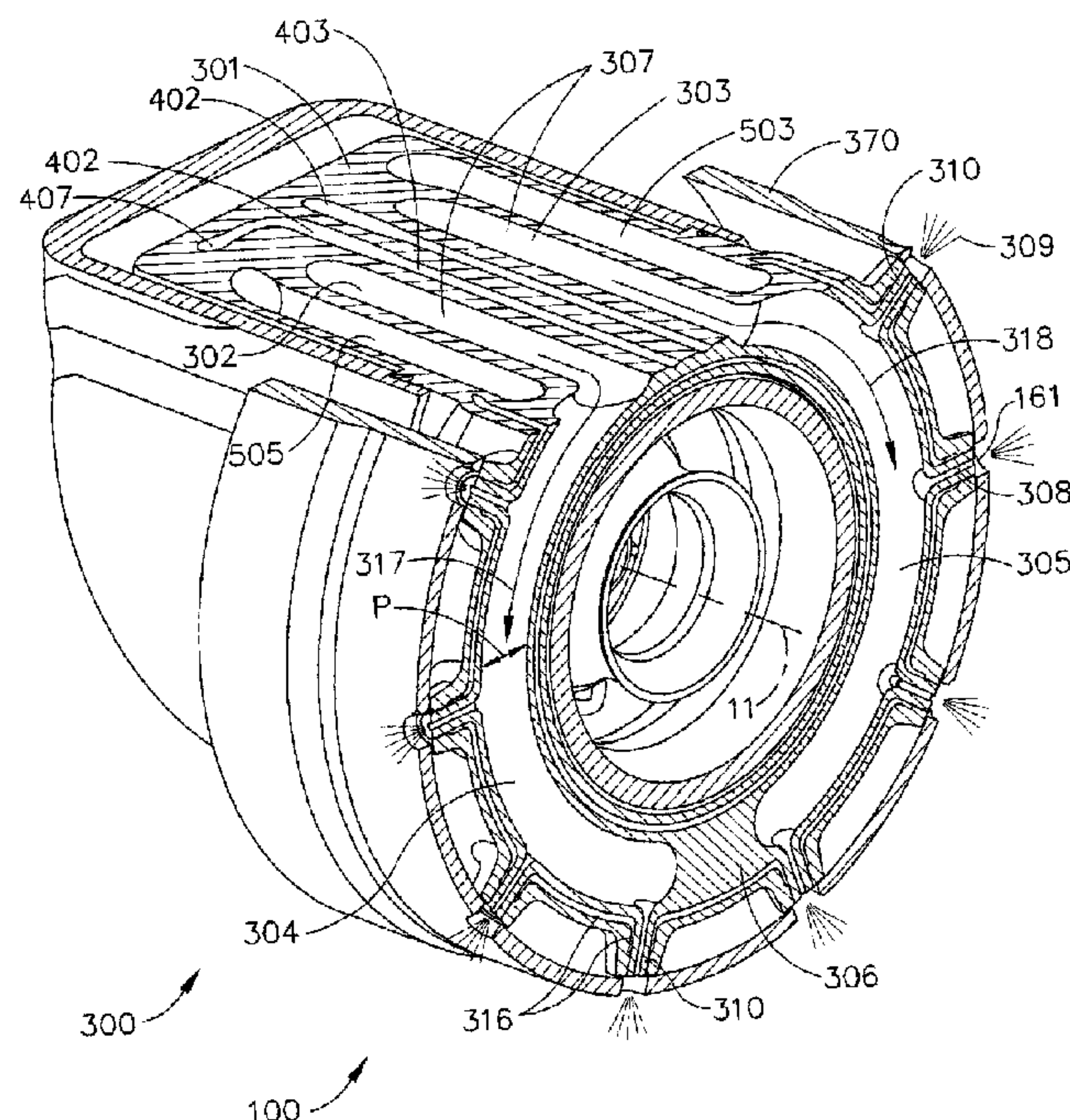




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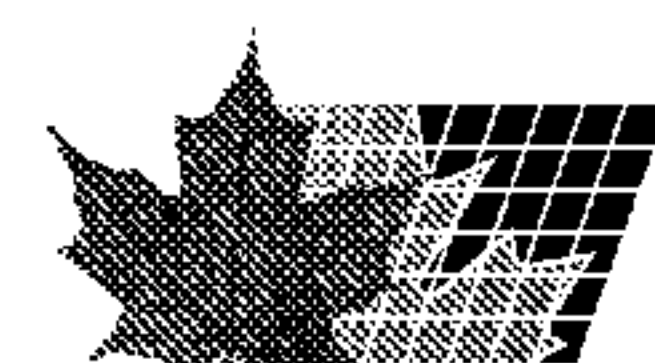
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(57) **Abrégé/Abstract:**

A unitary distributor (300) is disclosed, comprising at least one main flow passage (307) located within a distributor ring body (301), the main flow passage (307) having an arcuate portion (305) oriented in a circumferential direction around a distributor axis (11). A fuel distributor (100) is disclosed, comprising a fuel conduit (105) and a distributor (300) wherein the fuel distributor (100) has a unitary construction. A method for fabricating a unitary distributor (100) is disclosed, the method comprising the steps of determining three-dimensional information of the unitary distributor (300) having at least one flow passage (307) having an arcuate portion (305) located within a distributor ring body (301) having an axis (11), converting the three-dimensional information into a plurality of slices that each define a cross-sectional layer of the unitary distributor (300) and successively forming each layer of the unitary (distributor 300) by fusing a metallic powder using laser energy. A unitary fuel distributor (100) comprising a fuel conduit (105) and a distributor (300) is disclosed wherein the unitary fuel distributor (100) is made by using a rapid manufacturing process.



