AIAA SGV Young Professionals

JWST Mechanical Systems Lessons Learned

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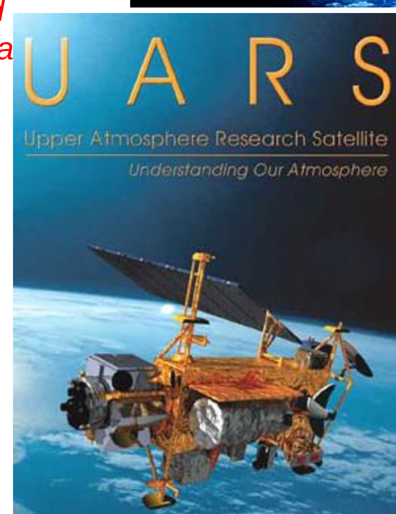
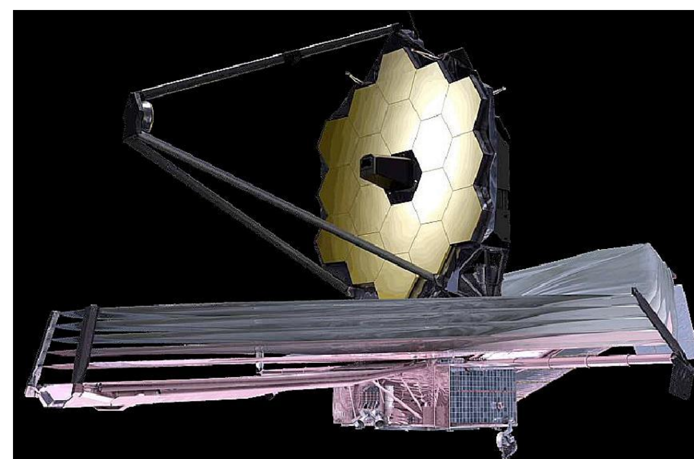
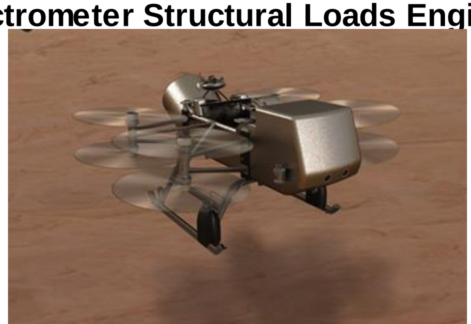
Introduction

- **Sandra Irish**
  - **BS Aerospace Engineering**
    - Aerodynamics focus
    - Worked in Glen L Martin wind tunnel
    - Boeing was my dream job!
  - **NASA/GSFC**
    - 39 years in Mechanical Systems Analysis
    - Group Lead, Mechanical Systems Analysis and Simulation Branch, Code 542
  - **Work Assignments**
    - Cosmic Background Explorer (COBE), First Light
    - UARS, BBXRT, ASTRO-E, ASTRO-E2
    - *James Webb Space Telescope (JWST) Mechanical Systems Structures Lead Engineer*
      - *Responsible for mechanical analysis and testing for launch and on-orbit mechanica performance*
  - **Current position is Dragonfly Mass Spectrometer Structural Loads Engineer**







Launch December 25, 2021

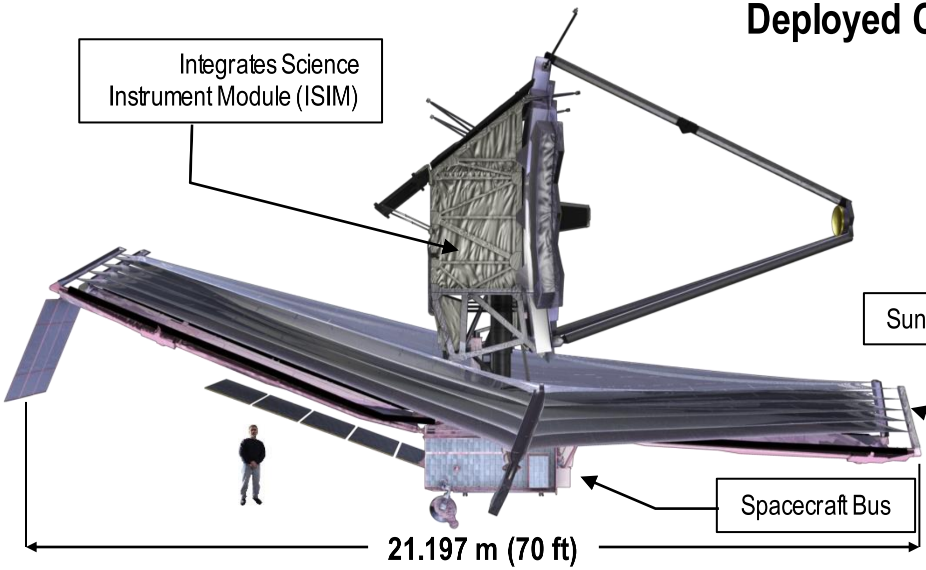
Webb Telescope Science!

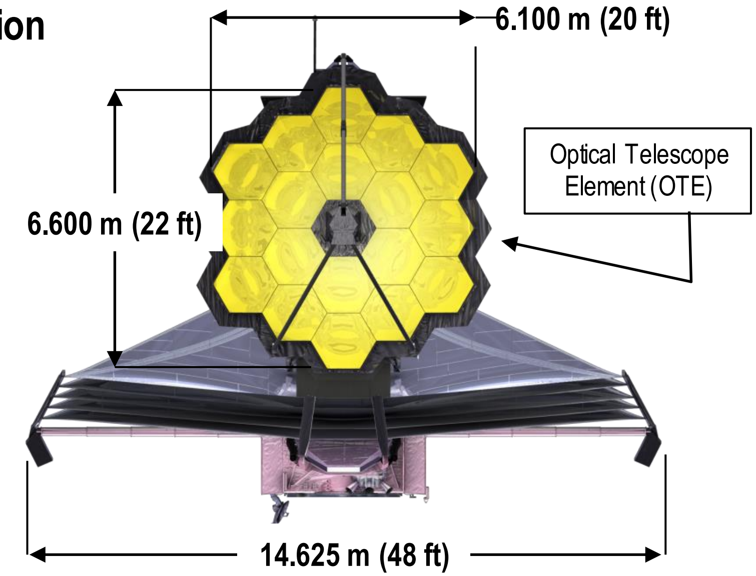
Topics of Discussion

- James Webb Space Telescope (JWST) Mission Engineering Design
- Mechanical Systems Challenges and Lessons Learned

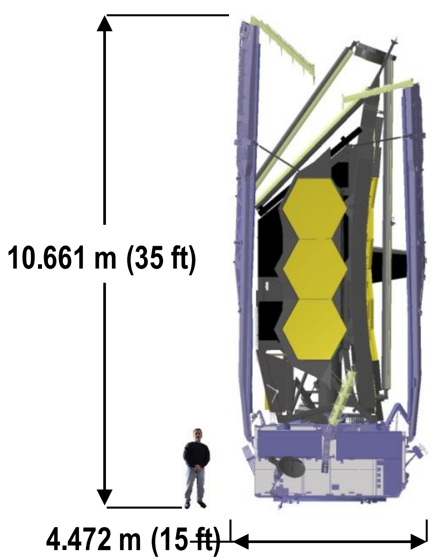
JWST Observatory Engineering Design

Deployed Configuration



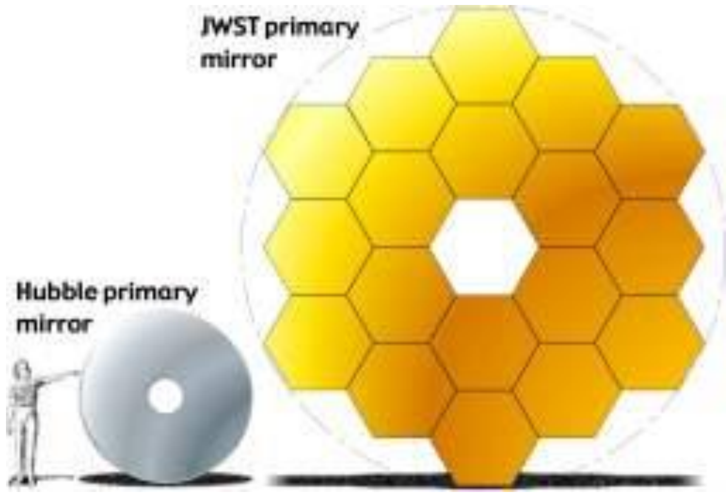


Stowed Configuration



- **Optical Telescope Element (OTE) diffraction limited at 2 micron wavelength.**
  - 25 m^2, 6.35 m (21 ft) average diameter aperture.
  - Deployable Primary Mirror (PM) and Secondary Mirror (SM).
  - 18 Segment PM with 7 Degree of Freedom (DOF) adjustability on each.
- **Integrated Science Instrument Module (ISIM) containing near and mid infrared cryogenic science instruments**
  - Cryogenic Instruments: MIRI, NIRCam, NIRSpec, FGS
- **Deployable sunshield for passive cooling of OTE and ISIM to below 50K (-370 F).**
- **OTE + ISIM referred to as OTIS or Telescope**
- **Mass: < 6310 kg (13910 lb) .**
- **Life: Designed for 10 years of operation.**

