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# An investigation of the early stages of fretting

Tighe, William F.

Massachusetts Institute of Technology

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AN INVESTIGATION OF THE  
EARLY STAGES OF FRETTING

William F. Tighe, Jr.











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AN INVESTIGATION OF THE EARLY STAGES OF FRETTING

by

William F. Tighe, Jr., Lieutenant, U.S. Coast Guard  
B.S., U.S. Coast Guard Academy (1946)

PRESENTED IN PARTIAL FULFILLMENT

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TIGHE

1954

THESIS  
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REQUIREMENTS FOR THE

DEGREE OF

MASTERS

IN MECHANICAL ENGINEERING

AT THE

MASSACHUSETTS INSTITUTE OF TECHNOLOGY

MAY, 1954

Letter on front cover:

AN INVESTIGATION OF THE EARLY  
STAGES OF FRETTING

WILLIAM F. TIGHE, JR.





ABSTRACT

Title: AN INVESTIGATION OF THE EARLY STAGES OF FRETTING

Author: William F. Tigue, Jr., Lieutenant, U.S. Coast Guard

Submitted to the Department of Naval Architecture and Marine Engineering on May 22, 1954, in partial fulfillment of the requirements for the degree of Naval Engineer.

The primary purpose of this investigation was to determine the shape of the initial portion of the curve of fretting weight loss versus the number of cycles run. Previous work in the field has shown this curve to be concave downward over the initial portion. It has been proposed that the curve is actually concave upward over this portion, due to the fact that the abrasive action is presumably more violent than the smearing action. The conditions under which the tests were conducted, were chosen such that it was anticipated that the specimen weight loss would be relatively large over a short interval of time. The tests of mild steel specimens fretted against mild steel specimens were conducted under these conditions, varying the duration of test from 1 to 10,000 cycles.

The results of this investigation showed that the curve in question actually had a point of inflection in the portion under investigation. At the origin, the curve was concave downward followed by a turn to concave upward. This result not only substantiated the initial proposal but also added some additional information which was not anticipated.

It is recommended that these tests be repeated in dry air as well as other atmospheres to establish definite quantitative results. It is also recommended that the frequency of alternation be lowered to as small a value as possible in order to increase the specimen weight loss in a given interval of time.

The second purpose of the investigation was to establish a relationship between specimen weight loss and some physical measurement of fretting damage. To this end, the area of damage as well as its depth was measured and plotted against specimen weight loss.

The result of this series of investigations showed that any attempt to use the area of damage as a substitute for weight loss is impractical. It appears to be quite possible to use the depth of damage as a measure of fretting damage. The relationship obtained between specimen weight loss and the depth of fretting damage can be considered qualitative only due to a lack of sufficient data. The depth of damage, however, definitely increases as the weight loss increases. It is recommended that additional tests be made to firmly establish the quantitative relationship between specimen weight loss and the depth of fretting damage.

Thesis Supervisor: I-Ming Ferg, Ph.D.  
Title: Assistant Professor of Mechanical Engineering

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28850





Technology

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DATE: MAY 22, 1954

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Secretary of the Faculty  
Massachusetts Institute of Technology  
Cambridge, Massachusetts

Dear Sir:

In accordance with the requirements for the Degree  
of Naval Engineer, I submit herewith a thesis entitled,  
"An Investigation of the Early Stages of Fretting."

Respectfully,

William F. Tighe, Jr.  
Lieutenant  
U. S. Coast Guard

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111101 An investigation of low energy neutrons at Berkeley-

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Organization: 111101 Institute of Technology, Institute of Technology.

Subject: Neutron analysis

The author wishes to express his sincere

thanks and appreciation to Professor I-Ming Feng

for his advice and encouragement during this

investigation. Appreciation is also extended

to Mr. J. Purdy for his help in setting up the

testing equipment.

CONFIDENTIAL

The subject wishes to express his sincere  
thanks and appreciation to Professor I. I. Schlegel  
for his advice and assistance during this  
investigation. Professor Schlegel is also indebted  
to W. J. [unclear] for his help in setting up the  
testing equipment.

TABLE OF CONTENTS

	<u>Page</u>
I INTRODUCTION	1
II PROCEDURE	10
III RESULTS	12
IV DISCUSSION OF RESULTS	20
V CONCLUSIONS	26
VI RECOMMENDATIONS	27
VII APPENDIX	28
A. SUPPLEMENTARY INTRODUCTION	29
B. DETAILS OF PROCEDURE	34
C. SUPPLEMENTARY DISCUSSION	38
D. LITERATURE CITATIONS	41



CONTENTS

1	INTRODUCTION	I
11	CHAPTER I	II
13	CHAPTER II	III
15	CHAPTER III	IV
17	CHAPTER IV	V
19	CHAPTER V	VI
21	CHAPTER VI	VII
23	CHAPTER VII	VIII
25	CHAPTER VIII	IX
27	CHAPTER IX	X
29	CHAPTER X	XI
31	CHAPTER XI	XII
33	CHAPTER XII	XIII
35	CHAPTER XIII	XIV
37	CHAPTER XIV	XV
39	CHAPTER XV	XVI
41	CHAPTER XVI	XVII
43	CHAPTER XVII	XVIII
45	CHAPTER XVIII	XIX
47	CHAPTER XIX	XX
49	CHAPTER XX	XXI
51	CHAPTER XXI	XXII
53	CHAPTER XXII	XXIII
55	CHAPTER XXIII	XXIV
57	CHAPTER XXIV	XXV
59	CHAPTER XXV	XXVI
61	CHAPTER XXVI	XXVII
63	CHAPTER XXVII	XXVIII
65	CHAPTER XXVIII	XXIX
67	CHAPTER XXIX	XXX
69	CHAPTER XXX	XXXI
71	CHAPTER XXXI	XXXII
73	CHAPTER XXXII	XXXIII
75	CHAPTER XXXIII	XXXIV
77	CHAPTER XXXIV	XXXV
79	CHAPTER XXXV	XXXVI
81	CHAPTER XXXVI	XXXVII
83	CHAPTER XXXVII	XXXVIII
85	CHAPTER XXXVIII	XXXIX
87	CHAPTER XXXIX	XL
89	CHAPTER XL	XLI
91	CHAPTER XLI	XLII
93	CHAPTER XLII	XLIII
95	CHAPTER XLIII	XLIV
97	CHAPTER XLIV	XLV
99	CHAPTER XLV	XLVI
101	CHAPTER XLVI	XLVII
103	CHAPTER XLVII	XLVIII
105	CHAPTER XLVIII	XLIX
107	CHAPTER XLIX	L
109	CHAPTER L	L

## I INTRODUCTION

Fretting is a type of damage that occurs at the interface of two loaded surfaces that are in contact and subject to relative slip. Fretting often appears on surfaces intended to have no relative motion but which are associated with vibrating machinery. It may occur, for example, on the mating surfaces of a bearing race and of a shaft tightly fitted together. It has been shown that some slippage, no matter how small, is necessary to cause fretting. In the absence of slip there is no fretting (3, 8).

Fretting damage is a continual source of uncertainty in the operation of all machinery subject to vibration, as it quickly destroys close tolerances and increases the susceptibility to fatigue (4). Examples of fretting damage are often found in variable-pitch propellers, connecting rods, knuckle pins, ball and roller bearings, clamped and bolted flanges, pins in gear trains, suspension springs, electrical contacts, and splined surfaces. This type of damage is particularly serious in the airplane and automotive industries where close fits are employed on equipment subject to vibration. In order to eliminate or mitigate the damage caused by fretting, a better understanding of the subject is essential. The purpose of the present investigation is to add to the understanding of the subject of fretting and the means of investigating fretting damage.

INTRODUCTION

Investing is a type of strategy that consists of the intentional  
of the investor to acquire an asset or liability in order to generate  
profit. Investing often occurs on a regular basis to take  
advantage of market opportunities that are associated with changing  
market conditions. In fact, the success of an investor depends on  
the ability to identify and exploit these opportunities. It has been  
found that successful investors are those who are able to identify  
and exploit these opportunities. In fact, the success of an investor  
depends on the ability to identify and exploit these opportunities.  
The purpose of this report is to provide an overview of the  
investing process and to discuss the various factors that influence  
investment decisions. The report is divided into three main sections:  
1. The Investment Process  
2. Factors Influencing Investment Decisions  
3. Conclusion



The majority of the work done to date in the field of fretting has dealt with the mechanism of fretting and some of its qualitative aspects. Feng (2, 9, 10) has analyzed the basic factors of metal transfer and wear. The mechanism of wear, as proposed by Feng, is caused by a pair of actually contacting high spots. When these contacting high spots support a normal load that is large enough to cause plastic deformation of the metal, the deformation will cause a roughening of the interface. This roughening of the interface produces a mechanical interlocking which strengthens the interface in resisting a tangential force. Thus the application of a tangential force will cause the peak of one of the pair of high spots to shear off instead of separating the contacting high spots at the original interface. This sheared peak may either become a loose wear particle or remain attached, depending upon the factors operating to cause it to adhere to the adjacent high spot. Feng and Rightmire (1) have applied this theory to explain the mechanism of fretting, and have shown mechanical wear to be the primary cause of fretting damage.

The wear particles formed by the shearing off of the peaks of the contacting high spots form hard oxides which cause abrasive wear. A number of investigations (1, 3, 8, 10) have been made in different atmospheres to determine the effect of oxides on fretting damage. These investigations have shown that oxidation, while having a very marked effect, is only a secondary cause of fretting.

The majority of the work done to date in the field of testing  
has dealt with the mechanism of testing and one of the qualitative  
aspects. For example, (1) has analyzed the basic factors of metal  
fracture and wear. The mechanism of wear, as proposed by Taylor, is  
caused by a rate of actually working slip. This theory  
concerns the slip process and a normal law is given which  
for cases of plastic deformation of the metal, the deformation will  
occur a proportion of the thickness. This proportion of the  
thickness is known as a mechanical threshold which depends  
on the nature of the material and the temperature. Thus the application  
of a threshold force will cause the part of one of the pair of  
slip planes to start off instead of working the remaining  
slip plane at the critical thickness. This theory has  
often shown a lower rate of plastic or tensile strength, depending  
upon the nature of the material and the amount of the slip  
high speed. For example, (2) has analyzed the theory of  
slip in the mechanism of testing, and has shown that  
it is to be the primary cause of testing damage.  
The work reported here is based on the theory of the basic  
of the mechanism of testing and has shown that the basic  
part. A number of investigations (1, 2, 3, 4) have been made in  
different directions to determine the effect of stress on testing  
damage. These investigations have shown that slip is  
testing a very marked effect, in spite of the secondary cause of testing.



In addition to the investigations of the effect of atmospheres, investigations have been made of some of the other factors affecting fretting damage. Tests conducted by Feng and Uhlig (8) have shown that a decrease in fretting damage is caused by an increase in relative humidity, temperature and frequency of alternation; and an increase in fretting damage is caused by an increase in the number of cycles run, relative slip and normal load. Parts of these tests have also been corroborated by previous investigators (1,3). In addition, fretting damage appears to be greater, other things being equal, the better the original fit of the mating surfaces (6).

Several investigations have been made of fretting damage using various metals and nonmetals fretted against themselves and against each other. Godfrey (7) used platinum, glass, quartz, ruby, mica, and chrome-alloy steel. He found that the tendency for fretting depended upon the surface hardness of the metal tested. He also found that the introduction of a lubricant between the surfaces of the materials decreased the amount of fretting damage done in all cases, but that it was not eliminated. This latter fact was also borne out in the investigations of Tomlinson, Thorpe and Gough (3).

References (1) and (8) both present the results of mild steel specimens fretted against mild steel specimens in dry air. These results are presented in the form of curves of Specimen Weight Loss versus Number of Cycles Run. Both of these curves are concave downward at the origin, i.e., during the shifting period from shearing

In addition to the investigation of the effect of temperature,
 investigations have been made of some of the other factors affecting
 fretting damage. These are described by King and Little (3) and show
 that a decrease in fretting damage is caused by an increase in
 relative humidity, temperature and frequency of vibration; and
 an increase in fretting damage is caused by an increase in the
 number of cycles, relative slip and normal load. Tests of
 these factors have also been conducted by previous investigators (1,2).
 In addition, fretting damage appears to be greater, other things
 being equal, the better the original fit of the mating surfaces (4).
 General investigations have been made of fretting damage using
 various metals and nonmetals tested against themselves and against
 each other. Bellamy (7) used platinum, glass, quartz, ruby, sapphire,
 and diamond-like metal. He found that the tendency for fretting
 depended upon the surface hardness of the metal tested. He also
 found that the incidence of a relationship between the surface
 of the material concerned and the amount of fretting damage was in
 all cases, but that it was not universal. This latter fact was
 also borne out in the investigation of Tullison, Thorge and Gough (3).
 Bellamy (1) and (2) both present the results of which show
 specimens tested against each other specimens of the same
 results are presented in the form of curves of specimen weight loss
 versus number of cycles for tests of three curves are shown
 diagrams of the weight loss during the testing period from starting



action to abrasive wear. Feng and Rightmire (1) have proposed that this curve is actually concave upward during the shifting period. This proposal is based on the fact that the rate of wear probably increases during the shifting period as the abrasive action is presumably more violent than the shearing action. This proposal seems to be supported by the points plotted in Figures 5 and 6 of the investigation by Wright (11). One of the purposes of the present investigation is to substantiate this proposal by decreasing the number of cycles run and increasing the amount of fretting that occurs by decreasing the frequency of alternation. This will tend to expand the initial portion of the curve. The test apparatus shown in Figures I, II, and III and described in Appendix A was used for the investigation.

Using weight loss as a measure of fretting damage is not always the best means, even though it can be measured quantitatively and relatively accurately. An excellent example is the case in which two clean surfaces are fretted against each other in a vacuum. Because of the adhesion between clean metallic surfaces in a vacuum, the peak sheared from one high spot sticks to the opponent high spot and becomes a piece of transferred metal. Thus very little loose wear material can be produced, metal merely being transferred back and forth from one specimen to another. If the specimens are made of the same material, the weight loss of each is practically nil.



action to determine what the true nature of the  
this curve is actually determined during the  
this proposal is based on the fact that the  
processes being the driving force of the  
knowledge more varied than the knowledge  
seems to be supported by the notes placed in Figures 2 and 3 of  
the investigation by Wilson (II). One of the purposes of the present  
investigation is to substantiate this proposal by determining the  
method of operation and determine the amount of friction that  
comes by operation in the presence of vibration. This will lead  
to reveal the initial portion of the curve. The first operation seems  
in Figure 1, II, and III and described in Appendix A and B. The  
the investigation. The investigation is being carried out by  
the investigation is a matter of finding out how  
shape the first curve, even though it can be measured qualitatively  
and relatively knowledge. An initial curve is the case in which  
two lines curves are fitted under each other in a curve.  
course of the relation between these curves in a curve,  
the first curve is the first curve in the present case.  
and because a space is indicated in the first curve.  
was obtained as a result, and every being observed from  
and that from one operation in another. In the presence of  
of the case which, the weight loss of each is practically nil.

