style and figure 8 is a diagonal rippled pattern. The latter design afforded lateral movement of the flow stream as well as an axial flow.

Twenty-Four-Hour Configurations

A one-man 24-hour superoxide atmosphere control unit was developed which contained 110 - 9.5 cm (3-3/4 in.) KO₂ discs*. Additional investigation of the performance of disc configurations was pursued in this work to determine if improved performance could be attained by changing diameter and length (L/D ratio). Testing for all 24-hour configurations was made at the specification of 45.4 g/hr O₂ or 31.7 liters/hr (STP), 50 g/hr CO₂ or 25.3 liters/hr (STP) and 45.4 g/hr H₂O. Ideally, a 24-hour mission configuration would generate 760 liters (STP) O₂, absorb 609 liters (STP) CO₂ and remove 1090 g of water.

*McGoff, M.J., Potassium Superoxide Atmosphere Control Unit, AMRL-TR-65-44 (AD 624 556), Aerospace Medical Research Laboratories, Wright-Patterson AFB, Ohio, September 1965.

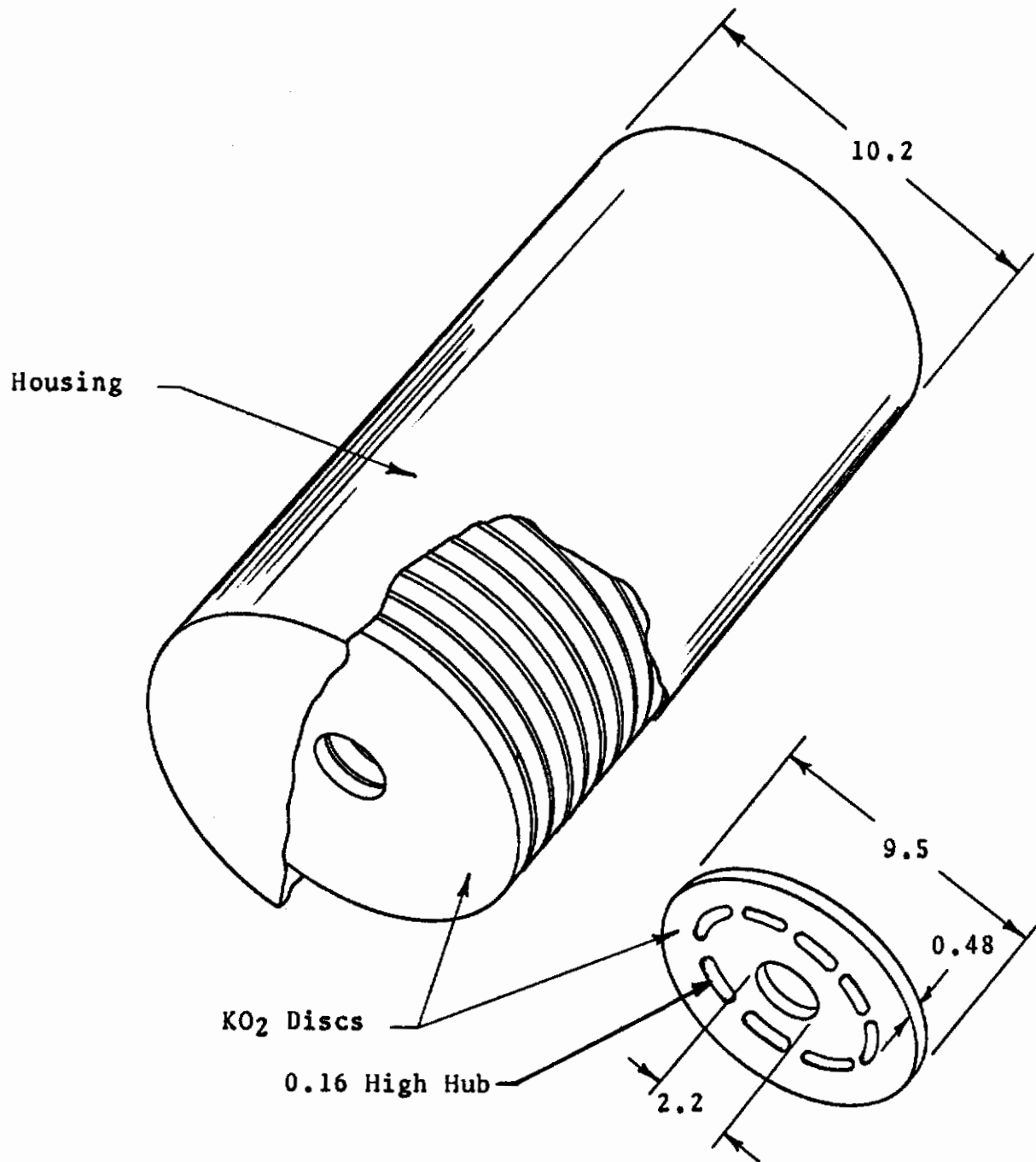


Dimensions in Centimeters

Superoxide Disc

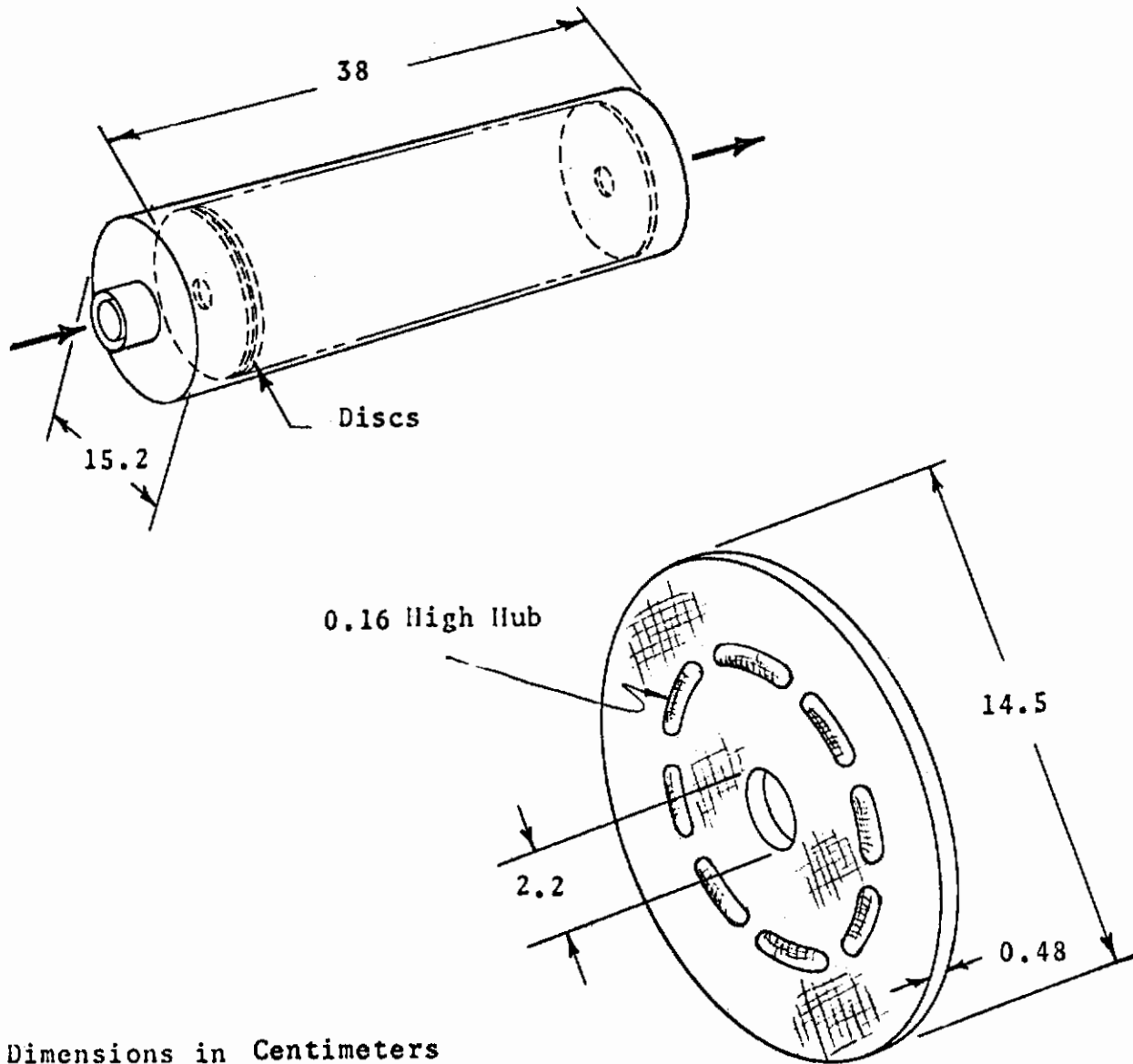
Surface Area - 90 cm²
Weight (Approx.) - 23 g

FIG. 2 - DISC CONFIGURATION WITH CIRCUMFERENTIAL HUBS



Dimensions in Centimeters

FIG. 3 - DISC CONFIGURATION WITH CIRCUMFERENTIAL HUBS

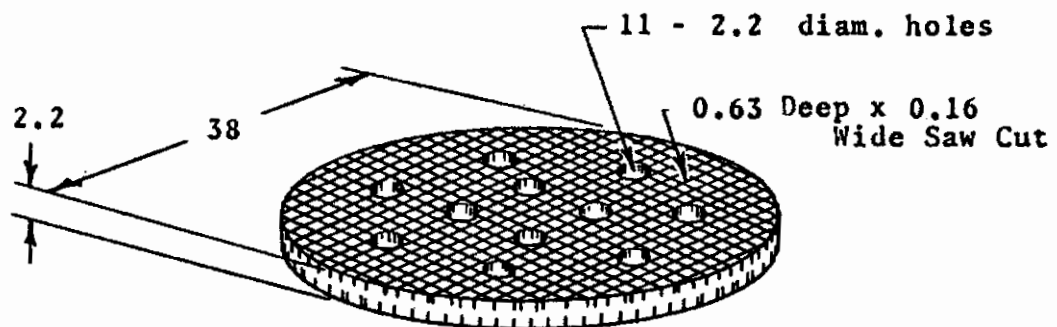
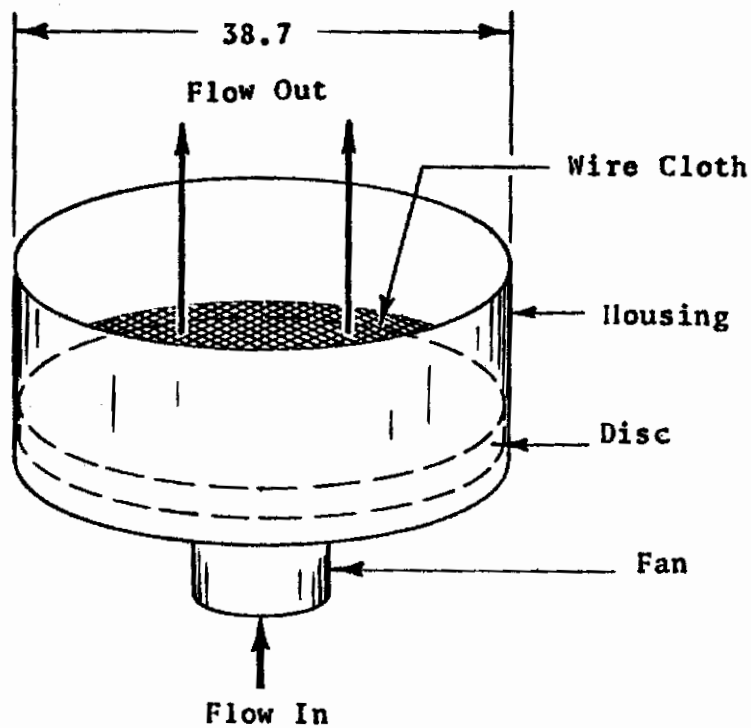


Dimensions in Centimeters

Superoxide Disc

Surface Area - 352 cm²
Weight Approx.) - 79 g

FIG. 4 - DISC CONFIGURATION WITH CIRCUMFERENTIAL HUBS

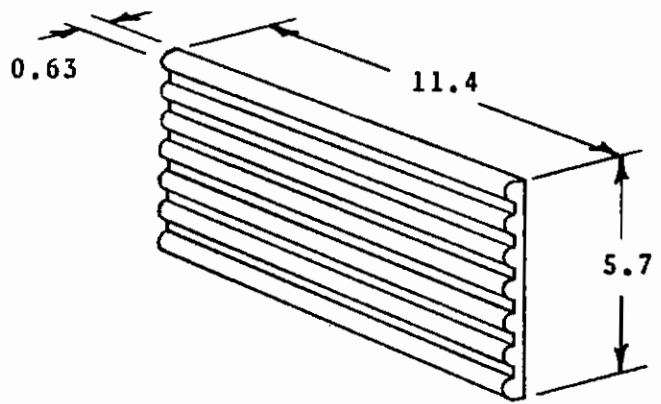
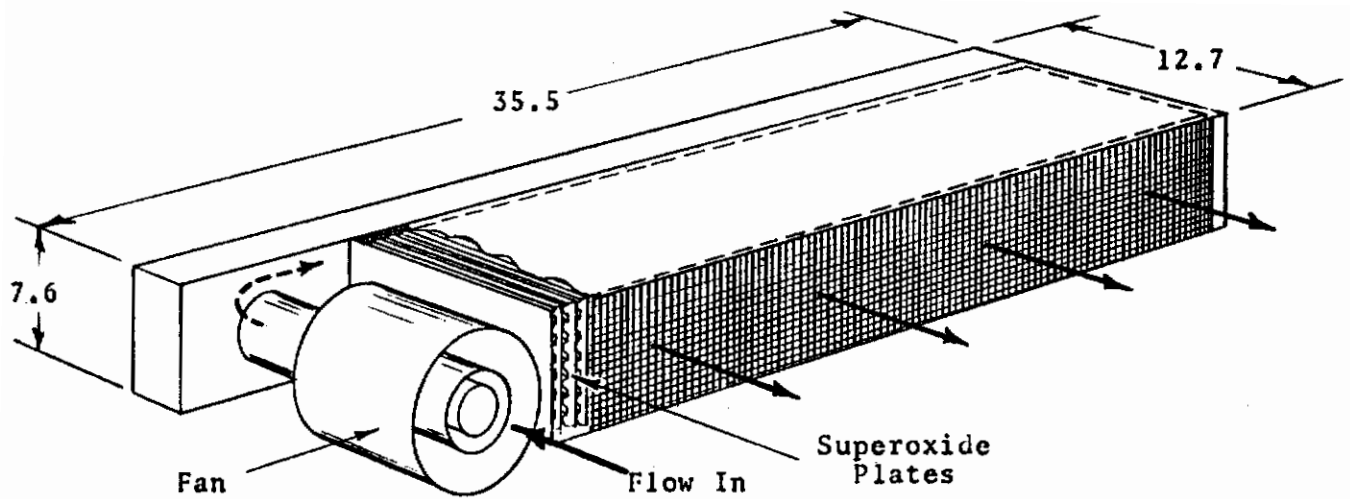


Dimensions in Centimeters

Superoxide Disc

Surface Area - 7300 cm²
Weight (Approx.) - 3300 g

FIG. 5 - DISC CONFIGURATION WITH WAFFLE PATTERN



Dimensions in Centimeters

Superoxide
Corrugated Plate

Surface Area - 190 cm²
Weight (Approx.) - 39 g (KO₂)

FIG. 6 - CORRUGATED PLATE CONFIGURATIONS

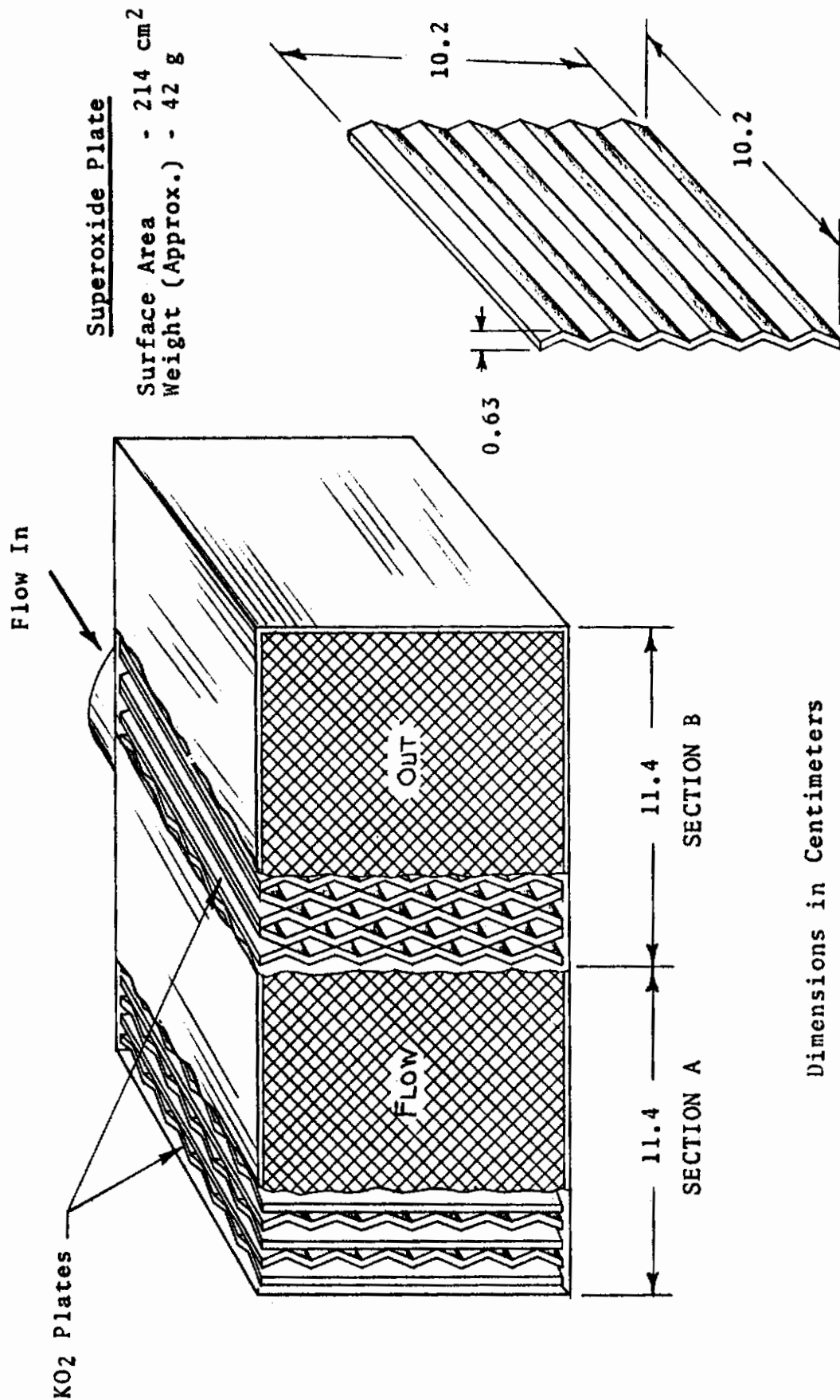


FIG. 7 - RIPPLED PLATE CONFIGURATIONS

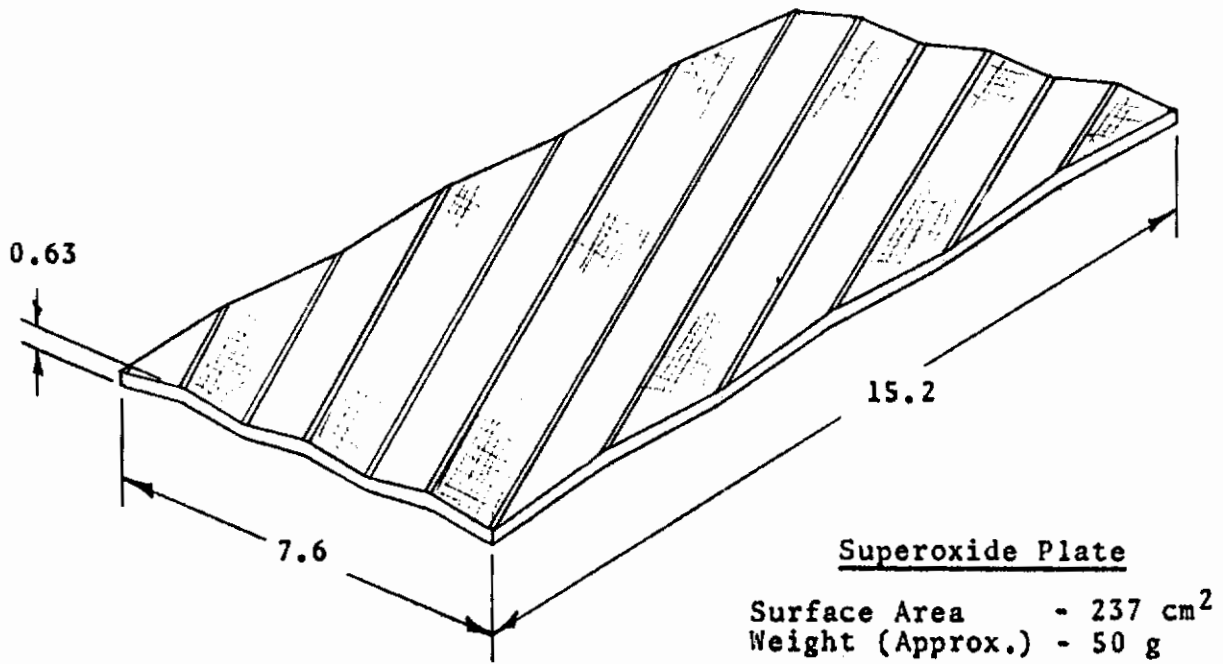
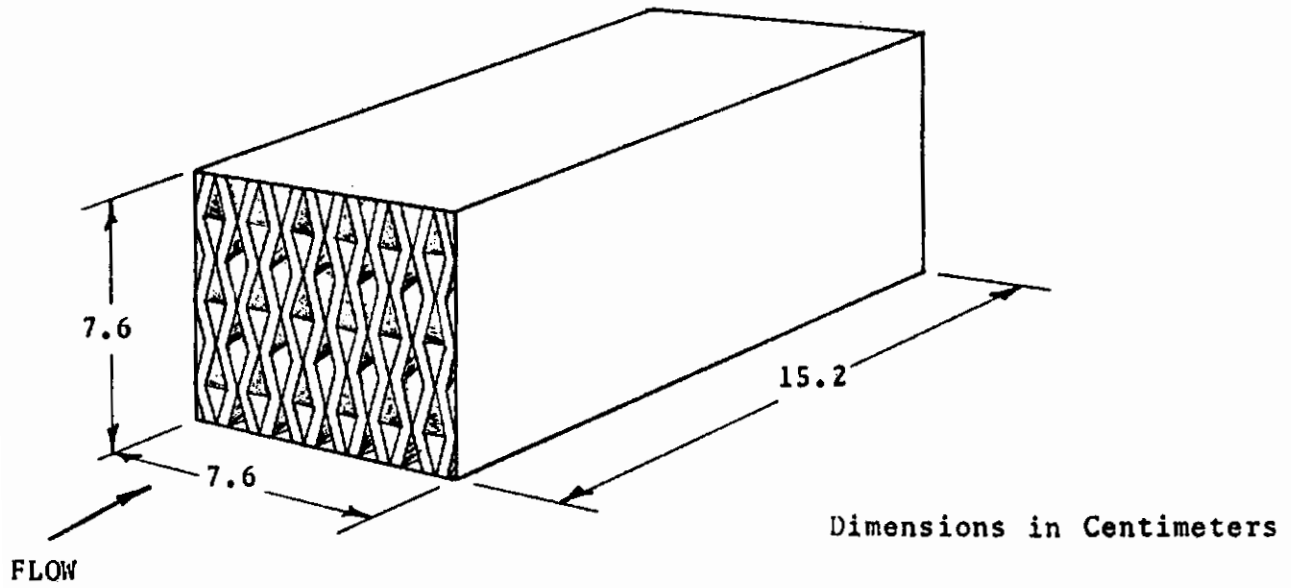


FIG. 8 - DIAGONAL RIPPLED SUPEROXIDE PLATE CONFIGURATION

Tests With Discs

Tests with disc designs featured flow through a central hole in the discs as well as flow around the outside of the discs and between the containment shells.