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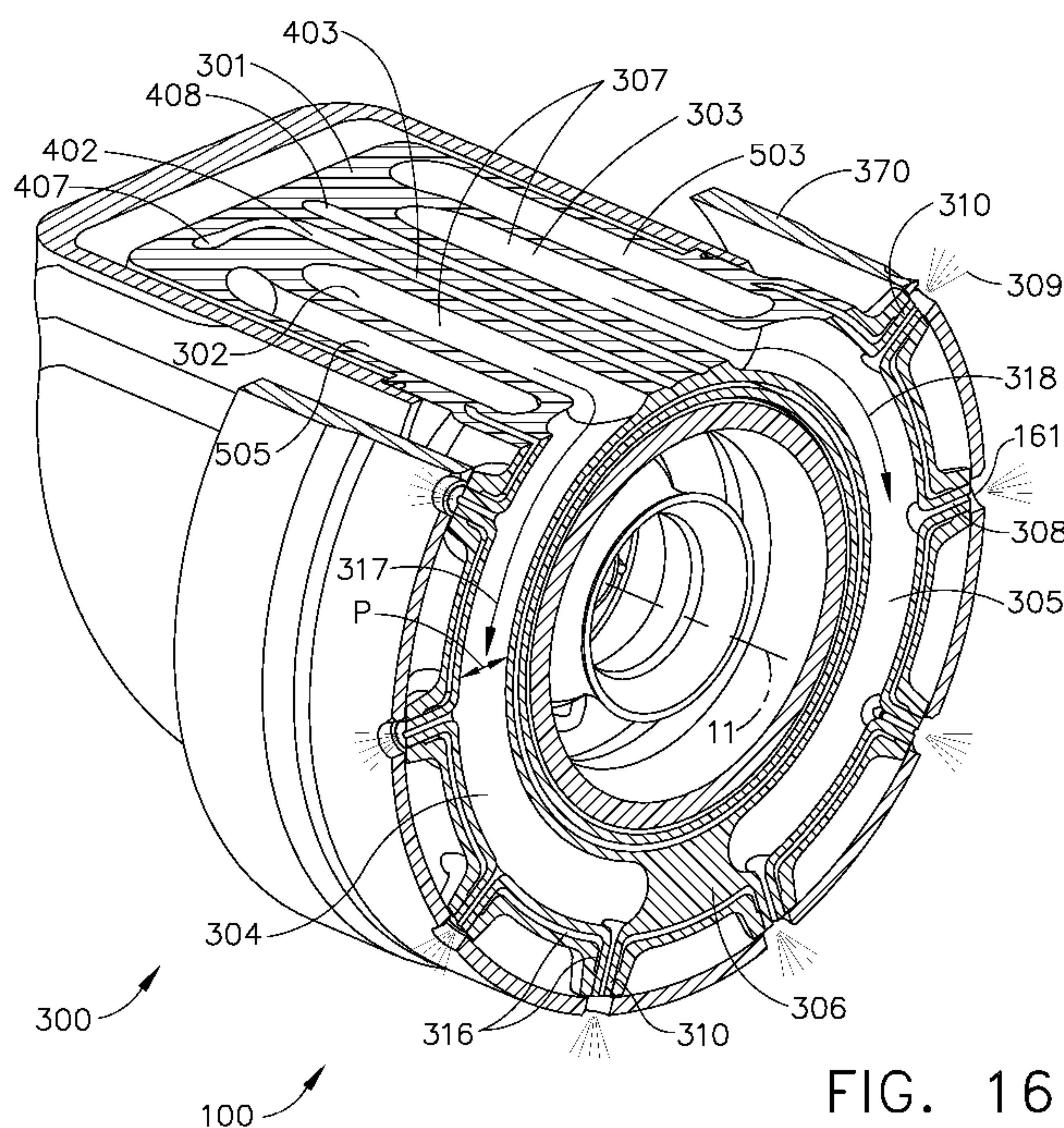


FIG. 16

(57) Abstract: A unitary distributor (300) is disclosed, comprising at least one main flow passage (307) located within a distributor ring body (301), the main flow passage (307) having an arcuate portion (305) oriented in a circumferential direction around a distributor axis (11). A fuel distributor (100) is disclosed, comprising a fuel conduit (105) and a distributor (300) wherein the fuel distributor (100) has a unitary construction. A method for fabricating a unitary distributor (100) is disclosed, the method comprising the steps of determining three-dimensional information of the unitary distributor (300) having at least one flow passage (307) having an arcuate portion (305) located within a distributor ring body (301) having an axis (11), converting the three-dimensional information into a plurality of slices that each define a cross-sectional layer of the unitary distributor (300) and successively forming each layer of the unitary distributor (300) by fusing a metallic powder using laser energy. A unitary fuel distributor (100) comprising a fuel conduit (105) and a distributor (300) is disclosed wherein the unitary fuel distributor (100) is made by using a rapid manufacturing process.