Nevertheless, both specimens are subject to serious damage caused  
[1]  
by metal transfer. A second purpose of this investigation is  
to try and establish a technique for measuring the damage in such  
cases by correlating weight loss and some physical measure of  
fretting damage. An attempt will be made to find some relationship  
between specimen weight loss and either the depth or the area of  
damage or both.

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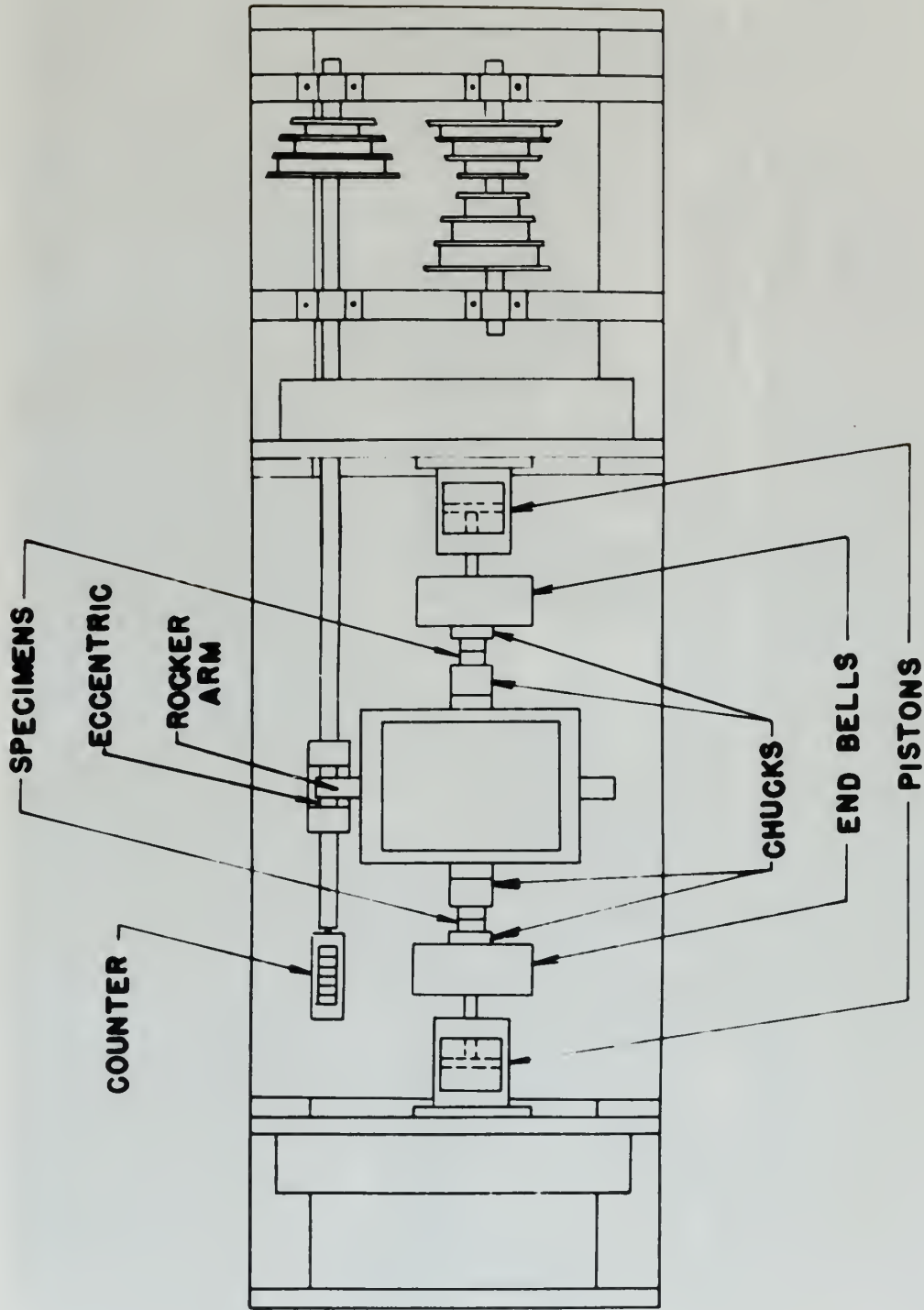
[1] Feng, I. Ming, and Rightmire, B.G., "The Mechanism of Fretting",  
Lubrication Engineering, Vol. 9, No. 3, 1953, p. 135.

Several hundred copies of this report are being distributed to various departments of the Government. It is hoped that it will be of some value to those who are interested in the subject of the investigation.

The following are the names of the persons who have been interviewed in connection with this investigation:

Mr. J. Edgar Hoover, Director, Federal Bureau of Investigation  
Mr. Clegg, Chief of Bureau of Investigation  
Mr. Glavin, Chief of Bureau of Investigation  
Mr. Ladd, Chief of Bureau of Investigation  
Mr. Nichols, Chief of Bureau of Investigation  
Mr. Rosen, Chief of Bureau of Investigation  
Mr. Tracy, Chief of Bureau of Investigation  
Mr. Carson, Chief of Bureau of Investigation  
Mr. Egan, Chief of Bureau of Investigation  
Mr. Gurnea, Chief of Bureau of Investigation  
Mr. Harbo, Chief of Bureau of Investigation  
Mr. Hendon, Chief of Bureau of Investigation  
Mr. Pennington, Chief of Bureau of Investigation  
Mr. Quinn, Chief of Bureau of Investigation  
Mr. Nease, Chief of Bureau of Investigation  
Mr. Gandy, Chief of Bureau of Investigation

[1] See also "The Bureau of Investigation," *Journal of the American Bar Association*, Vol. 3, 1915, p. 132.



**SCHEMATIC OF TEST MACHINE**

**FIGURE 1**

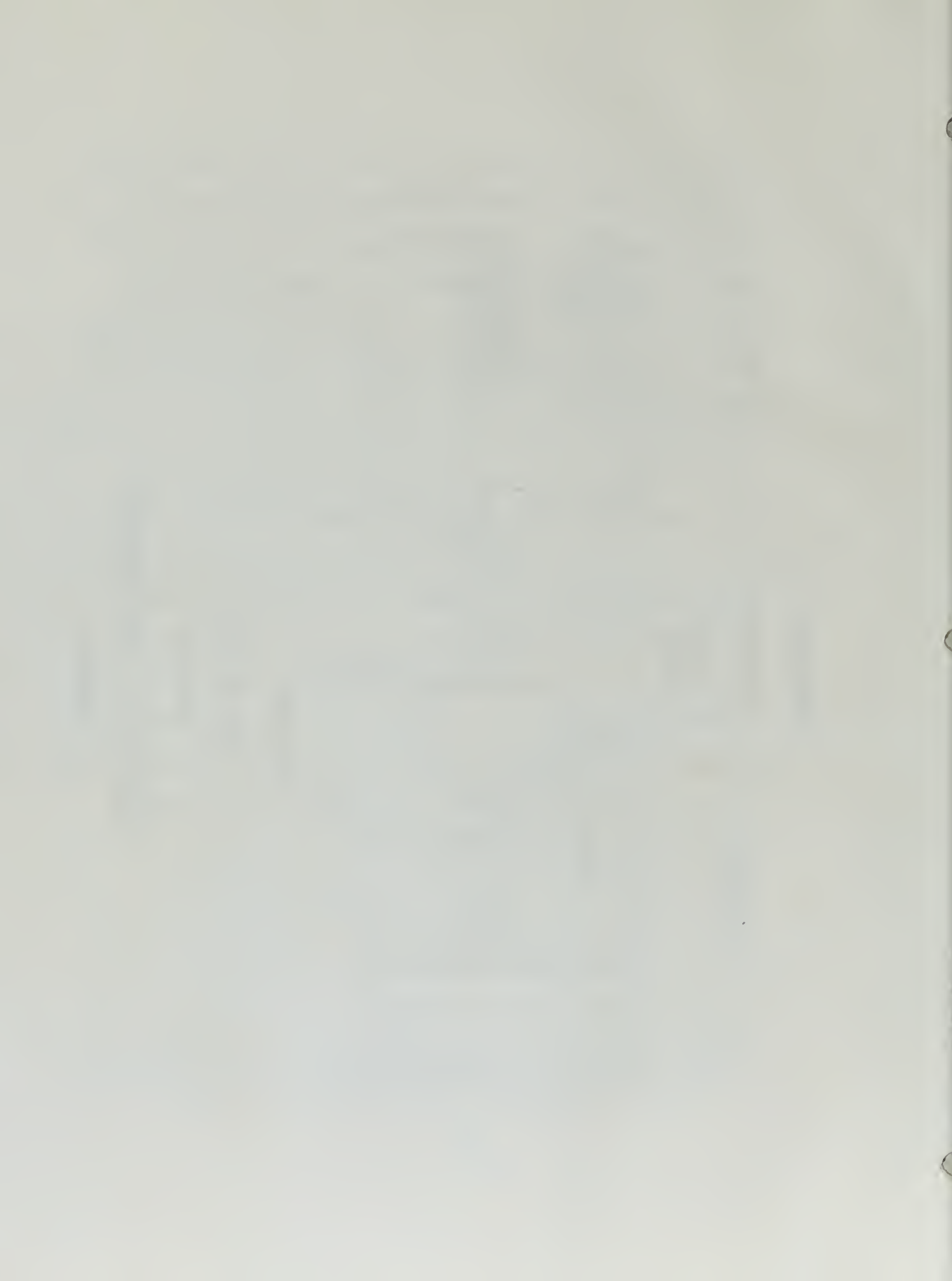
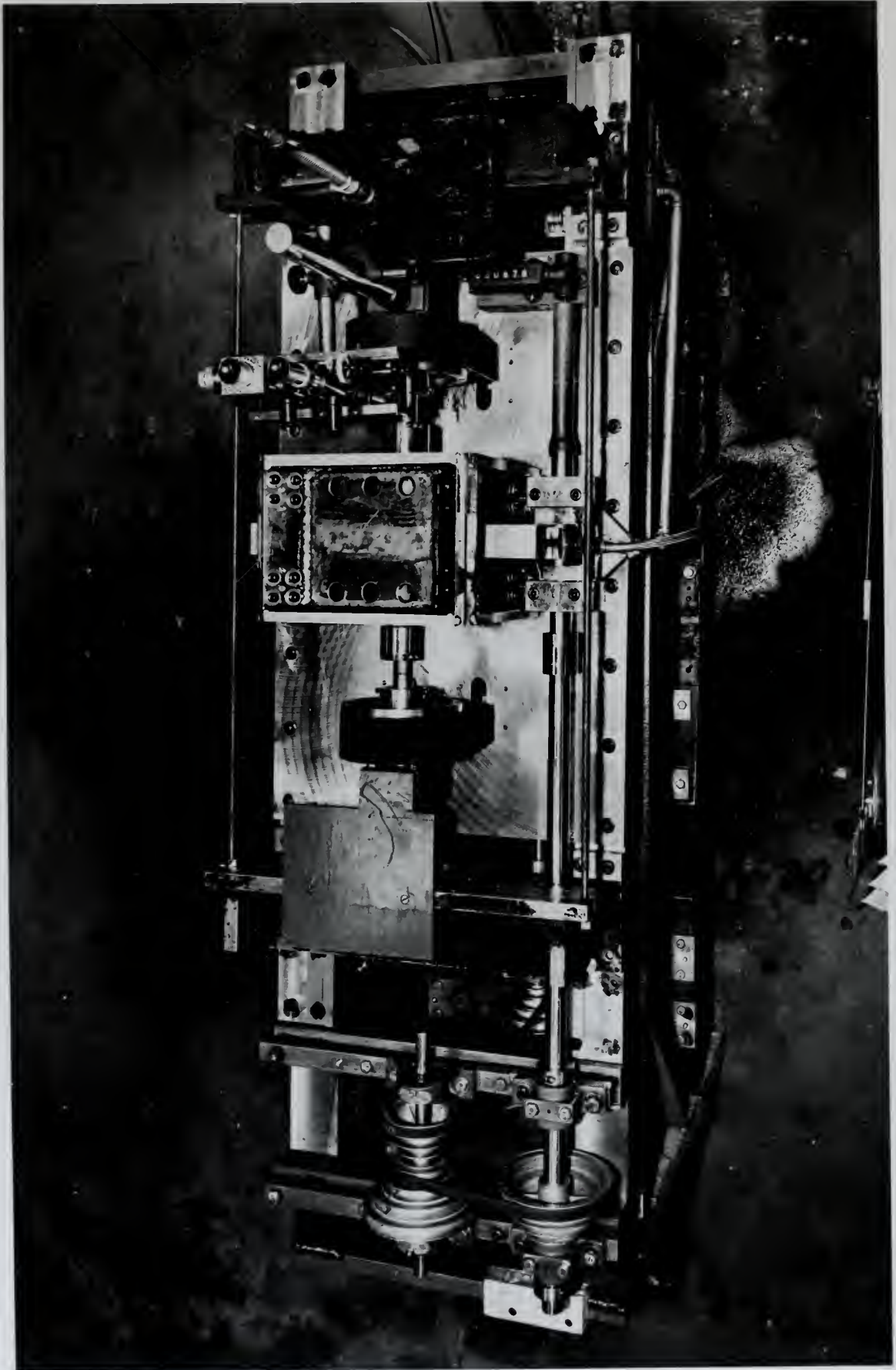