Comparison of JWST to HST Design Challenges



JWST Design Challenges

JWST Deployments: Over 6m dia. Fit in a 5m LV Fairing

~½ the mass of HST

Over 6.5 times the light collecting area of HST

Order of magnitude colder than HST. Roughly 4000 kg needs to be cooled below 50K

Performance Parameter	HST	JWST
OTE Diameter (meters)	2.4	6.1 by 6.6
Mass (kg)	11600	6310
Power (watts)	2400	2079
Light Collecting Aperture (Sq meters)	3.8	25
Overall Optical Transmission	45 to 25%	62% to 43%
OTE FOV (Arcmin)	14.6 (Radius)	~18 by 9
Wavelength of Diffraction Limit (Microns)	0.5	2
Rayliegh Radius (Arcsec)	0.043	0.069
OTE Strehl	80%	80%
Bulk Observatory Operating Temperatures	283K to 313K	40K to 400K
Pointing Accuracy (Arcsec)	22	7
Pointing Stability (Arcsec)	0.007	0.007
Total Pixels (mpixels)	56.8	66.1
Data Throughput (Gbits/day)	27	458
Observing Efficiency	50%	70%

Mechanical System Challenges

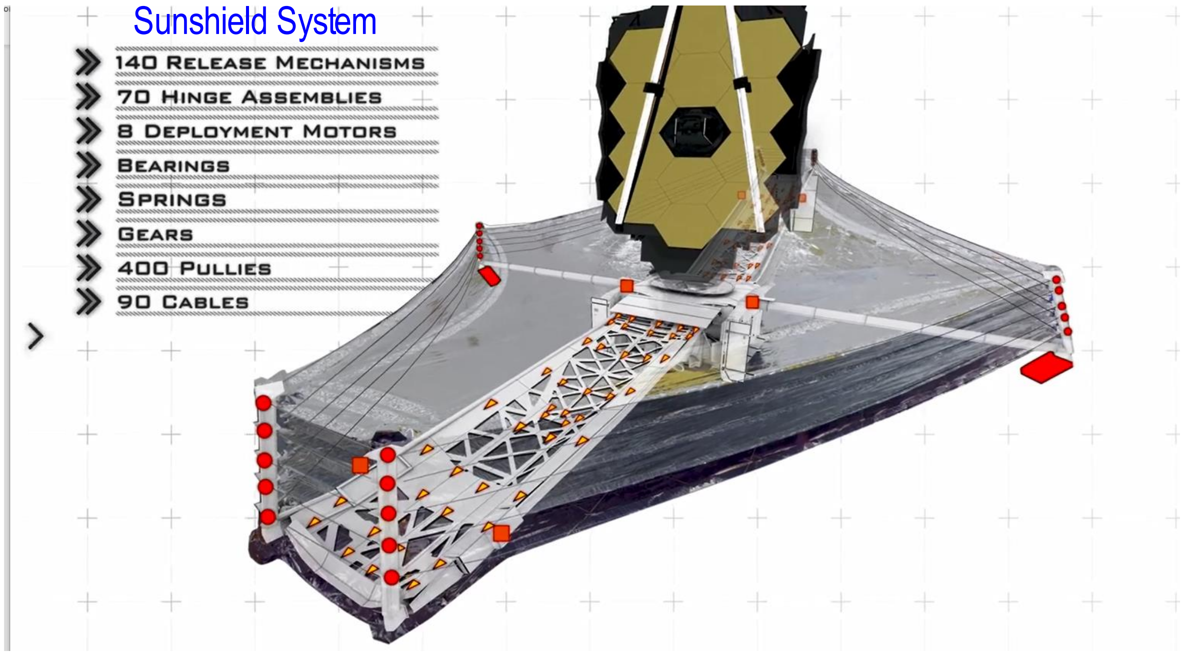
- **Unique Mechanical System challenges for JWST include:**
  - Deployments
  - Cryogenic Telescope
  - Verification

Deployments

- Largest space telescope every built by NASA had to fold and fit into the A5 Rocket Fairing 5.4 m (17.7 ft) diameter
- *50 Major Deployments* to its deployed configuration
- *178 Release Mechanisms* all had to work!
  - Sunshield most complex deployment system
  - Redundant low shock devices
- Sunshield membranes and telescope thermal multi-layer insulation concerns with snagging, billowing, clearances
  - Hardware inspected after every I&T Operation

29 days on the Edge JWST (Deployments)

https://www.youtube.com/watch?v=uUAvXYW5bml

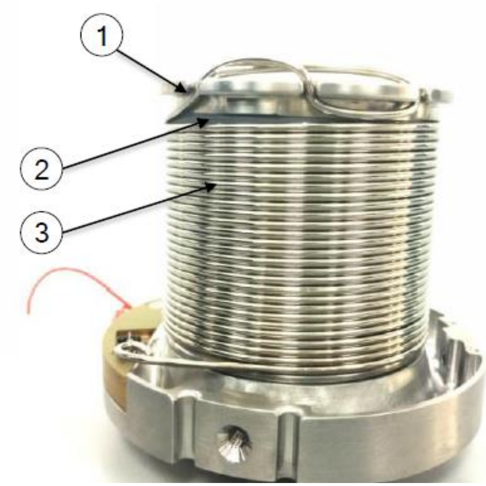


Non-Explosive Actuators (NEA) Concerns

- Custom ¾" NEA used for Telescope separation from Spacecraft.
- Found a concern with high shock load (> 2500 peakg SRS) when ambient release test performed
- Countless analyses and testing resulted in design changes to assure a reliable device for critical interface.
- Joint stiffness testing also performed.
- Recorded accelerometer data for all shock releases performed with the flight hardware to verify the updated design (max value recorded was less than 1800 peakg SRS requirement)
- Fatigue concern due to 14+ days ship voyage resulted in a MGSE joint design and Flight NEAs were installed in French Guiana.

The following key design features were changed or modified to resolve the issue of restraining wire fractures during actuation at max preload of 46,000 lbf

1. Spool Tie-off Slot
2. Dry Film Lubricant (DFL) on Spool
3. Restraining Wire



Extensive testing and design changes required to meet critical Spacecraft to Telescope Release low shock requirement.

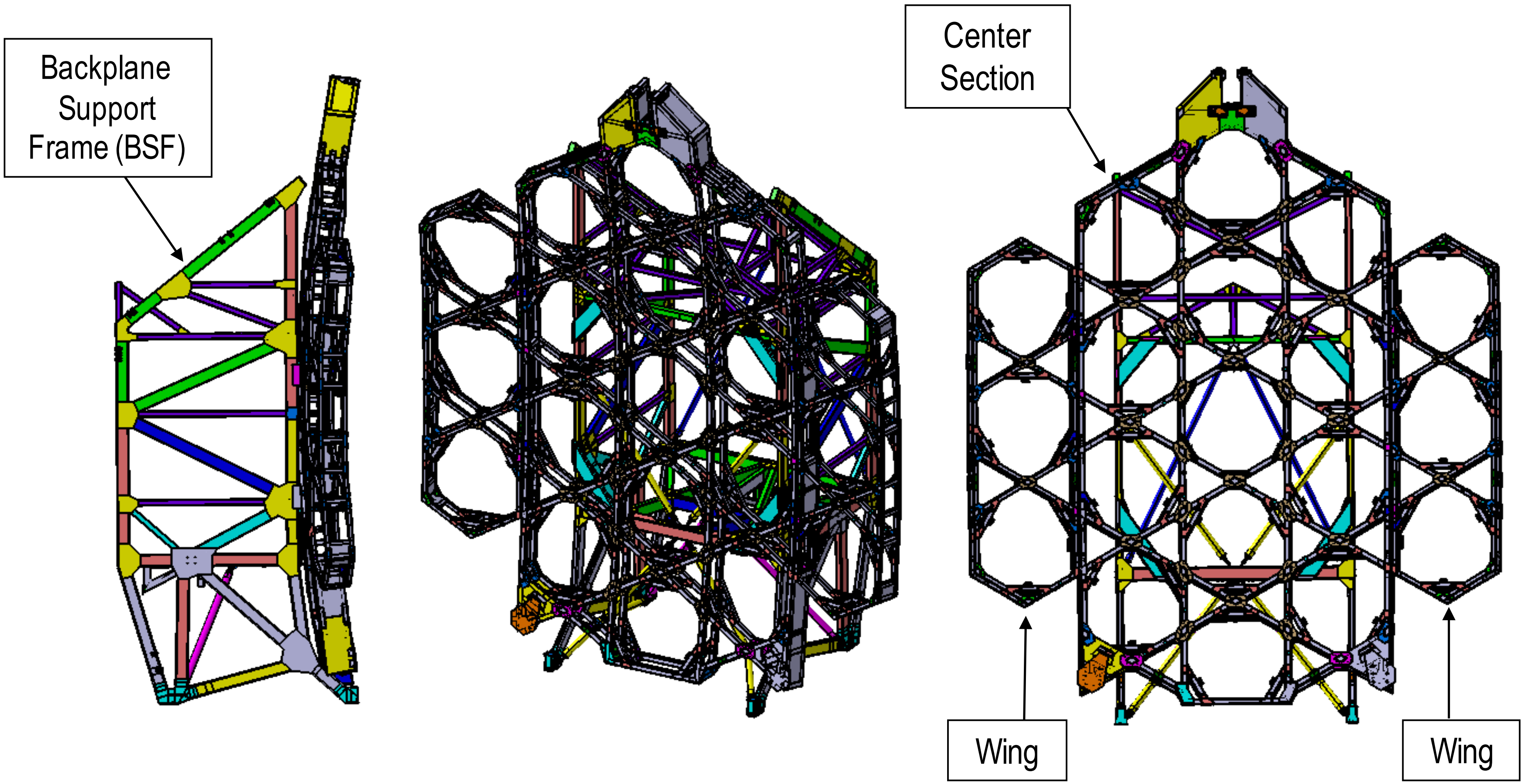
Lessons Learned from Deployments

- **Design for slack of cables, ribbons, or similar 'non-rigid' elements**
  - Fool-proof snag guards and cable/pulley guides were implemented
- **Ensuring deployable is mounted on the SC using a kinematic mount so thermal I/F deformations do not cause internal stresses**
  - Testing deployment system design under temperature limits
- **Avoid deployables designs that require a large number of releases in series as the risk of deployment failure is extremely large. Even for single mechanisms with a high reliability when placed in series their reliability decreases sharply.**
  - SS 107 release mechanisms in series (added redundant fuse wires, mechanism level testing)
- **Venting of lightweight flexible structures, blankets and composite honeycomb structures**
  - Venting analysis early in design
  - Had to verify delta pressure of A5 during launches prior to JWST
- **Consider leaving strain gage bolt wires in place to enable monitoring release mechanisms preload throughout testing (but this must be traded against having a non-disturbed deployment test)**
  - Component level hardware testing