Increased densification of the superoxide was an objective in this work, but adverse effects were found when discs were formed at higher pressures. This was found in Test 1, a 24-hour configuration having 175 - 7 cm diam. KO₂ discs packaged in tandem to a length of 106.5 cm (see figure 2), giving an L/D ratio of 16.0. The discs had a central 2.2 cm hole for air passage. Volume of the configuration envelope was 4100 cm³, weight 4100 g, and surface area 15,800 cm². An annular flow passage was provided by the 7.62 cm ID containment tube and the outside of the discs. The discs were formed at 296 Kg/cm². This test was terminated after 13 hours when O₂ generation and CO₂ absorption were low as evidenced by chamber gas concentrations. The O₂ evolved was 391 liters (STP) and CO₂ absorbed was 207 liters (STP). Flow rate for this test was 272 liters/min.

Improvement was obtained with this configuration when the 7 cm discs were pressed at 113 Kg/cm². Test 69 had 180 - 7 cm discs and the configuration generated 750 liters (STP) O₂ and absorbed 415 liters (STP) CO₂ in 24 hours.

Test 6 was made with fifty 14.5 cm diam. KO₂ discs. Bed length was 31.6 cm, the L/D ratio was 2.2. The volume of this configuration, including the 2.2 cm central flow hole was 5330 cm³ and the weight was 3925 g. The surface area of this configuration was 17,600 cm². This configuration evolved 758 liters (STP) O₂ and absorbed 547 liters (STP) O₂. The RQ was 0.72. These discs weighed 3925 g and were pressed at a force of 81 Kg/cm². The O₂ efficiency was 81%. The average relative humidity for this test was 48% at 24°C.

The 9.5 cm disc (see figure 3) was the type used in atmosphere control units*. This configuration has an L/D ratio of 7.2. The configuration contained 110 - 9.5 cm discs and occupied a volume of 4920 cm³, including the 2.2 cm central hole. The weight of these configurations was 3900 g and surface area was 16,700 cm². Three tests were made of an average relative humidity of 39% at 24°C, and a decrease in O₂ generated is accompanied by decreasing flow rate.

*McGoff, M.J., Potassium Superoxide Atmosphere Control Unit, AMRL-TR-65-44 (AD 624 556), Aerospace Medical Research Laboratories, Wright-Patterson AFB, Ohio, September 1965.

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<u>Flow Rate Liters/min.</u>	<u>O₂ Generated Liters (STP)</u>	<u>CO₂ Absorbed Liters (STP)</u>	<u>O₂ Efficiency (%)</u>	<u>RQ</u>
178	702	472	77.5	0.67
133*	605	396	67.2	0.65
229	790	484	83.6	0.61

*Terminated After 18 Hours.

The 9.5 cm disc configuration was again investigated in this program. Test 76 was made at a higher relative humidity of 63% at 24°C. A higher humidity as well as lower flow rate as shown above, adversely affected performance of the 9.5 cm disc configuration. Flow rate decreased from 269 liters/min. to 147 liters/min. and CO₂ absorption was only 364 liters (STP); O₂ generation was 700 liters (STP) and the O₂ efficiency was 76.1%. The RQ for this test was 0.52.

The data for 24-hour disc configuration tests is given in the Appendix. These results of the disc configuration show that decreased flow and increased humidity harmed performance, especially CO₂ absorption properties. This effect was also demonstrated in plate configurations. The higher humidities swelled the superoxide forms, which decreased the flow area, hence decreased flow rate and performance.

Tests With Plates

Plate forms of superoxide can be packaged into various combinations of cross-sectional areas and bed lengths. Rectangular shells were used, with flow passing through channels formed by the plates. The plate surfaces are in direct contact with the flow stream, whereas in disc arrays the surfaces are less actively exposed since the flow stream passes through a central hole and the annulus.

Test 40 was a 24-hour plate configuration having ninety-six 10.2 cm x 10.2 cm rippled KO₂ plates (see figure 7). The configuration had six beds, each containing 16 plates, and bed length was 61 cm long. This configuration had a weight of 3895 g in a chemical envelope of 6300 cm³: surface area was 20,300 cm². Flow rate averaged 204 liters/min. dropping from 271 liters/min. to 137 liters/min. during the test. O₂ generation was 895 liters (STP); 90.2% efficiency, and CO₂ absorption was 551 liters (STP). The RQ was 0.62. The CO₂ concentration was only 0.63% after

Contrails

24 hours, increasing to 0.87% at 26-1/2 hours when the test was terminated. The average humidity in the test chamber was low, being 32% RH at 24°C. This configuration was the most efficient for O₂ generation and CO₂ absorption in the prescribed 24-hour test.

Test 68 was a 24-hour plate configuration which contained eighty 7.6 cm x 15.2 cm diagonally rippled KO₂ plates (see figure 8). These plates provided a two-plane directional flow path because of the diagonal pattern. The configuration volume was 5900 cm³, being 7.6 cm x 12.7 cm x 61 cm long. The configuration had a weight of 4095 g and surface area was 19,150 cm². The more random flow path provided by the diagonal pattern of the 7.6 cm x 15.2 cm plates was expected to give better performance than the 10.2 cm x 10.2 cm plates at a corresponding flow rate. A lower flow rate was selected for Test 68. Flow rate was 91 liters/min. at the start and 85 liters/min. at the end of the test. The configuration had a lower flow rate than Test 40 and velocity through the configuration also was lower. The test terminated after 24 hours and 845 liters (STP) O₂ was generated and 468 liters (STP) CO₂ absorbed. The O₂ efficiency was 85.6% and RQ was 0.55. The average humidity was 52% RH at 24°C. Final CO₂ concentration was 2.0% after 24 hours in the 3680 liter chamber. This configuration performed more poorly than the Test 40 configuration because of the lower flow rate and higher humidity; the diagonal pattern plate showed no advantage at a low flow. Test 70 showed these effects also.

Test 70 was a configuration identical to Test 40, having ninety-six 10.2 cm x 10.2 cm KO₂ plates. The configuration was heavier, weighing 4130 g. Test conditions differed for this configuration; flow was lower at 150 liters/min. and humidity was higher, averaging 51% RH at 24°C. The O₂ generation was slightly higher than Test 40, being 908 liters (STP) O₂ but CO₂ absorption was lower at 475 liters (STP) CO₂. The O₂ efficiency was 93.1% and RQ was 0.55. The CO₂ concentration in the 3680 liter chamber was 1.89% after the 24-hour test.

As with disc configuration, the 24-hour test with plate type configurations demonstrated that better performance is gained with higher flow rates and lower humidities.

Test 81 was a 24-hour plate configuration. This configuration used 100 - 7.6 cm x 15.2 cm diagonally rippled KO₂ plates. The weight of KO₂ was 4195 g. The chemical envelope was 15.2 cm x 15.2 cm x 30.4 cm long for a total volume of 7050 cm³. The container for the plates was approximately 15.5 cm square x 35.5 cm long. An inlet and exit manifold (see figure 9) were employed for a U-return of the flow which passed through two KO₂ beds (25 plates per bed) on a top tier and two beds on the bottom

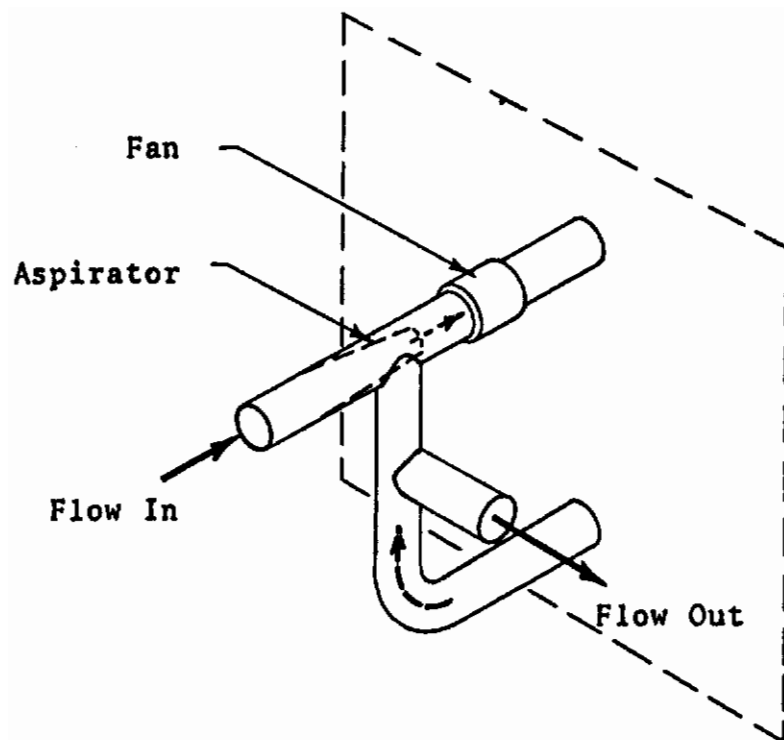


FIG. 9 - REFLUX MANIFOLD

Contrails

tier thereby providing a flow path 61 cm long. This manifold aspirated flow into the configuration with a fan which internally circulated flow greater than flow into and out of the canister. The net flow into the canister decreased from 241 to 150 liters/min. averaging 195 liters/min. The total internal flow through the configuration was 1100 liters/min. at the start of the test and the reflux flow was approximately 849 liters/min. The reflux stream preheated the inlet stream entering the configuration approximately 17°C initially, decreasing to 11°C near the end of the test. This configuration test was made at an average 50% RH at 24°F. The generated O₂ was 907 liters (STP), averaging 37.9 liters/hr (STP) O₂ and CO₂ absorbed was 491 liters (STP), averaging 20.4 liters/hr (STP) for the 24 hours. Final CO₂ concentration in the chamber was 1.2%. Flow did not decrease as much as in Test 40 but average flow was lower, being 195 liters/min. for Test 81 compared to 204 liters/min. average for Test 40. A larger flow area was provided by the Test 81 configuration compared to Test 40. If an equivalent humidity would have existed, in Test 40, larger flow reduction would probably have occurred and performance would have decreased.

Recirculation of the outlet flow can be utilized to preheat inlet flow streams as was described in Test 81 above. Better inlet bed performance is obtained, and is important for short missions to optimize performance. This approach is discussed more fully in the 8-hour and 4-hour configuration mission design tests.

Eight-Hour Configurations

The theoretical amount of KO₂ and NaO₂ for an 8-hour mission to meet an O₂ supply rate 45.4 g/hr is 1090 g KO₂ and 737 g NaO₂. The lower specified rate is 227 g/hr and the weight of KO₂ and NaO₂ would be one-half the above. The majority of tests for an 8-hour mission design were conducted with plates rather than discs when it was determined that more effective utilization was gained with the plates. At the upper specified rates of 45.4 g/hr O₂, 50 g/hr CO₂ and 45.4 g/hr H₂O, ideal performance for an 8-hour mission would be represented by the generation of 253 liters (STP) O₂ and the absorption of 213 liters (STP) CO₂.

The designs tested produced adequate O₂ but were short in CO₂ absorption. Over-design augmented CO₂ pickup. Tests were designed on the basis of providing near theoretical amounts of superoxide and manipulating conditions to enhance CO₂ absorption properties.

Tests With Discs

Tests 4 and 5 were conducted with 7 cm KO₂ discs of the type used in Test 1. Each configuration had a surface area of

Contrails

5420 cm². Test 4 contained 60 discs pressed at 171 Kg/cm² and had a weight of 1736 g. The bed length was 40 cm. The volume of the chemical, including the 2.2 cm central hole, was 1540 cm³. Test 4 generated 244 liters (STP) O₂ and absorbed 87.5 liters (STP) CO₂ with a flow rate of 257 liters/min. Test 5 contained 60 discs pressed at 295 Kg/cm²; the same densification as Test 1 discs. The configuration weighed 1350 g, the bed length was 36.8 cm and the volume was 1410 cm³. This configuration generated 133 liters (STP) O₂ and absorbed 62.5 liters (STP) CO₂. The flow rate for this test was 280 liters/min. O₂ efficiency for Tests 4 and 5 were 59% and 42% respectively and corresponding RQ's were 0.36 and 0.53. Both tests were terminated after 7 hours. The harder pressed discs of Test 5 performed more poorly than Test 4.

Test 36 again investigated 7 cm diam. discs using KO₂ discs pressed at 125 Kg/cm² with a weight of 1200 g. The O₂ generation was inadequate for an 8-hour mission, being only 154.5 liters (STP), and CO₂ absorbed was 78.5 liters (STP).

Test 7 was made with a single 38 cm diam., 2.2 cm thick KO₂ disc having eleven 2.2 cm holes for flow passage. The surface area was increased by 0.63 cm deep saw cuts. The disc was pressed at 120 Kg/cm². The configuration was intriguing since it represented a granular KO₂ bed self-supported upon a disc of KO₂. The configuration was very heavy for an 8-hour configuration with a weight of 3320 g. Surface area was 7280 cm². Flow rates were 269 liters/min, decreasing to 226 liters/min. after 6 hours when the test was terminated. O₂ generation was only 114.5 liters (STP) and CO₂ absorbed was 83 liters (STP). Poor performance is attributed to the large thickness which was needed to give structural integrity to this diameter disc and to the hardening of surfaces by the saw cuts.

Test 31 was an 8-hour configuration comprised of thirty-five 9.5 cm KO₂ discs formed at 127 Kg/cm². The configuration was 23 cm long and the volume was 1640 cm³. The weight was 1175 g and surface area of the discs was 5340 cm². Flow rate was 223 liters/min. and decreased to 167 liters/min. after 8 hours. O₂ generated was lower than Test 4 above, being 184 liters (STP), but CO₂ was greater at 105 liters (STP). The O₂ efficiency was 65.5% and RQ was 0.57.

Test 33 was with the same configuration as Test 31 but the last disc was without a hole. This configuration weighed 1180 g and generated 178 liters (STP) O₂ and absorbed 94 liters (STP) CO₂. No appreciable differences in performance were observed and no advantage was gained by this alteration.

Tests With Plates

The plate designs generally exhibited greater O₂ production and CO₂ absorption per gram of superoxide than did disc

Contrails

designs. These were extensively investigated in development of an 8-hour design. Tests 10, 11, 12, 13, and 72 were plate configurations having short 10.2 cm to 11.4 cm long, chemical beds. Theoretically, higher reaction rates should occur at inlet zones as compared to downstream zones since higher gas concentrations of CO₂ and moisture are present at the inlets than at the outlets.

Configurations of Test 10, 11, and 12 were chemical packages 6.4 cm x 25.4 cm x 11.4 cm long and occupied a volume of 1840 cm³. Test 10 had 40 KO₂ corrugated plates, each measuring 6.4 cm x 11.4 cm x 0.63 cm thick (see figure 6). Test 12 had the same number except the plates were a blend of 55% KO₂ - 45% NaO₂. Test 11 was made with 36 NaO₂ corrugated plates, made thicker than KO₂ plates to obtain structural rigidity. Tests 13 and 72 were made with 10.2 cm x 10.2 cm rippled plates (see figure 7). These configurations were 10.2 cm x 22.9 cm x 10.2 cm long, occupying a volume of 2360 cm³. Test 13 had 37 KO₂ and Test 72 had 36 KO₂ plates. Flow for Test 13 was 255 liters/min. initially decreasing to 198 liters/min. and Test 72 had a flow rate of 373 liters/min.

Performances of these configurations tested at 255-367 liters/min. flow rate are given below. The comparative performance of short bed configurations shows that Test 11 made with NaO₂ was the most effective configuration with Test 10 next most effective, on the basis of O₂ generated and CO₂ absorbed per pound of chemical. Test 11 was made with NaO₂ plates pressed at 134 Kg/cm². and were structurally weak and friable. Flow rate dropped from 277 liters/min. to 71 liters/min. because of enlargement of the plates from reaction and because of plate breakage. Although the Test 11 configuration performed well, on the basis of O₂ generated and CO₂ absorbed per pound, its structural properties made it an unsuitable design.

10.2-11.4 cm Bed Length

<u>Test No.</u>	<u>Superoxide Type</u>	<u>Weight (g)</u>	<u>Surface Area (cm²)</u>	<u>Volume (cm³)</u>	<u>O₂ Generated liters (STP)</u>	<u>CO₂ Absorbed liters (STP)</u>	<u>O₂ Eff. (%)</u>	<u>RQ</u>
10	KO ₂	1470	7220	1835	247	153	72.8	0.62
11	NaO ₂	1400	6520	1835	371	168	93.8	0.45
12	55% KO ₂ - 45% NaO ₂	1505	7220	2000	270	136	73.0	0.51
13	KO ₂	1640	7700	2360	236	161	60.0	0.68
72	KO ₂	1555	7220	2360	252	94	67.0	0.37

Contrails

Tests 39, 52, 53, 56, 71, 74, and 77 were made with plates having bed lengths of 30.4 cm. These tests investigated two types of plate designs, flow rates, and the effect of pre-heating.

Tests 39, 71, and 74 were made with 10.2 cm x 10.2 cm rippled pattern KO₂ plates (see figure 7). Test 39 had 25 plates pressed at 115 Kg/cm² and arranged in a 5.1 cm x 10.2 cm x 10.2 cm long bed. Tests 71 and 74 were larger configurations, having thirty-nine 10.2 cm x 10.2 cm plates. The plates of Test 71 were pressed at 115 Kg/cm², the same as Test 39, and the plates of Test 74 were pressed at 320 Kg/cm² to show effects of densification. Tests 71 and 74 were approximately 10.2 cm x 10.2 cm x 30.4 cm long beds. Both Tests 71 and 74 generated more O₂ than Test 39 because of larger amounts of KO₂ but CO₂ absorption in Test 39 was greater than in either Test 71 or 74. Flow rate for these tests was 246 liters/min. decreasing to 170-184 liters/min. at the end. Slightly lower humidity was present in the 3680 liter chamber for Test 39 than for Tests 71 and 74 where the humidity averaged 55% RH at 24°C. CO₂ absorbed by the Test 39 configuration was 99 liters (STP), while approximately 85 liters (STP) was absorbed in Tests 71 and 74. The Test 39 configuration was smaller and had a smaller flow area. This increased gas velocity and mass flow rate which presumably contributed to a slightly better CO₂ absorption even though the configuration had less superoxide. Data on these configurations are shown below.

Tests 52, 53, 56, 57, and 77 were made with 7.6 cm x 15.2 cm diagonally rippled KO₂ plates (see figure 8) with 30.4 cm long bed lengths. These tests investigated the preheating of the inlet flow stream, reduced pressure and mass flow. Tests 52, 53, 56, and 57 configurations had a volume of 3000 cm³. Twenty-four 7.6 cm x 15.2 cm plates were used. Tests 52 and 53 were duplicate

30.4 cm Bed Length

10.2 cm x 10.2 cm KO₂ Plates

<u>Test No.</u>	<u>Weight (g)</u>	<u>Surface Area (cm²)</u>	<u>Volume (cm³)</u>	<u>O₂ Generated liters (STP)</u>	<u>CO₂ Absorbed liters (STP)</u>	<u>O₂ Eff.</u>	<u>RQ</u>
39	1160	5350	1775	187	99	67.4	0.53
71	1590	8320	2725	225	86	60.0	0.38
74	1660	8320	2725	221	85	56.4	0.39

tests except that the Test 53 configuration had a jacket through which the inlet flow passed and was preheated. Flow for these tests was approximately 170-198 liters/min. The jacket design of Test 53 was not effective and was altered for Tests 56 and 57. Tests 56 and 57 were made with inlet flow temperatures increased approximately 8°C higher than Tests 52 and 53, by jacketing the configuration and using reaction heat to preheat the inlet flow stream. Flow rate for Test 56 was 357 liters/min. and for Test 57 it was 110 liters/min. The O₂ generation and CO₂ absorption characteristics showed no discernable differences. Test 57 demonstrated the largest O₂ production of 212 liters (STP) and Test 52 absorbed the most CO₂, 110 liters (STP). These configurations were inadequate for an 8-hour configuration design since O₂ generation and CO₂ absorption were low.

Test 77 was a larger configuration having forty 7.6 cm x 15.2 cm plates arranged in a 10.2 cm x 7.6 cm x 30.4 cm long bed. The volume was 2370 cm³. An increase in O₂ generation was seen, 278 liters (STP); however, CO₂ absorption was comparable to Test 52, 53, 56, and 57, being 106 liters (STP). The effect of preheating by jacketing the canister in the above tests was not of large enough magnitude to be considered an advantage. Test 77 was made at a flow of 243 liters/min. decreasing to 108 liters/min. Higher CO₂ absorption and O₂ generation was anticipated with this larger design; however, the decrease in flow lowered CO₂ absorption. The performances of the 30.4 cm long bed configurations made with 7.6 cm x 15.2 cm diagonally rippled plates are given below.