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FUEL DISTRIBUTOR AND METHOD OF MANUFACTURING

BACKGROUND OF THE INVENTION

[0001] This invention relates generally to fluid distributors, and more specifically to unitary fuel distributors for transporting fuel into fuel nozzles used in gas turbine engines.

[0002] Turbine engines typically include a plurality of fuel nozzles for supplying fuel to the combustor in the engine. The fuel is introduced at the front end of a burner in a highly atomized spray from a fuel nozzle. Compressed air flows around the fuel nozzle and mixes with the fuel to form a fuel-air mixture, which is ignited by the burner. Because of limited fuel pressure availability and a wide range of required fuel flow, many fuel injectors include pilot and main nozzles, with only the pilot nozzles being used during start-up, and both nozzles being used during higher power operation. The flow to the main nozzles is reduced or stopped during start-up and lower power operation. Such injectors can be more efficient and cleaner-burning than single nozzle fuel injectors, as the fuel flow can be more accurately controlled and the fuel spray more accurately directed for the particular combustor requirement. The pilot and main nozzles can be contained within the same nozzle assembly or can be supported in separate nozzle assemblies. These dual nozzle fuel injectors can also be constructed to allow further control of the fuel for dual combustors, providing even greater fuel efficiency and reduction of harmful emissions. The temperature of the ignited fuel-air mixture can reach an excess of 3500°F (1920°C). It is therefore important that the fuel supply conduits, flow passages and distribution systems are substantially leak free and are protected from the flames and heat.

[0003] Over time, continued exposure to high temperatures during turbine engine operations may induce thermal stresses in the conduits and fuel nozzles which may damage the conduits or fuel nozzle and may adversely affect their operation. For example, thermal stresses may cause fuel flow reductions in the conduits and may lead to excessive fuel maldistribution within the turbine engine. Exposure of fuel

flowing through the conduits and orifices in a fuel nozzle to high temperatures may lead to coking of the fuel and lead to blockages and non-uniform flow. To provide low emissions, modern fuel nozzles require numerous, complicated internal air and fuel circuits to create multiple, separate flame zones. Fuel circuits may require heat shields from the internal air to prevent coking, and certain tip areas may have to be cooled and shielded from combustion gases. Furthermore, over time, continued operation with damaged fuel nozzles may result in decreased turbine efficiency, turbine component distress, and/or reduced engine exhaust gas temperature margin.

[0004] Improving the life cycle of fuel nozzles installed within the turbine engine may extend the longevity of the turbine engine. Known fuel nozzles include a delivery system and a support system. The delivery system comprising conduits for transporting fluids delivers fuel to the turbine engine and is supported, and is shielded within the turbine engine, by the support system. More specifically, known support systems surround the delivery system, and as such are subjected to higher temperatures and have higher operating temperatures than delivery systems which are cooled by fluid flowing through the fuel nozzle. It may be possible to reduce the thermal stresses in the conduits and fuel nozzles by configuring their external and internal contours and thicknesses.

[0005] Conventional gas turbine engine components such as, for example, fuel nozzles and their associated conduits and distribution systems, are generally expensive to fabricate and/or repair because the conventional fuel nozzle designs having complex conduits and distribution circuits for transporting and distributing fuel include a complex assembly and joining of more than thirty components. More specifically, the use of braze joints can increase the time needed to fabricate such components and can also complicate the fabrication process for any of several reasons, including: the need for an adequate region to allow for braze alloy placement; the need for minimizing unwanted braze alloy flow; the need for an acceptable inspection technique to verify braze quality; and, the necessity of having several braze alloys available in order to prevent the re-melting of previous braze joints. Moreover, numerous braze joints may result in several braze runs, which may

weaken the parent material of the component. The presence of numerous braze joints can undesirably increase the weight and manufacturing cost of the component.

[0006] Accordingly, it would be desirable to have fluid distributors having complex flow passage circuits and conduits for transporting and distributing fluids such as, for example, liquid fuel for fuel nozzles, that have unitary construction for reducing potential leakage and other undesirable effects from thermal exposure described earlier. It is desirable to have fluid distributors having complex geometries for flow passages with a unitary construction to reduce the cost and for ease of assembly as well as providing protection from adverse thermal environment. It is desirable to have a method of manufacturing to provide a unitary construction for unitary fluid distributors having complex three-dimensional geometries for transporting fluids, such as, for example, fuel supply and distribution systems in fuel nozzles.

BRIEF DESCRIPTION OF THE INVENTION

[0007] The above-mentioned need or needs may be met by exemplary embodiments which provide a method for fabricating a unitary distributor, the method comprising the steps of determining three-dimensional information of the unitary distributor having at least one flow passage having an arcuate portion located within a distributor ring body having an axis, converting the three-dimensional information into a plurality of slices that each define a cross-sectional layer of the unitary distributor and successively forming each layer of the unitary distributor by fusing a metallic powder using laser energy.

[0008] In another aspect of the invention, a distributor comprises a flow passage with an arcuate portion located in a distributor ring body wherein the distributor is made by using a rapid manufacturing process.