Cryogenic Telescope

- Bonded joints/composite structure
- Cryo Temperatures (design for 25 – 323 K)
- Cryo Shock

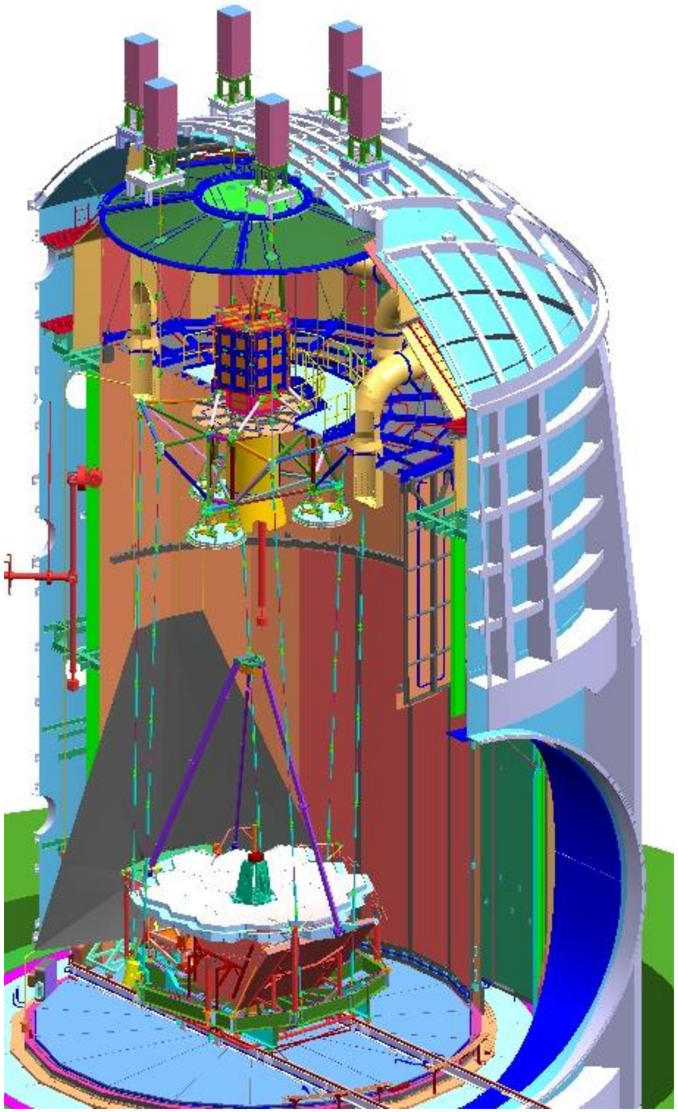
Telescope Backplane is a Tube Frame Composite Structure



- Tube frame construction is a stiff, high load capable, low distortion design approach
- Open construction allows access to the many interfaces
- Composite tubes, metallic end fittings
- Maintain stability from 25 K to 323 K

Cryo Environment

- **JWST Composite structures designed for large temperature range of 25 K (survival) to 323 K (launch ascent)**
- **Cryo-mechanical analyses performed to show positive margin with 1.5 safety factor**
- **Two cooldown tests performed to verify performance of GSE**
  - Required detailed modeling of isolation system and cryo test check-out
    - to reduce mirror distortions at cryo
    - To investigate damping at cryo and its affect to mirror tip/tilt modes
- **The Telescope CV test was a 3 month test of the flight telescope assembly under cryogenic temperature and vacuum environment.**
- **The test was conducted in the Chamber A facility at the Johnson Space Center (JSC).**
- **Perform optical test of the telescope assembly at cryo temperature.**



JSC Chamber Vibrations

Driven based on top of chamber vibrations

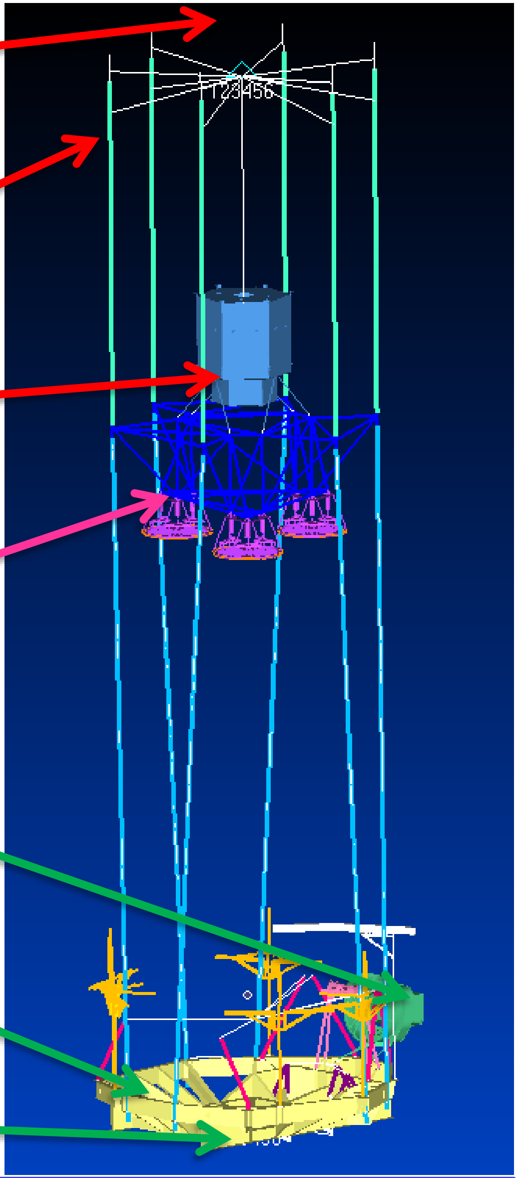
- Primary Ground Point RBE2 to Base of 6 Isolators
- Bellows Shorts Under each isolator
- COCOA Shorts

Driven based on 5th floor vibrations

- USF Shorts Above Each ACF

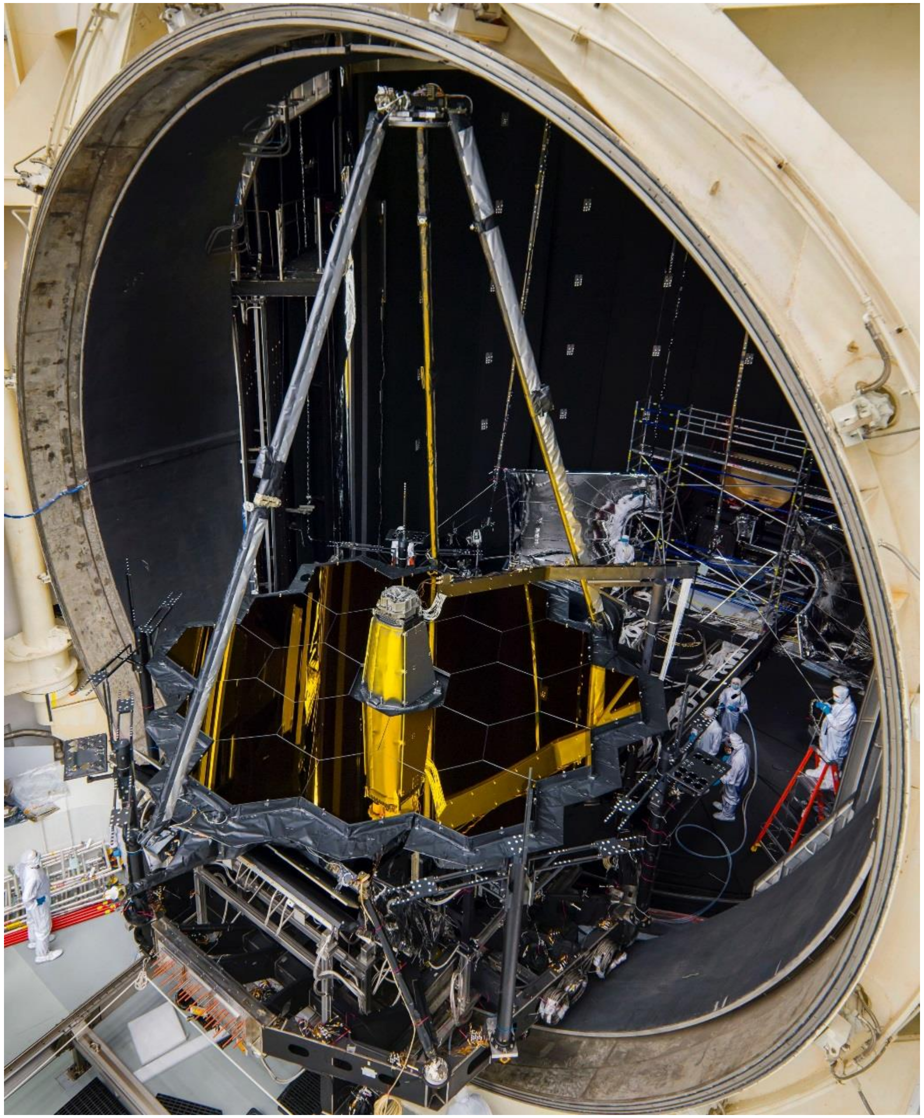
Driven based on chamber floor vibrations