FIGURE II  
Top view of test apparatus



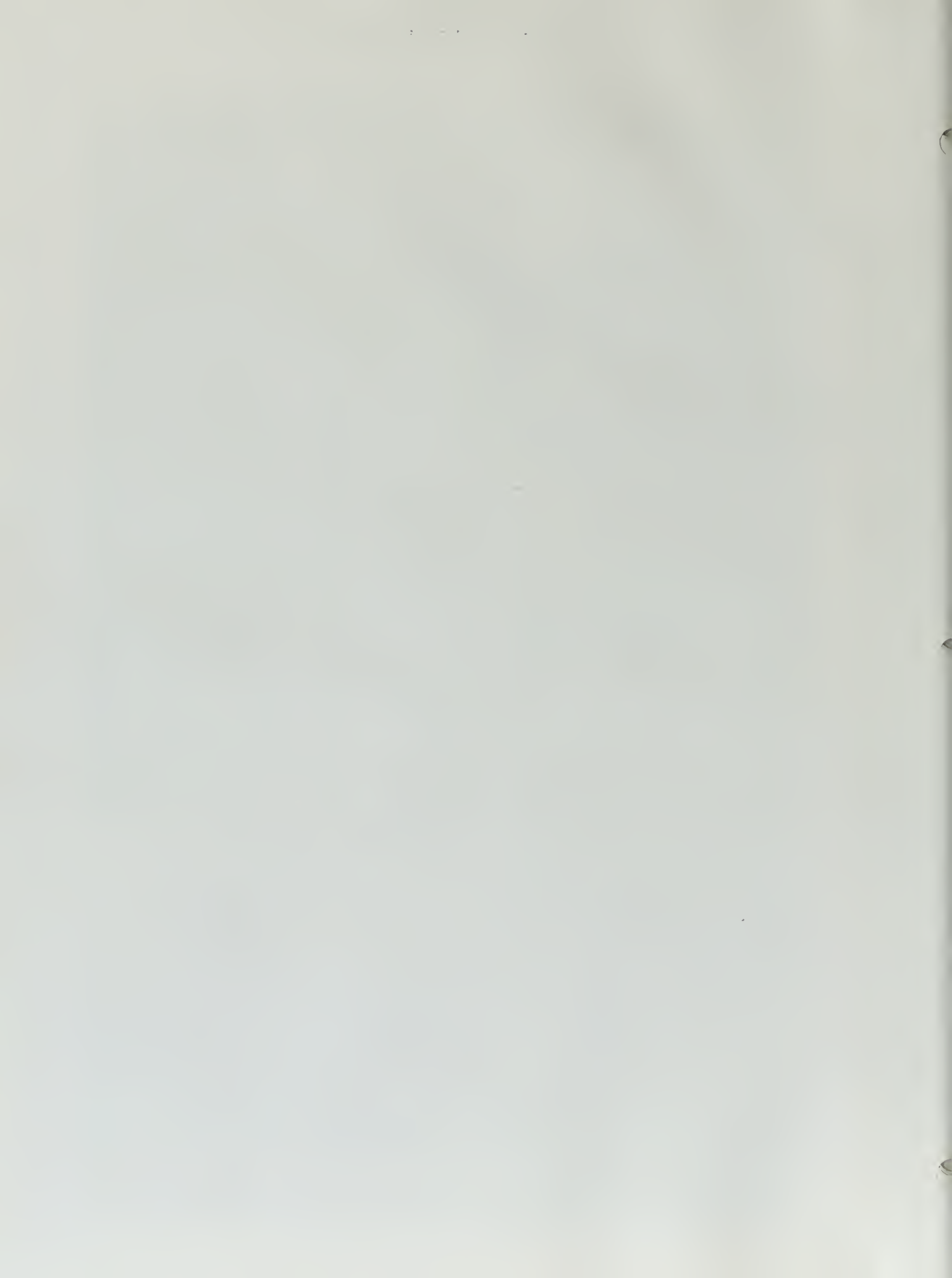
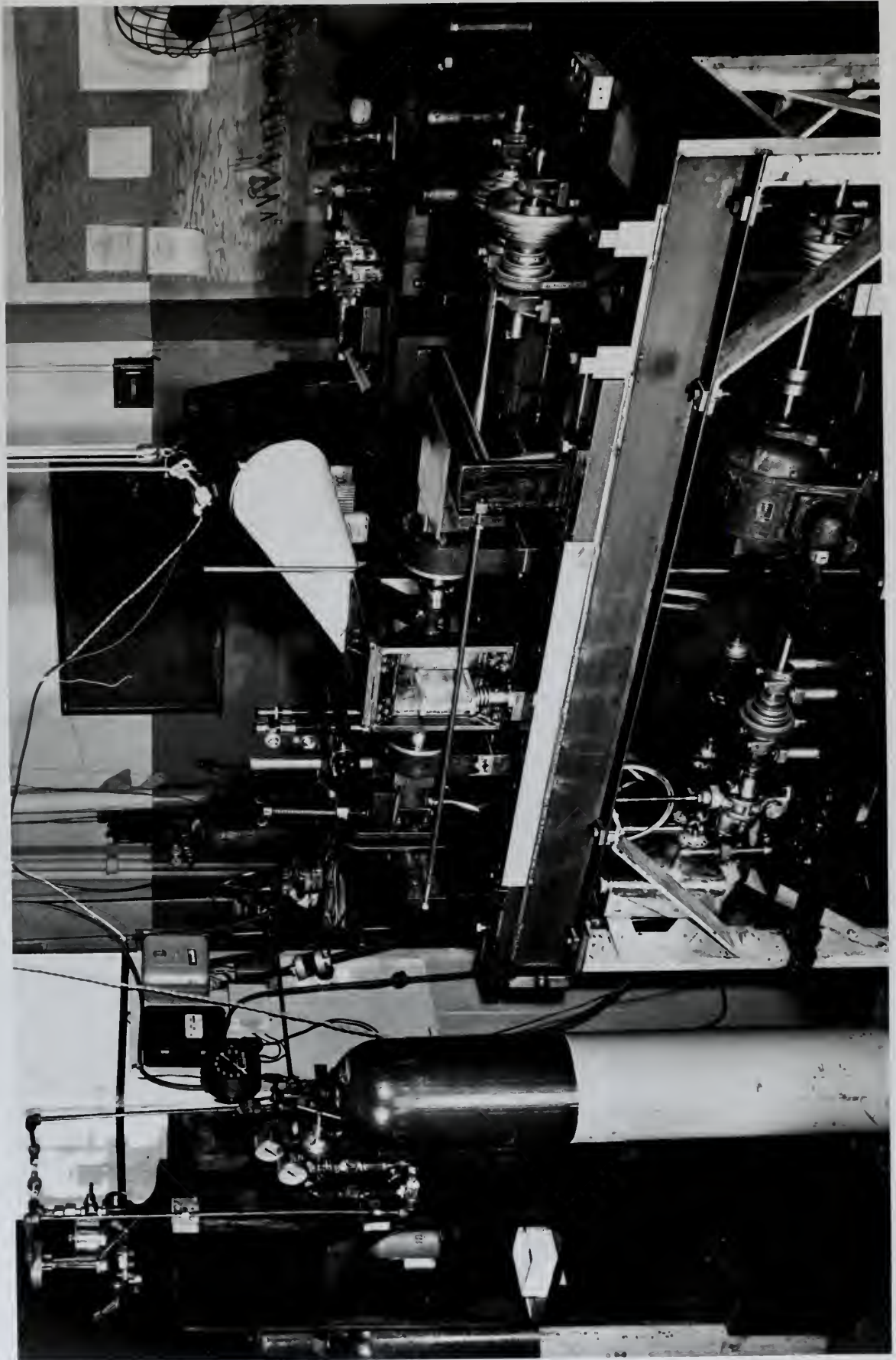


FIGURE III  
Side view of test apparatus





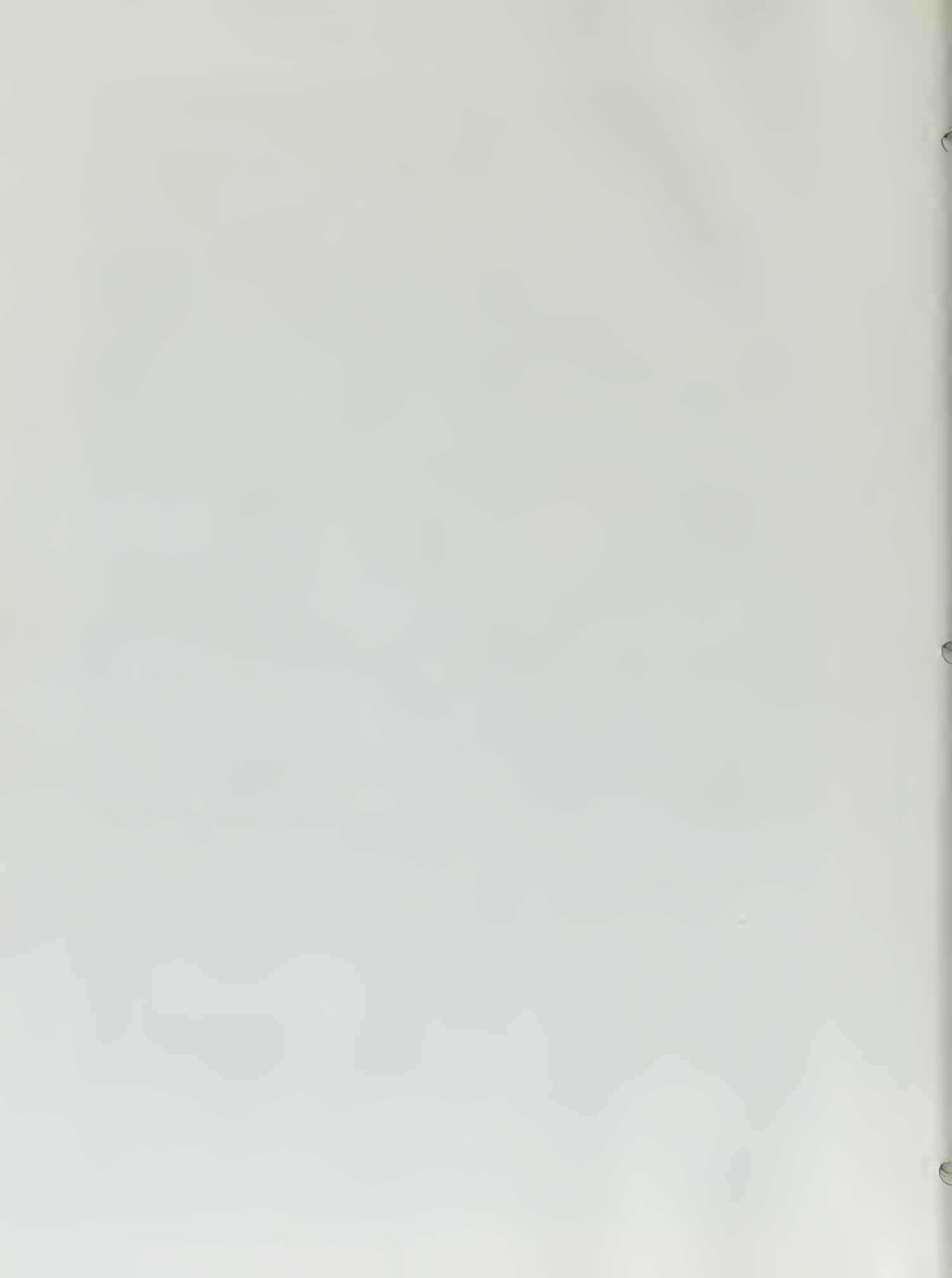
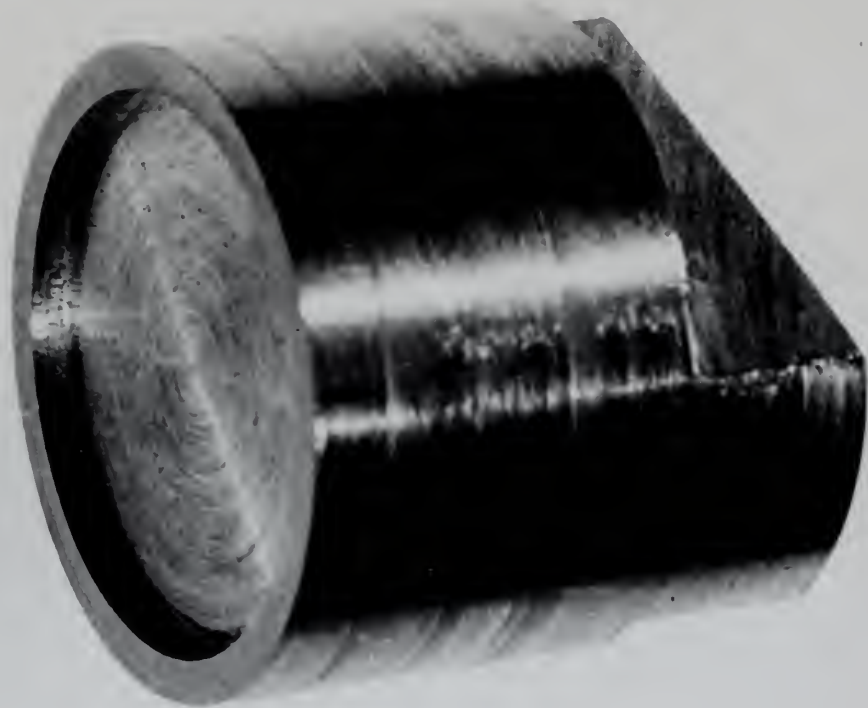
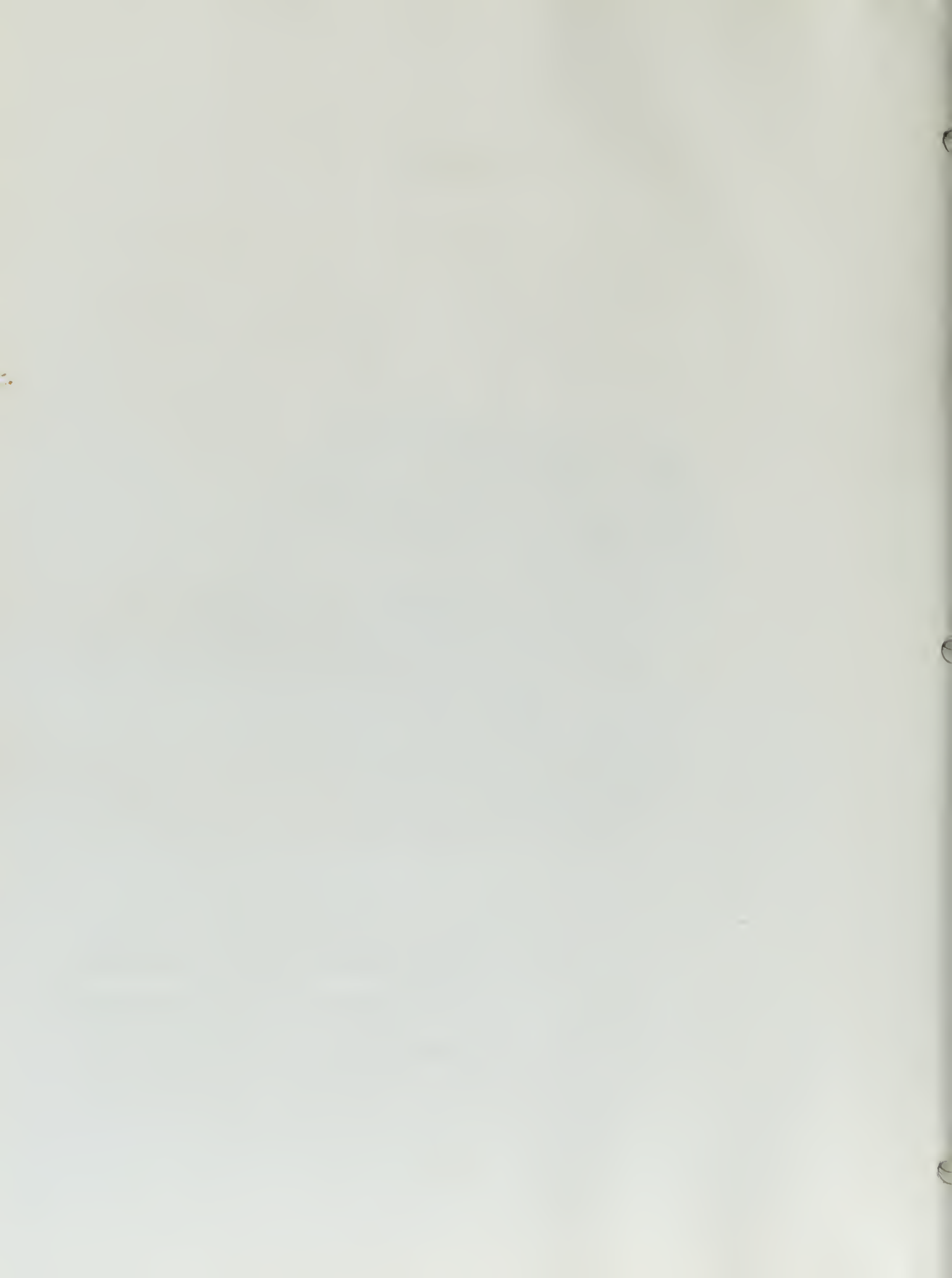