30.4 cm Bed Length

7.6 cm x 15.2 cm KO₂ Plates

<u>Test No.</u>	<u>Weight (g)</u>	<u>Surface Area (cm²)</u>	<u>Volume (cm³)</u>	<u>O₂ Generated liters (STP)</u>	<u>CO₂ Absorbed liters (STP)</u>	<u>O₂ Eff. (%)</u>	<u>RQ</u>
52	1220	5730	1770	193	109	65.0	0.57
53	1225	5730	1770	173	98	58.0	0.57
56	1200	5730	1770	200	91	69.0	0.43
57	1210	5730	1770	212	105	72.5	0.50
77	1720	9470	2365	279	107	68.7	0.38

Contrails

Three 8-hour plate configuration tests were made with 45.7 cm long beds having thirty-nine 7.6 cm x 15.2 cm diagonally rippled KO₂ plates, packaged to 8.3 cm x 7.6 cm x 45.7 cm dimensions. These were Tests 65, 67, and 73. A heat exchanger used the warm exit flow stream to heat the inlet flow stream. Tests 67 and 73 were conducted at a reduced pressure of 1/2 atmosphere. The results of Test 67 were invalidated because of low CO₂ production by the man simulator. Test 65 was made at one atmosphere pressure and a flow of 167 liters/min. In Test 67, the flow was 133 to 142 liters/min. at one atmosphere. In Test 73 the flow was increased to give a volumetric flow rate of 226 liters/min. at one atmosphere. The results of these tests with 45.7 cm long beds are given below.

45.7 cm Bed Length

7.6 cm x 15.2 cm KO₂ Plates

<u>Test No.</u>	<u>Weight (g)</u>	<u>Surface Area (cm²)</u>	<u>Volume (cm³)</u>	<u>O₂ Generated liters (STP)</u>	<u>CO₂ Absorbed liters (STP)</u>	<u>O₂ Eff. (%)</u>	<u>RQ</u>
65	1580	9220	2870	287	159	75.0	0.55
67*	1590	9220	2870	249	69	64.8	0.27
73*	1575	9220	2870	274	135	74.0	0.49

*Reduced Pressure Tests at 1/2 Atmosphere

Reduced pressure did not affect O₂ generation rates, although lower mass flow rates would decrease both O₂ and CO₂ absorption. At reduced pressure, the concentration of the inert gas film about the superoxide forms is lower, theoretically reducing diffusion resistance through this inert film thereby improving overall kinetics. The results of this test indicate that this inert gas film is not the major controlling resistance and that diffusion into the solid is controlling.

Test 65 had a more effective preheating arrangement with inlet temperatures elevated by 14-17°C. This aided O₂ production and CO₂ absorption of the inlet beds: chemical analysis showed the inlet and outlet beds to be equally effective. In previous designs without a preheated inlet flow stream, the O₂ generated and CO₂ absorbed were always less for the inlet bed. The center bed, however, evolved more O₂ and absorbed more CO₂ than either the inlet and outlet beds.

Four-Hour Configurations

Four-hour configurations tests were made in a 212 liter sealed chamber; a few tests were made in a 3680 liter chamber. The smaller chamber showed gas concentration changes more quickly than the larger chamber and pointed up performance characteristics more quickly. Plates were used entirely since discs did not provide as rapid O₂ generation and CO₂ absorption characteristics.

With shorter mission configurations, it becomes progressively more difficult to meet required performance with lower-surface solid shapes. Chemical methods of optimizing performance were studied. CO₂-absorbing additives and peroxide additives were investigated. A series of 4-hour tests were made with the configuration plates sprayed with water, thus providing a KOH surface (Tests 41, 46, 47, and 48). This approach was unsuitable since the CO₂ absorption per pound of superoxide showed no increase over other four-hour configuration designs. Preheating the inlet flow stream, varying bed lengths and flow rate effects were examined.

Tests With Additives

Five tests were made with 4-hour configurations in which chemical additives were blended with KO₂.

Test 28 had sixteen 10.2 cm x 10.2 cm rippled KO₂ plates arranged in a 10.2 cm x 10.2 cm x 10.2 cm long configuration. Plates in the array were treated with different additives, and analyzed separately after the run. Flow rate was 277 liters/min. Additives were LiOH, Na₂O₂, ascarite (NaOH) and CuOCl₂. The performances of these blends are shown in Table I. The plates containing 5% Na₂O₂ were more effective than plates containing 10% and 20% Na₂O₂ and were as effective as the plates containing 1% CuOCl₂ in CO₂ absorption. The pure KO₂ plates and 1% CuOCl₂ plates generated more O₂.

Test 38 was a 13 plate configuration of 10.2 cm x 10.2 cm rippled NaO₂ plates having the additives used in Test 28. This configuration had a weight of 895 g and a surface area of 2775 cm². Flow rate was 305 liters/min. None of the additives showed significant improvement over pure NaO₂. The NaO₂ configuration was less efficient than the KO₂. This resulted from making the NaO₂ plates thicker and pressing them harder at 225 Kg/cm² to make them hold together. Compositions and chemical analysis of the various plates are given in Table II.

Test 63 was made with twenty 7.6 cm x 15.2 cm plates (see figure 8), blended with 75% KO₂ and 25% LiOH granules. The volume of the configuration was 580 cm³ (6.4 cm x 7.6 cm x 15.2 cm long) and weighed 805 g. Surface area was 4770 cm². Flow rate was

TABLE I - SUMMARY OF INDIVIDUAL PLATES
Plate Size 10.2 cm x 10.2 cm x 0.63 cm

Run 28 - 4-Hour Test

Plate No.	KO ₂ Blend	Weight (g)	Forming Pressure (Kg/cm ²)	O ₂ Available liters (STP)	O ₂ Generated liters (STP)	CO ₂ Absorbed liters (STP)	O ₂ Efficiency (%)	RQ
1-2	KO ₂	90.7	130	21.7	12.2	7.2	56.3	0.59
3-4	KO ₂ and 10% LiOH	101.1	130	21.5	11.9	7.2	55.3	0.60
5-6	KO ₂ and 20% Na ₂ O ₂	111.6	130	24.5	11.8	8.3	49.8	0.71
7-8	KO ₂ and 10% Na ₂ O ₂	101.3	130	23.1	14.0	9.8	60.7	0.70
9-10	KO ₂ and 5% Na ₂ O ₂	96.4	130	22.4	14.9	10.4	66.6	0.68
11-12	KO ₂ and 10% Ascarite	101.8	130	21.5	12.9	8.1	60.1	0.62
13-14	KO ₂ and 1% CuOCl ₂	99.0	130	23.6	16.3	10.4	68.9	0.62
15-16	KO ₂	90.3	105	21.3	16.3	11.8	76.4	0.73
Totals				179.6	110.3	73.2	61.3	0.66

TABLE II - DATA ON INDIVIDUAL COMPOSITIONS

Run 38 - 4-Hour Test

Plate No.	Composition	Weight (g)	Weight Gain (g)	O ₂ Available liters (STP)	O ₂ Generated liters (STP)	CO ₂ Absorbed liters (STP)	O ₂ Efficiency (%)	RQ
1-2	NaO ₂	136.4	4.5	40.2	20.4	11.3	50.7	0.56
3-4	NaO ₂ + 10% LiOH anh.	138.6	4.0	36.5	19.5	11.3	53.5	0.58
5-6	NaO ₂ + 20% Na ₂ O ₂	139.5	9.2	40.4	20.6	9.9	51.0	0.48
7-8	NaO ₂ + 10% Na ₂ O ₂	137.5	6.3	38.5	16.4	10.5	42.6	0.64
9-10	NaO ₂ + 5% Na ₂ O ₂	139.1	5.0	39.9	19.5	11.3	48.9	0.58
11-12	NaO ₂ + 10% Ascarite	136.5	4.9	35.9	18.7	11.8	52.0	0.58
13	NaO ₂ + 1% CuOCl ₂	69.2	0	20.1	9.1	3.7	45.1	0.41
Totals			251.5	124.2	69.8	49.1	0.55	

169 liters/min. These plates were pressed with LiOH granules which were crushed into the KO₂ giving a plate with one side being KO₂ and the other LiOH. Anhydrous LiOH powder was blended in Test 28 and Test 38. In a 4-hour test, this configuration liberated 137.5 liters (STP) O₂ and absorbed 75 liters (STP). A high O₂ efficiency of 82.4% was obtained.

Test 66 incorporated the same mixture as Test 63 in a 24-plate design of 10.2 cm x 10.2 cm rippled plates. This configuration was 7.6 cm x 7.6 cm x 30.4 cm long to give a volume of 1770 cm³. Surface area was 5720 cm² and the configuration weighed 982 g. A performance increase was gained with 171 liters (STP) O₂ liberated and 93.2 liters (STP) CO₂ absorbed. The O₂ efficiency was 85%. Flow rate ranged from 175 to 185 liters/min.

Test 79 was a 20 plate KO₂ configuration, like Test 63. The additive was 1% CuOCl₂. The configuration weight was 805 g. The test was conducted in a 3680 liter chamber whereas Test 63 was made in a 212 liter chamber. The configuration used a reflux manifold of the same design as discussed for Test 81 to preheat the inlet flow stream. The flow rate was 325 liters/min. The O₂ generation showed an increase over Test 63 at 144 liters (STP) but CO₂ dropped off to 53 liters (STP) compared to 73.5 liters (STP) in Test 63. The O₂ efficiency was 78.3%. Lower CO₂ absorption is attributed to lower CO₂ concentration in the 3680 liter chamber test where CO₂ concentration did not exceed 0.8%, while in Test 63 CO₂ was 4% in the 212 liter chamber.

A limit of 7.6 mm Hg (1% CO₂) partial pressure of CO₂ is specified for the designs. When related to chamber volume size, the tolerance for CO₂ can be relaxed with larger chambers. For smaller chambers volumes, this becomes more critical and can be compensated for by increasing the size of the configurations.

Inlet Flow Stream Preheating

By preheating the inlet flow stream, the inlet bed performance improved to comparable levels observed for downstream beds. Without preheating, inlet bed O₂ efficiencies were 50% compared to 70% for downstream beds. Downstream beds benefited from the preconditioning afforded by upstream bed reactions which can increase the temperature.

Tests 50, 51, and 54 were configurations having twelve 7.6 cm x 15.2 cm KO₂ plates arranged in a 3.8 cm x 7.6 cm x 30.4 cm long bed. The surface area for these configurations were 2870 cm². Test 50 had a preheated inlet flow stream provided by a jacket which surrounded the canister. This test was made at an average flow rate of 200 liters/min. This configuration weighed 605 g, generated 111 liters (STP) O₂ and absorbed 82 liters (STP) CO₂.

Contrails

Tests 51 and 54 did not have a preheated inlet flow stream but flow rates differed for these tests. Flow rate for Test 51 was 300 liters/min. and for Test 54 the flow was 125 liters/min. The larger flow rate for Test 51 contributed to higher O₂ evolution and CO₂ absorption; however, both tests were less effective than Test 50. The respective O₂ generations for Test 51 and 54 were 101 liters (STP) and 89.5 liters (STP) and the CO₂ absorptions were 76.5 liters (STP) and 63.8 liters (STP). A summary of these test configuration inlet and outlet beds is given below.

<u>Test No.</u>	<u>Inlet Bed</u>	<u>Outlet Bed</u>	<u>Combined</u>	<u>Comment</u>	
50 -	O ₂ liters (STP)	62.8	48.7	111.4	Preheated Inlet Flow Stream
	CO ₂ liters (STP)	47.5	34.5	82.0	
	O ₂ Eff. (%)	83.8	73.5	79.0	
	RQ	0.76	0.71	0.74	
51 -	O ₂ liters (STP)	34.2	66.7	101.0	Inlet Flow Stream Not Preheated
	CO ₂ liters (STP)	31.1	45.2	76.3	
	O ₂ Eff. (%)	52.0	89.6	72.0	
	RQ	0.91	0.68	0.76	
54 -	O ₂ liters (STP)	29.7	59.6	89.4	Inlet Flow Stream Not Preheated
	CO ₂ liters (STP)	16.7	46.9	63.6	
	O ₂ Eff. (%)	47.0	72.0	61.2	
	RQ	0.56	0.79	0.71	

These configurations did not deliver the desired O₂ supply and required greater CO₂ absorption capacities. Increases were effected by increasing the number of plates.

Test 59 was a 15 plate configuration which was 5 cm x 7.6 cm x 30.4 cm long and weighed 622 g. This configuration weighed the same as the 12 plate configurations since the plates were made thinner and therefore lighter. Flow for this test averaged 113 liters/min. and O₂ production was 113 liters (STP) and CO₂ absorption was 75.8 liters (STP). The flow rate for this test was near that of Test 54 discussed above. Increasing the surface area increased performance.

Test 62 was a nineteen 7.6 cm x 15.2 cm plate configuration in which an air to air heat exchanger was used to raise the inlet flow stream. The exchanger created a high pressure drop, lowering flow to 85 liters/min. Low flow decreased performance and the test was terminated after 3 hours.

Tests 64, 78, and 79 were 20 plate configurations. Test 64 was made in a 212 liter chamber and Tests 77 and 79 in the 3680 liter chamber. These configurations were 6.4 cm x 7.6 cm x 30.4 cm long and the volume of the chemical package was 1475 cm³. Surface area of the twenty 7.6 cm x 15.2 cm KO₂ plates was 4770 cm². Test 64 configuration weighed 840 g and inlet air was preheated by a heat exchanger. The average flow rate was 250 liters/min. Test 78 configuration weighed 822 g and the inlet flow stream was preheated by mixing some of the outlet flow stream with it. Thus, the heat exchange was obtained without jacketing the container or a heat exchanger. The return flow for Test 78 was 1.5 that of the inlet flow. Flow rate from the system into the configuration was 300 liters/min, which decreased to 133 liters/min. Total flow rate initially, through the configuration was about 710 liters/min, with 425 liters/min. being returned. Performance was lower in Test 78 than in Test 64 because of an average lower flow rate and lower CO₂ concentration in the larger chamber. Test 64 showed 140 liters (STP) O₂ and 86 liters (STP) CO₂. Test 78 showed 92.5 liters (STP) O₂ and absorbed 32 liters (STP) CO₂.

Test 79 was the same configuration as Test 78 but the KO₂ plates were seeded with 1% CuOCl₂. This configuration showed a net improvement over Test 78. This configuration benefited from the combined effects of preheating, increased flow rate and the addition of a catalyzing agent.

Two-Hour Configurations

All 2-hour configurations tested were made with chemical additives to optimize performance characteristics. The additive most effective was copper oxychloride (CuOCl₂). Plates were used in preference to discs to give more dynamic design. A single test (Test 18) was made with KO₂ plates impregnated with 5% by weight asbestos fibers to determine if permeability of the solid KO₂ plate could be increased by the fibrous interstices. More plates were used in two-hour configurations, as the test continued, so that O₂ delivery and CO₂ absorption could be increased. Most of the tests were made in a 212 liter sealed chamber. Several tests were also made in the 3680 liter chamber.

The theoretical amount of KO₂ for a 2-hour configuration is 272 g KO₂ and 182 g NaO₂. The limited surface area presented by solid superoxide design creates a formidable problem in optimization. Efficiencies of 75% of available O₂ for 2-hour configurations gave close approximations to theoretical requirements; however, CO₂ absorption capacities fall short and design on 2-hour configurations, as with other mission configurations designs, is predicated upon CO₂ requirements.

Contrails

Test 15 involved study of the initial 2 hour configuration design. The configuration consisted of seven 10.2 cm x 10.2 cm rippled KO₂ plates seeded with 1% CuOCl₂, weighing 359 g and having a surface area of 1500 cm². The chemical volume was 525 cm³ (10.2 cm x 10.2 cm x 10.2 cm long bed). O₂ production efficiency was 65%; 56.3 liters (STP) O₂ was evolved and 44.7 liters (STP) CO₂ was absorbed.

Lithium peroxide was added to this configuration in Tests 16 and 17. Less O₂ was evolved and less CO₂ was absorbed. Test 19 contained 1/2% CuOCl₂ and this blend performed less effectively than the 1% CuOCl₂ used in Test 15. Test 20 also contained 1/2% CuOCl₂ along with 2-1/2% LiCl₂ as an additional moisture absorber; no improvement was gained. Test 23 had 5% LiCl₂ and showed no beneficial effects. Test 21 contained 5% LiOH and had very adverse effects on performance, only 35.7 liters (STP) of O₂ was generated and 15.9 liters (STP) CO₂ was absorbed. Test 22 had manganese oxide as an additive and this proved ineffective. The above configurations weighed approximately 340 g.

Test 24 was made with NaO₂ and this configuration evolved 56.6 liters (STP) O₂ but was less effective than Test 15 since only 35.7 liters (STP) CO₂ was absorbed. This configuration weighed 454 g. This increase in weight resulted because of compounding difficulties with NaO₂. In Test 25, a blend of 75% NaO₂ and 25% Li₂O₂ performed similarly to the Test 24 model. A blend of 80% KO₂ and 20% Li₂O₂ was also ineffective in Test 26. Test 27, made with 5% KMnO₄ as a catalyst with eight 10.2 cm x 10.2 cm KO₂ plates, did not show effective O₂ or CO₂ results.

Two-hour test configurations were made with 7.6 cm x 15.2 cm plates. Bed lengths of 15.2 cm and 30.4 cm were investigated. The combination of preheating the inlet flow stream and adding 1% CuOCl₂ was investigated. Test 55 had eight 7.6 cm x 15.2 cm KO₂ plates weighing 395 g. This test configuration was unacceptable with only 50.1 liters (STP) O₂ delivered and 20.9 liters (STP) CO₂ absorbed. The harmful effect of increasing flow areas, which decreases mass flow rate, was shown in Test 61, made with ten 7.6 cm x 15.2 cm KO₂ plates. Although more KO₂ plates were used than in Test 55, less O₂ was produced and less CO₂ was absorbed.

Tests 82-85 were made in a 3680 liter chamber. The number of plates was increased to 12 and weight of these configuration was approximately 454 g. These configurations included a reflux manifold to preheat the inlet flow and additives were blended with KO₂ and NaO₂. The configurations of Tests 82-84 were 7.6 cm x 7.6 cm x 15.2 cm long, with volumes of 880 cm³. Test 82 had 1% KMnO₄ as an additive to the KO₂ plates. Test 83 contained 1% CuOCl₂ as an additive to NaO₂ plates. The NaO₂ plates had to be

pressed harder than KO₂ plates to achieve structural rigidity. Test 84 contained 1% CuOCl₂ as a catalytic additive to KO₂ plates. The configurations of Tests 82, 83, and 84 gave off comparable amounts of O₂; Test 84 being the largest at 75.5 liters (STP): CO₂ absorption was the largest in Test 84 also, being 40.8 liters (STP) CO₂. These configurations were tested in a 3680 liter chamber in which the initial CO₂ concentration was increased to 0.5% by addition of CO₂ to the chamber.

Test 85 was a configuration of 12 plates of the same composition as Test 84. The configuration was arranged so that the flow path was across the shorter 7.6 cm width of the plates. O₂ production was slightly less at 71.6 liters (STP), as was CO₂ absorption at 34.8 liters (STP). Flow rates were of equal magnitude but a lower mass flow rate prevailed in the Test 85 configuration. This is explained as the cause of lower efficiency.

Forty-Eight-Hour Configurations

Two 48-hour configuration tests were made in Tests 9 and 75. The theoretical requirement for a 48-hour mission to supply 45.4 g O₂/hr is 6540 g KO₂ and 4540 g NaO₂.

Test 9 was a configuration having 100 - 14.5 cm KO₂ discs having a weight of 7860 g. The volume of the configuration was 10,650 cm³. Flow rate averaged 300 liters/min. and humidity averaged 40% at 24°C. The discs, having a 2.2 cm central hole, were contained in a 15.2 cm diameter duct which provided a 0.35 cm annular clearance. The configuration evolved 1825 liters (STP) O₂ and absorbed 1274 liters (STP) CO₂. The configuration evolved 97% of the available O₂ and RQ was 0.70. Both O₂ and CO₂ control exceeded specified amounts of 1520 liters (STP) O₂ and 1217 liters (STP) CO₂. This configuration represented a sizeable amount of superoxide and this was shown to over-ride the moisture control of the cooler in the chamber.

Test 75 was a combination of fifty 14.5 cm KO₂ discs and eighty 7.6 cm x 15.2 cm KO₂ plates. The discs were upstream and bed length was 31.8 cm. The plates were in a downstream bed which was 61 cm long. This size disc showed lower initial O₂ generation rates in Test 6, a 24-hour configuration design and in Test 9 discussed above. The design plan was to have the upstream disc bed act as a preconditioning bed reducing the moisture content of the flow stream to the downstream KO₂ plate bed and thereby provide more uniform O₂ generation. The round duct of the KO₂ discs was jointed to the rectangular duct of the KO₂ plates with a 1.25 cm plenum between the two beds. The test was made at a flow rate of 345 liter/min. and average humidity was 44% RH at 24°C. Both O₂ and CO₂ performance were near, but below, specification; O₂ generation was 1438 liters (STP) and CO₂ absorption was 820 liters (STP).

Contrails

Although the 14.5 cm discs performed well in Test 9, this size disc showed poor performance in this test with only 508 liters (STP) O₂ generated (55% efficiency) and 249 liters (STP) CO₂ absorbed. O₂ efficiency for the plates in this 48-hour test was 99%; 928 liters (STP) O₂ was evolved and 572 liters (STP) CO₂ absorbed. Plates demonstrated superior performance over discs in this configuration test. The 14.5 cm discs performed well in Test 6 (a 24-hour test) and Test 9 discussed above. The flow rate and humidities for these tests were very nearly the same for the three tests. Poor performance of the discs may have been due to low flow rate through the annular area while most of the flow passed through the central hole of the discs. The outer surfaces of the discs would thereby be less exposed to the flow stream which would adversely affect performance. The plate surfaces are always exposed to the flow stream and thereby exhibit superior performance.

Man Tests

Three-man tests were made with solid superoxide forms. In these tests, the subject exhaled into the configuration and inspired through an adjoining breathing bag circuit. O₂, CO₂ and moisture concentrations were monitored. Volume of the rebreather circuit was about 74 liters.

Test 32 was made with ten 9.5 cm KO₂ discs (see figure 3). The weight was 332 g and surface area of the discs was 1520 cm². Bed length was 6.4 cm. This test was terminated after 1 hour when CO₂ concentrations reached 3%, making the subject uncomfortable. O₂ efficiency was 33.5%; 26.9 liters (STP) O₂ was evolved.

Test 35 contained twenty 9.5 cm KO₂ discs. This configuration had twice the weight and surface as the Test 32 configuration. This test was terminated after 2 hours when CO₂ concentration reached 2.37%. O₂ efficiency was 44%; 708 liters (STP) O₂ was evolved.