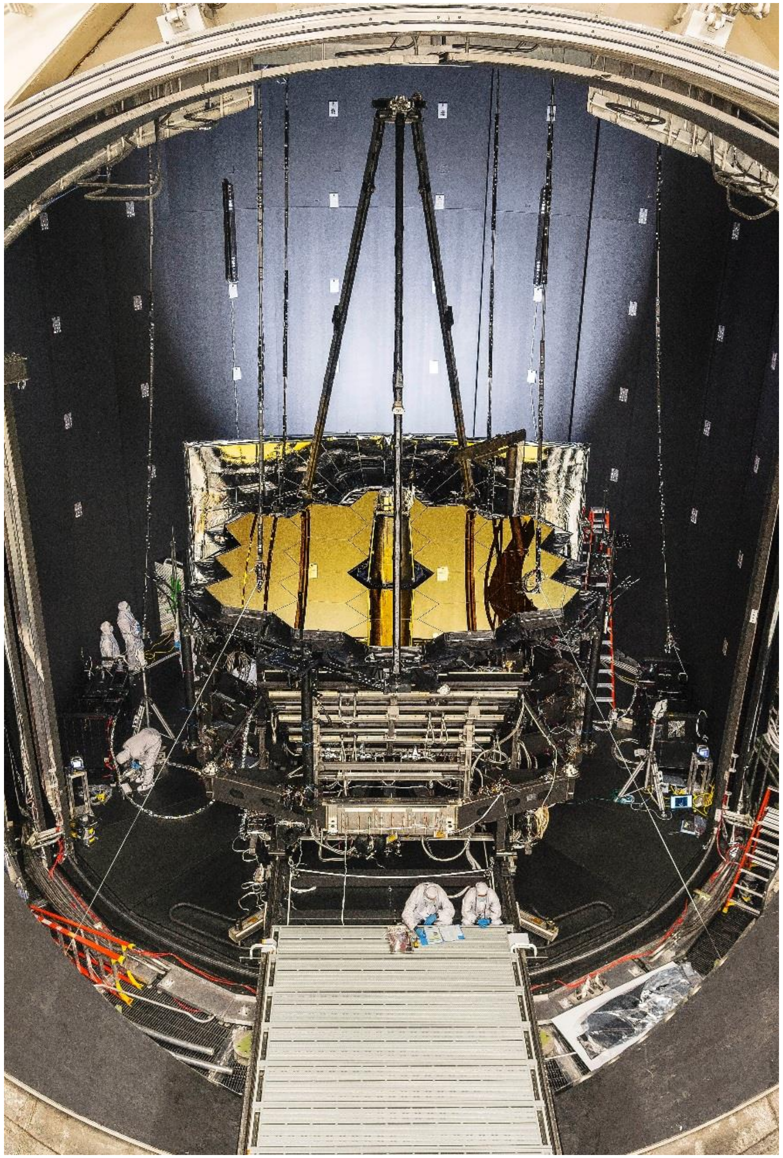
- SVTS Short
- HOSS He lines & Cable Shorts around HOSS
- HOSS Mag Dampers



Jitter concern of isolators and harness identified and remedied before cryo test of flight telescope

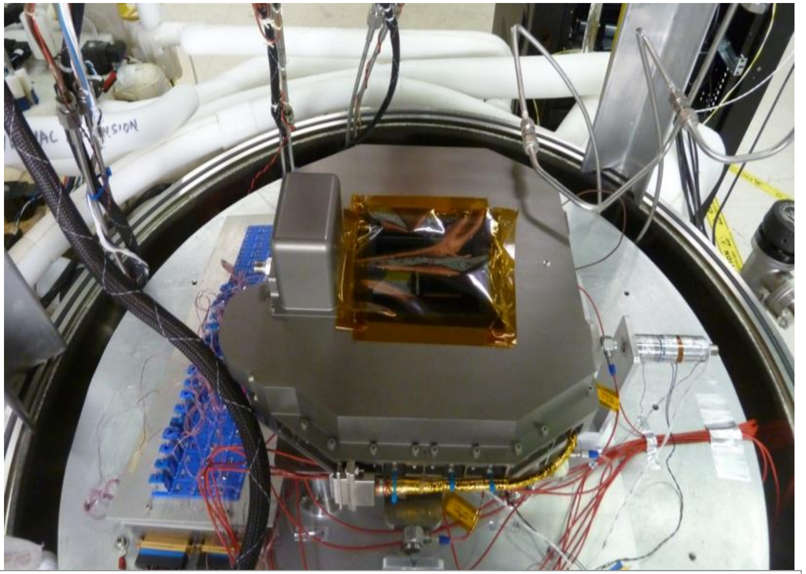
OTIS at JSC Chamber (before door close on July 12, 2017)

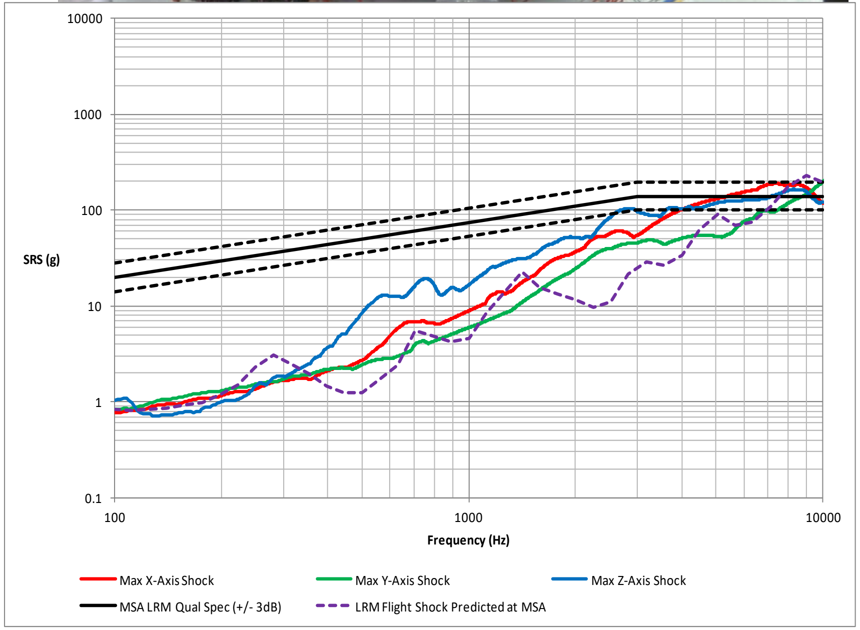




Component Cryo-shock Tests

- Shock attenuation increased for cryo composite hardware.
- Performed Cryo-shock tests on shock sensitive components: Applied high frequency shock level to ~100 gpeak at range of 85 – 160 K
- Tests performed at GSFC in Building 4 thermal chamber.
- Functional checking after test demonstrated success





Lessons Learned from Cryogenics

- **Internal Mechanical shorts need to be considered**
  - Cable stiffness (harness)
  - Critical clearances

- **Huge value of the pathfinder tests**
  - External Dynamical shorts

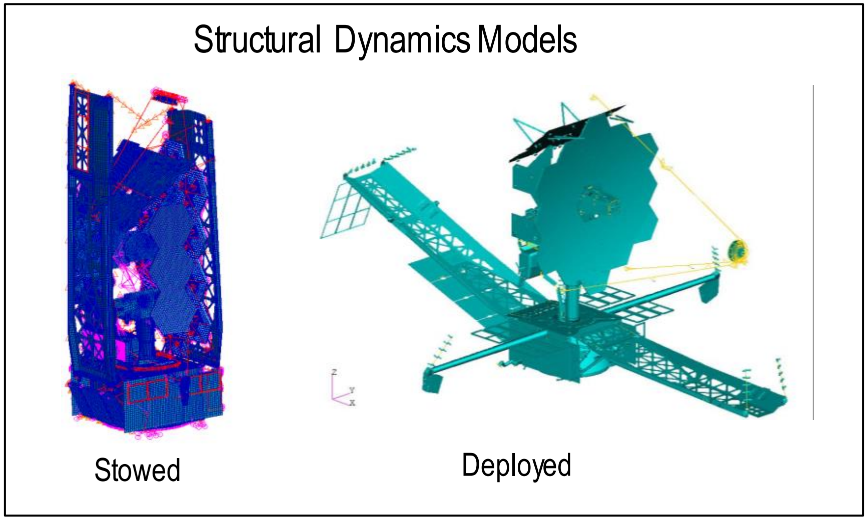
- **Thermal stability and soft structure**
  - 4 lbs of force made the difference