FIGURE IV  
Standard test specimen





## II PROCEDURE

The specimens to be tested were prepared as outlined in Appendix B, mounted in the test machine and the tests made. All of the tests were made under a standard set of test conditions in an atmosphere of dry air at room temperature. The standard normal loading was 5300 psi. The relative slip was maintained at 0.0036 inch, and the frequency of alternation was kept constant at 79 cycles per minute.

Several tests were first made to determine an appropriate number of cycles at which the fretting damage was such that it was fairly easy to identify individual pits. Two runs were then made, one for five cycles duration and one for ten cycles duration. A number of individual pits were selected from each specimen and a measurement made of each pit area and its depth. This procedure was followed in order to find a relationship between pit area and depth indicating pit growth. It was anticipated that this might lead to a relationship that could be correlated with specimen weight loss.

Several tests were then made varying the duration of test from 10 to 300 cycles. The specimens were pickled once and weighed upon the completion of each test. The recorded specimen weight loss was an average of the weight losses for the four specimens tested. A representative specimen from each of six tests was selected, and

II. PROCEDURE

The procedure for the present work is outlined in Appendix I, which is in the text and the text made. All of the data were made with a standard set of test conditions in an atmosphere of dry air at room temperature. The standard normal loading was 1000 psi. The relative humidity was maintained at 0.005 inch, and the frequency of vibration was kept constant at 10 cycles per minute. Several tests were first made to determine an appropriate number of cycles at which the fracture damage was such that it was fairly easy to identify individual pits. The tests were then made, one for five cycles duration and one for ten cycles duration. A number of individual pits were selected from each specimen and a measurement made of each pit area and its depth. This procedure was followed in order to find a relationship between pit area and depth indicating pit growth. It was anticipated that this might lead to a relationship that could be correlated with specimen weight loss.

Several tests were then made varying the duration of test from 10 to 100 cycles. The specimens were weighed once and weighed again after the completion of each test. The recorded specimen weight loss was an average of the weight losses for the four specimens tested. A representative specimen from each of six tests was selected, and



a measurement was made of the total area of fretting damage and the greatest depth of damage. The purpose of this series of tests was to find the shape of the curve of specimen weight loss versus the number of cycles run. In addition to this, the tests were an attempt to find a relationship between total area and depth of damage and to corrolate this with specimen weight loss.

A series of tests was made varying the duration of test from 1 to 10,000 cycles. The specimens were cleaned and weighed after test, then pickled and reweighed. This was followed by a second pickling and reweighing. One or two specimens from each test were selected and a measurement made of the deepest depth of fretting damage. The purpose of this series of tests was three fold. First it was an attempt to determine the fretting weight loss curve. Secondly it was felt that this procedure would lead to a relationship between specimen weight loss and depth of damage. Thirdly it was an attempt to determine what effect a first and second pickling procedure would have upon specimen weight loss.

A measurement was made of the total area of the surface of the  
to water in the form of a solid. The purpose of this was to  
was to find the area of the surface of the solid in the form  
of a solid. In addition to this, the weight of the solid was  
measured and the volume of the solid was also measured. The  
weight of the solid was measured by weighing it in a  
balance. The volume of the solid was measured by measuring  
the amount of water displaced by the solid. The density of the  
solid was then calculated by dividing the weight of the solid  
by its volume. The purpose of this was to find the density of  
the solid. The density of the solid was found to be 2.7  
grams per cubic centimeter. This is the density of aluminum.  
The weight of the solid was found to be 27 grams. The  
volume of the solid was found to be 10 cubic centimeters.  
The density of the solid was found to be 2.7 grams per  
cubic centimeter. This is the density of aluminum. The  
weight of the solid was found to be 27 grams. The volume  
of the solid was found to be 10 cubic centimeters. The  
density of the solid was found to be 2.7 grams per cubic  
centimeter. This is the density of aluminum.

### III RESULTS

The results of the investigation are presented in Tables I, II, and III, and in figures V, VI, VII, and VIII. Significant points to be noted are as follows:

1. Initially the area of an individual pit increases faster than the depth. The depth then begins to increase faster than the area, followed by the area again increasing faster than the depth.
2. Initially the rate of specimen weight loss is high and soon reaches a steady state. Shortly after this steady state is reached, the rate of weight loss again increases markedly and settles at a new steady state value.
3. The specimen weight loss due to both first and second pickling is not a constant, but is a function of the amount of damage caused by fretting.
4. The total area of fretting damage is essentially a constant over the range from 30 to 300 cycles.
5. The specimen weight loss increases with an increase in the depth of fretting damage.



CHAPTER III

The results of the investigations are presented in Tables I, II, III, and in Figures 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100.

to be noted are as follows:

1. Initially the rate of an individual oil lamp was lower than the rate of the other lamps. The rate then began to increase faster than the other lamps, followed by the other lamps increasing faster than the other lamps.
2. Initially the rate of a medium weight lamp is high and the rate of a heavy weight lamp is low. The rate of a heavy weight lamp is high and the rate of a medium weight lamp is low.
3. The medium weight lamp has the highest rate and the heavy weight lamp has the lowest rate. The rate of a heavy weight lamp is high and the rate of a medium weight lamp is low.
4. The total rate of the lamps is constant. The rate of a heavy weight lamp is high and the rate of a medium weight lamp is low.
5. The medium weight lamp has the highest rate and the heavy weight lamp has the lowest rate. The rate of a heavy weight lamp is high and the rate of a medium weight lamp is low.

TABLE I

INDIVIDUAL PIT MEASUREMENT DATA

Normal Load - 5300 psi  
Slip - 0.0036 in.

Medium - dry air

Pit	Duration of Test (cycles)	Frequency of Test (cpm)	Pit Area ( $\times 10^{-6}$ in <sup>2</sup> )	Pit Depth ( $\times 10^{-4}$ in)
1	5	79	18.05	0.762
2	5	79	49.20	1.476
3	5	79	38.40	1.738
4	5	79	45.10	2.500
5	5	79	62.60	3.167
6	5	79	134.80	4.048
7	5	79	113.10	6.310
8	10	57	70.10	1.953
9	10	57	70.85	1.953
10	10	57	39.60	2.310
11	10	57	38.20	2.500
12	10	57	41.60	2.500
13	10	57	79.20	2.500
14	10	57	38.20	2.928
15	10	57	75.00	3.309
16	10	57	176.20	3.500
17	10	57	114.50	3.809
18	10	57	159.7	3.977

I. STATE

STATE DEPARTMENT OF REVENUE

1917 - 1918

1917 - 1918  
1917 - 1918

Rate (per cent)	Rate (per cent)	Percentage of Total (per cent)	Percentage of Total (per cent)	Rate
1.00	1.00	10	10	1
1.25	1.25	10	10	2
1.50	1.50	10	10	3
1.75	1.75	10	10	4
2.00	2.00	10	10	5
2.25	2.25	10	10	6
2.50	2.50	10	10	7
2.75	2.75	10	10	8
3.00	3.00	10	10	9
3.25	3.25	10	10	10
3.50	3.50	10	10	11
3.75	3.75	10	10	12
4.00	4.00	10	10	13
4.25	4.25	10	10	14
4.50	4.50	10	10	15
4.75	4.75	10	10	16
5.00	5.00	10	10	17
5.25	5.25	10	10	18
5.50	5.50	10	10	19
5.75	5.75	10	10	20

TABLE II

TABULATED RESULTS

Load - 5300 psi  
 Slip - 0.0036  
 Frequency - 79 cpm

Medium - Dry air  
 Polish - No. 00 Emery/Paper

Number of cycles run	Weight loss after 1st pickling (mg) 4 specimen Average	Weight loss after 2nd pickling (mg) 2 specimen Average	Depth of Damage after 1st pickling ( $\times 10^{-3}$ in.)	Area of Damage after 1st pickling ( $\text{in}^2$ )	Depth of Damage after 2nd pickling ( $\times 10^{-3}$ in.)
10	0.825	1.0	1.60	-	-
20	1.088	-	-	-	-
20	0.800	1.0	-	-	-
30	0.610	-	3.064	0.0356	-
40	0.800	-	2.508	0.0413	-
50	1.150	-	2.104	0.0350	-
75	1.250	-	2.828	0.0425	-
125	1.000	1.20	-	-	2.17
150	1.000	-	2.710	0.0411	-
300	1.725	-	4.393	0.0436	-



TABLE II

REVENUE ACCOUNTS

the year - 1951

1951 - 1952  
1952 - 1953

To credit Total amount (1951)	To credit Total amount (1952)	To credit Total amount (1953)	Total amount (1951-53)	Total amount (1951-53)	Total amount (1951-53)
1000.0	1000.0	1000.0	3000.0	1000.0	1000.0
2000.0	2000.0	2000.0	6000.0	2000.0	2000.0
3000.0	3000.0	3000.0	9000.0	3000.0	3000.0
4000.0	4000.0	4000.0	12000.0	4000.0	4000.0
5000.0	5000.0	5000.0	15000.0	5000.0	5000.0
6000.0	6000.0	6000.0	18000.0	6000.0	6000.0
7000.0	7000.0	7000.0	21000.0	7000.0	7000.0
8000.0	8000.0	8000.0	24000.0	8000.0	8000.0
9000.0	9000.0	9000.0	27000.0	9000.0	9000.0
10000.0	10000.0	10000.0	30000.0	10000.0	10000.0

TABLE III

TABULATED RESULTS

Load - 5300 psi  
 Slip - 0.0036 in.  
 Frequency - 79 cps

Medium - dry air  
 Polish - No. 00 Emery Paper  
 Weight Loss - specimen average

Number of Cycles run	Weight loss after test (mg)	Weight loss after 1st pickling (mg)	Weight loss after 2nd pickling (mg)	Depth of Damage after 2nd pickling ( $\times 10^{-3}$ in.)
1	-	0.600	0.750	-
80	0	1.100	1.625	2.04
100	0	1.175	1.450	3.04
100	0	1.175	1.450	2.36
100	0	0.925	1.100	-
200	0	0.925	1.600	-
200	0	1.075	1.275	2.83
200	0	0.750	1.450	2.65
300	0	1.375	1.950	2.76
500	0	1.675	1.925	3.18
500	0	1.675	1.925	4.24
1000	0.2	1.725	2.000	3.10
3000	0.3	1.925	2.675	5.95
5000	0.5	2.450	3.200	5.50
10,000	1.1	3.500	4.100	7.08