[0009] In another aspect of the invention, a unitary fuel distributor comprises a fuel conduit and a distributor wherein the unitary fuel distributor is made by using a rapid manufacturing process.

BRIEF DESCRIPTION OF THE DRAWINGS

[0010] The subject matter which is regarded as the invention is particularly pointed out and distinctly claimed in the concluding part of the specification. The invention, however, may be best understood by reference to the following description taken in conjunction with the accompanying drawing figures in which:

[0011] FIG. 1 is a diagrammatic view of a high bypass turbofan gas turbine engine.

[0012] FIG. 2 is an isometric view of a fuel distributor according to an exemplary embodiment of the present invention.

[0013] FIG. 3 is a transverse cross-sectional view of the fuel distributor shown in FIG. 2.

[0014] FIG. 4 is an isometric view of a fuel distributor according to an alternative exemplary embodiment of the present invention.

[0015] FIG. 5 is a transverse cross-sectional view of the fuel distributor shown in FIG. 4.

[0016] FIG. 6 is an isometric view of a fuel distributor according to another alternative exemplary embodiment of the present invention.

[0017] FIG. 7 is a transverse cross-sectional view near an inlet end of the fuel distributor shown in FIG. 6.

[0018] FIG. 8 is a transverse cross-sectional view at an intermediate location of the fuel distributor shown in FIG. 6.

[0019] FIG. 9 is a transverse cross-sectional view near an exit end of the fuel distributor shown in FIG. 6.

[0020] FIG. 10 is an isometric longitudinal cross sectional view of a fuel distributor according to another exemplary embodiment of the present invention.

[0021] FIG. 11 is an isometric view of an exemplary fuel nozzle having a fuel distributor according to an exemplary embodiment of the present invention.

[0022] FIG. 12 is a partial isometric cross-sectional view of the exemplary fuel nozzle shown in FIG. 11.

[0023] FIG. 13 is a partial isometric cross-sectional view of the exemplary fuel nozzle shown in FIG. 11.

[0024] FIG. 14 is another isometric view of the exemplary fuel nozzle shown in FIG. 11.

[0025] FIG. 15 is an axial cross-sectional view of an exemplary distributor tip of the exemplary fuel nozzle shown in FIG. 14.

[0026] FIG. 16 is an isometric cross-sectional view of an exemplary distribution ring shown in the exemplary distributor tip shown in the FIG. 15.

[0027] FIG. 17 is another isometric cross-sectional view of the exemplary distribution ring shown in the exemplary distributor tip shown in the FIG. 15.

[0028] FIG. 18 is an isometric cross-sectional view of the exemplary distributor tip of the exemplary fuel nozzle shown in FIGS. 14 and 15.

[0029] FIG. 19 is another isometric cross-sectional view of the exemplary distribution ring shown in the exemplary distributor tip shown in the FIG. 15.

[0030] FIG. 20 is another isometric cross-sectional view of the exemplary distributor tip of the exemplary fuel nozzle shown in FIGS. 14 and 15.

[0031] FIG. 21 is an isometric cross-sectional view of another exemplary distributor having a single pilot conduit.

[0032] FIG. 22 is another isometric cross-sectional view of the exemplary distributor having a single pilot conduit shown in FIG. 21.

[0033] FIG. 23 is an axial cross-sectional view of an exemplary fuel nozzle tip with the exemplary distributor shown in FIG. 21.

[0034] FIG. 24 is a partial view of an axial cross-section of flow passages and heat shields in an exemplary fuel distributor.

[0035] FIG. 25 is an isometric view of an exemplary distributor having an annular ring.

[0036] FIG. 26 is a flow chart showing an exemplary embodiment of a method for fabricating a unitary distributor.

DETAILED DESCRIPTION OF THE INVENTION

[0037] Referring now to the drawings in detail, wherein identical numerals indicate the same elements throughout the figures, FIG. 1 shows in diagrammatic form an exemplary gas turbine engine 10 (high bypass type) incorporating an exemplary embodiment of a conduit for transporting liquid fuel and a distributor for distributing the fuel in fuel injectors. The exemplary gas turbine engine 10 has an axial centerline axis 12 therethrough for reference purposes. Engine 10 preferably includes a core gas turbine engine generally identified by numeral 14 and a fan section 16 positioned upstream thereof. Core engine 14 typically includes a generally tubular outer casing 18 that defines an annular inlet 20. Outer casing 18 further encloses and supports a booster 22 for raising the pressure of the air that enters core engine 14 to a first pressure level. A high pressure, multi-stage, axial-flow compressor 24 receives pressurized air from booster 22 and further increases the pressure of the air. The pressurized air flows to a combustor 26, where fuel is injected into the pressurized air stream and ignited to raise the temperature and energy level of the pressurized air. The high energy combustion products flow from combustor 26 to a first (high pressure) turbine 28 for driving the high pressure compressor 24 through a first (high pressure) drive shaft 30, and then to a second (low pressure) turbine 32 for driving booster 22 and fan section 16 through a second (low pressure) drive shaft 34 that is coaxial with first drive shaft 30. After driving each of turbines 28 and 32, the combustion products leave core engine 14 through an exhaust nozzle 36 to provide at least a portion of the jet propulsive thrust of the engine 10.