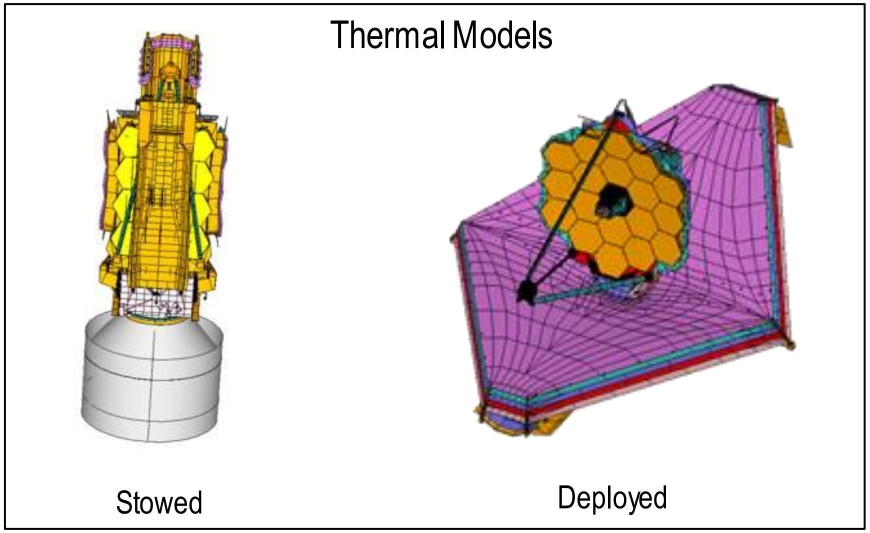
Verification

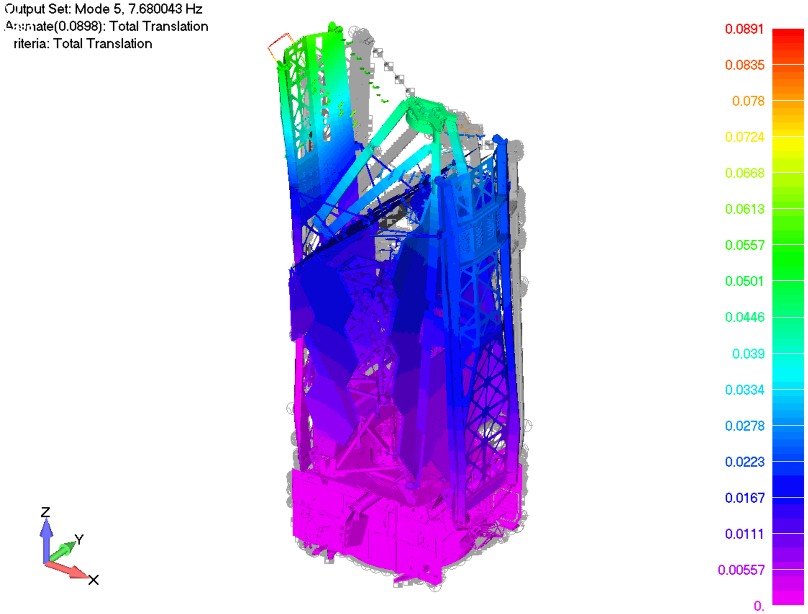
- Integrated System Modeling
- Specialized MGSE
  - Custom Shakers
  - Contamination Tent Frame
  - Earthquakes!
- A5 Requirements: Mechanical Testing
  - Sine Vibration (Up to 100 Hz and Stay Above Floor Levels)
  - Acoustics (0 dB Tolerance and Homogeneity)

Verification Using Analytical Models

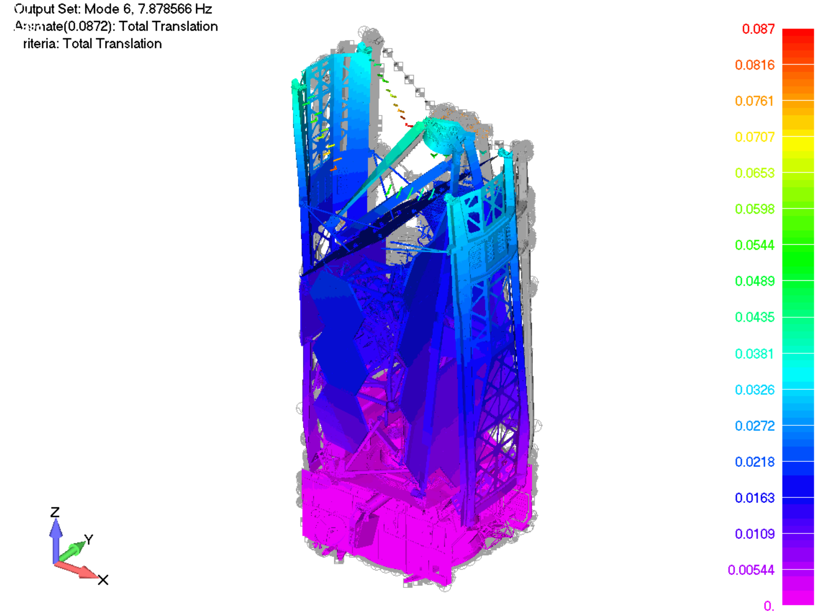
- **Verification of the stowed configuration and on-orbit performance involved analytical models which were correlated / anchored to "as-built" hardware by tests at lower levels of assembly.**
  - This proves that what is mathematically modeled is what was actually built.
- **Observatory system models were then assembled from these lower level models. The observatory level models were then correlated as practical to the as built observatory by system level tests.**
  - This proves the interfaces are modeled correctly.
- **The correlated models such as those shown on the right were used to predict and verify the on-orbit performance of:**
  - Thermal Performance
  - Optical Thermal Stability
  - Dynamics
  - Staylight



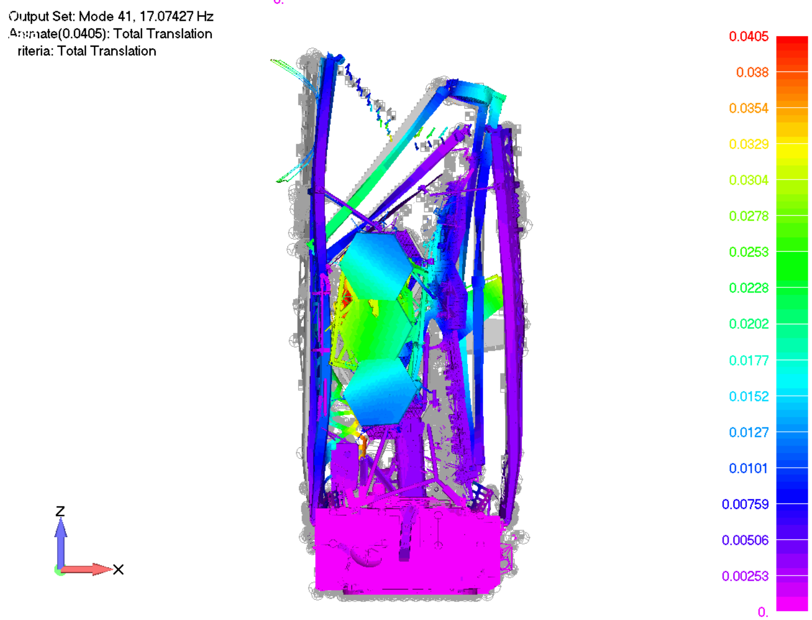




Output Set: Mode 5, 7.680043 Hz
Animate(0.0898): Total Translation
riteria: Total Translation
0.0891
0.0835
0.078
0.0724
0.0668
0.0613
0.0557
0.0501
0.0446
0.039
0.0334
0.0278
0.0223
0.0167
0.0111
0.00557
0.
Z
Y
X



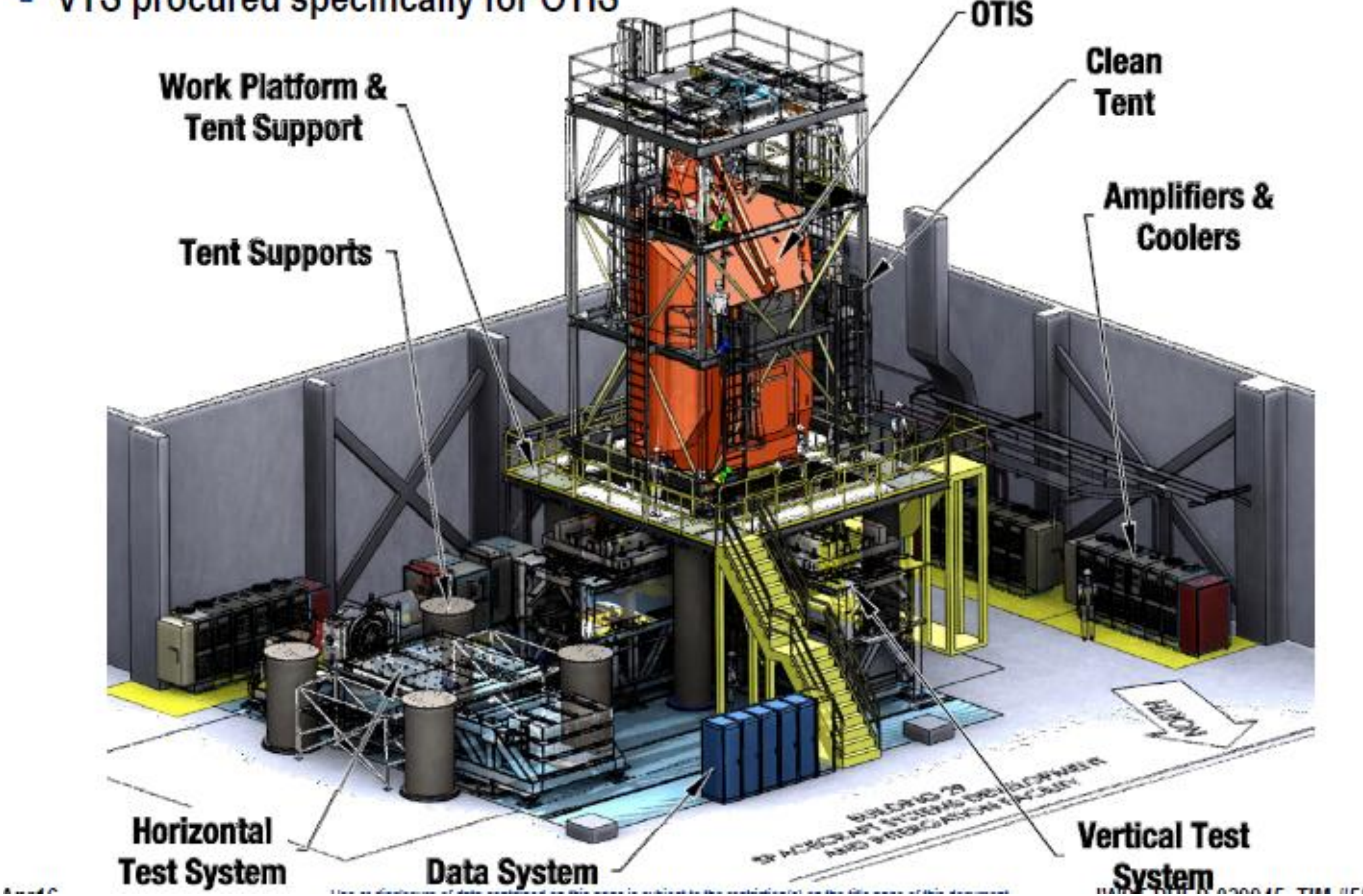
Output Set: Mode 6, 7.878566 Hz
Animate(0.0872): Total Translation
riteria: Total Translation
0.087
0.0816
0.0761
0.0707
0.0653
0.0598
0.0544
0.0489
0.0435
0.0381
0.0326
0.0272
0.0218
0.0163
0.0109
0.00544
0.
Z
Y
X