Test 37 contained thirty 9.5 cm KO₂ discs. The weight of this configuration was 1000 g and had a surface area of 4570 cm². Bed length was 19 cm. This test was terminated after 2.3 hours at which time CO₂ concentration was 2.16%. O₂ efficiency was 40.8%; 97.4 liters (STP) O₂ was evolved.

Tests With Granules

Test 8 consisted of six - 6-hour tests with 2-4 mesh KO₂ granules made from KO₂ fluff of various densities and O₂ content. Although granules were not to be employed in a mission configuration, the tests were performed to demonstrate starting KO₂ density effects on O₂ generation and CO₂ absorption capability. The tests were made at 255 liters/min. with 1000 g of 2-4 mesh KO₂ granules,

packaged in a 15.2 cm diameter canister. Bed length ranged from 7.6 cm to 10.2 cm. The lowest RQ (volume ratio CO_2/O_2) was observed in Test 8F which had granules made from fluff having the lowest apparent density of 0.2 g/cm^3 . The highest RQ was 0.72 in Tests 8C and 8E which utilized granules made from KO_2 fluff having densities of 0.46 g/cm^3 and 0.42 g/cm^3 respectively.

Structural Tests

The strength of superoxide forms was measured in a shear test. The superoxide forms were fixed to a table edge and a bucket suspended by a wire, was hung from the superoxide forms. Weights were added to the bucket until the superoxide forms broke. The force to shear the superoxide forms was recorded. The shear strength increased with forming pressure. KO_2 exhibited higher shear values than NaO_2 . The tests were made with plates. The shear stress was calculated by dividing the cross-sectional area perpendicular to the force, into the force required to break the plates. The results are given in Table III. The results of the tests show KO_2 to be approximately twice as strong as NaO_2 at a forming pressure of 320 Kg/cm^2 and five times as strong at 105 Kg/cm^2 .

TABLE III - STRENGTH OF SUPEROXIDE FORMS

<u>Plate Composition</u>	<u>Pressure to Form (Kg/cm²)</u>	<u>Average Shear Stress (Kg/cm²)</u>	<u>Type of Plate and Size</u>
KO ₂	70	2.8	Flat
	105	3.5	6.4 cm x 11.4 cm
	210	5.3	
	320	7.1	
NaO ₂	105	0.7	
	320	3.9	6.4 cm x 11.4 cm
KO ₂	105	3.2	Rippled
	300	5.3	10.2 cm x 10.2 cm
KO ₂ & 25% LiOH	104	2.5	Flat Plate
	320	3.5	6.4 cm x 10.4 cm

The configuration designs tested were self-spacing and self-supporting. To gain strength, the plates may be pressed at

Contrails

higher forming pressure, but as discussed previously, this tends to decrease the O₂ evolution and CO₂ absorption properties. The plates can be made more resistant to breakage by pressing wire mesh with the superoxide. The network of wires through the superoxide plates prevents disintegration of pieces if the plate becomes fractured. This technique was found feasible with the wavy-pattern of the 7.6 cm x 15.2 cm diagonally rippled plates and 10.2 cm x 10.2 cm rippled plates.

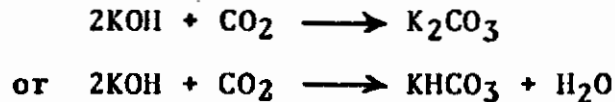
Section IV

DESIGN PHASE

The generation of oxygen from superoxide configurations is dependent upon the presence of moisture in the flow stream. For KO_2 this reaction is:



This reaction must occur to form the hydroxide which is necessary for absorption of CO_2 . The reaction of CO_2 may be either:



Thus, the two driving forces in performance of a superoxide configuration are the moisture and carbon dioxide concentrations.

Other factors to consider are the type of superoxide, flow rate and mass flow rate, surface to volume ratio, pressure to shape the forms and temperature.

Design Coefficients

Rate data was collected from the configuration tests. This data was collected for disc and plate type configurations. The rate of O_2 generation and CO_2 absorption in liters/hr (STP) can be calculated by monitoring chamber conditions during tests to obtain a mass balance of constituents. Inlet and outlet streams were monitored for constituent gas concentrations to supplement this data and provide additional information for correlating performance.

The generation of oxygen and absorption of carbon dioxide by superoxides are mass transfer operations. The superoxide configurations can be treated in this manner. Like heat transfer coefficients in heat exchange operations, mass transfer coefficients can be described for exchange of mass. In heat exchange, the overall coefficient is related to amount of heat transferred, q , by the equation:

$$q = U A \Delta T_{LM}$$

Contrails

Analogously, in mass transfer, the mass transfer coefficients, K_{ga} can be described for both O_2 production rate and CO_2 absorption rate in grams/hr of gas by the equation:

$$\text{grams/hr} = K_{ga} \times \text{Volume} \times \Delta P_{LM}$$

Whereas in heat transfer the driving force is the temperature difference, ΔT , in mass transfer this driving force is the partial pressure of reference gases. For O_2 generation with superoxide, this is the vapor pressure of water in the flowing stream. For O_2 , the generation coefficient is defined to be:

$$K_{ga} (O_2) = \frac{\text{grams/hr } O_2}{V \Delta P_{LM}}$$

where K_{ga} is the overall transfer coefficient for O_2 production in units of:

$$\frac{\text{grams } O_2}{\text{hr-cm}^3\text{-atmosphere}}$$

and a is the surface to volume ratio of the configuration. In mass transfer operations, this is referred to as the interfacial area per unit of volume of apparatus. Variations in coefficients due to variations in flow rates, type of packing, etc., have been attributed to changes in the value of a as much as to changes in K_g . In the case with superoxide, reaction of the shapes can change this value as the configuration becomes spent and can be expected to be changing continuously. Other units are, V , the volume of the configuration in cubic centimeters and ΔP_{LM} , the driving force for O_2 generation in atmospheres. This latter term is the log mean pressure difference exerted by the vapor pressure of water. This was determined by measurement of inlet and outlet gas streams of the configuration.

Likewise, for CO_2 absorption, an overall coefficient can be described:

$$K_{ga} (CO_2) = \frac{\text{grams/hr } CO_2}{V \Delta P_{LM}}$$

For O_2 generation the ΔP_{LM} is:

Contrails

$$\Delta P_{LM} = \frac{H_2O \text{ concentration in} - H_2O \text{ concentration out}}{\ln \frac{H_2O \text{ concentration in}}{H_2O \text{ concentration out}}} = \text{atmosphere}$$

Similarly for CO₂ absorption, the ΔP_{LM} is:

$$\Delta P_{LM} = \frac{CO_2 \text{ concentration in} - CO_2 \text{ concentration out}}{\ln \frac{CO_2 \text{ concentration in}}{CO_2 \text{ concentration out}}} = \text{atmosphere}$$

In testing the configurations both moisture and CO₂ concentrations into and out of the configurations were monitored and the ΔP_{LM} for O₂ generation and CO₂ absorption were calculated. Rates of O₂ generation and CO₂ absorption in liters/hr (STP) were calculated by mass balances between the simulator and the chamber. These were then converted to grams/hr. The volume of the configuration performance, were calculated periodically as the tests progressed. An average coefficient was obtained from these calculated values.

Configuration tests were basically of two types: 1) passive-dynamic design with discs having no direct forced flow between them and 2) dynamic designs with plates where the surfaces are directly exposed to forced flow streams. The latter are referred to as dynamic designs and were employed as the design approach for short mission configurations because of their more responsive characteristics.

A fresh surface of superoxide possesses no surface barrier for O₂ generation and O₂ is readily evolved from it. As the reaction proceeds from the surface and into it, a surface crust forms and impedes O₂ generation and CO₂ absorption. Thus, the reciprocal of the overall coefficients (k_{ga}) above are comprised of gas film resistance (k_g , analogous to a gas film resistance in heat transfer), and a diffusion resistance (k_s) offered by the solid chemical reactants. The relationship of these resistances can be expressed by the equation:

$$1/k_{ga} = 1/k_g + 1/k_s$$

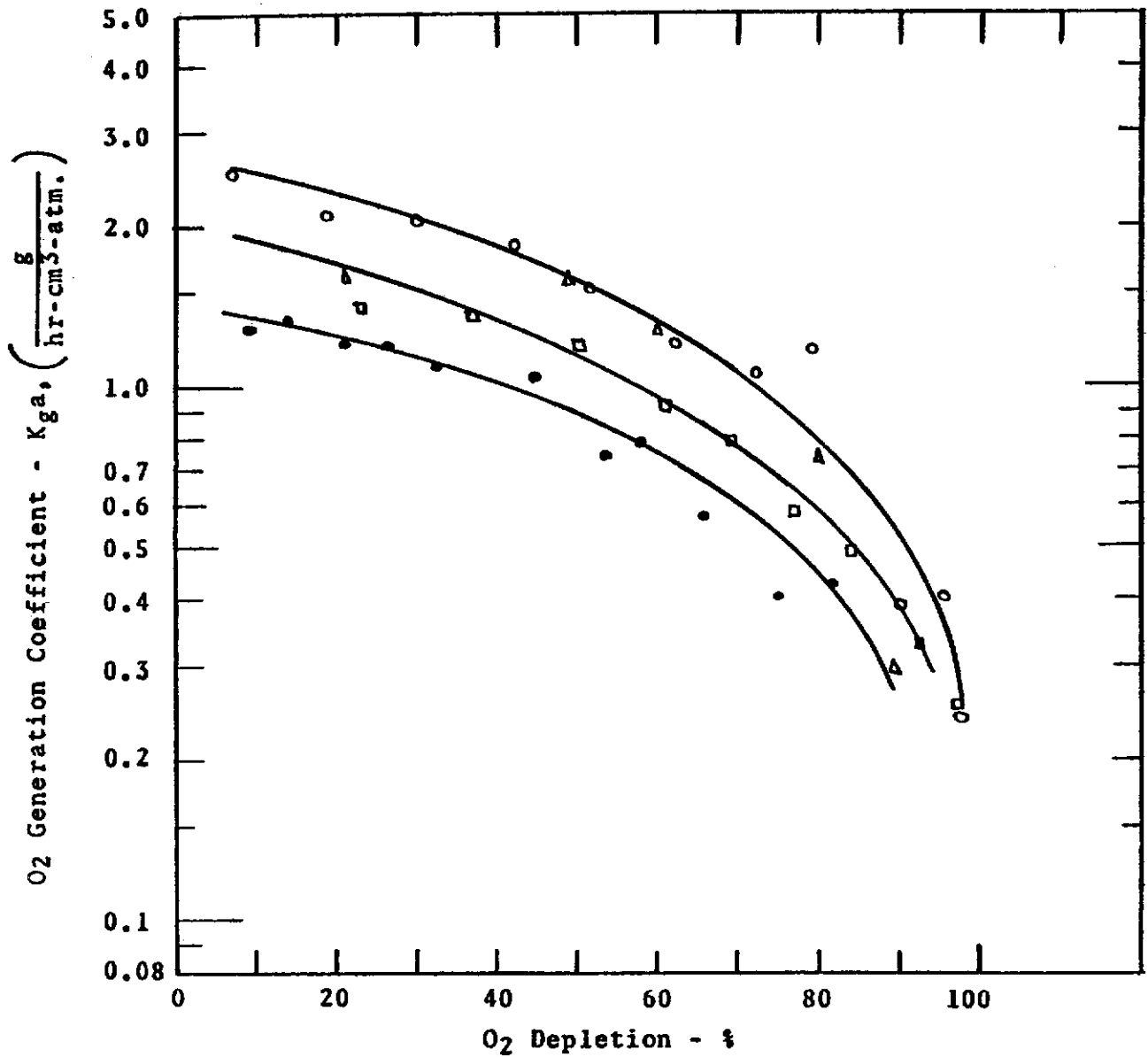
Utilization of available O₂ in short mission configurations was more difficult since less bulk superoxide was required, and thus there was less surface area for reaction. In the above

equation, the gas film resistance, $1/k_g$, can be decreased by increasing flow rate. This increases the individual O_2 generation and CO_2 absorption coefficients thereby enhancing performance with the same surface area.

Increasing inlet temperatures also increased performance since chemical reaction rates are favored by temperature increases. A chemical additive such as $CuOCl_2$ was effective in increasing reaction rates. These three techniques were used to gain performance increases which are more important in short mission designs. Longer mission configurations have more superoxide and hence more area and chemical additives for quick release of oxygen are not necessary. Higher moisture concentrations in the flow stream also increase O_2 generation.

Results and Correlations

Oxygen generation coefficients and CO_2 absorption coefficients for plate configurations used in Tests 40, 65, 68, 70, and 81 are shown in Figures 10 and 11. In Figure 10, the O_2 generating coefficient K_{gO_2} is plotted versus percent O_2 depletion, and Figure 11 is a plot of the CO_2 absorption coefficient versus O_2 depletion. Both plots show drop in coefficients with time. This is due to 1) decrease in active chemical surface-to-volume ratio with time and 2) a steady increase in diffusion resistances. The latter is a result of the reaction products which build up and impede gas diffusion into and out of the solid superoxide forms. This crust may have become more impervious at higher humidities effecting a decrease in coefficients. Examination of the forms exposed to higher humidities appeared to have a more glazed surface than those exposed to lower humidity conditions. Figures 12 and 13 are corresponding plots for disc configurations. These configurations are inherently less dynamic since areas between adjacent discs have less turbulent flow patterns. These disc configurations showed lower coefficients initially, but fell off less rapidly in comparison to plate configurations. The plate configuration for Test 40 displayed the most dynamic CO_2 control of all configurations tested. CO_2 was absorbed at the production rate of the simulator and detectable ($> 0\%$) CO_2 concentrations in the chamber were not observed until 60% of the O_2 was depleted. Lower flow rate and higher humidity detracted from performance. Tests 68 and 70 were made at flow rates of 100 liters/min. and 150 liters/min. respectively and Test 40 at 255 liters/min. Specific humidities were higher in Test 68 and 70, averaging 0.0098 g H_2O/g air (corresponds to 53% RH at $24^\circ C$) compared to 0.0070 g H_2O/g air ($\sim 38\%$ RH at $24^\circ C$) for Test 40. Test 81 was a 24-hour plate configuration with a reflux manifold to preheat the inlet flow stream. The flow rate into the configuration averaged 195 liters/min. which gave a velocity of 82 cm/sec.

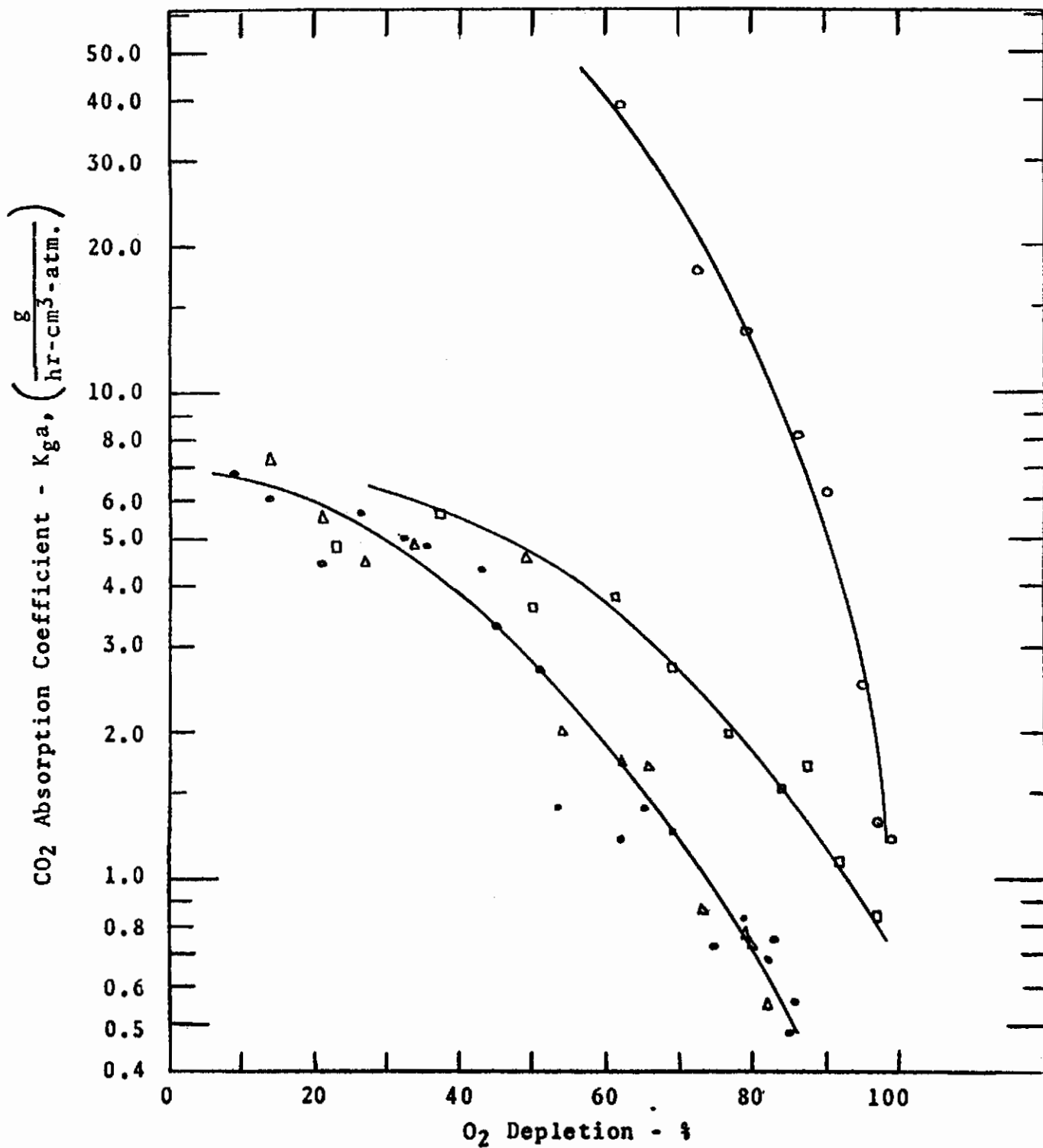


LEGEND

- Test 40 - 116 cm/sec.
- △ Test 70 - 64 cm/sec.
- Test 68 - 48 cm/sec.
- ◻ Test 81 - 82 cm/sec.

FIG. 10 - O₂ GENERATION COEFFICIENTS WITH KO₂ PLATES

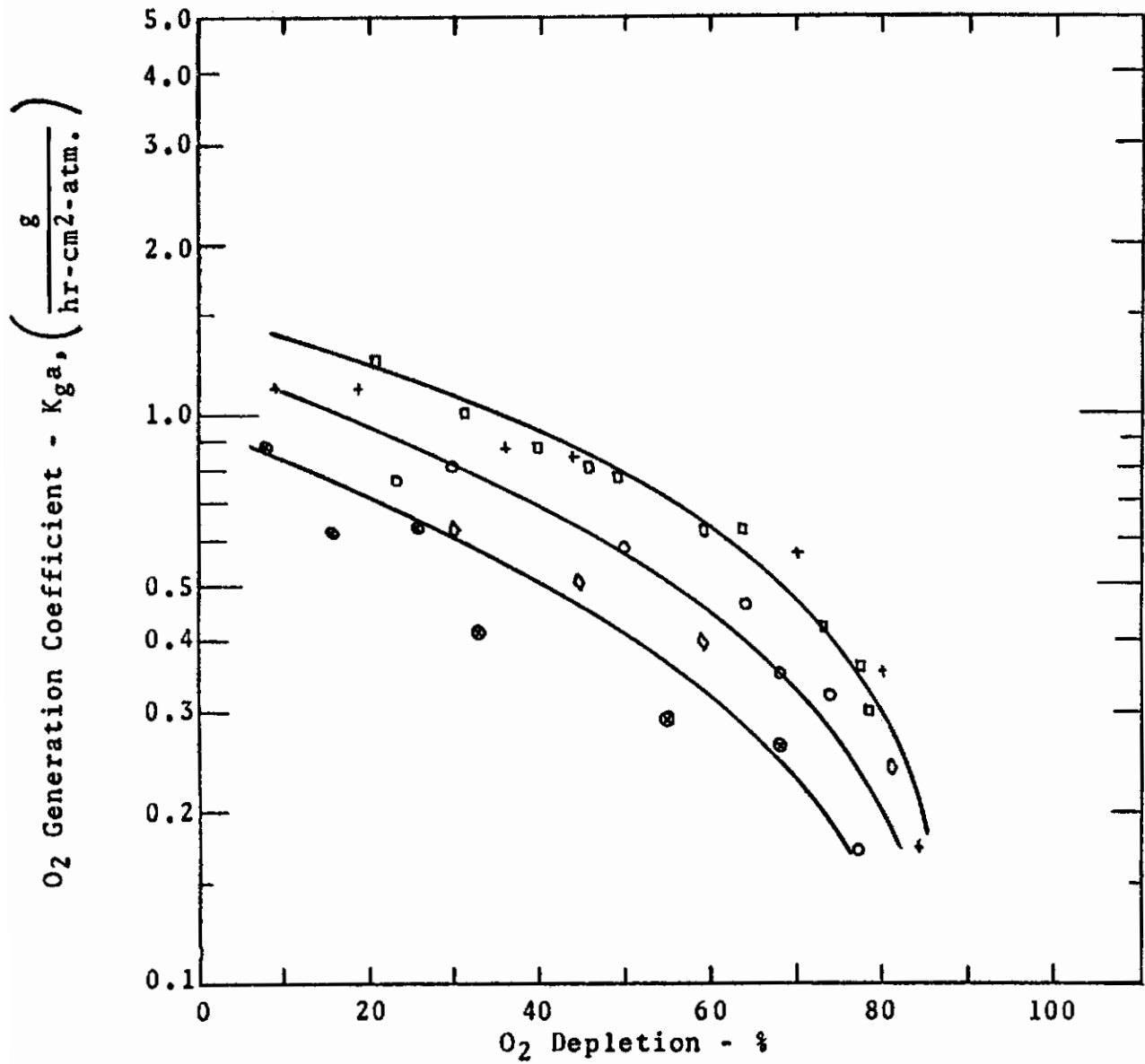
Contrails



LEGEND

- Test 40 - 116 cm/sec.
- △ Test 70 - 64 cm/sec.
- Test 68 - 48 cm/sec.
- Test 81 - 82 cm/sec.