[0038] Fan section 16 includes a rotatable, axial-flow fan rotor 38 that is surrounded by an annular fan casing 40. It will be appreciated that fan casing 40 is supported from core engine 14 by a plurality of substantially radially-extending, circumferentially-spaced outlet guide vanes 42. In this way, fan casing 40 encloses fan rotor 38 and fan rotor blades 44. Downstream section 46 of fan casing 40 extends over an outer portion of core engine 14 to define a secondary, or bypass, airflow conduit 48 that provides additional jet propulsive thrust.

[0039] From a flow standpoint, it will be appreciated that an initial air flow, represented by arrow 50, enters gas turbine engine 10 through an inlet 52 to fan casing 40. Air flow 50 passes through fan blades 44 and splits into a first compressed air flow (represented by arrow 54) that moves through conduit 48 and a second compressed air flow (represented by arrow 56) which enters booster 22.

[0040] The pressure of second compressed air flow 56 is increased and enters high pressure compressor 24, as represented by arrow 58. After mixing with fuel and being combusted in combustor 26, combustion products 60 exit combustor 26 and flow through first turbine 28. Combustion products 60 then flow through second turbine 32 and exit exhaust nozzle 36 to provide at least a portion of the thrust for gas turbine engine 10.

[0041] The combustor 26 includes an annular combustion chamber 62 that is coaxial with longitudinal axis 12, as well as an inlet 64 and an outlet 66. As noted above, combustor 26 receives an annular stream of pressurized air from a high pressure compressor discharge outlet 69. A portion of this compressor discharge air flows into a mixer (not shown). Fuel is injected from a fuel nozzle tip assembly to mix with the air and form a fuel-air mixture that is provided to combustion chamber 62 for combustion. Ignition of the fuel-air mixture is accomplished by a suitable igniter, and the resulting combustion gases 60 flow in an axial direction toward and into an annular, first stage turbine nozzle 72. Nozzle 72 is defined by an annular flow channel that includes a plurality of radially-extending, circumferentially-spaced nozzle vanes 74 that turn the gases so that they flow angularly and impinge upon the first stage turbine blades of first turbine 28. As shown in FIG. 1, first turbine 28

preferably rotates high pressure compressor 24 via first drive shaft 30. Low pressure turbine 32 preferably drives booster 24 and fan rotor 38 via second drive shaft 34.

[0042] Combustion chamber 62 is housed within engine outer casing 18. Fuel is supplied into the combustion chamber by fuel nozzles, such as for example shown in FIGS. 11, 12, 13 and 14. Liquid fuel is transported through conduits such as, for example, through unitary conduits 105 shown in FIGS. 2, 4, 6 and 10, to the fuel nozzles. Other conduits 105 that do not have a unitary construction may alternatively be used for transporting the liquid fuel into the fuel nozzles. The fuel supply conduits, such as the unitary conduits 105, may be located within a stem 102 and coupled to a fuel distributor tip 190. Pilot fuel and main fuel is sprayed into the combustor 26 by fuel nozzle tip assemblies, such as for example, shown in FIGS. 15 and 20. During operation of the turbine engine, initially, pilot fuel is supplied through a pilot fuel passageway 153 (see, for example, FIG. 10) during pre-determined engine operation conditions, such as during startup and idle operations. The pilot fuel is discharged from fuel distributor tip 190 through the pilot fuel outlet 162. When additional power is demanded, main fuel is supplied through main fuel passageways 151, 152 (see, for example, FIG. 10) and the main fuel is sprayed using the main fuel outlets 161.

[0043] FIGS. 15-25 show exemplary embodiments of the present invention of a unitary distributor 300. FIGS. 2-14 show exemplary embodiments of a fuel distributor 100 comprising a conduit 105 and a unitary distributor 300. The term “unitary” is used in this application to denote that the associated component, such as the distributor 300 described herein, is made as a single piece during manufacturing. Thus, a unitary component has a monolithic construction for the component, and is different from a component that has been made from a plurality of component pieces that have been joined together to form a single component.

[0044] FIG. 2 shows an isometric view of a fuel distributor 100 according to an exemplary embodiment of the present invention. The exemplary fuel distributor 100 shown in FIG. 2 includes a conduit 105 and a unitary distributor 300. The conduit 105 and the distributor 300 may have a unitary construction as shown in FIG. 2 made using methods described subsequently herein. Alternatively, the fuel distributor 100 may be fabricated by making the unitary distributor 300 and the conduit 105

separately and coupling them together using suitable conventional attachment means such that the unitary distributor 300 is in flow communication with the conduit 105.