Output Set: Mode 41, 17.07427 Hz
Animate(0.0405): Total Translation
riteria: Total Translation
0.0405
0.038
0.0354
0.0329
0.0304
0.0278
0.0253
0.0228
0.0202
0.0177
0.0152
0.0127
0.0101
0.00759
0.00506
0.00253
0.
Z
X

Specialized MGSE: Custom Shaker at NASA/GSFC JWST Vibration Test System (VTS)

- VTS procured specifically for OTIS



Key Facts of Custom Shakers at NASA/GSFC

- **Fail-safe operation: system must shutdown “softly” to protect payload**
  - Performed analyses to determine safe shutdown duration for hardware
- **Clean environment provided by contamination tent—tent supports needed**
- **Large overturning moment due to offset CG (due to ISIM)**
  - Specify key requirements
    - Mass/force
    - Moments
    - Cross-axis response
- **Horizontal slip table configuration expected to provide full levels for lateral 2 axes**
- **Vertical facility requires guided head expander to react overturning moments**
  - Large mass of head expander
    - Design requires shaker to generate sufficient force to achieve specified levels
    - Design includes independent feedback loops/controls for shaker

Custom Shakers required early procurement and extensive checkout.

JWST Vibration Test System (VTS)

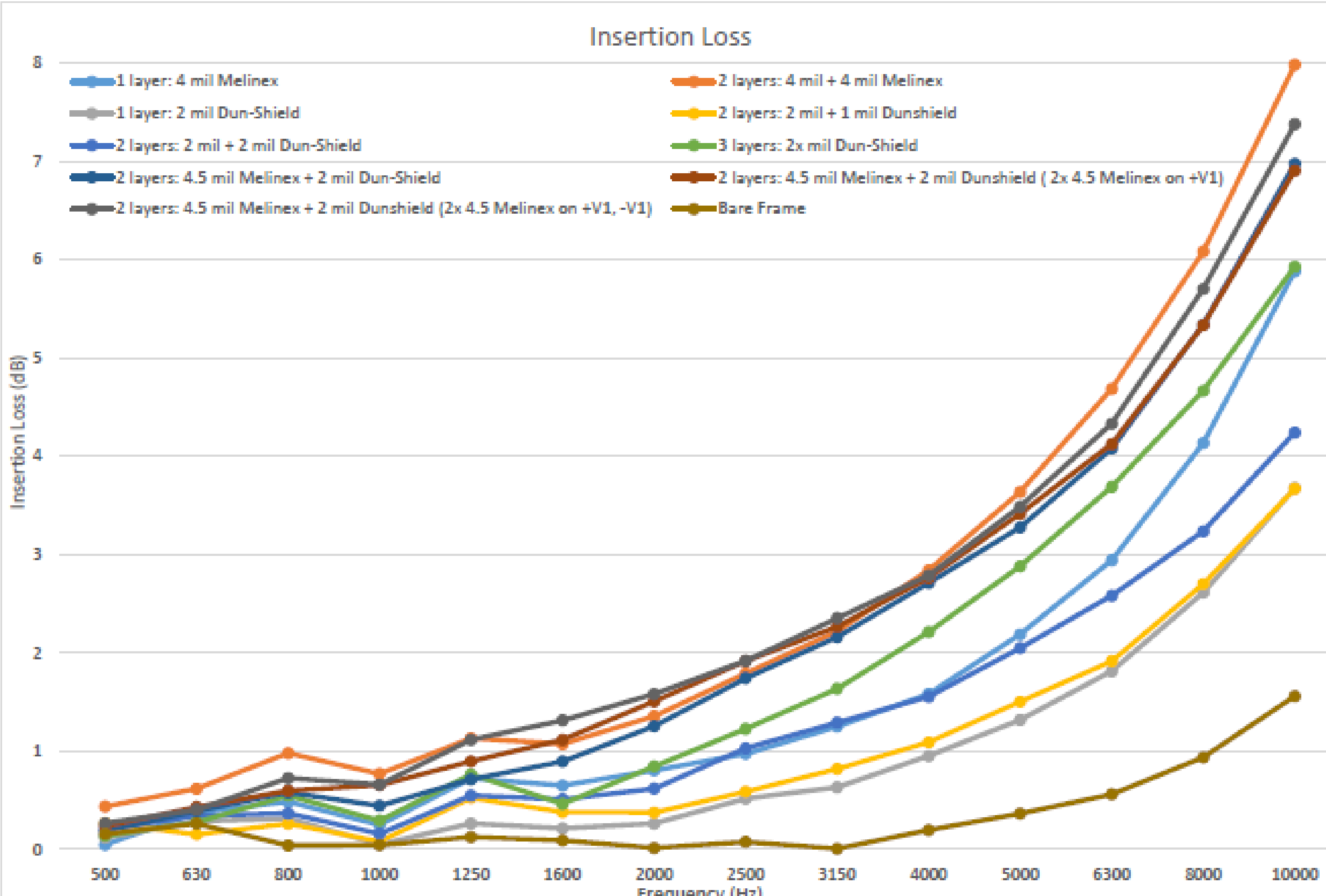
Specialized GSE: Contamination Tent Frame

- **Attached to Test Supports for OTIS Sine Vibration Tests**
  - Not attached to OTIS during testing; stiffness does not affect OTIS hardware
- **Used with Dolly in OTIS Acoustic Test**
  - Tent Frame Design reviewed for Acoustic Environment
    - Acoustic loads factored into tent frame design
    - Tent material reviewed for acoustic attenuation
      - Two layers, 4.5 mil Melinex + 2 mil Dun-shield (final design)
      - Provides filter for high frequency load into microshutters
      - Maintain A5 acoustic spec to 2000 Hz
      - Visibility is considered for lifting over OTIS
  - Tent Frame Design Verified in Tent Frame Proof Test and Acoustic Check-out Test

Contamination Tent designed to withstand acoustic loading and limit high frequency loading to sensitive instrument microshutters.

Bagging Material for Telescope Tent

Insertion loss data was collected from acoustic runs with outside microphone control, nominal gas pressure, and the same controller references/tolerances as control.



Contamination tent materials chosen to obtain required A5 Acoustic Input but limit frequency input between 2500 – 30000 Hz.

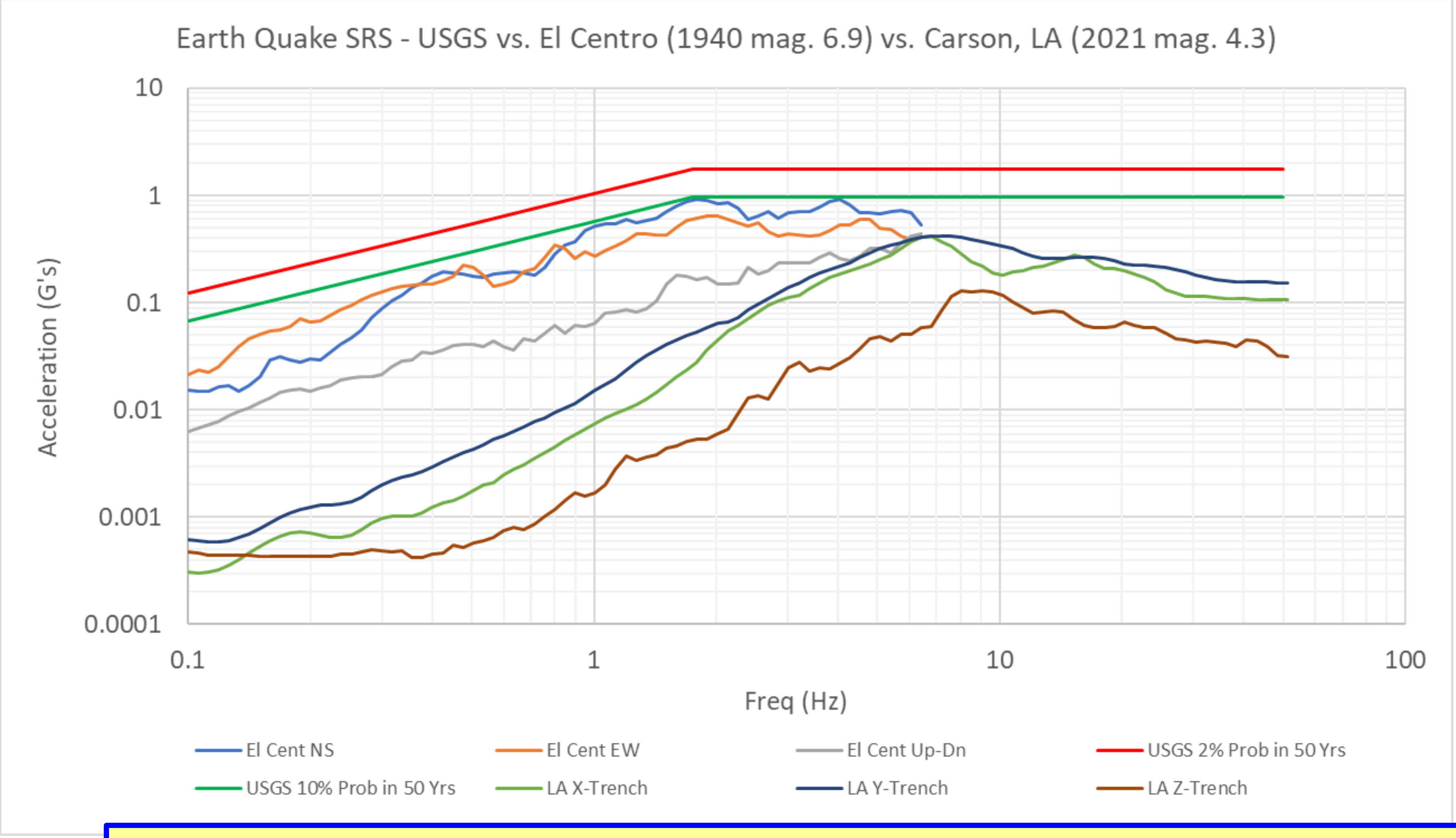
Earthquakes!