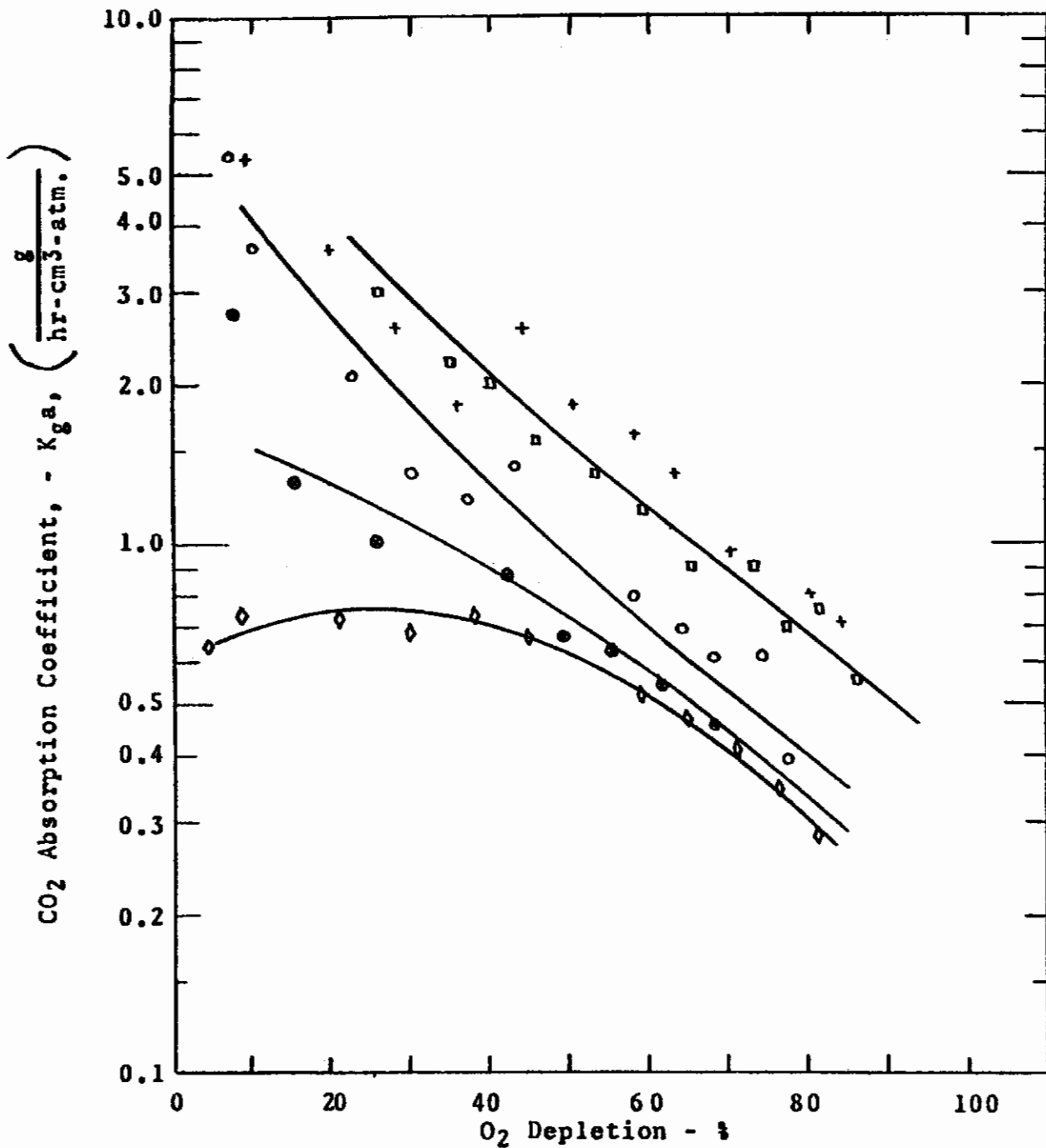
FIG. 11 - CO₂ ABSORPTION COEFFICIENTS FOR KO₂ PLATES
40



LEGEND

- ◇ 14.5 cm discs x 32 cm long - 35 cm/sec.
- 9.5 cm discs x 69 cm long - 35 cm/sec.
- 9.5 cm discs x 69 cm long - 50 cm/sec.
- + 9.5 cm discs x 69 cm long - 64 cm/sec.
- 7.0 cm discs x 107 cm long - 59 cm/sec.

FIG. 12 - O₂ GENERATION COEFFICIENTS FOR DISCS



LEGEND

- ◇ 14.5 cm discs x 32 cm long - 35 cm/sec.
- 9.5 cm discs x 69 cm long - 35 cm/sec.
- 9.5 cm discs x 69 cm long - 50 cm/sec.
- + 9.5 cm discs x 60 cm long - 64 cm/sec.
- 7 cm discs x 107 cm long - 59 cm/sec.

FIG. 13 - CO₂ ABSORPTION COEFFICIENTS FOR DISCS

through the plates. The effect of increasing velocity is demonstrated in Figures 10 and 11.

The relationship of the overall resistance (reciprocal of overall coefficients) for O₂ generation is shown in Figure 14 for Test 40, 65, 68, 70, and 81. This relationship is represented as a straight line plot of the form:

$$Y = a + b (X)$$

and is analogous to the equation relating the overall coefficients with individual coefficients as a function of O₂ depletion:

$$1/K_g = 1/k_g + 1/k_s (X)$$

Thus, the intercept (at X = 0, no O₂ depletion) represents the gas film resistance, and the slope the resistance of the solid chemical reactants. The gas film resistance for Test 40 is lowest (higher coefficient, k_g) for the three tests and Test 40 had the highest flow rate. The relationship can be seen to be a function of velocities through the configuration. Test 40 (velocity was 116 cm/sec.) had the lowest overall resistance with increasing resistance as velocity decreased. The velocity in Test 70 was 64 cm/sec. and in Test 68 it was 48 cm/sec. The absorption coefficients for the plate configurations of Tests 40, 65, 68, 70, and 81 are shown in Figure 15. Disc configuration behaved in this manner; increasing flow rate lowered resistance and increased coefficients. The disc configurations exhibited higher resistance values than plate configurations at corresponding flow rates.

Figures 14 and 15 for plate configuration also illustrate performance of Test 65, which was an 8-hour configuration. This configuration was smaller than the 24-hour configurations of Test 40, 68, and 70 and had a preheated flow stream which increased the inlet temperature by 8-12°C. The combined effect of preheating and a high mass flow through the configuration increased performance by lowering the surface resistance, as represented by lower slope lines. The initial resistances, or generation and absorption coefficients, are higher since less bulk superoxide was present. The lower slope for Test 65 demonstrated performance gained by higher inlet temperature and flow. This was again illustrated in Test 81, a 24-hour configuration which had the inlet stream preheated by using a reflux manifold.

The plots of Figures 14 and 15 are shown as straight lines. Above 80% O₂ depletion, data became scattered, suggesting

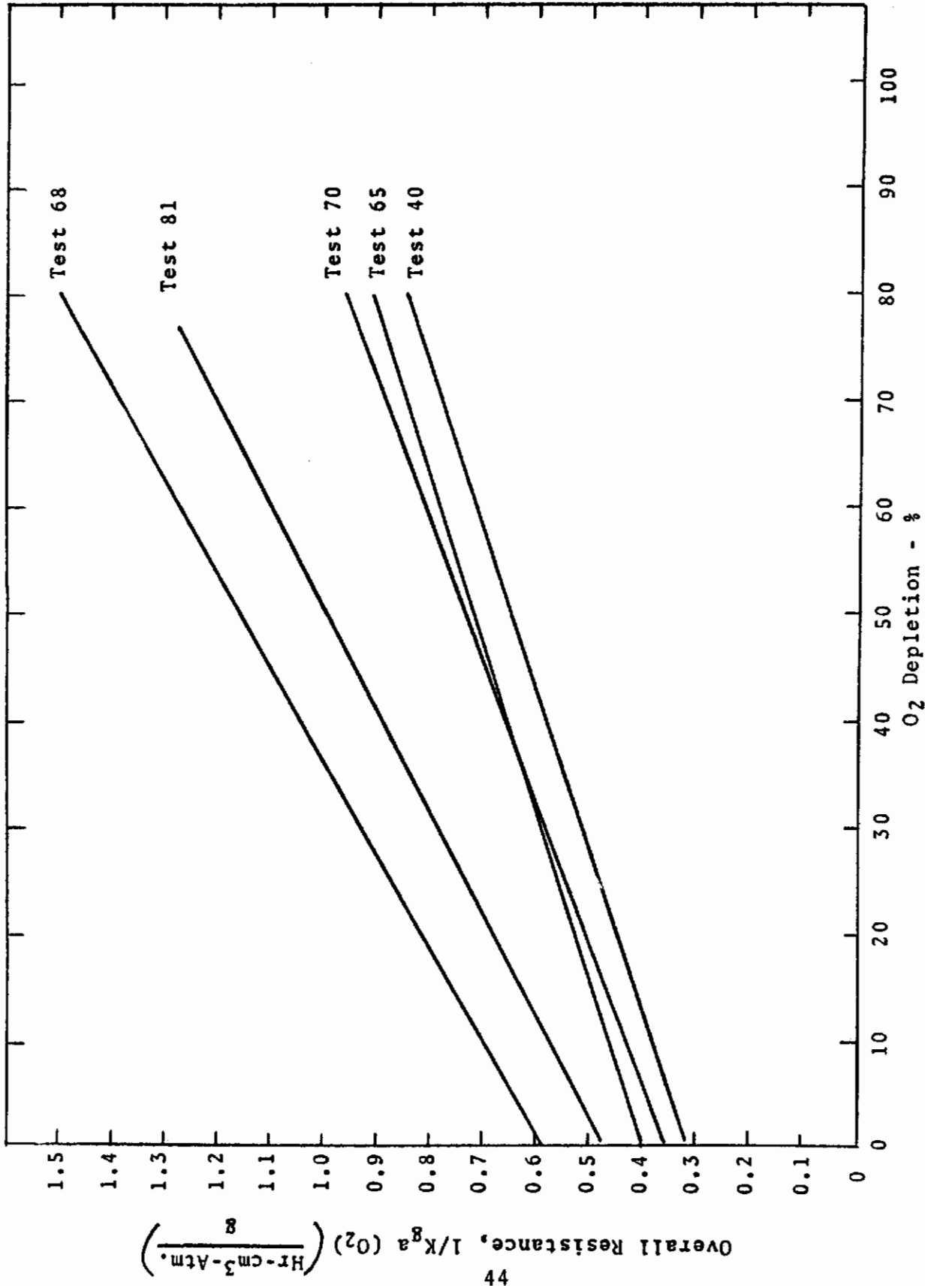


FIG. 14 - O₂ GENERATION RESISTANCES IN KO₂ PLATES

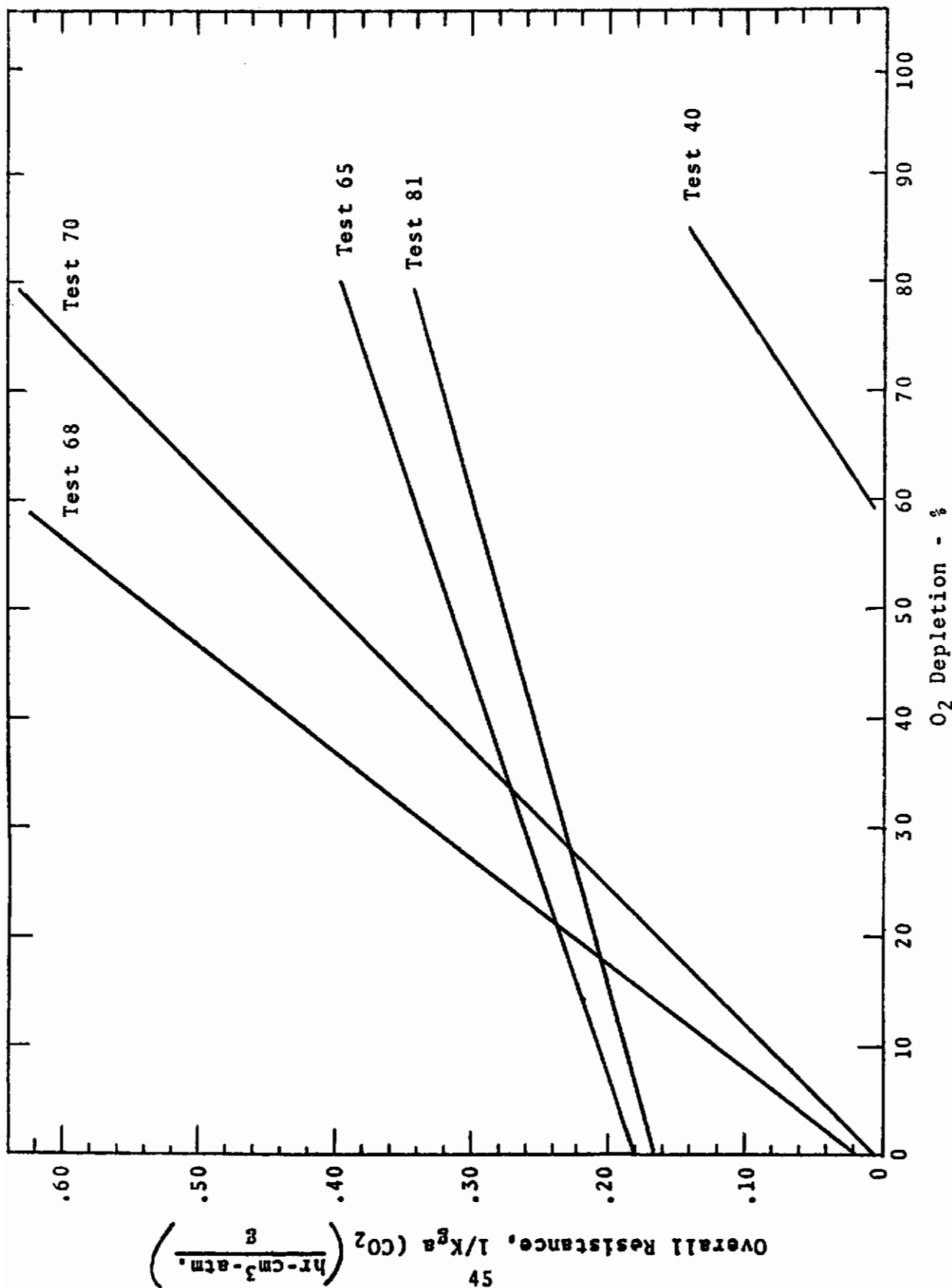


FIG. 15 - CO₂ ABSORPTION RESISTANCE IN KO₂ PLATE CONFIGURATIONS

Contrails

that the overall reaction rates are not truly linear and are of higher order.

Individual coefficients are shown to change very rapidly. The use of HTU, height of a transfer unit with dimensions of centimeters, is employed in mass transfer because it is more nearly constant. The HTU when plotted against mass flow, designated by G and with units of g/hr-cm^2 , gives a general correlation of the mass transfer operations. The HTU for O_2 generation and CO_2 absorption were calculated from the relation:

$$\text{HTU} = \frac{G}{K_{ga} (1-y)_f} \quad \text{where}$$

G is the mass flow rate of gas through the configuration per unit cross-sectional area for flow. K_{ga} is the average transfer coefficient for O_2 generation or CO_2 absorption observed during the test. The units for K_{ga} in this application are:

$$\frac{\text{g (gas being transferred)}}{\text{hr-cm}^3 \text{ (chemical volume) - atmosphere}}$$

The term $(1-y)_f$ is the pressure in atmospheres of a layer of insoluble gas through which the soluble gases (H_2O in the case of O_2 generation and CO_2 for the case of CO_2 absorption) must pass. The value of y in the term $(1-y)_f$ represents the partial pressure in atmospheres of the diffusing gas. This value is low in relation to the total pressure $(1-y)_f$ and is essentially the ambient pressure.

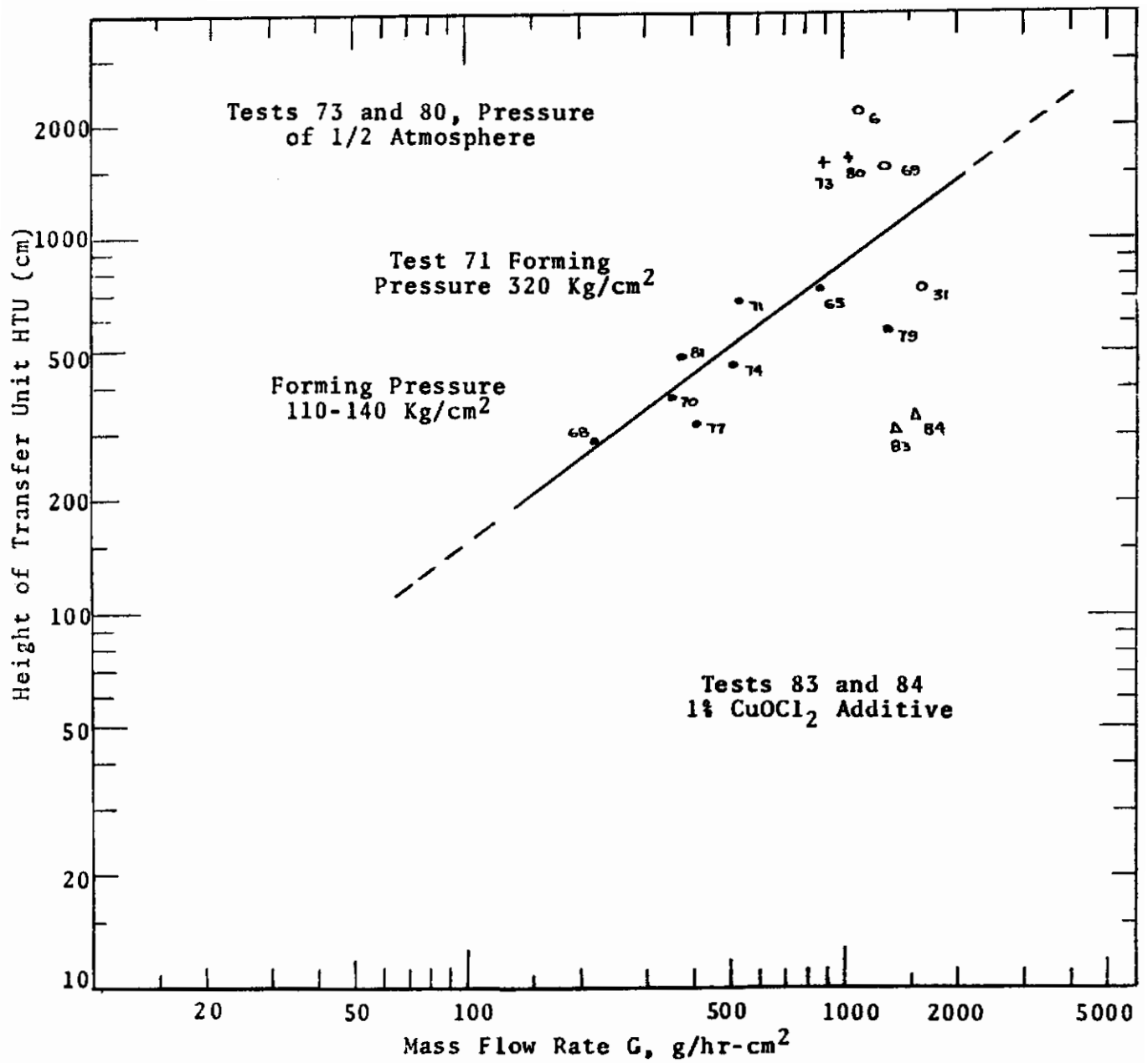
For configuration tests made at atmospheric pressure; ($P = 1 \text{ atm.}$) the HTU for O_2 becomes:

$$\text{HTU}_{\text{O}_2} = \frac{G}{K_{ga} (\text{O}_2)}$$

and for CO_2 :

$$\text{HTU}_{\text{CO}_2} = \frac{G}{K_{ga} (\text{CO}_2)}$$

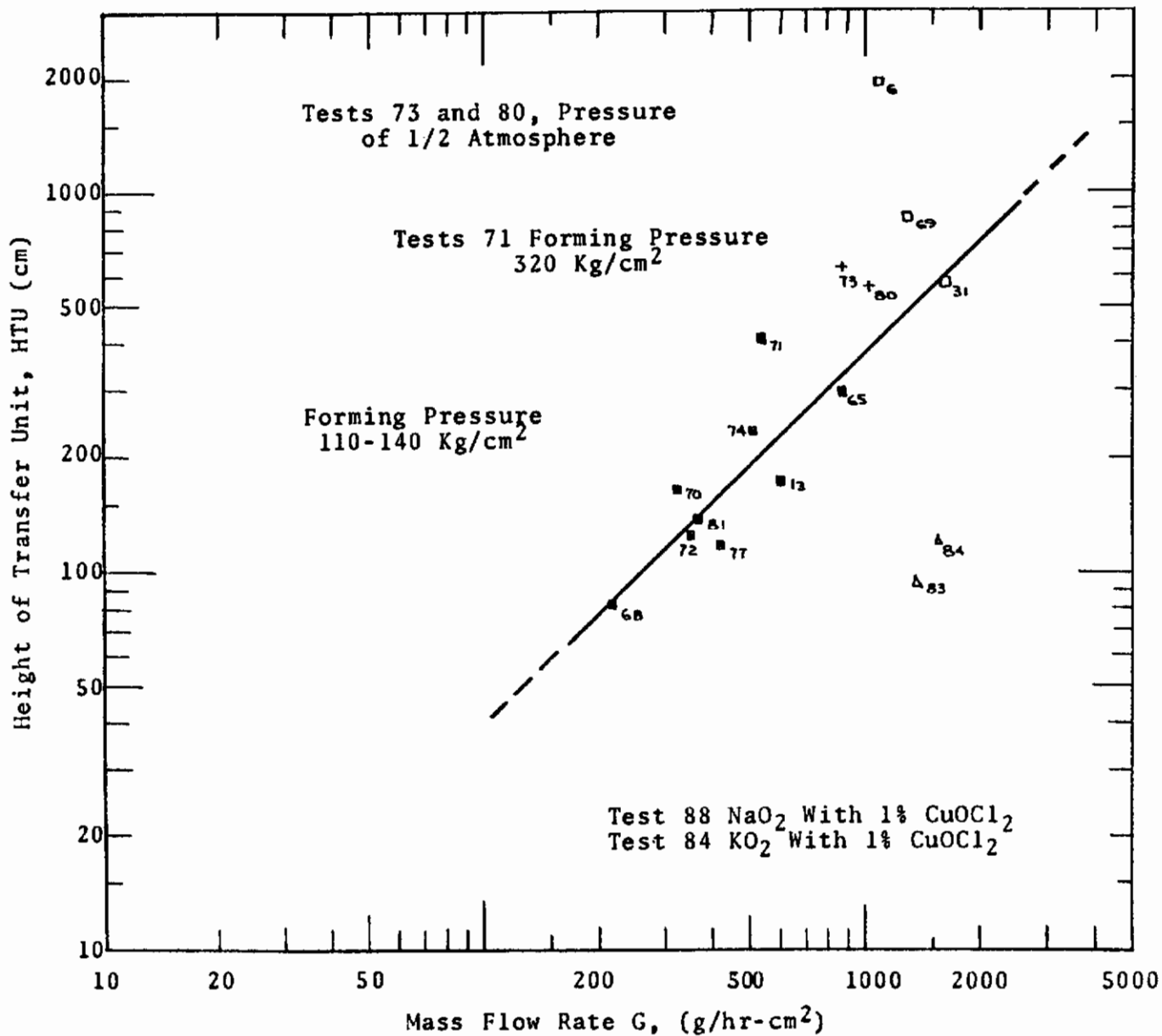
Values of HTU for O_2 plate configuration tests are shown in Figure 16 and for CO_2 in Figure 17. These are shown as straight



LEGEND

- Plates (Number designates test)
- Discs
- + Plates at 1/2 Atmosphere
- △ Plates with 1% CuOCl₂

FIG. 16 - HTU FOR O₂ GENERATION WITH KO₂ CONFIGURATIONS



LEGEND

- Plates (Number designates test)
- Discs
- + Plates at 1/2 Atmosphere
- △ Plates with 1% CuOCl₂

FIG. 17 - HTU FOR CO₂ ABSORPTION WITH KO₂ CONFIGURATIONS

Contrails

line plots for the short range of data obtained from the configuration tests.