[0045] As shown in FIGS 2-10, the conduit 105 comprises one or more flow passages 108 located within a conduit body 106. The conduit 105 has an inlet end 111 and an exit end 112. Fluid enters the conduit 105 at the inlet end 111 and flows in a longitudinal direction 101 towards the exit end 112, and exits from the conduit 105 at the exit end 112. FIG. 3 shows a transverse cross-sectional view of the exemplary unitary conduit shown in FIG. 2. As shown in FIG. 2, the exemplary unitary conduit 105 comprises a conduit body 106 having an exterior contour 140 and multiple flow passages 108 located within the conduit body 106. The flow passages have a cross sectional shape 120 and an interior contour 141. In the exemplary embodiment shown in FIG. 3, there are four passages, each having a circular cross-sectional shape. As shown in FIG. 2, the flow passages may have different sizes. For example, in the exemplary embodiment shown in FIG. 2, the two outwardly located passages 155, 157 are pilot fuel flow passages and the two interior passages 151, 152 are main fuel flow passages used in a fuel distributor 100. Each flow passage 108 has a wall, such as, for example, shown as item 114, that separates the interior contour 141 of the flow passage 108 from the exterior contour 140 of the conduit body 106. Adjacently located flow passages 108 within the conduit body 106 are separated from each other by a separation wall, such as, for example, shown as item 116. In the exemplary embodiment shown in FIGS. 2 and 3, the main flow passages 151, 152 each have a diameter between about 0.060 inches and 0.150 inches, and the pilot flow passages 155, 157 each have a diameter between about 0.040 inches and 0.150 inches. The wall 114 has a thickness between about 0.020 inches and 0.060 inches. The separation wall 116 has a thickness between about 0.020 inches and 0.060 inches.

[0046] Circular cross sections usually have been selected in flow passages based on manufacturing considerations. However, it is advantageous in certain cases, such as for example in fuel circuits that are subjected to thermal stresses, to have flow passages 118 that have a non-circular cross section. It is possible to reduce stress concentrations in flow passages 108 by suitably contouring the interior portions of the flow passage 108 and the exterior contour 140 of the conduit body 106. The flow

passages 108 can be round (see FIG. 3) or ovalized (FIG. 5). The round passages would provide a smaller length, but a larger width. The ovalized passages would provide a smaller width, but a larger length. The smaller width provides more flexibility in the supply portion of the conduit 105 and facilitates reduction of the thermal stresses in the conduit body 106. FIG. 4 shows an isometric view of a fuel distributor having a conduit 105 according to an alternative exemplary embodiment of the present invention, wherein a flow passage 118 has a non-circular cross sectional shape 121. FIG. 5 shows a transverse cross-sectional view of the exemplary conduit 105 shown in FIG. 4. The interior contour 141 of each flow passage 118 can be selected to be circular, non-circular or any suitable combination of circular and non-circular shapes. FIG. 5 shows an exemplary embodiment of a conduit 105 having one flow passage with a circular contour and three flow passages 118 with non-circular contours 141. Each flow passage 118 has a wall 114 that separates its interior contour 141 from the exterior contour 140 of the conduit body 106. Adjacently located flow passages 118 within the conduit body 106 are separated from each other by a separation wall 116. In the exemplary embodiment shown in FIGS. 5, the non-circular flow passages 118 have cross-sectional areas between about 0.004 square-inches and 0.018 square-inches, and the circular pilot flow passage has a cross-sectional area of about 0.005 square-inches. The wall 114 has a thickness between about 0.020 inches and 0.060 inches. The separation wall 116 has a thickness between about 0.020 inches and 0.060 inches.

[0047] In the exemplary embodiments of the conduit 105 shown in FIGS. 2-5, the cross-sectional shapes 120, 121 of the flow passages 108 remains substantially constant from the inlet end 111 to the exit end 112 of the conduit 105. Similarly, the cross-sectional areas of each flow passage 108 may be substantially constant from the inlet end 111 to the exit end 112 of the conduit 105. Alternately, the cross-sectional area of a flow passage 108 may be varied, preferably substantially uniformly, from the inlet end 111 to the exit end 112 of the conduit 105, in order to achieve suitable flow characteristics within the distributor tip 190 of the fuel nozzle. For example, it is possible to accelerate the fluid in some flow passages 108 within the conduit 105 by reducing the flow area, preferably substantially uniformly, between the inlet end 111 and the exit end 112.

[0048] In some applications, it is advantageous to vary the interior contour 141 and cross-sectional area of the flow passage 108 in the conduit 105 between the inlet end 111 and the exit end 112. FIGS. 6-9 show an exemplary embodiment of a conduit 105 having four flow passages 108 that having a first cross sectional shape 131 near the inlet end 111 and a second cross sectional shape 132 near the exit end 112. The cross sectional shape 141 changes substantially uniformly between the first cross sectional shape 131 near the inlet end 111 and the second cross sectional shape 132 near the exit end 112. FIG. 7-9 show transverse cross sections of the conduit 105 near the inlet end 111, at the exit end 112 and at an intermediate location between the inlet end 111 and the exit end 112. As shown in FIGS. 7-9, the first cross-sectional shape 131 is circular for each of the four passages 108. The second cross-sectional shape 132 near the exit end 112 is non-circular for three of the passages and remains circular for the fourth passage (pilot passage 153). FIG. 8 shows cross section at an intermediate location, showing the transition from a circular cross-section to a non-circular cross section for the three flow passages 118.