- **JWST observatory was assembled at Northrop Grumman in Redondo Beach, CA—quite active seismic loading environment!**
- **Extensive testing was performed of the observatory while it was in its deployed configuration.**
  - Sunshield, deployed tower assembly, secondary mirror, primary mirror wing deployments performed several times after mechanical testing
  - Concern for hardware to experience seismic loading while in deployed configuration.
- **Seismic analysis was performed to design MGSE for deployment testing and shipping configuration.**
  - Reviewed latest USGS seismic loading and applied to combined hardware and MGSE design.
  - Seismic accelerometers were mounted to the MGSE, building floor and ceiling and the flight hardware.
    - Data was continuously recorded during integration and testing. Safe limits set for all data.
    - Earthquake operation plan developed, and mechanical systems team alerted to data immediately from seismic event.
- **Many events occurred, the largest being when observatory was horizontal for shipping (Carson, CA EQ 4.3 mag, 9/17/21, 8pmPST)**

MGSE designed to limit seismic loading to flight hardware during I&T activities.

Seismic Assessment for JWST Observatory

- **USGS Seismic Inputs used for analysis compared to El Centro SRS data Circa 1940 magnitude 6.9 and Carson 09/17/21 magnitude 4.3**
- **Analyzed data:**
  - TRW SRS profile for 10% probability of exceedance in 20 years
  - USGS SRS profile for 10% probability of exceedance in 50 years



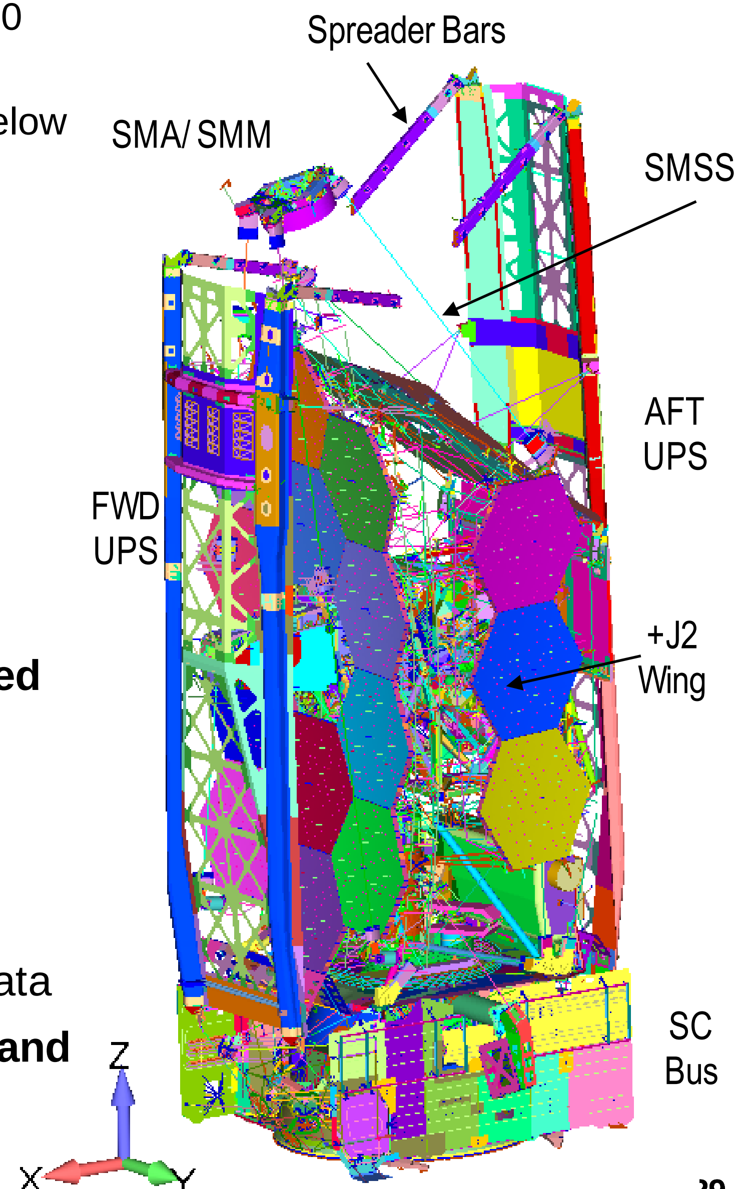
LA earthquake data compared to seismic analysis input data to verify hardware integrity.

A5 Requirement: Sine Vibration

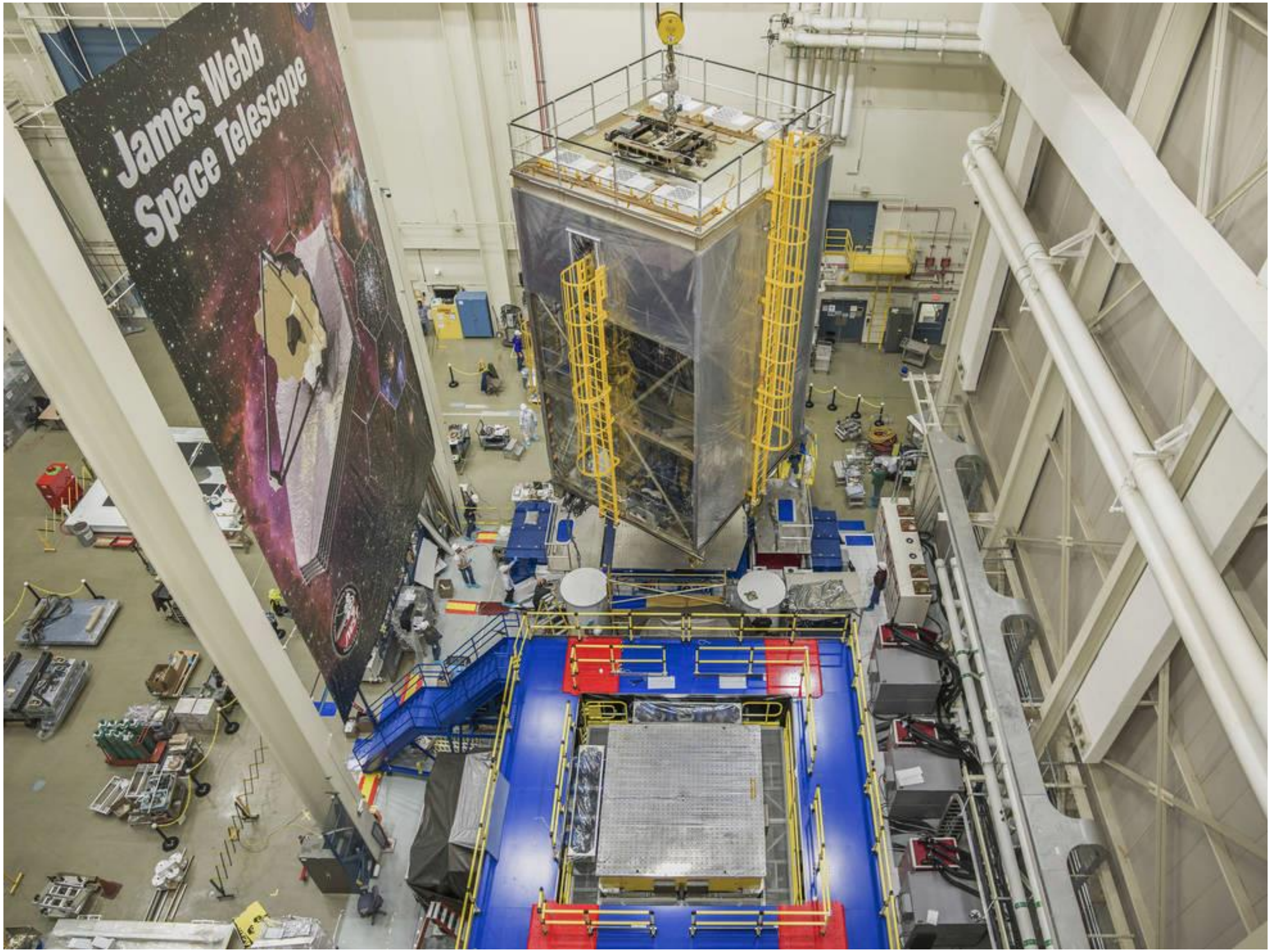
- **Ariane 5 sine vibration specifications to 100 Hz.**
  - Required all modal surveys to correlate many modes out to 100 Hz.
  - Overall JWST stowed configuration FEM had ~1200 modes below 100 Hz---JWST was dynamically rich!
- **POGO analysis performed by Arianespace since observatory was not meeting the axial frequency requirement.**