This treatment when applied to disc configuration yielded scattering of data points and the performance of disc configurations is less definitive than for plates. Mass flow rates were calculated using the flow area through the disc configuration as was done in plate configuration. However, the non-dynamic flow pattern of disc configuration contributed to less predictable performance and scattered results.

For an absorption bed of differential thickness, dz , the mass balance and mass transfer relations can be expressed as:

$$G dy = K_g a (y-y^*) dz \quad (1)$$

rearranging gives

$$\frac{dy}{(y-y^*)} = \frac{K_g a}{G} dz \quad (2)$$

defining HTU as given previously to be

$$HTU = \frac{G}{K_g a}$$

results in

$$\frac{dy}{y-y^*} = \frac{dz}{HTU} \quad (3)$$

HTU will be nearly constant for a given column and equation (3) can be integrated:

$$\int_{y_2}^{y_1} \frac{dy}{y-y^*} = \frac{z}{HTU} \quad (4)$$

and a quantity of NTU can be defined as:

$$NTU = \frac{dy}{y-y^*} \quad (5)$$

hence we have

$$NTU = \frac{Z}{HTU} \quad (6)$$

For the case where the equilibrium gas concentration y^* is small compared to the gas concentration y , the NTU becomes

$$NTU = \int_{y_2}^{y_1} \frac{dy}{y} = \ln \frac{y_1}{y_2} \quad (7)$$

This occurs for any non-reversible reaction. Thus the relation

$$\ln \frac{y_1}{y_2} = \frac{Z}{HTU} \quad (8)$$

Where y_1 is inlet concentration of the gas being absorbed and y_2 is the outlet gas concentration. The relation of the plots of Figures 16 and 17 provide a basis for calculating configuration performance.

Applications of the Equations

The plots of Figures 16 and 17 were generated from 8-hour and 24-hour test data on plates pressed at 110-140 Kg/cm². As discussed previously, the higher forming pressure decreased performance, that is, displaced the line plot of HTU vs G upward.

A single configuration design may not match both the O₂ production or CO₂ absorption desired. This was demonstrated in the tests where O₂ production was adequate but CO₂ absorption lagged.

Contrails

The equations and correlation plots presented previously can be used to predict configuration performance. Complete utilization of available O₂ cannot be achieved especially for short mission configurations and must be considered in the design. Test data for 8-hour plate-type configurations have shown an O₂ efficiency of 70% with KO₂ and for 24-hour configurations the O₂ efficiency is approximately 90%. A second point to consider is that CO₂ absorption is a more limiting factor on design than is O₂ generation. Therefore, calculations illustrate configuration based on CO₂ absorption capability. This assumes that the inlet flow stream has moisture which is necessary to generate O₂ and produce hydroxide for CO₂ absorption. Most of the configuration tests were made at humidities of 50% RH at 24°C and lower.

To illustrate the use of the correlation plots and equation we decided to design an 8-hour configuration which will provide:

45.4 g O₂/hr, 50 g CO₂/hr using 7.6 cm x 15.2 cm diagonally rippled plates (see figure 8) and 70% utilization of available O₂.

For the reaction of superoxide,



the amount of KO₂ can be calculated.

$$\text{KO}_2 = \frac{144}{48} 45.4 \text{ g O}_2/\text{hr} \times 8 \text{ hr} =$$

$$1090 \text{ g KO}_2$$

For a 70% utilization the amount of KO₂ required becomes:

$$1090/0.7 = 1560 \text{ g KO}_2$$

For plates weighing 44 g each, approximately 36 plates are required. Arbitrarily, arrange the plates as 2 beds in series, each bed having 18 plates. Each bed being 15.2 cm long to give a total bed length of 30.4 cm.

- (a) Select a flow rate and calculate bed length required to generate 45.4 g/hr O₂.

Contrails

A trial calculation is made for 400 liters/min.
STP flow rate.

Chamber humidity is 50% RH at 24°C (1.46% H₂O)

$$400 \text{ liters/min. (STP)} = 24,000 \text{ liters/hr (STP)} = \\ 31,200 \text{ g/hr flow (air)}$$

Calculate outlet moisture concentration y_2 , to
generate:

$$45.4 \text{ g/hr O}_2$$

Amount of H₂O required is:

$$18/48 (45.4) = 17.1 \text{ g/hr H}_2\text{O or } 31,200 \\ (0.0146 - y_2) = 17.1$$

$$y_2 = \frac{439}{31,200} = .0141 \text{ or } 1.41\% \text{ outlet} \\ \text{moisture concentration}$$

$$\text{Number Transfer Units, NTU} = \int_{y_2}^{y_1} \frac{dy}{y} =$$

$$\ln y \left[\begin{array}{l} y_1 \\ y_2 \end{array} \right]$$

$$\text{NTU} = \ln \frac{1.46}{1.41} = \ln 1.035 = 0.0344$$

Flow area for 18 plate wide configuration
(1.61 cm² per plate)

$$A = 18 \times 1.61 = 29 \text{ cm}^2$$

$$\text{Mass flow rate, } G = \text{g/hr cm}^2$$

Contrails

$$G = 31,200/29 = 1070 \text{ g/hr cm}^2$$

HTU for O₂ from Figure 16

$$\text{HTU} = 900 \text{ cm for } G = 1075 \text{ g/hr-cm}^2$$

$$\text{Bed Length } Z = \text{NTU} \times \text{HTU} = 0.034 \times 90 = 30.7 \text{ cm}$$

This checks with 30.4 cm length above and at a flow of 400 liters/min. the average O₂ generation should be approximately 45.4 g/hr.

- (b) For this configuration and flow rate, what bed length is required to remove 50 g/hr if the inlet CO₂ concentrations is 1% (y₁ = 1%).

50 g/hr CO₂

Calculate outlet concentration at

$$31,200 (0.001 - y_2) = 50$$

$$y_2 = \frac{260}{31,000} = 0.0084 \quad (0.84\% \text{ CO}_2)$$

$$\text{Number of transfer units, NTU} = \left[\begin{array}{c} y_1 \\ \ln y \\ y_2 \end{array} \right] =$$

$$\ln \frac{0.010}{0.0084} = 0.1735$$

HTU for CO₂ from Figure 17

$$\text{HTU} = 390 \quad \text{for } G = 1070 \text{ g/hr cm}^2$$

Bed length required, Z for CO₂ removal

$$Z = \text{NTU} \times \text{HTU} = 0.1735 \times 390 = 67.7 \text{ cm long}$$

bed is needed.

Contrails

This shows that a single configuration may not satisfy O₂ generation and CO₂ absorption requirements depending upon the limits set. If the inlet CO₂ concentration, y₁ is permitted to be 2.0%, the bed length can be matched. The higher CO₂ concentration provides a greater driving force for absorption and shortens the bed.

Let y₁ = 2.0% CO₂ inlet concentration

Calculate outlet concentration, y₂ at 15 SCFM flowrate

$$31,000 (0.02 - y_2) = 50$$

$$y_2 = \frac{620 - 50}{31,000} = \frac{.570}{31,000} = 0.0184$$

$$\text{Number of Transfer Units, NTU,} = \left[\ln y \right] \begin{matrix} y_1 \\ y_2 \end{matrix} =$$

$$\ln \frac{0.020}{0.0184} = 0.0805$$

HTU for CO₂ is 390 from above

Bed length required, Z, for CO₂ removal

$$Z = \text{NTU} \times \text{HTU} = 0.0805 \times 390 = 31.4 \text{ cm}$$

The above calculations illustrate the use of the equations and plots and show the effects of gas concentrations upon performance of a selected configuration. The calculations for this configuration show that at a flow of 400 liters/min. (STP) the average O₂ generation will be 45.4 g/hr and CO₂ absorption rate will be 50 g/hr at an inlet CO₂ concentration of 2.0%. One might also have selected a 36 plate wide array rather than the 18 plate arrangement. Calculations for this configuration at 400 liters/min. (STP) would show a decrease in O₂ generation rate and CO₂ absorption rate because of a decrease in mass flow rate. Conversely a narrower and a longer configuration might be selected. An increase in O₂ generation rate and CO₂ absorption would be obtained because of the increase in mass flow rate, however, the pressure drop would increase because of the longer bed length.

Configuration Recommendations

The investigation of the superoxide configurations has yielded data from which designs are suggested for 2-, 4-, 8-, 24-, and 48-hour missions. Plate configurations are recommended over disc configurations, and the diagonal plate design provides less chance of flow obstruction from breakage. In the disc design a fragment could obstruct the center hole and adversely affect performance. With this type of plate design, the flow can still pass through the many channels provided by the diagonal pattern. The use of KO_2 is recommended for these designs since NaO_2 did not possess equivalent structural integrity. For 2- and 4-hour mission designs, seeding of the KO_2 with 1% $CuOCl_2$ promotes more effective performance for these short life missions. No advantage is gained in longer life missions since the additional time promotes better utilization of the superoxide.

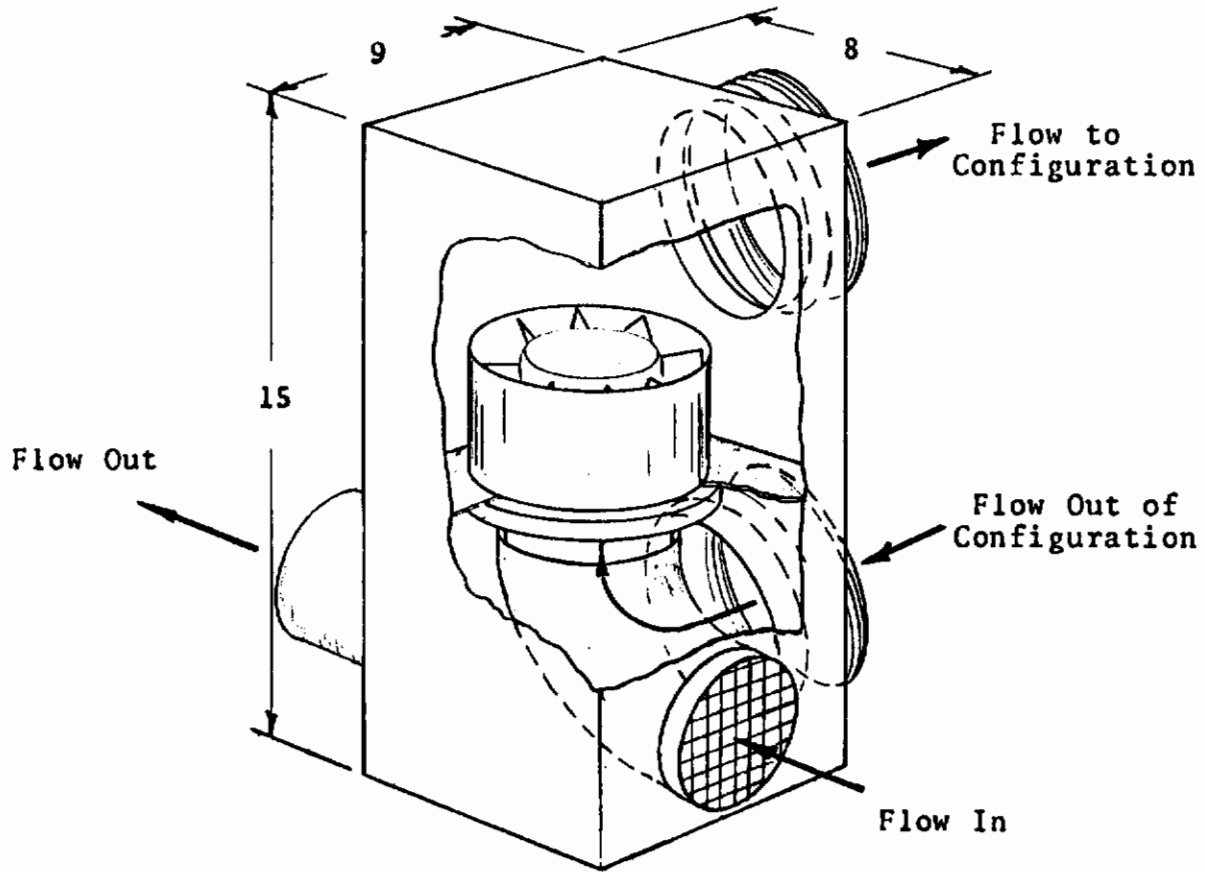
A reflux manifold is suggested to partially recirculate exhaust gases. Gases flowing into the configuration are preheated, promoting better utilization of the inlet superoxide bed. Figure 18 represents a reflux manifold design.

Figure 19 shows a design for 2-hour and 4-hour configurations. The inlet and outlet parts mate to the reflux manifold shown in Figure 18. The 2-hour and 4-hour designs use 7.6 cm x 15.2 cm diagonally rippled KO_2 plates seeded with 1% $CuOCl_2$ to give accelerated performance and more efficient utilization of the superoxide in the short mission time.

Specifications for the five mission configurations are tabulated for comparison.

<u>Mission Configuration (hr)</u>	<u>No. Plate</u>	<u>Weight (g)</u>	<u>Volume of Plate Envelop (cm³)</u>	<u>Inlet Flow Rate (liters/min.)</u>	<u>Total* Internal Flow Rate (liters/min.)</u>	<u>Pressure Drop (cm H₂O)</u>	<u>Power (watts)</u>
2	15	660	923	425	1150	1.8	27
4	24	1060	1400	280	850	3.6	24
8	40	1760	2300	425	1150	2.5	27
24	100	4000	5400	225	850	2.3	24
48	200	8000	10,800	85	280	0.8	21

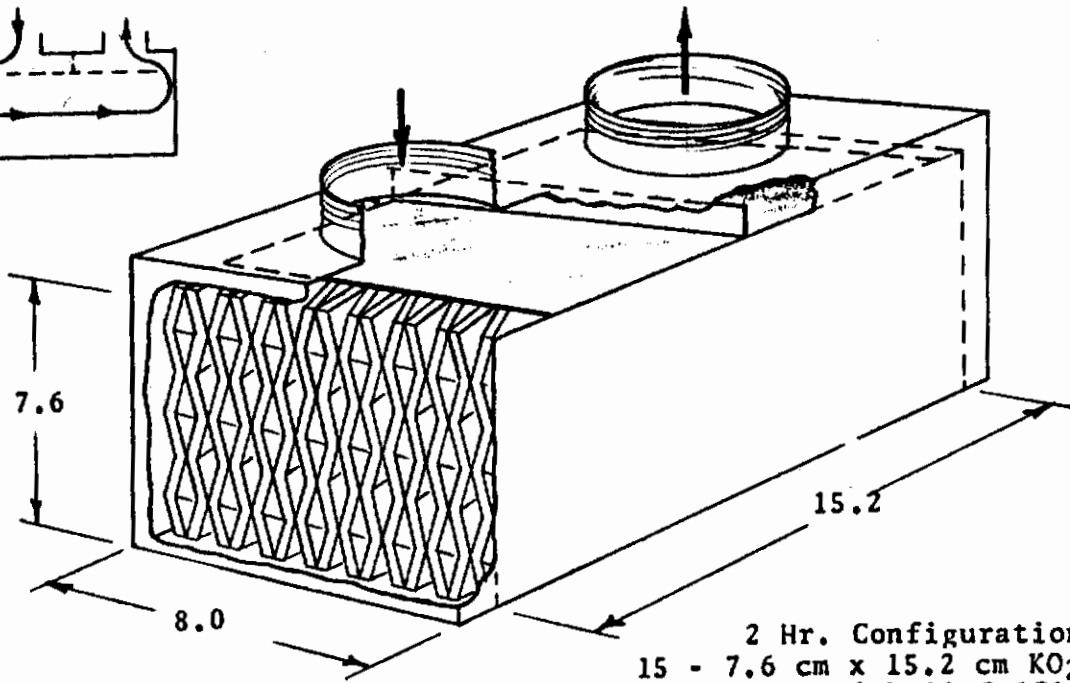
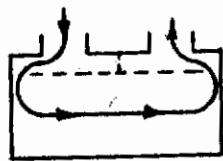
* Total flow less inlet flow gives reflux flow.



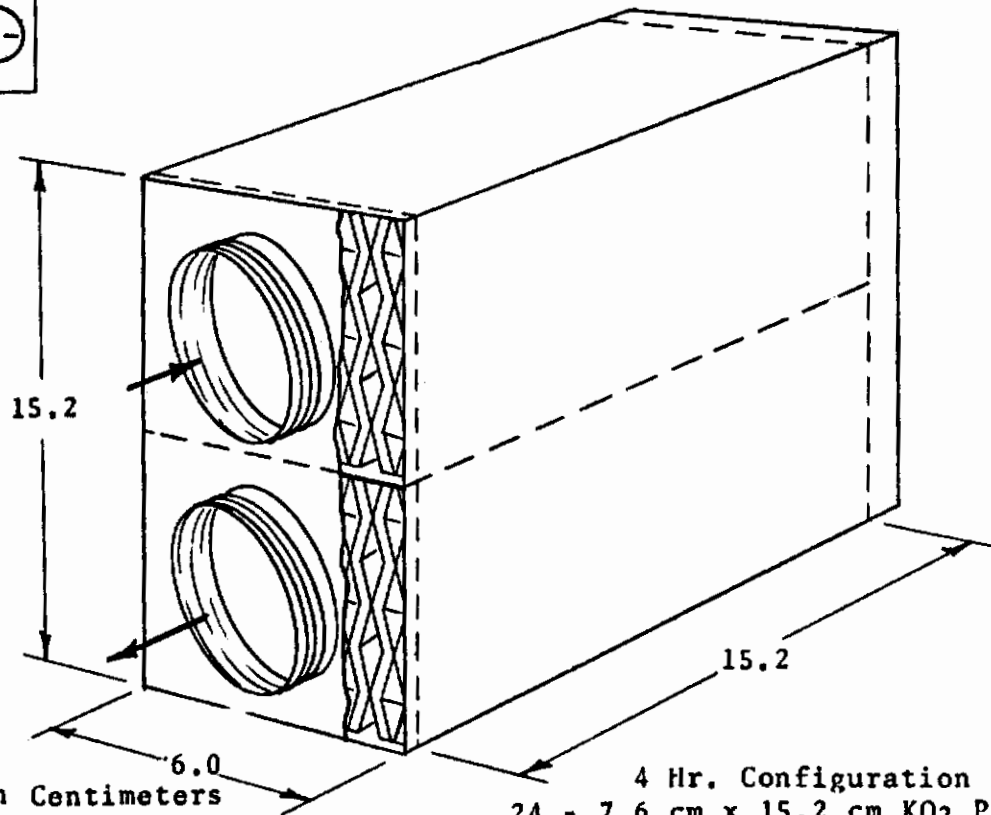
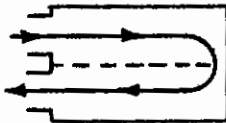
Dimensions in Centimeters

FIG. 18 - REFLUX MANIFOLD

Contrails



2 Hr. Configuration
15 - 7.6 cm x 15.2 cm KO_2 Plates
with $1\frac{1}{2}$ $CuOCl_2$



Dimensions in Centimeters

4 Hr. Configuration
24 - 7.6 cm x 15.2 cm KO_2 Plates
With $1\frac{1}{2}$ $CuOCl_2$

FIG. 19 - TWO-HOUR AND FOUR-HOUR CONFIGURATION DESIGNS

Figure 20 represents the 8-hour and 24-hour mission configuration. The 48-hour mission configuration, not shown, would be two 24-hour mission configurations in series.

Configuration Samples

Two laboratory samples of the KO_2 configurations shown in Figures 2-4, 6-8 were submitted to AMRL. Samples of NaO_2 , 50% NaO_2 - 50% KO_2 , KO_2 with 1% $CuOCl_2$ and KO_2 with 25% $LiOH$ were also furnished. These were pressed to the 7.6 cm x 15.2 cm diagonally rippled plate configuration pattern. Three modules containing six 7.6 cm x 15.2 cm plates were also supplied to illustrate packaging formation. One module contained KO_2 plates, another KO_2 plates with 1% $CuOCl_2$ and a third KO_2 plates having internal wire mesh. A six plate module of 10.2 cm x 10.2 cm rippled KO_2 plates was a fourth module delivered for evaluation. These six plate modules were encased in No. 2 mesh wire cloth.