THE STATE

OFFICE OF THE COMMISSIONER OF REVENUE

THE STATE OF TEXAS  
 OFFICE OF THE COMMISSIONER OF REVENUE  
 DALLAS, TEXAS

FOR THE YEAR 1912  
 BY THE COMMISSIONER OF REVENUE

AMOUNT OF TAXES  
 COLLECTED IN 1912

PROPERTY TAXES  
 COLLECTED IN 1912

SALES TAXES  
 COLLECTED IN 1912

AMOUNT OF TAXES  
 COLLECTED IN 1911

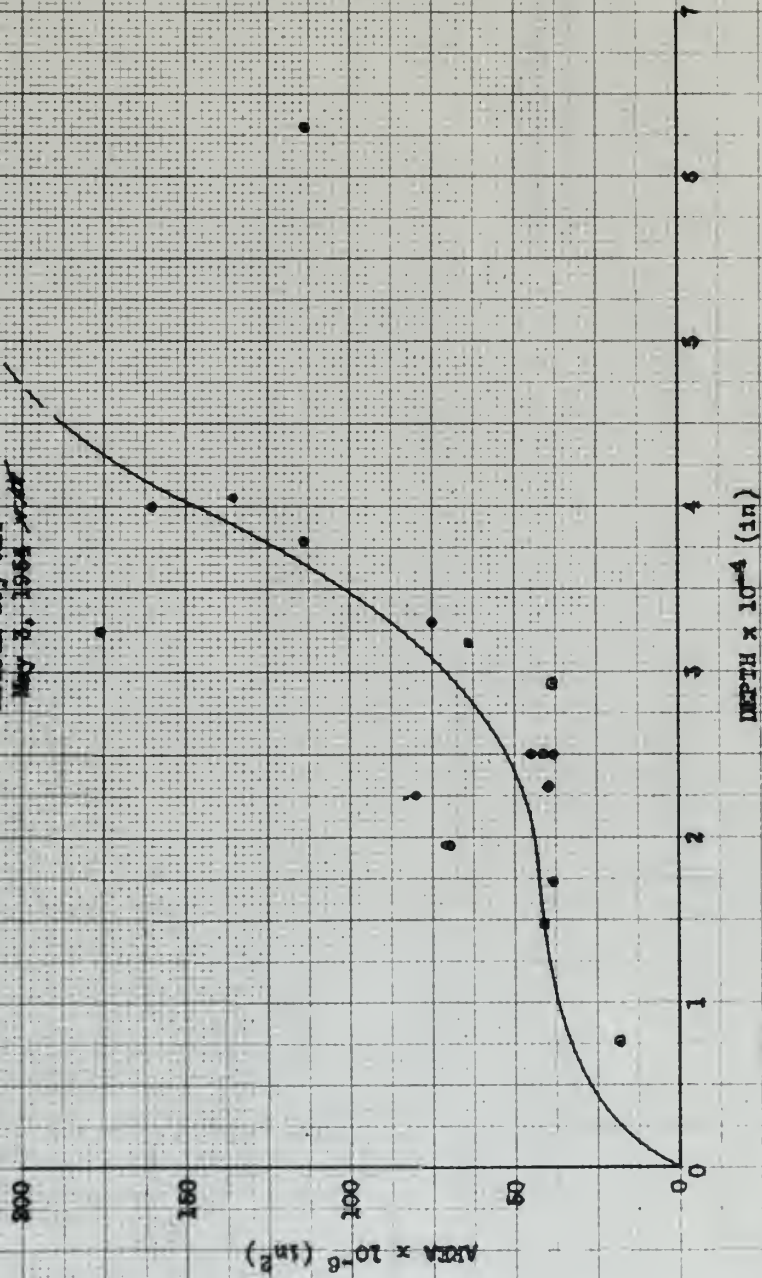
TO THE  
 COMMISSIONER OF REVENUE

1912	1911	1910	1909	1908
10,000,000	9,500,000	9,000,000	8,500,000	8,000,000
2,000,000	1,800,000	1,600,000	1,400,000	1,200,000
1,000,000	900,000	800,000	700,000	600,000
500,000	450,000	400,000	350,000	300,000
250,000	225,000	200,000	175,000	150,000
125,000	112,500	100,000	87,500	75,000
62,500	56,250	50,000	43,750	37,500
31,250	28,125	25,000	21,875	18,750
15,625	14,062	12,500	10,937	9,375
7,812	7,031	6,250	5,468	4,687
3,906	3,515	3,125	2,734	2,343
1,953	1,757	1,562	1,367	1,171
976	878	781	684	587
488	439	390	341	292
244	219	195	170	146
122	109	97	85	73
61	54	48	42	36
30	27	24	21	18
15	13	12	10	9
7	6	6	5	4
3	3	3	2	2
1	1	1	1	1

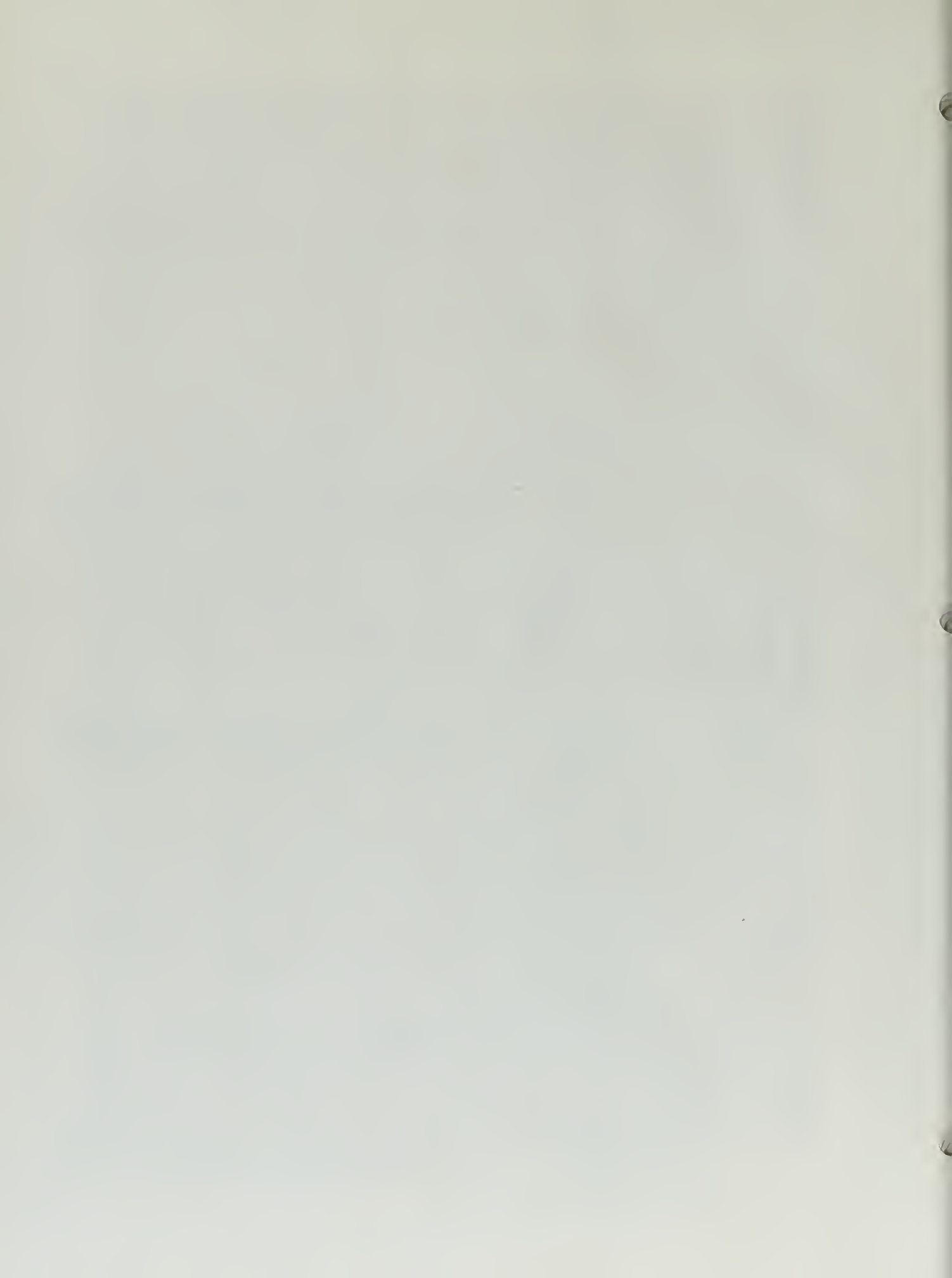


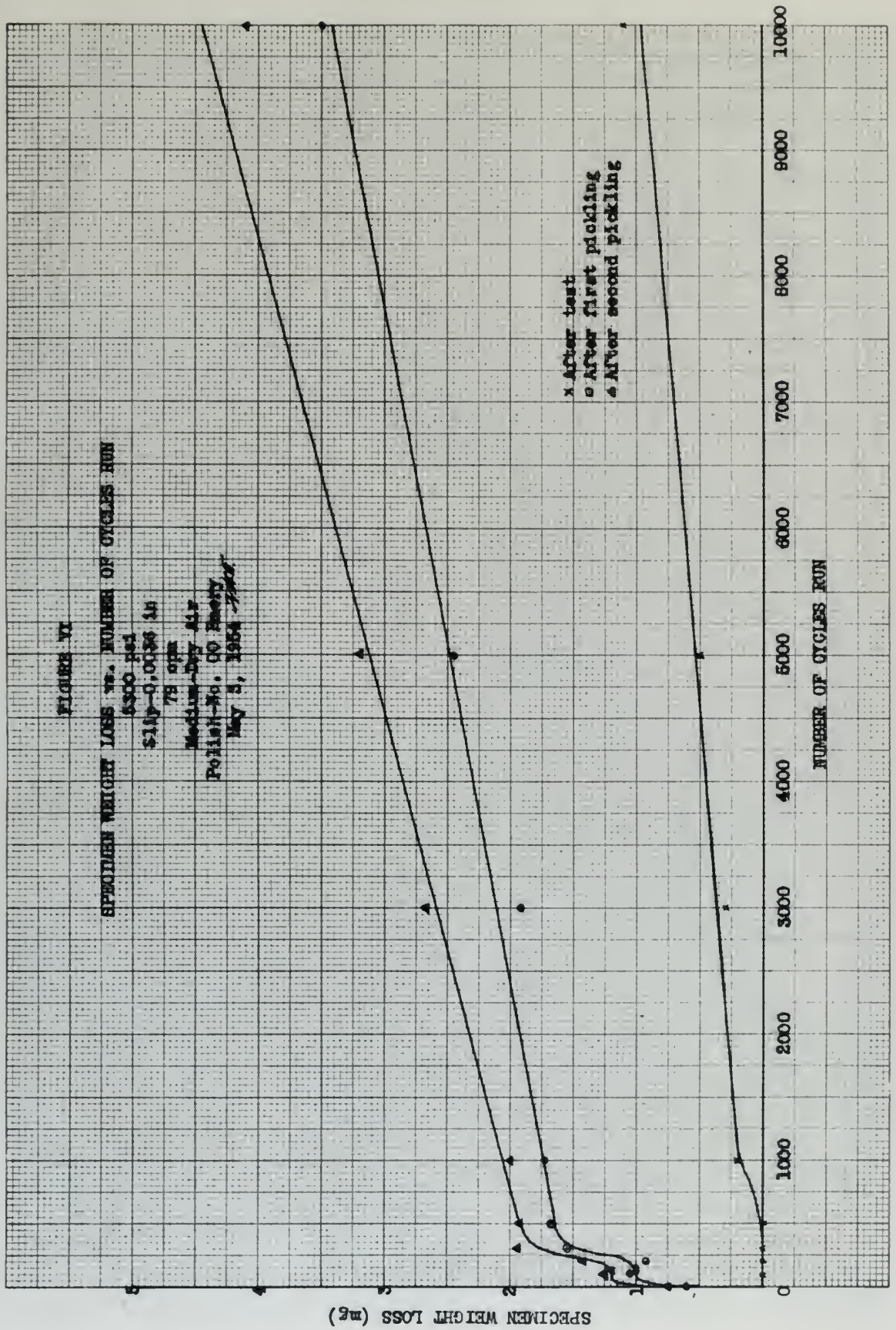
FIGURE 7

PIT AREA vs. PIT DEPTH  
5200 psi  
SLIP-0.0026 in  
Medium-Dry Air  
May 3, 1964