[0049] In addition to varying the cross-sectional shapes 131, 132, it may be advantageous to vary the thicknesses for the walls 114 and the separation walls 116 in the conduit 105 in order to reduce thermal stresses and weight. For example, the conduit 105 may be transitioned from a thicker section from a valve braze area near the inlet end 111 to a thinner section near the exit end 112 located near the distributor tip 190, to reduce thermal stresses in the conduit 105. The wall thickness 114 for the fuel passages 108 may be maintained substantially constant at a particular cross section, as shown in FIG. 7 to reduce the weight. Alternatively, at a particular cross section, conduit body 106 exterior contour 140 and the wall thickness 114 for the fuel passages 108 may be contoured to obtain a flat outer surface between the right-most and left-most fuel passages, as shown in FIG. 5. It may be advantageous to have a combination of the approaches described above at different cross sectional locations on the conduit 105, based on the thermal stresses profiles at those locations. The conduit 105 cross sections and exterior contour 140 may be shaped to generally conform to the shape of the passages in the conduit body 106 (see FIGS. 7-9), or they can be shaped to have a smoother external surface (see FIGS. 3, 5). In fuel nozzle applications of the conduit 105, it is possible to locate one or more pilot supply

conduits, such as described below, such that the fuel flowing through the pilot supply conduits cools the conduit body 106 and the fluid passages located within, and facilitates the reduction of thermal stresses.

[0050] FIG. 10 is a partial cross-sectional isometric view of an exemplary unitary conduit 105 used for transporting liquid fuel in a fuel nozzle. In the exemplary embodiment, the unitary conduit 105 includes a flow passage 108 located within the conduit body 106 which serves as the main fuel passageway into the fuel nozzle, and a pilot fuel passage 153 extending within the conduit body 106. Fuel from the pilot fuel passage 153 is directed into the fuel nozzle by a pilot supply tube 154 and exits through a pilot fuel outlet 162. In some unitary conduits 105, it is advantageous to have a flow passage 108 that branches into two or more sub-passages 109, 110, such as, shown for example, in FIG. 10. As shown in FIG. 10 for a fuel nozzle application of the unitary conduit 105, the flow passage 108 branches into a first main passage 151 and a second main passage 152. Liquid fuel is supplied into the nozzle through a main passage inlet 126 and enters the flow passage 108. The fuel flow then branches into the two streams, one through the first main passage 151 and the other through the second main passage 152, before entering the distributor tip 190. As shown in FIG. 10, the main fuel passageway 108, the sub-passages 151, 152, and the pilot fuel passageway 153 extend generally axially in a longitudinal direction 101 in the conduit body 106, between the inlet end 111 and the exit end 112.

[0051] An exemplary fuel distributor 100 having a conduit 105 as described herein and used in a gas turbine engine fuel nozzle is shown in FIGS. 11-13. In the exemplary embodiment, a unitary conduit 105 is located within a stem 102 which has a flange 160 for mounting in a gas turbine engine 10. The unitary conduit 105 is located within the stem 102 such that there is a gap 107 between the interior of the stem and the conduit body 106 of the unitary conduit 105. The gap 107 insulates the unitary conduit 105 from heat and other adverse environmental conditions surrounding the fuel nozzle in gas turbine engines. Additional cooling of the unitary conduit 105 may be accomplished by circulating air in the gap 107. The unitary conduit 105 is attached to the stem 102 using conventional attachment means such as brazing. Alternatively, the unitary conduit 105 and the stem 102 may be made by

rapid manufacturing methods such as for example, direct laser metal sintering, described herein. In the exemplary embodiment, fuel distributor tip 190 extends from the unitary conduit 105 and stem 102 such that main fuel passageways (first main passage 151 and the second main passage 152) and the pilot fuel passageway 153 are coupled in flow communication with a fuel distributor 300, such as, for example, shown in FIG. 13. Specifically, main fuel passageways 151, 152 are coupled in flow communication to main fuel circuits defined within fuel distributor 300. Likewise, primary pilot passage 155 and secondary pilot passage 157 are coupled in flow communication with corresponding pilot injectors (see, for example, items 163, 563 shown in FIG. 15) positioned radially inward within a fuel nozzle. It will be apparent to those skilled in the art that although the conduit 105 has been described herein above as a unitary conduit (i.e., having a unitary construction), it is possible to use conduits 105 having other suitable manufacturing constructs using methods known in the art.

[0052] An isometric view of an exemplary fuel nozzle having a distributor tip 190 and a distributor 300 is shown in FIG. 14. FIG. 15 shows an axial cross-sectional view of the exemplary distributor tip 190 of the exemplary fuel nozzle shown in FIG. 14. The exemplary distributor tip 190 comprises a distributor 300 which receives the fuel flow from the supply conduit 105, such as described previously, and distributes the fuel to various locations in the fuel nozzle, such as main fuel passages and pilot fuel passages as described below. FIGS. 15-20 show exemplary embodiments of the present invention having two main flow passages 304, 305 and two pilot flow passages 402, 502 that distribute the fuel in a fuel nozzle tip assembly 68. FIGS. 21-23 show another exemplary embodiment of the present invention having two main flow passages 604, 603 and a single pilot flow passage 602.

[0053] The exemplary distributor 300 shown in FIGS. 15-20 comprises a distributor ring body 301 that contains the main flow passages and pilot flow passages described herein. The main flow passages 302, 303 in the distributor 300 are in flow communication with corresponding main flow passages (such as, for example, shown as items 151, 152 in FIG. 3) in the supply conduit 105. The exemplary main fuel

passages shown and described herein each comprise an inlet portion 307 that transport the fuel flow from the supply conduit 105 to two arcuate portions 304, 305 that are located circumferentially around a distributor axis 11.