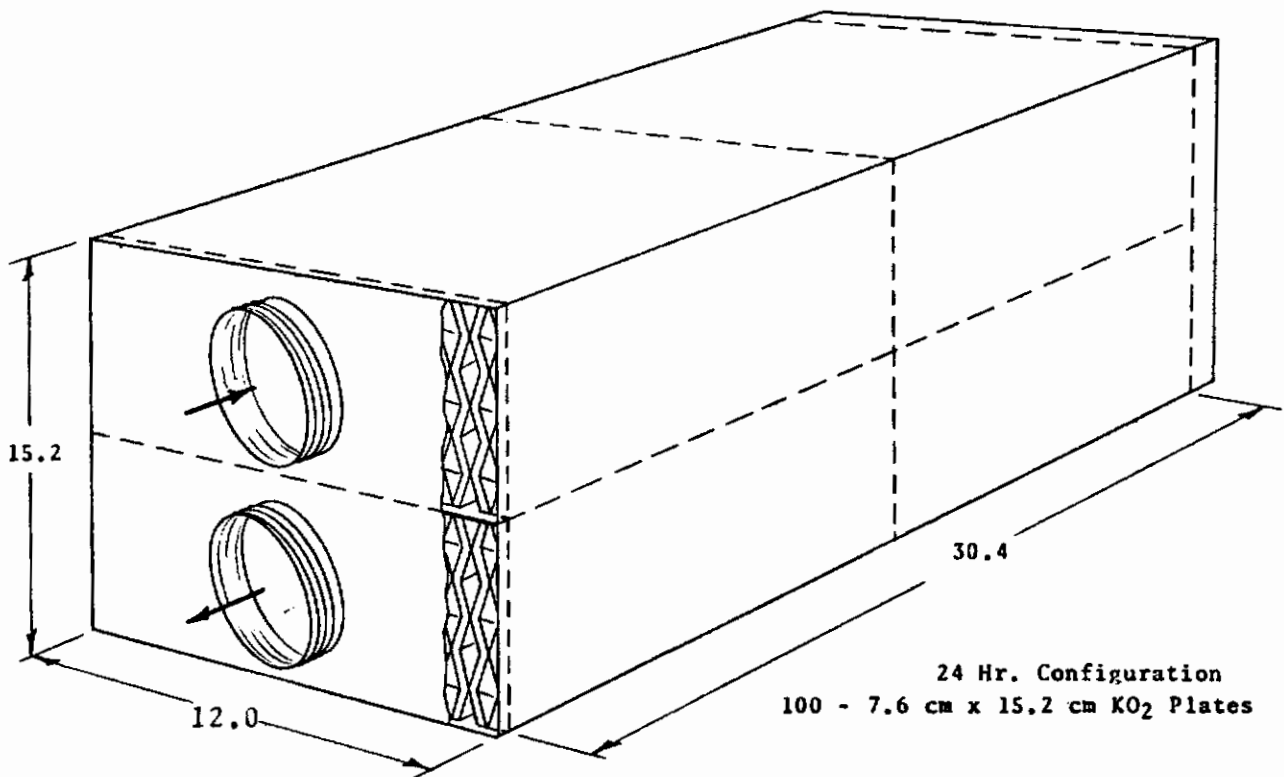
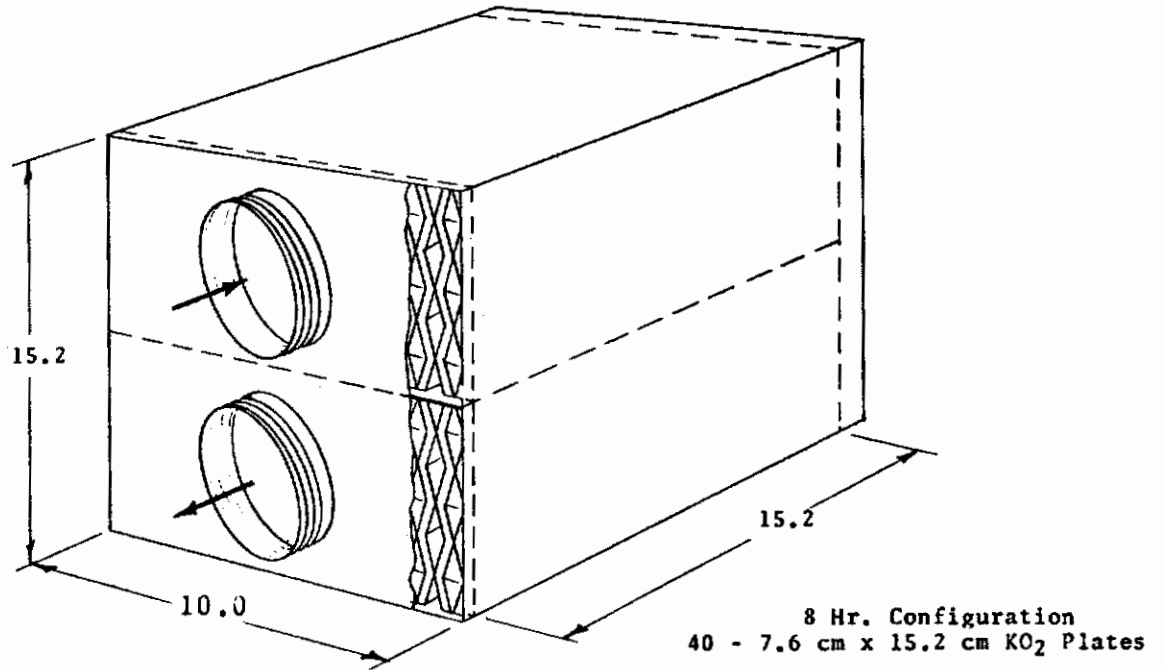


FIG. 20 - EIGHT-HOUR AND TWENTY-FOUR-HOUR CONFIGURATION DESIGNS

Section V

CONCLUSIONS AND RECOMMENDATIONS

Solid superoxide configurations have been further defined for application to life support systems. Analysis of 2-, 4-, 8-, 24-, and 48-hour mission configuration tests has supplemented the engineering design parameters.

Plate designs are more efficient than disc designs tested because of the more dynamic flow arrangements. The more dynamic flow patterns of plate type configurations lead to more definitive performance than do disc configuration designs.

The theory of the O_2 generation and CO_2 absorption by a superoxide configuration was advanced in this work. The rate limiting factors for O_2 generation and CO_2 absorption consisted of a gas film resistance and a diffusion resistance into the solid superoxide. The gas film resistance was shown to be decreased by increasing flow or velocity through the configuration. The diffusion resistance of the solid was shown to be decreased, especially for CO_2 absorption by increasing temperatures. These factors were integrated into performance correlations.

Correlation of results was obtained by application of mass transfer equations. For O_2 generation, the superoxide was considered on its moisture absorption properties. Both O_2 generation and CO_2 absorption correlations were represented as a height of a transfer unit versus mass flow rate to effect the desired mass exchange. The correlation equations provide a method of calculating configuration performance and assist the analysis of the effects of ambient pressure and O_2/N_2 balance.

Chemical methods to accelerate reactions and improve performance were studied. The addition of $CuOCl_2$ proved to be beneficial in short 2-hour and 4-hour mission configurations but offered no advantage in longer mission configuration designs. Additions of lithium and sodium hydroxides and peroxides to the superoxide to give more CO_2 absorption capability were of no apparent value.

No design advantages are offered by NaO_2 over KO_2 in solid superoxide configurations. The NaO_2 , even when pressed harder than the KO_2 , does not have equivalent structural strength and the performance is not as good because of decreased porosity.

Densification had more adverse effects on performance than benefits to be gained in volume savings. In one case a disc configuration volume of 4120 cm^3 had a density of 0.88 g/cm^3 when

Conclusions

the discs were pressed at 120 Kg/cm²: when pressed at 320 Kg/cm² the density was 1.01 g/cm³. In the latter case O₂ generation decreased 45% and the CO₂ absorption decreased 40%. Both disc and plate-type configurations showed poorer performance with increased densification.

High humidity decreased performance in the absorption of CO₂ more than generation of O₂. Swelling of the superoxide forms occurred to a greater degree at the higher humidities than at lower humidities. This swelling constricted the flow area and decreased the flow rate.

Reduced pressure and combination of O₂/N₂ balance had no serious effects on configuration performance. If mass flow rate is maintained at a lower pressure comparable performance will be obtained. Theoretically, at the same partial pressure of CO₂, absorption at a lower total pressure should be somewhat greater than that at a higher pressure since the inert gas is less concentrated. In the few pressure reduced tests made, O₂ generation was comparable to that at ambient pressure and there was a slight decrease in CO₂ absorption. There is evidence that mass flow was somewhat lower than measured.

Recommendations

For short mission configurations, optimization approaching theoretical amounts of superoxides becomes increasingly difficult to attain. Chemical additives of the catalytic type offer some improvement, but the primary factor is to increase surface area. Since solid forms have a limiting surface-to-volume ratio and must retain some thickness for structural rigidity, the use of granules is indicated to increase surface exposure. Deviation from solid configurations and study of granular forms to obtain adequate CO₂ control for short mission designs is recommended. Granular forms were examined in a test to characterize KO₂ made from different fluff starting materials; however, no further granular tests were made since the work was to investigate only solid forms. Designs encompassing granular forms of superoxide and granular type of driers and CO₂ absorbers in combination would be of interest.

Scale up of configuration designs to service more than one man is recommended for further study. Testing designs for several men would extend the correlation plots presented in this report.

More work at reduced pressure would extend the information of superoxide for application to back-pack service or in transfer modules. More extensive testing should be performed to fully determine effects of rarified atmospheres and inert gases other than nitrogen.

Contrails

High humidity causes swelling of the superoxide configurations, and decreases flow. This effect is minimized by using solid shapes, rather than granules. Whether the high humidity or decrease flow harms configuration performance was not fully ascertained. Tests made at constant flow rate would determine if crusting of the superoxide surfaces is the major impediment.

APPENDIX

CONFIGURATION TEST DATA

CONFIGURATION TEST DATA

Simulation: 1.12 SCFH O₂; 0.896 SCFH CO₂; 0.1 lb m/hr H₂O

Test Chamber: Pressure - 1 Atm.
Atmosphere - Air

Test No.	1	2	3	4	5	6	7
Chemical	KO ₂	KO ₂	KO ₂	KO ₂	KO ₂	KO ₂	KO ₂
KO ₂ Fluff - Avail. O ₂ , cc/g (STP)	238	238	238	238	238	238	238
- Specific Gravity	0.3	0.3	0.3	0.3	0.3	0.3	0.3
Run Time (hr)	13	12	12	7	7	24	6
Chemical Configuration	Disc	Plate	Plate	Disc	Disc	Disc	Disc
Dimensions (cm)	7 x 0.63	6.3 x 11.4 x 0.63	6.3 x 11.4 x 0.63	7 x 0.63	7 x 0.63	14.5 x 0.63	38 x 2.2
Pressure to Form (Kg/sq cm)	1430	650-750	650-750	830	1430	390	580
Number of Shapes Used	175	60	60	60	60	50	1
Total Chemical Weight (g)	4103	2344	2458	1336	1348	3926	3320
Total Surface Area (sq cm)	15,800	11,450	11,150	5420	5420	17,600	7300
Chemical Bed Length (cm)	106.7	11.4	76.2	40.1	36.8	32.5	2.3
Housing - Free Flow Area (sq cm)	46.3	242.0	36.2	46.3	46.3	183	1200
Flow Area, Total*(sq cm)	12.2	54.7	27.9	12.2	12.2	19.7	83.3
Residence Time (sec.)	0.3	0.1	0.1	0.1	0.1	0.1	0.04
Final O ₂ Concentration (%)	16.5	18.0	17.2	18.3	16.0	16.0	17.0
Final CO ₂ Concentration (%)	4.4	3.3	2.2	3.6	3.4	2.6	2.6
Chamber Volume (liters)	3680	3680	3680	3680	3680	3680	3680
Flow Rate (liters/min.)							
Start	27.0	26.2	29.2	25.6	28.3	27.6	26.8
End	24.8	20.3	15.5	25.6	27.3	23.9	22.5
Chemical Analysis							
O ₂ Evolved, liters (STP)	392.0	396.0	398.5	243.0	132.6	75.8	114.0
CO ₂ Absorbed, liters (STP)	206.5	209.5	196.5	87.5	70.8	54.8	83.0
O ₂ Efficiency (%)	40.0	71.0	68.0	59.0	41.5	81.0	15.1
RQ	0.5	0.5	0.5	0.4	0.5	0.7	0.7
Ave. O ₂ Pro. Rate, liters/hr (STP)	30.2	30.2	33.1	34.9	19.0	31.7	19.0
Ave. CO ₂ Abs. Rate, liters/hr (STP)	15.8	17.5	16.4	12.4	10.1	22.8	13.6

*Cross-sectional Area of Canister Perpendicular to Flow.

Test No.	8A	8B	8C	8D	8E	8F
Chemical	KO ₂	KO ₂	KO ₂	KO ₂	KO ₂	KO ₂
KO ₂ Fluff - Avail. O ₂ , cc/g (STP)	232	234	227	239	231	238
- Specific Gravity	0.5	0.42	0.45	0.32	0.42	0.20
Run Time (hr)	6	6	6	6	6	6
Chemical Configuration	Granules	Granules	Granules	Granules	Granules	Granules
Dimensions (cm)	2-4 Mesh	2-4 Mesh	2-4 Mesh	2-4 Mesh	2-4 Mesh	2-4 Mesh
Pressure to Form (Kg/sq cm)	580	580	580	580	580	580
Number of Shapes Used	---	---	---	---	---	---
Total Chemical Weight (g)	1000	1000	1000	1000	1000	1000
Total Surface Area (sq cm)	---	---	---	---	---	---
Chemical Bed Length (cm)	9.2	7.9	9.2	10.2	9.9	9.2
Housing - Free Flow Area (sq cm)	183	183	183	183	183	183
Flow Area, Total (sq cm)	---	---	---	---	---	---
Residence Time (sec.)	0.38	0.34	0.31	0.39	0.39	0.35
Final O ₂ Concentration (%)	18.0	16.9	17.0	17.3	18.0	17.0
Final CO ₂ Concentration (%)	2.19	2.61	2.23	2.49	1.83	2.01
Chamber Volume (liters)	3680	3680	3680	3680	3680	3680
Flow Rate (liters/min.)	---	---	---	---	---	---
Start	255	263	266	269	263	260
End	216	204	198	170	105	184
Chemical Analysis						
O ₂ Evolved, liters (STP)	152.4	136.3	143.0	135.3	154.8	162.4
CO ₂ Absorbed, liters (STP)	92.8	83.8	103.3	88.0	111.2	94.8
O ₂ Efficiency (%)	65.8	58.5	63.0	56.6	66.9	68.2
RQ	0.63	0.61	0.72	0.65	0.72	0.59
Ave. O ₂ Pro. Rate, liters/hr (STP)	25.5	22.7	23.9	22.6	25.8	27.0
Ave. CO ₂ Abs. Rate, liters/hr (STP)	16.0	14.0	17.2	14.6	18.8	15.8

Test No.	9	10	11	12	13	14
Chemical						
KO ₂ Fluff - Avail. O ₂ , cc/g (STP)						
Specific Gravity						
Run Time (hr)						
Chemical Configuration						
Dimensions (cm)						
Pressure to Form (Kg/sq cm)						
Number of Shapes Used						
Total Chemical Weight (g)						
Total Surface Area (sq cm)						
Chemical Bed Length (cm)						
Housing - Free Flow Area (sq cm)						
Flow Area, Total (sq cm)						
Residence Time (sec.)						
Final O ₂ Concentration (%)						
Final CO ₂ Concentration (%)						
Chamber Volume (liters)						
Flow Rate (liters/min.)						
Start						
End						
Chemical Analysis						
O ₂ Evolved, liters (STP)						
CO ₂ Absorbed, liters (STP)						
O ₂ Efficiency (%)						
RQ						
Ave. O ₂ Pro. Rate, liters/hr (STP)						
Ave. CO ₂ Abs. Rate, liters/hr (STP)						

Test No.	15	16	17	18	19	20
Chemical	KO ₂ and 1% CuOCl ₂	KO ₂ and 3.5% Li ₂ O ₂	KO ₂ , 1% CuOCl ₂ and 10% Li ₂ O ₂	KO ₂ and asbestos fibers	KO ₂ and 1/2% CuOCl ₂	KO ₂ , 1/2% CuOCl ₂ and 2.5% LiCl
KO ₂ Fluff - Avail. O ₂ , cc/g (STP)	239	239	239	239	239	239
- Specific Gravity	0.33	0.33	0.33	0.33	0.33	0.33
Run Time (hr)	2	2	2	2	2	2
Chemical Configuration	Plate	Plate	Plate	Plate	Plate	Plate
Dimensions (cm)	10.2 x 10.2 x 0.63	10.2 x 10.2 x 0.63	10.2 x 10.2 x 0.63	10.2 x 10.2 x 0.63	10.2 x 10.2 x 0.63	10.2 x 10.2 x 0.63
Pressure to Form (Kg/sq cm)	650	650	650	650	650	650
Number of Shapes Used	7	7	7	8	8	8
Total Chemical Weight (g)	359	327	267	358	363	326
Total Surface Area (sq cm)	1500	1500	1500	1710	1710	1710
Chemical Bed Length (cm)	10.2	10.2	10.2	10.2	10.2	10.2
Housing - Free Flow Area (sq cm)	90.5	90.5	80.5	80.5	80.5	80.5
Flow Area, Total (sq cm)	17.0	17.0	16.8	19.4	19.4	19.4
Residence Time (sec.)	0.04	0.06	0.04	0.05	0.05	0.04
Final O ₂ Concentration (%)	17.0	11.5	14.0	15.0	18.0	16.0
Final CO ₂ Concentration (%)	2.82	4.8	2.67	2.04	2.07	2.52
Chamber Volume (liters)	212	212	212	212	212	212
Flow Rate (liters/min.)	274	187	255	221	224	283
Start	204	167	255	221	309	331
End						
Chemical Analysis						
O ₂ Evolved, liters (STP)	55.2	53.5	47.6	46.7	51.3	50.7
CO ₂ Absorbed, liters (STP)	35.9	33.7	33.4	35.1	30.0	34.5
O ₂ Efficiency (%)	65.0	68.5	75.0	54.8	59.2	65.0
RQ	0.65	0.63	0.7	0.75	0.59	0.68
Ave. O ₂ Pro. Rate, liters/hr (STP)	27.3	26.5	23.8	23.4	25.7	25.4
Ave. CO ₂ Abs. Rate, liters/hr (STP)	18.0	16.9	16.7	17.6	15.0	17.3

Test No.	21	22	23	24	25	26
Chemical	KO ₂ and 5% LiOH	KO ₂ and 5% MnO ₂	KO ₂ and 5% LiCl	NaO ₂	NaO ₂ and 20% Li ₂ O ₂	KO ₂ , 1% CuOCl ₂ and 19% Li ₂ O ₂
	239 0.33 2	239 0.33 2	239 0.33 2	-- -- 2	-- -- 2	239 0.33 2
	Plate 10.2 x 10.2 x 0.63 650	Plate 10.2 x 10.2 x 0.63 650	Plate 10.2 x 10.2 x 0.63 650	Plate 10.2 x 10.2 x 0.63 1090	Plate 10.2 x 10.2 x 0.63 1090	Plate 10.2 x 10.2 x 0.63 650
	8	8	8	8	8	8
Pressure to Form (kg/sq cm)	331	345	342	473	397	431
Number of Shapes Used	1710	1710	1710	1710	1710	1710
Total Chemical Weight (g)	10.2	10.2	10.2	10.2	10.2	10.2
Total Surface Area (sq cm)	80.5	80.5	80.5	80.5	80.5	80.5
Chemical Bed Length (cm)	19.4	19.4	19.4	19.4	19.4	19.4
Housing - Free Flow Area (sq cm)	0.05	0.05	0.05	0.05	0.05	0.05
Flow Area, Total (sq cm)	13.0	17.0	16.5	14.8	15.2	17.5
Residence Time (sec.)	5.9	1.97	2.47	3.39	2.97	3.49
Final O ₂ Concentration (%)	212	212	212	212	212	212
Final CO ₂ Concentration (%)	261	233	224	233	255	269
Chamber Volume (liters)	258	224	247	82	193	218
Flow Rate (liters/min.)						
Start						
End						
Chemical Analysis						
O ₂ Evolved, liters (STP)	35.6	54.1	37.3	57.1	54.6	48.4
CO ₂ Absorbed, liters (STP)	15.8	32.6	17.5	35.4	33.4	29.3
O ₂ Efficiency (%)	44.7	68.6	48.2	43.4	51.2	60.6
RQ	0.47	0.6	0.47	0.62	0.61	0.6
Ave. O ₂ Pro. Rate, liters (STP)	17.8	27.1	18.7	28.6	27.3	24.2
Ave. CO ₂ Abs. Rate, liters (STP)	8.0	16.3	8.9	17.7	16.7	14.7

Contrails

Test No.	27	28	29	30	31	32*
Chemical						
KO ₂ Fluff - Avail. O ₂ , cc/g (STP)						
- Specific Gravity						
Run Time (hr)						
Chemical Configuration						
Dimensions (cm)						
Pressure to Form (Kg/sq cm)						
Number of Shapes Used	8	16	16	16	35	10
Total Chemical Weight (g)	317	792	752	748	1173.6	334.6
Total Surface Area (sq cm)	1730	3440	3440	3440	5350	1525
Chemical Bed Length (cm)	10.2	10.2	10.2	10.2	22.9	6.4
Housing - Free Flow Area (sq cm)	51.7	103.4	103.4	51.7	80.6	80.6
Flow Area, Total (sq cm)	19.4	38.8	38.8	19.4	13.4	13.4
Residence Time (sec.)	0.04	0.09	---	0.09	0.2	---
Final O ₂ Concentration (%)	16	14	18.6	18	19.5	19
Final CO ₂ Concentration (%)	5.3	3.8	2.67	5.88	1.67	3.03
Chamber Volume (liters)	212	212	212	212	3680	73.5
Flow Rate (liters/min.)						
Start	410	278	326	258	225	---
End	311	291	379	162	166	---
Chemical Analysis						
O ₂ Evolved, liters (STP)	41.0	110.0	100.0	119.0	184.0	26.9
CO ₂ Absorbed, liters (STP)	22.4	72.5	58.5	72.5	105.0	14.2
O ₂ Efficiency (%)	57.0	61.5	55.8	66.4	65.5	33.5
RQ	0.52	0.66	0.58	0.61	0.57	0.53
Ave. O ₂ Pro. Rate, liters/hr (STP)	20.7	27.5	25.2	29.7	22.9	26.9
Ave. CO ₂ Abs. Rate, liters/hr (STP)	10.8	18.2	14.7	18.2	13.0	14.2

*Man Test

Test No.	33	34*	35**	36	37	38
Chemical	KO ₂	KO ₂ , Na ₂ O ₂ Na ₂ O ₂	KO ₂	KO ₂	KO ₂	NaO ₂
KO ₂ Fluff - Avail. O ₂ cc/g (STP)	239	239	239	239	239	
Run Time (hr)	0.33	0.33	0.33	0.33	0.33	
Chemical Configuration	8 Disc	2.5 Disc	2 Disc	8 Disc	Discs	4 Rippled Plates
Dimensions (cm)	9.5 x 0.63	10.2 x 10.2 x 0.63	9.5 x 0.63	7 x 0.63	9.5 x 0.63	10.2 x 10.2 x 0.63
Pressure to Form (Kg/sq cm)	610	610	610	610	610	1090
Number of Shapes Used	35	14	20	54	30	13
Total Chemical Weight (g)	1178.5	767.3	667.3	1199.6	1000.8	896.8
Total Surface Area (sq cm)	5360	3010	3050	4880	4520	2780
Chemical Bed Length (cm)	22.9	10.2	12.7	35.6	19.1	10.2
Housing - Free Flow Area (sq cm)	80.6	103.5	80.6	45.2	80.8	103.5
Flow Area, Total (sq cm)	9.7	34.0	13.3	12.2	13.3	31.6
Residence Time (sec.)	0.2	0.04	---	0.23	---	0.07
Final O ₂ Concentration (%)	19	24	22	18.5	22	11.5
Final CO ₂ Concentration (%)	2.16	1.7	2.37	2.67	2.16	5.8
Chamber Volume (liters)	3680	212	73.5	3680	73.5	212
Flow Rate (liters/min.)						
Start	245	484	---	305	---	317
End	243	458	---	283	---	263
Chemical Analysis						
O ₂ Evolved, liters (STP)	178	83.6	70.8	1545	125	125
CO ₂ Absorbed, liters (STP)	94.2	49.8	34.5	81.2	48.7	71.2
O ₂ Efficiency (%)	63.1	47.4	44.4	53.8	40.8	49.8
RQ	0.53	0.59	0.49	0.51	0.46	0.55
Ave. O ₂ Pro. Rate, liters/hr (STP)	22.1	15.3	35.4	19.3	42.4	31.4
Ave. CO ₂ Abs. Rate, liters/hr (STP)	11.9	9.1	17.3	9.9	20.4	17.3

* After 2.5 hr, CO₂ Concentration exceeded 6% (Recorder off scale) Simulator turned off.
Configuration tested additional 3 hr. Total test period 5.5 hr.