Axis	Frequency (Hz)			
	Requirement	Test 0dB Sweep TF	Test Self-Check TF	Model TF
J3	≥ 15.0	19.50	19.44	19.50
J1	≥ 7.5	7.50	7.69	7.68
J2	≥ 7.5	8.08	8.38	8.35

- **Sine vibration input was required to be above specified floor level, 15-20 Hz range difficult to meet**
  - Particle dampers for telescope composite hardware needed to meet requirement
- **FEM Verification of frequency and damping**
  - Adjustments made to CLA if FEM did not match test data
- **Many deployment mechanisms, difficult to set limits and aborts**
- **605 accelerometers—Telescope accels survive cryo**

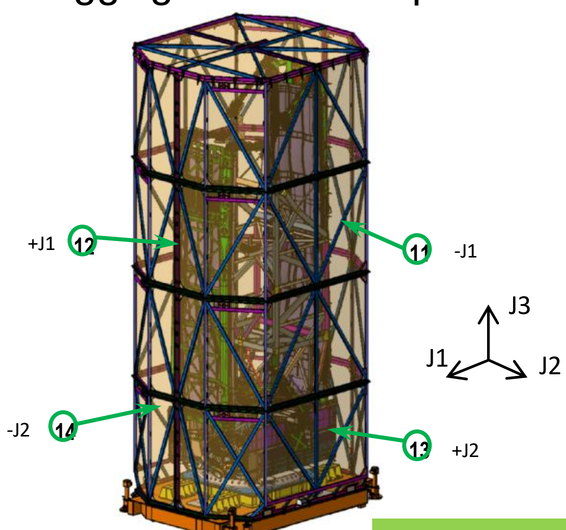


OTIS Sine Vibe Test: Changing Axes



A5 Requirements: Acoustics

- **Arianespace requires S/C Test Plan level to be minimum level to be achieved by the average of the control microphones for the Acoustic Test (0 dB/+1 dB)**
- **Levels provided in full octave bands but ran in 1/3 octave**
- **Test Tolerances applies for the homogenity of the acoustic field in the chamber**
  - Microphones internal to the test frame bagging measured up to 40 kHz



Control Microphones
All Inside the Bagging

Table 4-2 Acceptance Acoustic Test Levels

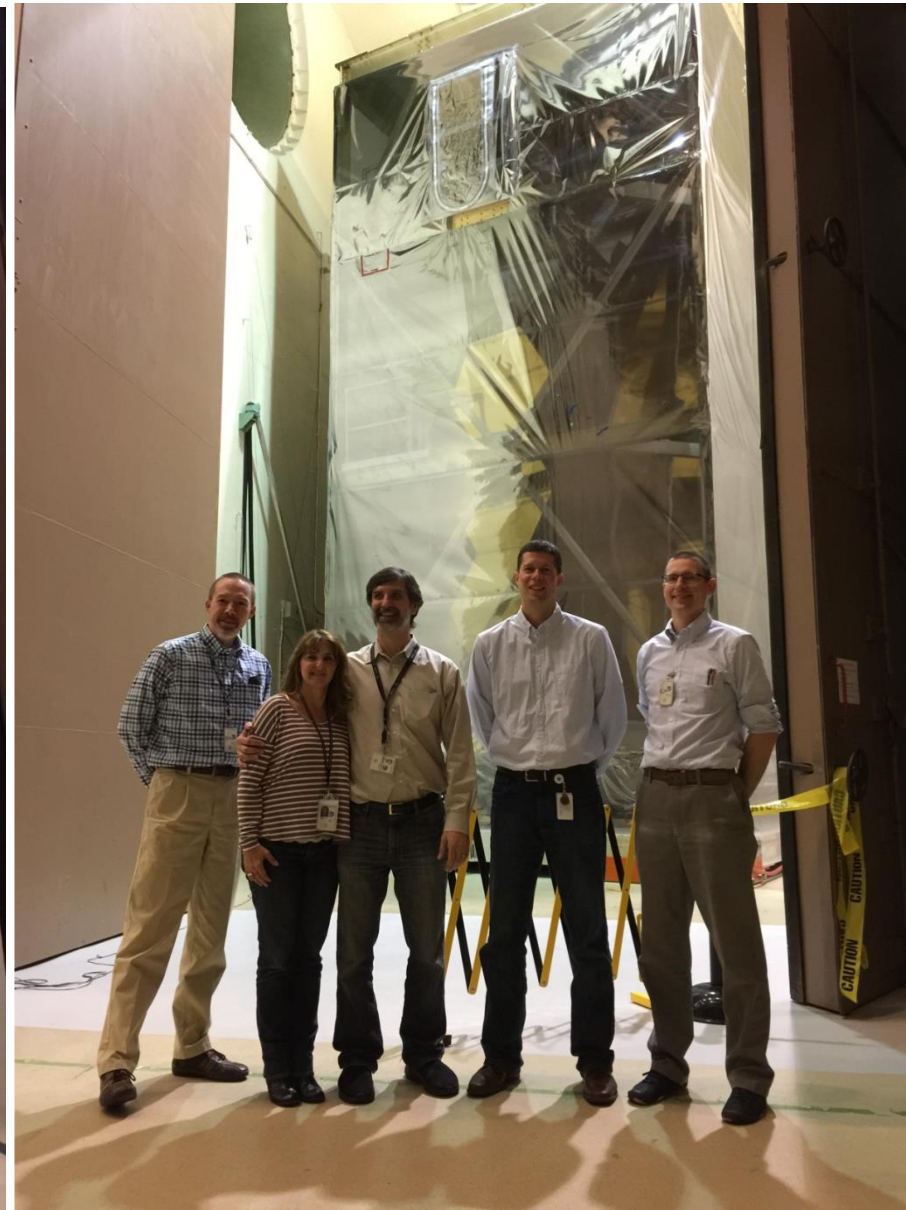
F (1/3 Octave) (Hz)	Acceptance SPL (minimum) (dB)				
	S/C Test Plan (Fill factor <63%)		Test Results	MUA Iss. 5 rev.2 Oct 2016	Test Tolerances
25	123.4				
31.5	124.1	129	130.9	*(128+1) 129	-2,+4
40	125.0				
50	125.5				
63	126.6	131.5	132.2	*(131+0.5) 131.5	-1,+3
80	127.8				
100	130.8				
125	131.7	136	136.9	136	-1,+3
160	131.1				
200	129.4				
250	128.1	133	133.6	133	-1,+3
315	126.8				
400	125.6				
500	124.1	129	129.9	129	-1,+3
630	122.4				
800	120.0				
1000	118.1	123	124.5	123	-1,+3
1250	115.4				
1600	113.0				
2000	111.1	116	118.6	116	-1,+3
2500	108.4				
OPSL (dB)	139.6	**139.6**	**140.6**	**139.6**	-1,+3
Duration	1 minute		1 minute	1 minute	

* Third octave equivalents derived assuming a fill factor < 63%

Ref.: 0dB = 2×10^{-5} Pascal

Unique A5 Acoustic requirements were met.

Telescope Acoustic Test



Observatory Acoustic Testing

Observatory Acceptance Acoustic Test
(140.6 dB): 8/11–13/2020 at NG LATF

Observatory Sine Vibration Test at NGSS

Observatory Acceptance 3-axis sine vibration test:
8/24–10/2/2020 at NG M4

J3 Vertical Axis

Mounting to the J2 Lateral Axis

Observatory Vibration Test Team

Lessons Learned from Mechanical Systems Design and Testing

A. **Mechanism Redundancy**
   - Primary and Secondary fuse wires for NEAs

B. **All changes approved by all engineering disciplines**
   - SS Fasteners

C. **Involve all engineering disciplines in mechanical test planning**
   - HGA contamination concerns, tent frame design, cryo accelerometers

D. **Test Instrumentation**
   - Start instrumentation early
   - Include redundant instrumentation
   - For mechanisms, instrument/monitor for “shock” events due to gapping, expect non-linearities

E. **Pre-Test Analysis and Testing**
   - Allow sufficient time for MGSE integration, handling, and testing with EM/dummy hardware prior to use with flight hardware
   - Pathfinder testing when possible (ship loads voyage, Mechanical I&T operations)
   - Leave sufficient time to verify all component hardware limits prior to test start; coordination with all interested hardware partners, pre-test analysis TIMs
   - Conservative damping (Q=40, minimum) should be assumed in the pre-test analysis when developing test limits for composite hardware
   - Component testing buys down risk and system level test complications!!
   - Video!

Lessons Learned from my Career

- **Strive to learn something new every day!**

- **Life begins on the edge of your comfort zone!**
  - Be willing to do a task you haven't done before
  - Volunteer, be involved in group activities
  - Lead a group
  - Do the best job in the job you are in!

- **Stay in Engineering!**
  - Find an advocate, someone who supports your work
  - Attend events, ie. AIAA, WEST/SWE, find a support network in your job

S5C Highbay, CSG, French Guiana, Oct. 2021