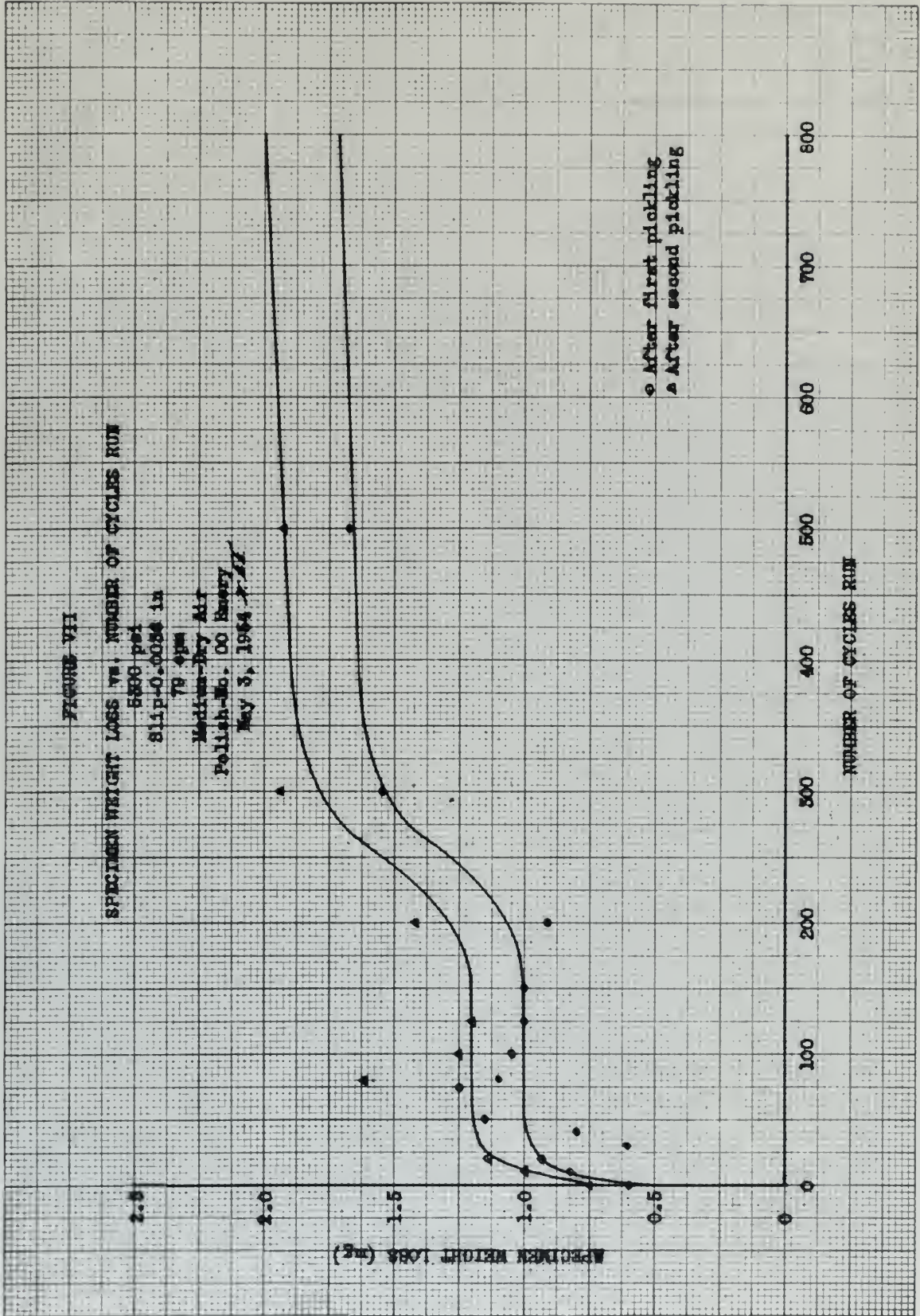




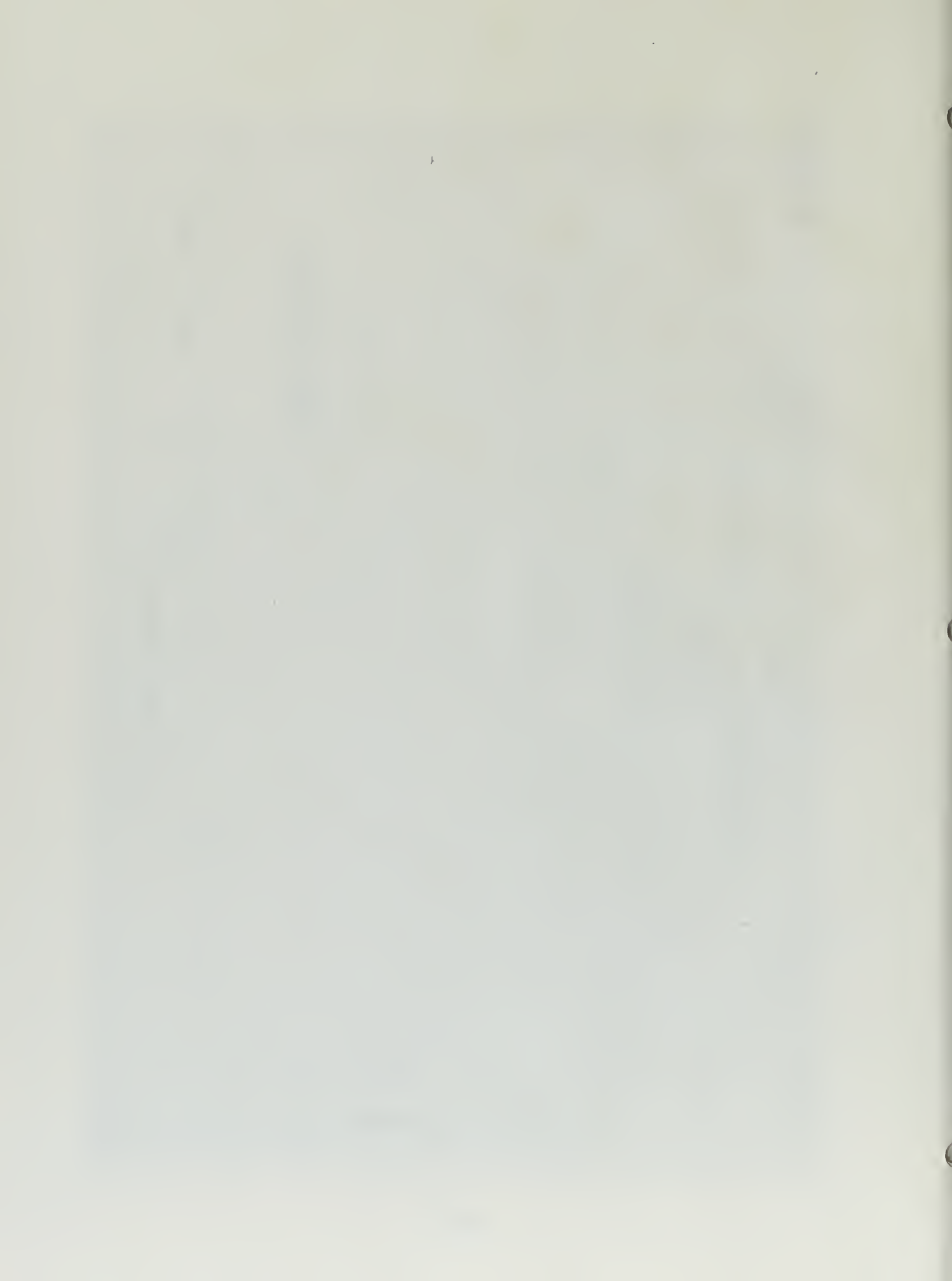


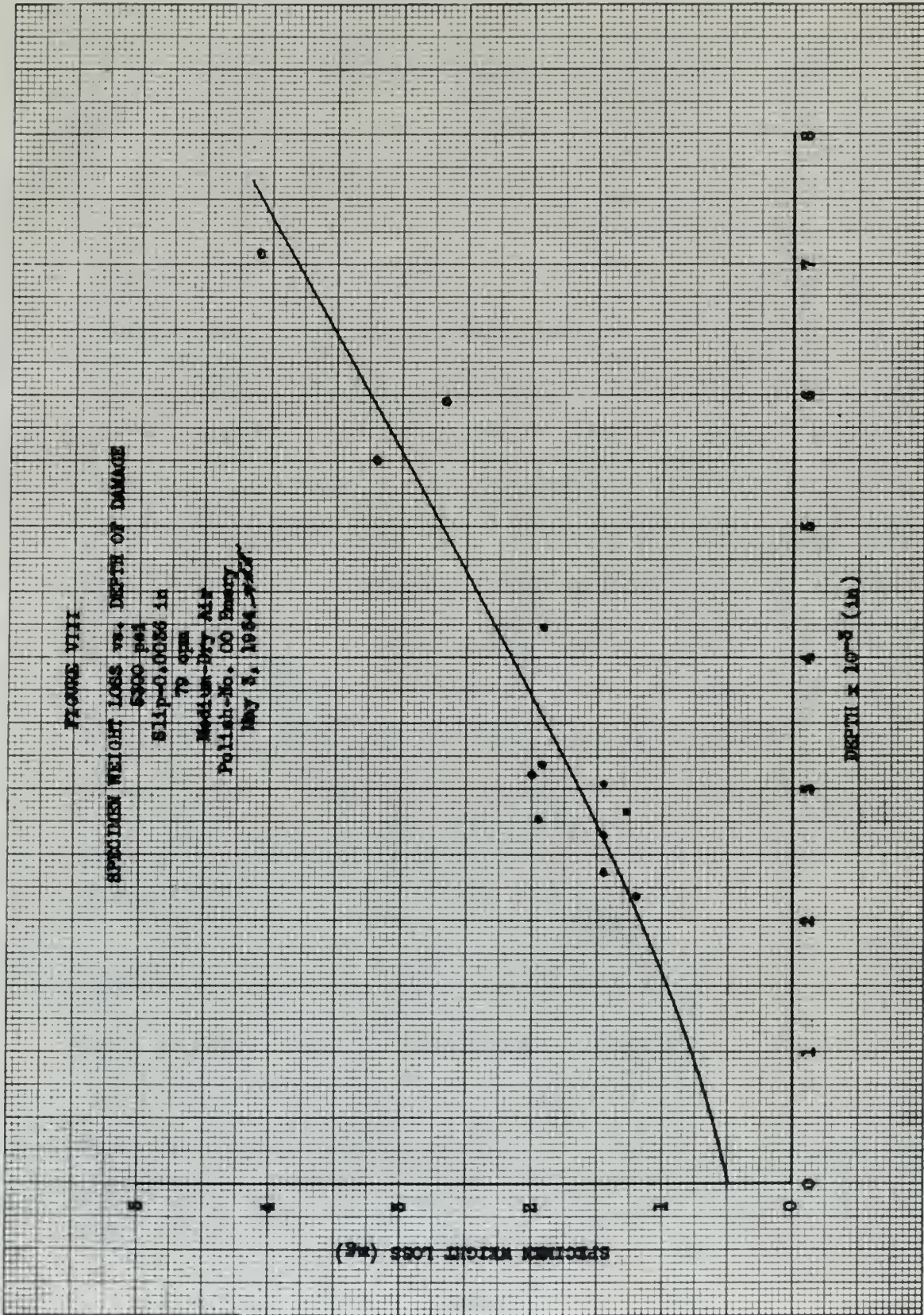
















#### IV DISCUSSION OF RESULTS

During the investigation of pit growth, it was found that individual pits could be easily identified in the neighborhood of ten cycles. In attempting to measure the area of the individual pits, however, it was found that a random surface polish with No. 1 emery paper was not satisfactory. When a pit was photographed under the microscope, the scratches left in the surface by this polish were so large and random that the boundary of the pit could not be determined with any degree of accuracy. When the surface was given a unidirectional polish with No. 000 or No. 0000 emery paper, the scratches left in the surface were considerably smaller. Since these scratches were unidirectional, the boundary of any pit running slightly off the direction of polish could be accurately determined.

It was found that any attempt to use individual pit areas or depths as a substitute for weight loss was impractical. This is due mainly to the fact that in order to distinguish a pit as a single pit, the pit must be so small that the area and depth of all pits so selected fall in the same range of values.

That the above is true may be seen from an analysis of Figure V. When two clean surfaces begin to fret, the sheared off high spots begin to form an area of damage with essentially no depth. Thus we see that in Figure V the area increases faster than the depth. The depth then begins to increase faster than the area. It is suspected that this is due to the abrasive action of the loose wear particles,



EXAMINATION OF RESULTS

During the investigation of the growth, it was found that individual pits could be easily identified in the neighborhood of ten cycles. In attempting to measure the size of the individual pits, however, it was found that a random surface polish with No. 1 emery paper was not satisfactory. When a pit was photographed under the microscope, the scratches left in the surface by this polish were so large and random that the boundary of the pit could not be determined with any degree of accuracy. When the surface was given a withdrawal polish with No. 000 or No. 0000 emery paper, the scratches left in the surface were considerably smaller. Since these scratches were withdrawal, the boundary of any pit remaining slightly off the direction of polish could be accurately determined. It was found that any attempt to use individual pit areas or depths as a substitute for weight loss was impractical. This is due mainly to the fact that in order to distinguish a pit as a single pit, the pit must be so small that the area and depth of all pits so selected fall in the same range of values.

That the above is true may be seen from an analysis of Figure V. When two linear surfaces begin to form, the smoothed off high spots begin to form in areas of damage with essentially no depth. Then we see that in Figure V the area increases faster than the depth. The depth then begins to increase faster than the area. It is suspected that this is due to the abrasive action of the local wear particles.

limited by the small amplitude of the relative motion of the specimens. The pit will eventually reach a size such that it will join with the adjacent pit forming a new pit of increased area but with a depth essentially the same as that of the old pit. Thus the area of what is still a single pit, begins to increase faster than the depth. This process continues, the pits increasing in size, until very shortly a single band of damage is formed on the specimen. It is for this reason that "individual" pit areas and depths begin to fall in the same range of values. It is further felt that the process just described will cause the curve of Figure V to continue to increase in a stepwise fashion until such time as the area of damage becomes such that it will remain essentially constant, and the depth of damage will continue to increase. This theory appears to be borne out by the data on the total area of damage given in Table II. The areas over the range from 30 to 300 cycles appear to be essentially constant which would indicate that this particular range is over a flat step in the curve.

In Figure VI, the curve of specimen weight loss after test and before pickling serves no real purpose. Above about 500 cycles the values are inaccurate due to the fact that a certain amount of the debris remains on the specimen and some falls off. In either case, the amount is unknown and thus the value recorded is not a true measure of specimen weight loss. This portion of the curve can serve only to indicate that specimen weight loss increases with the



limited by the small magnitude of the relative motion of the specimen. The pit will eventually reach a size such that it will join with the adjacent pit forming a new pit of increased size but with a depth essentially the same as that of the old pit. Thus the size of what is still a single pit, begins to increase faster than the depth. This process continues, the pits increasing in size, until very shortly a single band of damage is formed on the specimen. It is for this reason that "individual" pits occur and depths begin to fall in the same range of values. It is further felt that the process just described will cause the curve of Figure V to continue to increase in a stepwise fashion until such time as the mass of damage becomes such that it will remain essentially constant, and the depth of damage will continue to increase. This theory appears to be borne out by the data on the total mass of damage given in Table II. The means over the range from 30 to 300 cycles appear to be essentially constant which would indicate that this particular curve is now a flat step in the curve.

In Figure VI, the curve of specimen weight loss after test and before etching agrees in real purpose. Above about 200 cycles the values are inaccurate due to the fact that a certain amount of the debris remains on the specimen and some falls off. In either case, the curve is believed and thus the value recorded is not a true measure of specimen weight loss. The portion of the curve can serve only to indicate that specimen weight loss increases with the

number of cycles run. Below about 500 cycles, the recorded weight loss was zero, but it is felt that this is not actually the case. It is felt that if the weight loss could be measured fine enough, the initial portion of this curve would have a shape similar to that of the curves after pickling.

It may readily be seen from an examination of the curves of weight loss after first and second pickling, that the weight loss due to pickling is not a constant. It is thought that this is caused by two factors. First, the plastically deformed material is attacked more readily than the material that has not been plastically deformed. Secondly, the first pickling does not remove either all the plastically deformed material or all the debris. This is substantiated by the findings of Feng and Uhlig (8). Their investigations showed that the loss of weight for clean, untested specimens was about 0.3 milligrams per specimen. An investigation should be made to determine a means of finding the true weight loss of the specimens.

The curves of Figure VII are enlargements of the initial portions of the curves of Figure VI. An analysis of their shape not only substantiates the initial proposal of this investigation, but also the basic mechanism of fretting. The early portion of those curves resembles ordinary wear curves. The shearing off of the contacting high spots produces loose wear particles which do not oxidize immediately. These loose wear particles remain relatively soft and



number of plates per. Below about 100 plates, the recorded weight  
loss was very low. It is felt that at the weight loss could be measured from weight,  
the initial portion of this curve would have a slope similar to  
that of the curves after starting.  
It was possible to see from an examination of the curves  
of weight loss after 1 hour and 2 hours, that the weight  
loss was not increasing as fast as a constant. It is thought that this  
is caused by the fact that the plasticity of the material  
is increased very rapidly from the start and has not been  
plastically relaxed. It is felt that the weight loss has not  
reached all the plasticity relaxation material in all the plates.  
This is substantiated by the findings of the first set of plates (H).  
These investigations showed that the loss of weight for clean,  
undisturbed specimens was about 0.3 milligrams per specimen. An  
investigation should be made to determine a way of finding the  
true weight loss of the specimens.  
The curves of Figure VII are representative of the initial  
portion of the curves of Figure VI. An analysis of their shape  
not only substantiates the initial portion of this investigation,  
but also the basic mechanism of stretching. The early portion of the  
curves resembles ordinary work curves. The remainder of the curves  
indicate that some plastic relaxation has taken place but not all  
immediately. These curves were particularly similar to those

the abrasive action caused by them is not too great. The original loading is rather poor, being distributed over a relatively small number of contacting high spots. A better distribution of loading takes place through the wear process itself. These two factors combine to cause a leveling off of the rate of wear, and a tendency to arrive at a steady state value.