** Man Test. Fan used, flow at 250 liters/min.

Test No.	39	40	41	42	43	44
Chemical						
KO ₂ Fluff - Avail. O ₂ , cc/g (STP)						
- Specific Gravity						
Run Time (hr)	0.33	0.33	0.33	0.33	0.33	0.33
Chemical Configuration	8	4	4	4	4	4
Dimensions (cm)	Plates 10.2 x 10.2 x 0.63	Plates 10.2 x 10.2 x 0.63	Plates 10.2 x 10.2 x 0.63	Plates 10.2 x 10.2 x 0.63	Plates 10.2 x 10.2 x 0.63	Plates 10.2 x 10.2 x 0.63
Pressure to Form (Kg/sq cm)	545	545	545	545	545	545
Number of Shapes Used	25	95	16	18	18	18
Total Chemical Weight (g)	1159.4	3895.2	702.4	744.7	765.6	749.4
Total Surface Area (sq cm)	5360	20,350	3440	3870	3870	3870
Chemical Bed Length (cm)	30.5	61.0	20.3	30.5	30.5	33.0
Housing - Free Flow Area (sq cm)	51.7	103.3	51.7	38.8	38.8	38.8
Flow Area, Total (sq cm)	19.4	38.8	19.4	14.5	14.5	7.7
Residence Time (sec.)	0.16	0.55	0.09	0.1	0.29	0.5
Final O ₂ Concentration (%)	20	24	12, 21	20	22.5	24
Final CO ₂ Concentration (%)	1.95	0.87	2.49, 0.15	2.75	1.5	1.6
Chamber Volume (liters)	3680	3680	212	212	212	212
Flow Rate (liters/min.)						
Start	247	273	283	272	91	86
End	188	136	252	297	128	93
Chemical Analysis						
O ₂ Evolved, liters (STP)	186.3	92.6	250.5	116.7	115.4	82.6
CO ₂ Absorbed, liters (STP)		570	75	79.7	78.5	73.2
O ₂ Efficiency (%)	67.4	98.2	62.7	67.8	65.0	66.6
RQ	0.53	0.62	0.68	0.66	0.66	0.65
Ave. O ₂ Pro. Rate, liters/hr (STP)	23.3	33.6	25.5	29.1	28.8	31.7
Ave. CO ₂ Abs. Rate, liters/hr (STP)	12.5	20.7	17.3	19.3	19.0	20.7

Test No.	45	46	47	48	49	50
Chemical						
KO ₂ Fluff - Avail. O ₂ , cc/g (STP)						
- Specific Gravity						
Run Time (hr)						
Chemical Configuration						
Dimensions (cm)	10.2 x 10.2 x 0.63	10.2 x 10.2 x 0.63	10.2 x 10.2 x 0.63	10.2 x 10.2 x 0.63	10.2 x 10.2 x 0.63	7.6 x 15.2 x 0.63
Pressure to Form (kg/sq cm)	545	545	545	545	545	545
Number of Shapes Used	21	21	21	18	18	12
Total Chemical Weight (g)	853.6	884.9	901.0	788.8	766.3	607.0
Total Surface Area (sq cm)	4520	4520	4520	3870	3870	2870
Chemical Bed Length (cm)	30.5	30.5	30.5	38.1	38.1	15.2
Housing - Free Flow Area (sq cm)	51.7	45.2	45.2	38.8	38.8	58.2
Flow Area, Total (sq cm)	19.4	19.4	19.4	19.4	19.4	14.2
Residence Time (sec.)	0.4	0.4	0.4	0.2	0.1	0.12
Final O ₂ Concentration (%)	20	28	30	18	25	18
Final CO ₂ Concentration (%)	2.2	1.6	1.6	3.1	1.9	2.3
Chamber Volume (liters)	212	212	212	212	212	212
Flow Rate (liters/min.)						
Start	117.0	119.0	109.6	189.6	247.0	221.0
End	104.5	93.4	79.0	204.5	272.0	181.2
Chemical Analysis						
O ₂ Evolved, liters (STP)	111.0	137.4	139.0	86.8	114.5	111.1
CO ₂ Absorbed, liters (STP)	78.3	83.8	94.0	83.2	74.7	82.1
O ₂ Efficiency ‡ - total	64.0	67.0	67.0	63.0	64.0	79.0
‡ - inlet bed	54.0	55.0	61.0	64.0	76.0	84.0
‡ - middle bed	66.0	69.0	68.0	72.0	64.0	--
‡ - outlet bed	72.0	77.0	71.0	54.0	53.0	74.0
RQ - total	0.7	0.61	0.62	0.96	0.65	0.74
- inlet total	0.61	0.5	0.56	0.92	0.69	0.76
- middle bed	0.71	0.64	0.64	0.9	0.67	
- outlet bed	0.77	0.67	0.64	1.1	0.59	
Ave. O ₂ Pro. Rate, liters/hr (STP)	27.7	34.2	34.8	21.8	28.6	27.7
Ave. CO ₂ Abs. Rate, liters/hr (STP)	19.5	20.9	23.5	20.9	18.7	20.4

Test No.	51	52	53	54	55	56
Chemical	KO2	KO2	KO2	KO2	KO2	KO2
KO ₂ Fluff - Avail. O ₂ , cc/g (STP)	232	242	242	242	242	242
- Specific Gravity	0.33	0.38	0.38	0.38	1 1/2	8
Run Time (hr)	4	8	8	4	8	8
Chemical Configuration	Plates	Plates	Plates	Plates	Plates	Plates
Dimensions (cm)	7.6 x 15.2 x 0.63	7.6 x 15.2 x 0.63	7.6 x 15.2 x 0.63	7.6 x 15.2 x 0.63	7.6 x 15.2 x 0.63	7.6 x 15.2 x 0.63
Pressure to Form (Kg/sq cm)	545	545	545	545	545	545
Number of Shapes Used	12	24	24	12	8	24
Total Chemical Weight (g)	607.8	1222.6	1229.6	605.5	394	1198
Total Surface Area (sq cm)	2870	5730	5730	2870	1910	5730
Chemical Bed Length (cm)	15.2	30.5	30.5	15.2	15.2	30.4
Housing - Free Flow Area (sq cm)	58.2	58.2	58.2	58.2	58.7	58.1
Flow Area, Total (sq cm)	14.2	14.2	14.2	14.2	14.5	4.8
Residence Time (sec.)	0.1	0.3	0.3	0.15	0.34	---
Final O ₂ Concentration (%)	15	20	18	12	20.8	19
Final CO ₂ Concentration (%)	2.5	1.7	2.9	6	1.5	0.96
Chamber Volume (liters)	212	3680	3680	212	212	3680
Flow Rate (liters/min)	272	176	180	179	227	356
Start	320	204	198	74	148	334
End						
Chemical Analysis						
O ₂ Evolved, liters (STP)	101	193	173	89.4	50.1	199.5
CO ₂ Absorbed, liters (STP)	76.4	109.3	97.6	63.7	20.9	85.2
O ₂ Efficiency % - Total	72	65	58	61	52.3	69.0
% - inlet bed	52	48	52	47	---	63.5
% - middle bed	---	78	59	---	---	---
% - outlet bed	90	88	69	72	---	74
RQ - Total	0.76	0.57	0.59	0.71	0.42	0.43
- inlet bed	0.9	0.43	0.51	0.58	---	0.32
- middle bed	---	0.61	0.6	---	---	---
- outlet bed	0.68	0.66	0.66	0.79	---	0.52
Ave. O ₂ Pro. Rate, liters/hr (STP)	25.2	24.1	21.5	22.4	---	24.9
Ave. CO ₂ Abs. Rate, liters/hr (STP)	19.3	13.6	12.2	15.9	---	11.3

3

Test No.	57	58*	59	60	61	62
Chemical						
KO ₂ Fluff - Avail. O ₂ , cc/g (STP)	242	242	242	242	242	242
- Specific Gravity	--	--	0.38	0.38	0.38	0.3
Run Time (hr)	6 3/4	2 5/6	4	3	2	4
Chemical Configuration	Plates	Plates	Plates	Plates	Plates	Plates
Dimensions (cm)	7.6 x 15.2	7.6 x 15.2	7.6 x 15.2	7.6 x 15.2	7.6 x 15.2	7.6 x 15.2
	545	545	545	545	545	545
Pressure to Form (kg/sq cm)	24	16	12	12	10	19
Number of Shapes Used	1210	782	623	488	423	774
Total Chemical Weight (g)	5730	3820	3580	2870	2390	4540
Total Surface Area (sq cm)	30.4	60.8	15.2	30.4	30.4	30.4
Chemical Bed Length (cm)	58.1	38.7	72.7	43.6	32.3	29.1
Housing - Free Flow Area (sq cm)	14.5	4.8	25.8	25.8	19.4	14.5
Flow Area, Total (sq cm)	0.34	---	0.18	0.26	0.16	0.3
Residence Time, (sec.)	20.8	19.0	18.0	18.0	14.3	20.0
Final O ₂ Concentration (%)	1.5	0.96	3.84	4.5	>6.0	1.23
Chamber Volume (liters)	3680	73	212	212	212	212
Flow Rate (liters/min.)	111	---	105	181	164	104
Start	91.4	---	125	189	170	85
End						
Chemical Analysis						
O ₂ Evolved, liters (STP)	212	91	113.3	76.5	35.1	104.8
CO ₂ Absorbed, liters (STP)	105	51.4	75.8	46.4	17	43.2
O ₂ Efficiency (%)	72.5	48.2	75	65	34.6	56
RQ	0.5	0.56	0.67	0.61	0.49	0.41
Ave. O ₂ Pro. Rate, liters/hr (STP)	31.4	32.3	28.3	25.5	17.6	26.4
Ave. CO ₂ Abs. Rate, liters/hr (STP)	15.6	18.1	19	22.9	8.5	10.8

* Man Test with Breathing Bag.

Test No.	63	64	65	66	67*	68
Chemical	KO ₂ and 25% LiOH	KO ₂	KO ₂	KO ₂ , 25% LiOH and 1/2% CuOCl ₂	KO ₂	KO ₂
KO ₂ Fluff - Avail. O ₂ , cc/g (STP)	242	242	242	242	242	242
- Specific Gravity	0.38	0.38	0.38	0.38	0.38	0.38
Run Time (hr)	4	4	8	4	8	24
Dimensions (cm)	7.6 x 15.2 x 0.63	7.6 x 15.2 x 0.63	7.6 x 15.2 x 0.63	7.6 x 15.2 x 0.63	7.6 x 15.2 x 0.63	7.6 x 15.2 x 0.63
Pressure to Form (Kg/sq cm)	545	545	545	545	545	545
Number of Shapes Used	20	20	39	24	39	81
Total Chemical Weight (g)	815	823	1581	978	1588	4096
Total Surface Area (sq cm)	4780	4780	1581	5730	9230	19,170
Chemical Bed Length (cm)	30.4	30.4	42.7	30.4	42.7	61.0
Housing - Free Flow Area (sq cm)	29.1	29.1	58.1	58.1	58.1	96.9
Flow Area, Total (sq cm)	14.5	14.5	19.4	19.4	22.6	32.3
Residence Time (sec.)	0.15	0.12	0.38	0.32	0.2	1.29
Final O ₂ Concentration (%)	16.8	19.3	21.2	25.8	---	22.5
Final CO ₂ Concentration (%)	2.25	4.59	0.93	1.32	---	2.01
Chamber Volume (liters)	212	212	3680	212	3680	3680
Flow Rate (liters/min.)	167	198	167	175	133	91
Start	206	300	---	184	142	85
End						
Chemical Analysis						
O ₂ Evolved, liters (STP)	137.6	139.8	287.5	171.1	254.6	848
CO ₂ Absorbed, liters (STP)	73.7	86.1	158.6	93.2	67.8	468
O ₂ Efficiency (%)	82.4	70.2	75.0	85.4	64.8	85.6
RC	0.54	0.63	0.55	0.54	0.27	0.55
Ave. O ₂ Pro. Rate, liters/hr (STP)	34.5	34.8	35.9	35.7	31.1	35.4
Ave. CO ₂ Abs. Rate, liters/hr (STP)	18.4	21.5	19.8	23.2	8.5	19.6

* Test conducted at reduced pressure 1/2 atm. (~380 mm Hg).

Test No.	69	70	71	72	73*	74
Chemical	KO ₂	KO ₂	KO ₂	KO ₂	KO ₂	KO ₂
KO ₂ Fluff - Avail. O ₂ , cc/g (STP)	242	242	236	236	236	236
- Specific Gravity	0.33	0.3	0.29	0.29	0.29	0.29
Run Time (hr)	24	24	8	8	8	8
Chemical Configuration	Discs	Plates	Plates	Plates	Plates	Plates
Dimensions (cm)	7 x 0.63	10.2 x 10.2 x 0.63	10.2 x 10.2 x 0.63	10.2 x 10.2 x 0.63	7.6 x 15.2 x 0.63	10.2 x 10.2 x 0.63
Pressure to Form (Kg/sq cm)	545	545	545	545	545	545
Number of Shapes Used	180	96	39	36	39	39
Total Chemical Weight (g)	3646	4132	1290	1552	1575	1662
Total Surface Area (sq cm)	2520	3185	1706	1194	1443	1290
Chemical Bed Length (cm)	106.7	61	30.5	10.2	45.7	30.5
Housing - Free Flow Area (sq cm)	45.8	103	103	232	58.1	103
Flow Area, Total (sq cm)	12.2	38.7	31.5	87.2	21.0	31.5
Residence Time (sec.)	0.31	1	0.23	0.14	0.23	0.23
Final O ₂ Concentration (%)	21	25.7	22	21.8	24	22
Final CO ₂ Concentration (%)	1.86	1.89	2.13	2.19	1.08	1.07
Chamber Volume (liters)	3680	3680	3680	3680	3680	3680
Flow Rate (liters/min.)						
Start	249	150	246	377	170	246
End	113	150	187	377	218	170
Chemical Analysis						
O ₂ Evolved, liters (STP)	751.3	908.3	225.2	242.6	274.3	221.1
CO ₂ Absorbed, liters (STP)	409.9	495.6	86.6	93.9	134.5	85.2
O ₂ Efficiency (%)	86.2	93.1	60.0	66.4	74.0	56.4
RQ	0.55	0.55	0.38	0.39	0.49	0.39
Ave. O ₂ Pro. Rate, liters/hr (STP)	31.4	37.9	28.3	30.3	34.2	27.8
Ave. CO ₂ Abs. Rate, liters/hr (STP)	17.0	20.7	10.8	11.6	17.0	10.8

* Reduced pressure test at 1/2 atm. (380 mm Hg).

Test No.	75	76	77*	78*	79*	80**
Chemical	KO ₂	KO ₂	KO ₂	KO ₂	KO ₂ and 1/2% CuOCl ₂	KO ₂
KO ₂ Fluff - Avail. O ₂ , cc/g (STP)	236	236	236	236	236	236
Specific Gravity	0.29	0.29	0.29	0.29	0.29	0.29
Run Time (hr)	48	24	8	4	4	8
Chemical Configuration	Discs and Plates	Discs	Plates	Plates	Plates	Plates
Dimensions (cm)	14.5 x 0.63 and 7.6 x 15.2 x 0.63	9.5 x 0.63	7.6 x 15.2 x 0.63	7.6 x 15.2 x 0.63	7.6 x 15.2 x 0.63	7.6 x 15.2 x 0.63
Pressure to Form (Kg/sq cm)	545	545	545	545	545	545
Number of Shapes Used	130	110	40	20	20	40
Total Chemical Weight (g)	7866	3904	1720	824	804	1616
Total Surface Area (sq cm)	6250	2590	1468	740	740	1480
Chemical Bed Length (cm)	91.5	68.6	30.5	30.5	30.5	30.5
Housing - Free Flow Area (sq cm)	182.5 and 97.0	78.2	87.2	43.9	43.9	97.0
Flow Area, Total (sq cm)	19.7 and 38.7	94.4	32.3	16.1	16.1	32.3
Residence Time (sec.)	0.64	0.14	0.1	0.1	0.09	0.15
Final O ₂ Concentration (%)	24.3	23.6	22.6	22.6	22.1	52
Final CO ₂ Concentration (%)	2.1	2.88	1.38	0.96	0.75	1.44
Chamber Volume (liters)	3680	3680	3680	3680	3680	3680
Flow Rate (liters/min.)	283	269	243	297	329	388
Start	408	147	108	133	218	470
End						
Chemical Analysis	1440	700	278	92.6	148.7	237.4
O ₂ Evolved, liters (STP)	821.8	363.5	104.4	32.1	53.0	117.1
CO ₂ Absorbed, liters (STP)	77.6	76.1	68.7	47.7	78.3	62.2
O ₂ Efficiency (%)	0.57	0.52	0.38	0.55	0.36	0.45
RQ	30	29.2	34.8	23.2	37.4	29.7
Ave. O ₂ Pro. Rate, liters/hr (STP)	17.3	15.3	13.3	7.7	13.3	14.7
Ave. CO ₂ Abs. Rate, liters/hr (STP)						

* Reflux test to preheat inlet flow stream.

** Reduced pressure test at 1/2 atm. (~380 mm Hg) and 50% O₂/50% N₂ ratio.

Test No.	81*	82*	83*	84*	85*
Chemical	KO ₂	KO ₂ with 1½ KMnO ₄	NaO ₂ with 1½ CuOCl ₂	KO ₂ with 1½ CuOCl ₂	KO ₂ with 1½ CuOCl ₂
KO ₂ Fluff - Avail. O ₂ , cc/g (STP)	236	236	280	236	236
Specific Gravity	0.31	0.31	0.31	0.31	0.31
Run Time (hr)	24	2	2	2	2
Chemical Configuration	Plates	Plates	Plates	Plates	Plates
Dimensions (cm)	7.6 x 15.2 x 0.63	7.6 x 15.2 x 0.63	7.6 x 15.2 x 0.63	7.6 x 15.2 x 0.63	7.6 x 15.2 x 0.63
Pressure to Form (Kg/sq cm)	545	545	750	510	545
Number of Shapes Used	100	12	12	12	12
Total Chemical Weight (gm)	4195	495	481	474	474
Total Surface Area (sq cm)	23,700	2840	2840	2840	2840
Chemical Bed Length (cm)	61	15.2	15.2	15.2	7.6
Housing - Free Flow Area (sq cm)	116.3	48.4	48.4	48.4	96.8
Flow Area, Total (sq cm)	40.3	19.4	19.4	19.4	38.8
Residence Time (sec.)	0.75	0.1	0.05	0.05	0.05
Final O ₂ Concentration (%)	28.0	23.1	23.1	21.9	21.1
Final CO ₂ Concentration (%)	1.2	1.05	0.87	0.87	0.99
Chamber Volume (liters)	3680	3680	3680	3680	3680
Flow Rate (liters/min.)	241	306	332	425	346
Start	150	88	396	346	351
End					
Chemical Analysis					
O ₂ Evolved, liters (STP)	907	72.5	72.3	75.6	71.6
CO ₂ Absorbed, liters (STP)	490.5	29.7	32.3	40.8	34.8
O ₂ Efficiency (%)	91.7	61.2	54.2	68.4	64.6
RQ	0.54	0.41	0.45	0.54	0.49
Ave. O ₂ Pro. Rate, liters/hr (STP)	37.7	36.2	36.2	37.9	35.7
Ave. CO ₂ Abs. Rate, liters/hr (STP)	20.4	15.0	16.2	20.4	17.6

* Reflux test to preheat inlet flow stream.

Security Classification

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13. ABSTRACT Solid superoxide forms were studied to evolve optimized configuration designs for life support of one man on 2-, 4-, 8-, 24-, and 48-hour space missions. Suitable designs were developed to generate O ₂ for these missions, but CO ₂ control becomes progressively more difficult as mission time decreases. Optimization for short mission configurations were gained by dynamic flow designs, preheating inlet flow streams, and use of a catalyzing agent. The evolution of available O ₂ was as high as 85% for 4-hour mission configurations and as high as 98% for 24-hour missions. The superoxide configurations that have been developed are in plate form as opposed to discs since the former have more efficient O ₂ generation and CO ₂ absorption characteristics. This was the effect of flow orientation rather than specific shape, per se. The configurations feature rippled superoxide plates, which, when packaged, achieve a 20% increase in bulk density over granules, and a lower pressure drop, thereby minimizing fan power. Heat generated by the superoxide reaction was utilized in the following manner: the inlet flow stream was preheated by refluxing a part of the outlet stream with it. This technique increased performance of the inlet portion of the superoxide bed. Mass transfer correlations were developed to describe the mechanics of the reactions. Effects of humidity, reduced pressure, O ₂ /N ₂ balance and densification of solid forms on the mass transfer behavior of the superoxide configurations are described.		

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14.	KEY WORDS	LINK A		LINK B		LINK C	
		ROLE	WT	ROLE	WT	ROLE	WT
	Carbon Dioxide Removal Oxygen production Water Vapor removal potassium superoxide Sodium superoxide Atmosphere control						

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