The loose wear particles tend to be trapped in the hollows of the small-scale waviness of the surface, due to the small amplitude of relative motion. These loose wear particles now begin to oxidize, forming the hard oxide  $\text{Fe}_2\text{O}_3$ . The accumulation of oxide particles quickly fills the space among the high spots. An entire group of high spots thus unites into a single area. These united areas will develop into large pits as the process continues. The rate of weight loss thus increases sharply during this period, as the abrasive action is very effective when the layer of oxide particles is thin. The abrasive action itself will tend to thicken the layer of oxides and thus the rate of weight loss will begin to decrease as time increases. The oxide particles eventually escape into the depressed regions associated with the large-scale waviness of the surface. This eventually leads to a thickening of the layer of oxide particles over the entire area. As the oxide layer becomes thicker and thicker, further increase in the thickness has less effect on decreasing the abrasive action and the rate of weight loss thus tends to reach a steady state.

the chemical action caused by them is not too great. The relative  
 loading is rather good, being distributed over a relatively small  
 number of supporting steel girders. A better distribution of loading  
 takes place through the web process itself. These two features  
 combine to cause a loading of the top of web, and a tendency  
 to arrive at a steady state with...

The lower end portion tends to be tapered in the hollow  
 of the wall-section members of the web, due to the small thickness  
 of relative section. These lower end portions are liable to buckle,  
 thereby the web will be... The compression of these portions  
 probably will be some along the edge... An entire group of  
 high spots that will be a... These spots will  
 develop into large pits in the groove sections. The rate of weight  
 loss from corrosion rapidly during this period, as the relative action  
 is very effective when the layer of white product is thin. The  
 relative action itself will tend to thicken the layer of white and  
 then the rate of weight loss will begin to decrease as the thickness,  
 The white product eventually covers the depressed regions  
 associated with the irregular surfaces of the hollow. This eventually  
 leads to a thickening of the layer of white product over the whole  
 area. As the white layer becomes thicker and thicker, certain portions  
 in the hollows are liable to be depressed for the same reason and  
 the rate of weight loss will begin to reach a steady state.



The foregoing analysis was roughly substantiated by optical observations. After a run of 500 cycles duration, the reddish oxide could just be seen with the naked eye and was quite visible under the microscope. In the vicinity of 200 cycles, some reddish oxides were just visible under the microscope. Examination of the specimens run for about 50 cycles showed no trace of oxides. These observations tend to check the analysis of the shape of the curve.

It is felt that the results presented in Figures VI and VII should only be treated in a qualitative way. The data presented is rather limited in amount and somewhat random in nature to be considered quantitatively. This data should be substantiated by further experiments. If the present test machine were altered to produce frequencies in the neighborhood of ten cycles per minute, it should be possible to obtain a much better quantitative result. It would also be beneficial if a finer balance were used for measuring the specimen weight loss. Additional tests should also be made in the range a little above 10,000 cycles, and the entire range repeated in different atmospheres.

Figure VIII presents a curve of specimen weight loss versus the depth of damage. The data for this curve is inadequate to determine any exact relationship between weight loss and depth of damage. The curve does indicate, however, that the depth of damage should be able to be used as a substitute for weight loss in the measurement



The following results were roughly summarized by means of

observations. After a run of 100 cycles duration, the weight  
of the sample was found to be less than the original weight  
under the microscope. In the vicinity of 500 cycles, some weight  
loss was observed under the microscope. The duration of the  
specimen run for about 20 cycles showed no trace of weight.

These observations tend to check the analysis of the data of the  
curve.

It is felt that the results presented in Figures VI and VII

should only be treated in a qualitative way. The data presented  
is rather limited in amount and somewhat random in nature so far  
concerned qualitatively. This data should be substantiated by  
further experiments. If the present test results were taken to  
produce specimens in the neighborhood of ten cycles per minute,  
it should be possible to obtain a much better quantitative result.  
It would also be beneficial if a finer balance were used for  
measuring the specimen weight loss. Additional tests should also  
be made in the range a little above 10,000 cycles, and the entire  
range repeated in different specimens.

Figure VIII presents a curve of specimen weight loss versus  
the depth of damage. The data for this curve is somewhat in doubt  
due to the relationship between weight loss and depth of damage.  
The curve has indicated, however, that the depth of damage should be  
also to be used as a substitute for weight loss in the measurement

of fretting damage. From this data and the preceding discussion of area measurements, it is felt that any attempt to use area as a measure of fretting damage is impractical. It is recommended that investigations be conducted over a wide range of cycles and in different atmospheres; and the relationship between specimen weight loss and the depth of fretting damage be firmly established.

of existing conditions. From this data and the preceding discussion  
it was determined, it is felt that any attempt to put into  
a measure of relative change in the amount of the  
the investigation be conducted over a wide range of values and  
in different circumstances; and the relationship between species  
weight loss and the degree of feeding damage be clearly established.

The following is a summary of the results of the investigation.

The first part of the investigation was devoted to the study  
of the effect of the amount of feeding damage on the weight  
loss of the insects. It was found that the weight loss  
of the insects was directly proportional to the amount of  
feeding damage. The weight loss of the insects was  
found to be directly proportional to the amount of feeding  
damage. The weight loss of the insects was found to be  
directly proportional to the amount of feeding damage.

The second part of the investigation was devoted to the study  
of the effect of the amount of feeding damage on the weight  
loss of the insects. It was found that the weight loss  
of the insects was directly proportional to the amount of  
feeding damage. The weight loss of the insects was  
found to be directly proportional to the amount of feeding  
damage. The weight loss of the insects was found to be  
directly proportional to the amount of feeding damage.

## V CONCLUSIONS

The significant conclusions drawn from this investigation are as follows:

1. A unidirectional surface polish with No.000 emery paper is satisfactory for measuring the area and depths of individual pits.
2. A unidirectional surface polish with No. 00 emery paper is satisfactory for measuring the depth of fretting damage.
3. The use of any area measurements or the depth of individual pits as a substitute for weight loss is impractical.
4. The specimen weight loss due to pickling is not a constant but is a function of the amount of fretting damage.
5. The curve of specimen weight loss versus the number of cycles run is initially concave downward. The curve then becomes concave upward followed by a downward curvature leading to a steady rate of weight loss.
6. The depth of fretting damage may be used as a substitute for weight loss in measuring fretting damage.



APPENDIX V

The following conditions govern the investigation:

are as follows:

1. A representative surface shall be used for the investigation in order to determine the effect of the surface on the results of the investigation.
2. The surface shall be prepared in a standard manner and the results of the investigation shall be compared with the results of the investigation on a standard surface.
3. The use of any one measurement of the depth of the surface shall be a sufficient basis for the investigation.
4. The results of the investigation shall be compared with the results of the investigation on a standard surface.
5. The curve of the surface shall be determined by the use of a standard method.
6. The curve of the surface shall be determined by the use of a standard method.
7. The curve of the surface shall be determined by the use of a standard method.
8. The curve of the surface shall be determined by the use of a standard method.

## VI RECOMMENDATIONS

The following recommendations for future work are made:

1. An investigation should be made to determine a method for finding the true weight loss of the specimens.
2. Additional tests should be made in dry air plus other atmospheres, to substantiate quantitatively the shape of the curve of fretting weight loss.
3. Tests should be run at a frequency in the neighborhood of  $\frac{1}{2}$  to 10 cycles per minute to quantitatively determine the very early portion of the curve of fretting weight loss.
4. Investigations should be conducted over a wide range of cycles and in different atmospheres to determine the quantitative relationship between the depth of fretting damage and specimen weight loss.

RECOMMENDATIONS

The following recommendations for future work are made:

1. An investigation should be made to determine a method for finding the true weight loss of the specimens.
2. Additional tests should be made in the line of other specimens, to substantiate quantitatively the shape of the curve of testing weight loss.
3. Tests should be run at a frequency in the neighborhood of 1 to 10 cycles per minute to quantitatively determine the very early portion of the curve of testing weight loss.
4. Investigations should be conducted over a wide range of cycles and in different specimens to determine the quantitative relationship between the shape of testing curves and testing weight loss.

VII APPENDIX



CHAPTER I

The first part of the report deals with the general situation of the country and the progress of the work done during the year. It also contains a list of the names of the members of the committee and a list of the names of the persons who have been appointed to various positions.

The second part of the report deals with the work done during the year. It contains a list of the names of the persons who have been appointed to various positions and a list of the names of the persons who have been appointed to various positions.

CHAPTER II

The second part of the report deals with the work done during the year. It contains a list of the names of the persons who have been appointed to various positions and a list of the names of the persons who have been appointed to various positions.

APPENDIX A

SUPPLEMENTARY INTRODUCTION

1. VISITA

REPUBLICAN YANKEES

## SUPPLEMENTARY INTRODUCTION

### DESCRIPTION OF APPARATUS

The fretting test machine used for this investigation is shown in Figures I, II, and III. The machine was designed by H. H. Uhlig, W. D. Tierney, and A. McClellan and is described in detail in Reference (8).

The machine was designed to produce fretting damage by oscillatory motion of two pairs of test specimens held in place by two moving and two stationary chucks. The chucks allow the tangs of the specimens to fit into a clearance slot. Opposing pairs of set screws in the clearance slot of each chuck, acting against thin shims, clamp the tang perpendicular to the axis of the specimen. The shoulder of each specimen is seated against sheet nylon cemented to the chuck to avoid fretting at this area. The two moving chucks are shrunk on square milled sections at opposite ends of a square shaft. This shrink fit provides a positive joint and minimizes fretting in this area of the machine. The square rocker-arm shaft, which carries the moving chuck, is pinned and bolted to eight leaf springs. These leaf springs form two co-axial crosses, which are bolted and pinned at their extremities to a square cage. The leaf springs thus provide a bearing which will allow small torsional oscillations but which is extremely stiff with respect to any lateral motion.



EXPERIMENTAL INVESTIGATION

DESCRIPTION OF APPARATUS

The first part of this investigation is devoted to a study of the effect of the rate of flow of the gas on the rate of reaction between the gas and the solid reactant. The reaction was studied by means of the apparatus shown in Figure 1, 2, and 3. The reaction was studied at 25°C. and at various pressures. The rate of reaction was determined from the volume of gas evolved in a given time. The apparatus consisted of a gas reservoir, a gas flowmeter, a reaction vessel, and a gas collector. The gas reservoir was a 2-liter flask containing a known volume of gas. The gas flowmeter was a U-tube manometer. The reaction vessel was a 2-liter flask containing a known amount of solid reactant. The gas collector was a 2-liter flask containing a known volume of liquid. The gas evolved from the reaction vessel passed through the gas flowmeter and into the gas collector. The volume of gas evolved was measured by the displacement of liquid in the gas collector. The rate of reaction was determined from the volume of gas evolved in a given time.

An I-beam of aluminium is shrunk on the rocker arm shaft at its midpoint, and is the member through which the motion is applied to the shaft. One end of the rocker arm goes to a cam drive and the other end to a coil spring used to keep the rocker arm in contact with the cam. A variable eccentric in which rotation of the sleeve relative to the shaft changes the eccentricity is used to vary the amount of relative motion between the specimen pairs. The drive shaft is connected to a three-phase, one horsepower motor, operating at 1800 rpm, by a system of V-belt pulleys which allows tests to be conducted at a number of different frequencies.

The normal load between the fixed and moving specimens is applied by pneumatic pistons actuated by high pressure nitrogen. The pistons have hardened spherical ends which bear on hardened plates pinned to the back of end-bell diaphragms in order to transmit the load through the fixed chuck and fixed specimen to the test surface.

To conduct tests in other than laboratory air, two split rectangular cells are provided. Each cell is clamped over a mated pair of specimens and the desired environment is then introduced to the cell. A glass window bolted and cemented to the top of the cell allows observation of the specimens during test.

The standard test specimen (shown in Figure IV) is cut from SAE 1080 cold-finished steel. The specimen is one inch in diameter and one inch long. One end of the specimen is counterbored  $7/8$  inch

An I-beam of standard dimensions is drawn on the rollers and held  
at its midpoint, and in the center through which the rollers are applied  
to the shaft. One end of the roller runs over a cam driver and  
the other end to a ball spring used to keep the roller and in con-  
tact with the cam. A vertical eccentric in which rotation of the  
shaft relative to the shaft changes the eccentricity is used to  
vary the amount of relative motion between the specimen jaws. The  
drive shaft is connected to a three-speed, low horsepower motor,  
operating at 1500 rpm, by a system of V-belt pulleys which allow  
speeds to be obtained of a number of different magnitudes.

The axial load between the fixed and moving specimens is  
applied by pneumatic cylinders actuated by high pressure nitrogen.  
The pistons have hardened spherulite ends which bear on hardened  
plates pivoted to the back of end-bell bearings in order to transmit  
the load through the fixed jaws and fixed specimen to the base  
plates.

To prevent deformation of the specimen during the test, the  
specimen ends are hardened. Each end is ground over a metal  
pair of specimens and the desired environment is then introduced to  
the cell. A glass window polished and cemented to the top of the cell  
allows observation of the specimen during test.

The standard test specimen (shown in Figure IV) is cut from  
the 1050 cold-rolled steel. The specimen is one inch in diameter  
and one inch long. One end of the specimen is untempered 1/8 inch



in diameter by  $1/16$  inch deep, forming an annular test surface of 0.184 square inch at a mean radius of 0.438 inch. The opposite end of the specimen is cut away to form a centered square tang  $5/16$  inch long. In test, the specimens are pressed together with the annular surfaces in contact. A jig is used to align the specimens concentrically with each other and with respect to the shaft of the moving chunks.





Details of Procedure

The first step in the procedure is to determine the number of samples to be taken. This is done by dividing the total number of samples by the number of samples per day. The next step is to determine the time of day when the samples should be taken. This is done by dividing the 24 hours of the day into the number of samples per day. The third step is to determine the location where the samples should be taken. This is done by dividing the area to be sampled into the number of samples per day. The fourth step is to determine the method of sampling. This is done by selecting a method that is suitable for the type of material to be sampled. The fifth step is to determine the equipment to be used for sampling. This is done by selecting equipment that is suitable for the method of sampling. The sixth step is to determine the personnel to be used for sampling. This is done by selecting personnel who are trained in the method of sampling. The seventh step is to determine the frequency of sampling. This is done by selecting a frequency that is suitable for the type of material to be sampled. The eighth step is to determine the duration of the sampling program. This is done by selecting a duration that is suitable for the type of material to be sampled. The ninth step is to determine the cost of the sampling program. This is done by selecting a cost that is suitable for the type of material to be sampled. The tenth step is to determine the results of the sampling program. This is done by selecting a method that is suitable for the type of material to be sampled.

APPENDIX B

DETAILS OF PROCEDURE

The first step in the procedure is to determine the number of samples to be taken. This is done by dividing the total number of samples by the number of samples per day. The next step is to determine the time of day when the samples should be taken. This is done by dividing the 24 hours of the day into the number of samples per day. The third step is to determine the location where the samples should be taken. This is done by dividing the area to be sampled into the number of samples per day. The fourth step is to determine the method of sampling. This is done by selecting a method that is suitable for the type of material to be sampled. The fifth step is to determine the equipment to be used for sampling. This is done by selecting equipment that is suitable for the method of sampling. The sixth step is to determine the personnel to be used for sampling. This is done by selecting personnel who are trained in the method of sampling. The seventh step is to determine the frequency of sampling. This is done by selecting a frequency that is suitable for the type of material to be sampled. The eighth step is to determine the duration of the sampling program. This is done by selecting a duration that is suitable for the type of material to be sampled. The ninth step is to determine the cost of the sampling program. This is done by selecting a cost that is suitable for the type of material to be sampled. The tenth step is to determine the results of the sampling program. This is done by selecting a method that is suitable for the type of material to be sampled.

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## DETAILS OF PROCEDURE

All of the tests were run under a standard set of test conditions, varying only the number of cycles that the tests were run. The test conditions were selected after a study of reference (8), and were so chosen that a substantial amount of damage would be caused in a fairly short interval of time. The standard conditions selected were, a normal loading of 5300 psi, a relative slip of 0.0036 inch and a frequency of alternation of 79 cycles per minute. The atmosphere chosen was dry air at room temperature.

Having selected the test conditions, several tests were first made to determine an approximate number of cycles at which the fretting damage was significant yet such that it was possible to identify individual damage pits. The surface of specimens for these tests was given a random polish with No. 1 emery paper.

A test was then run for 10.5 cycles using specimens having a random surface polish with No. 1 emery paper. Prior to final polishing, the surfaces of all the specimens were given three diamond indentations spaced approximately 120 degrees apart. These diamond indentations were made using a Vickers Hardness Test machine and a diamond indenter having a major axis ratio of 35 to 1 and a minor axis ratio of 6 to 1. The loading used on the Vickers machine was 20 kilograms. Upon completion of the test, several individual pits were selected at random from one specimen and photographs taken of them using a magnification of 120X. A photograph of one of the diamond indentations was also



RESULTS OF EXPERIMENT

All of the tests were run under a standard set of test conditions, varying only the number of cycles and the test rate. The test conditions were selected after a study of references (1) and (2) and were so chosen that a substantial amount of damage would be caused in a fairly short interval of time. The standard conditions selected were, a normal loading of 2300 psi, a relative slip of 0.0030 inch and a frequency of vibration of 19 cycles per second. The specimens chosen were of the type shown in figure 1.

Testing included the test conditions, several tests were first made to determine an approximate number of cycles at which the testing damage was significant for each test it was possible to identify individual damage sites. The nature of specimens for these tests was given a random polish with No. 1 emery paper.

A test was then run for 10.5 cycles with specimens having a random surface finish with No. 1 emery paper. After the final polishing the surface of all the specimens were given three different treatments spaced approximately 100 degrees apart. These different treatments were made using a Wilson's Abrasive Test Machine and a diamond indentor having a major axis ratio of 32 to 1 and a minor axis ratio of 8 to 1. The facility used on the Wilson's Machine was 50 kilograms. Upon completion of the test, several individual pins were removed at random from one specimen and subjected to a series of tests using a magnifying glass. A photograph of one of the finished specimens was also

taken using the same magnification. The specimen was carefully dressed down by hand, using No. 000 and No. 0000 emery paper, until each pit under observation just disappeared. As each pit disappeared, a photograph was again taken of the same diamond indentation. The area of each pit was measured from the photograph using a planimeter. The depth of each pit was determined by the difference in the successive indentation photographs using the trigonometric relationships for a right triangle.

A test was run for 5 cycles duration at a frequency of 79 cycles per minute. The surface preparation was a unidirectional polish with No. 0000 emery paper. Another test was run for 10 cycles at a frequency of 57 cycles per minute. The surface preparation for this test was a unidirectional polish with No. 000 emery paper. Four to six individual pits were selected from each of two specimens and the area and depth of each pit was determined as set forth in the preceding paragraph. These tests were run at different frequencies and with different surface finishes because it was felt that the pit growth should depend only on the length of time that the pit was allowed to grow.

A number of runs were made varying the duration of test from 10 to 300 cycles. The surface preparation of the specimens for these tests was a unidirectional polish with No. 00 emery paper. All specimens were weighed before testing and were pickled and weighed after testing. One specimen from each of six tests was selected and a photograph taken



taken during the same investigation. The two other men certainly  
diverged from the line, being No. 100 and No. 1000 very close, well  
near the same observation post. The distance between them was  
4 feet and was about the same as the distance between the two  
of which the distance from the observation post was 10 feet. The  
depth of each pit was determined by the distance in the direction  
indicated by the line, which the two men were following for a  
right angle.

A hole was dug for 2 inches diameter at a distance of 10  
feet from the line. The surface was a horizontal line  
parallel to the line. Another hole was dug for 10 inches in  
a diameter at 20 inches from the line. The surface was a horizontal  
line and a horizontal line parallel to the line. For the  
six feet of the line were marked from each of the two points and the  
two and depth of each pit was determined by the distance in the direction  
indicated by the line, which the two men were following for a  
right angle. The distance between the two points was 10 feet and the  
distance between the two points was 10 feet. The distance between the  
two points was 10 feet and the distance between the two points was 10 feet.

Two  
A number of pits were dug during the investigation of the line. In  
No. 100 and No. 1000. The surface was a horizontal line for the  
line was a horizontal line parallel to the line. All pits were  
were marked during the investigation and were marked with a horizontal  
line. The distance between the two points was 10 feet and the distance  
between the two points was 10 feet.

of the entire fretted surface. The photographs were enlarged until the specimen was 10 times its original size. The entire area of damage was then measured using a planimeter. The deepest depth of damage was then measured, the specimen being dressed down until all damage just disappeared. The technique for measuring depths was the same as that used before except that the standard Vicker's diamond indenter was used with a 40 kilogram load. The standard indenter was used since it was felt that the depths would be too great for the previously used indenter.

A second series of tests was made varying the duration of test from 1 to 10,000 cycles. The specimen surface preparation for these tests was again a unidirectional polish with No. 00 emery paper. The specimens were again weighed before testing. Upon completion of the test, the specimens were rinsed in boiling benzene, dried and weighed. The specimens were then pickled and weighed again. All specimens were then given a second pickling and reweighed. After the second pickling, one or two specimens from each test were given a diamond indentation with the standard Vickers indenter using a load of 40 kilograms. The small ridge formed around the indentation was carefully dressed off and the deepest depth of damage to the specimen then determined as previously outlined for the preceding tests.





## PREPARATION AND CLEANING OF SPECIMENS

The test specimens were given the desired surface finish by hand polishing on emery paper, using a polishing guide to maintain a flat surface. The specimens were then cleaned in acetone and weighed. The specimens were then clamped firmly in the test machine and the full test procedure applied.

When the test was completed the specimens were degreased in hot benzene. Depending upon the particular test under study, the specimens were then weighed, or pickled and weighed after pickling. The pickling procedure was carried out as follows:

1. The specimen was immersed for 30 seconds in a pickling solution heated to 50°C (120°F). The pickling solution is 5% by weight sulfuric acid and 0.1% by weight of quinolinethiodide, a pickling inhibitor.
2. The specimen, held in tongs, was taken from the pickle solution and placed under running water.
3. The fretted surface of the specimen was then scrubbed with a stiff bristle brush and rinsed again in running water.
4. The specimen was then rinsed in hot acetone followed by a rinse in boiling distilled benzene.
5. The dried specimen was placed in a desiccator and left for at least one hour to allow thermal equilibrium to be attained.
6. Each specimen was then weighed and the weight recorded.

PREPARATION OF SPECIMENS

The test specimens were given the desired surface finish by hand polishing on wet paper, using a polishing grade to maintain a flat surface. The specimens were then cleaned in acetone and washed. The specimens were then allowed to dry in the test machine and the full test procedure applied.

When the test was completed the specimens were depressed in the test machine. Depending upon the particular test under study, the specimens were then weighed, or weighed and weighed after drying.

The pickling procedure was carried out as follows:

1. The specimens are immersed for 30 seconds in a pickling solution heated to 20° (100° F). The pickling solution is 5% by weight nitric acid and 0.1% by weight of hydrofluoric acid, a pickling inhibitor.

2. The specimens, held in force, are taken from the pickling solution and rinsed under running water.

3. The finished surface of the specimen are then wrapped in a dry cloth which is held and stored until in storage.

4. The specimens are then stored in the manner indicated by a label in a sealed plastic container.

5. The dried specimen are placed in a desiccator and left for at least one hour to allow residual pickling to be removed.

6. Each specimen are then weighed and the weight recorded.



EXPERIMENTAL PROCEDURE

The diameter of the specimen under test depends on the diameter of the hole in the plate. This should not vary with the diameter of the hole in the plate. The error in the radius of the hole is negligible.

The diameter of the hole in the specimen is calculated from the diameter of the hole in the plate. The error in the diameter of the hole in the plate is negligible. The error in the diameter of the hole in the specimen is negligible. The error in the diameter of the hole in the specimen is negligible.

The diameter of the hole in the specimen is calculated from the diameter of the hole in the plate. The error in the diameter of the hole in the plate is negligible. The error in the diameter of the hole in the specimen is negligible. The error in the diameter of the hole in the specimen is negligible.

APPENDIX C

SUPPLEMENTARY DISCUSSION

The diameter of the hole in the specimen is calculated from the diameter of the hole in the plate. The error in the diameter of the hole in the plate is negligible. The error in the diameter of the hole in the specimen is negligible. The error in the diameter of the hole in the specimen is negligible.

It is concluded that the error involved in the calculation is negligible. This is particularly true of all specimens in which the hole is parallel to the axis of the specimen.



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APPENDIX

EXHIBIT

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## SUPPLEMENTARY DISCUSSION

The diameters of the specimen faces were accurate to 0.0005 inch. With careful hand polishing on a flat glass or steel plate, the error in the surface flatness of the specimens was negligible.

The pressure at the interface of the specimens is estimated to be within  $\pm 30$  psi. Even with an accurate pressure gauge there is an error. If the faces of the two specimens do not meet exactly parallel and together with no pressure applied, a small amount of pressure is necessary to bring them into contact when the test begins.

The frequency of alternation was checked periodically and was accurate to within  $\pm 1$  cpm. The total number of cycles run, measured with a counter attached to the eccentric shaft, was estimated to be accurate to within  $\pm 5$  cycles in 10,000 cycles.

The specimen weight loss was measured with an analytical balance that read to 0.1 milligram. It is felt that the accuracy here is in question, particularly in the regions of small weight loss. It is recommended that each specimen be weighed twice, each time by a different person.

It is estimated that the error involved in pickling is negligible. This is particularly true if all pickling is done by the same person and is done in exactly the same manner each time.

EXPERIMENTAL PROCEDURE

The amount of the specimen loss was measured to 0.0005 gms. With special care in the use of the balance, the error in the weight of the specimen was negligible. The pressure at the interface of the specimen is estimated to be within  $\pm 10$  psi. Even with an accurate pressure gauge there is an error. If the loss of the specimen is not exactly equal and opposite with no pressure applied, a small amount of pressure is necessary to bring them into contact with the test bed. The frequency of vibration was checked periodically and was accurate to within  $\pm 1$  cps. The total number of cycles run, measured with a counter attached to the electronic shell, was estimated to be accurate to within  $\pm 2$  cycles in 10,000 cycles. The specimen weight loss was measured with an analytical balance that read to 0.1 milligram. It is felt that the accuracy here is in question, particularly in the region of small weight loss. It is recommended that each specimen be weighed twice, each time by a different person. It is estimated that the error involved in weighing is negligible. Thus in particular, even if all weighing is done by the same person and is done in exactly the same manner each time.



There are errors involved in the measurement of the depth of damage. If the two specimens do not meet exactly parallel, the pressure is not the same over the entire surface of contact. Since the depth measured is the deepest found, this difference in pressure will introduce errors in the measurement. The diamond indentations may also introduce errors if they are not exactly correct. It is felt, however, that <sup>WITH</sup> the standard Vickers indenter this error is usually negligible. There is also an error introduced in the measurement of depth due to an inaccuracy in determining when the damage just disappears. If the dressing down is done by hand, and all observations are made under a microscope, it is felt that this error may be reduced to the point where it will also be negligible.

#### ANALYSIS OF SPECIMEN STOCK

The certified mill analysis of the SAE 1018 cold-finished steel used in the specimens is as follows:

Carbon, percent	0.15
Manganese, percent	0.75
Phosphorus, percent	0.008
Sulphur, percent	0.027

A check analysis made by the Department of Metallurgy indicated a carbon content of 0.16 percent.



There are errors involved in the measurement of the depth of change. If the two specimens do not meet exactly parallel, the pressure is not the same over the entire surface of contact. Hence the depth measured is the deepest point, this difference in pressure will introduce errors in the measurement. The diamond indentations may also introduce errors if they are not exactly correct. It is felt, however, that the standard Vitreous Silica standard used as usually negligible. There is also an error introduced in the measurement of depth due to an inaccuracy in determining when the change takes place. If the drawing down is done in hand, and all observations are made under a microscope, it is felt that error may be reduced to the point where it will also be negligible.

ANALYSIS OF RESULTS

The results will consist of the following:

These are in the following order:

0.15	Carbon, percent
0.75	Silicon, percent
0.005	Iron, percent
0.007	Aluminum, percent

A check analysis was made by the Bureau of Chemistry and a carbon content of 0.16 percent.

APPENDIX D

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DECLARATION

I, the undersigned, do hereby certify that the foregoing is a true and correct copy of the original as the same appears in the records of the Board of Health of the City of New York.

Witness my hand and the seal of the Board of Health at New York, this 1st day of June, 1901.

JOHN W. WARD, Mayor of the City of New York.  
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