[0054] Referring to FIG. 16, in the viewing angle shown therein, the main flow passage comprises a left axial portion (shown as item 302) and a right axial portion (shown as item 303). The flow within the left axial portion 302 and the right axial portion 303 is in a generally axial direction, with respect to the distributor axis 11. The fluid flow from the main flow passage left axial portion 302 enters a left circumferential portion 304. The left main flow passage circumferential portion 304 has an arcuate shape that is oriented generally circumferentially around the distributor axis 11. Similarly, the fluid flow from the main flow passage right axial portion 303 enters a right circumferential portion 305. The right main flow passage circumferential portion 305 has an arcuate shape that is oriented generally circumferentially around the distributor axis 11. The main flow passage left circumferential portion 304 and the right circumferential portion 305 are located generally at the same axial location (see FIG. 15) and are separated by a wall 306 that prevents flow from the two circumferential paths from mixing. The fluid flow directions in the main flow passages are shown in FIG. 16 as item 317 for the left passages 302, 304, and as item 318 for the right passages 303, 305. The fuel flows circumferentially in a clockwise direction in the main passage right circumferential portion 305, and in a counter-clockwise direction in the main passage left circumferential portion 304. Although two axial flow passages 302, 303 and corresponding circumferential passages 304, 305 are shown in the embodiments described herein, it is understood by those skilled in the art that it is possible to have other configurations for the flow passages and other orientations in the unitary distributor 300 and are within the scope of the present invention.

[0055] As shown in FIG. 16, fuel flow from the main flow passages 304, 305 is directed circumferentially outward from the distributor 300 by a plurality of main flow exit passages 308 that are located in the distributor ring body 301 and arranged circumferentially around the distributor axis 11. In the exemplary embodiments shown in FIGS. 15-25, each main flow exit passage 308 is located

inside a fuel post 310. The fuel posts 310 are formed as a part of the distributor ring body 301. Each exit passage 308 is in flow communication with a main flow passage 304, 305. Pressurized fuel from the main flow passages 304, 305 enters the exit passages 308 and is ejected out of the distributor 300 as fuel sprays 309 (see FIG. 16). In some embodiments of the present invention described herein, it is possible to make the main flow passage 304, 305 such that the cross section area (denoted as “P” in FIG. 16) of the passage 304, 305 varies uniformly in the circumferential direction. The variation of cross section area “P” is sized using known methods so as to maintain a constant pressure within the main flow passage 304, 305 as the fuel flows within the passage 304, 305 into a plurality of exit passages 308 that are arranged in the circumferential direction around the distributor axis in the distributor ring body 301.

[0056] As described previously, fuel nozzles, such as those used in gas turbine engines, are subject to high temperatures. Such exposure to high temperatures may, in some cases, result in fuel coking and blockage in the fuel passages, such as for example, the exit passage 308, located in the distributor ring body 301. One way to mitigate the fuel coking and/or blockage in the distributor 300 is by using heat shields to protect the passages 308 from the adverse thermal environment. In the exemplary embodiments of the present invention shown in FIG. 16 and FIG. 24, the fuel post 310 is protected by a heat shield that surrounds the fuel post 310. The exemplary embodiment shown in FIG. 24 comprises a forward heat shield 312 and an aft heat shield 314 that surround the fuel post 310. As shown in FIG. 16, the heat shields may also surround at least a portion of the main flow passages 304, 305 in the circumferential direction around the distributor axis 11. The heat shields 314, 312 are made such that there is an insulation gap 316 between the walls of the fuel passages (such as, for example, shown as items 308, 304, 305 in FIGS. 16 and 24) and the heat shields 312, 314. The insulation gap 316 provides further protection to the fuel passages from adverse thermal environment. The heat shields can be made from any suitable material with ability to withstand high temperature, such as, for example, cobalt based alloys and nickel based alloys commonly used in gas turbine engines. In exemplary embodiments of the present invention, such as for example shown in FIGS. 15-25, the distributor 300 has a unitary construction wherein the distributor ring body

301, the flow passages 302, 303, 305, 306, the fuel post 310, the heat shields 312, 314 and the gaps 316 are formed such that they have a monolithic construction. Methods of manufacturing such unitary distributors 300 are described subsequently herein.

[0057] In another aspect of the present invention, the unitary distributor 300 has at least one flow passage, such as for example, shown as items 402, 502 in FIG.18) for flowing pilot fuel in order to cool the distributor ring body 301 and protect the flow passages from adverse thermal environment. FIGS. 15-20 show exemplary embodiments of the present invention having two pilot fuel flow cooling passages, referred to herein as a primary pilot flow passage 402 and a secondary pilot flow passage 502. Referring to FIG. 15, the fuel from the primary pilot flow passage 402 exits the fuel nozzle through a primary pilot fuel injector 163 and the fuel from the secondary pilot flow passage 502 exits the fuel nozzle through a secondary pilot fuel injector 563. The primary pilot flow passage 402 in the distributor 300 is in flow communication with a corresponding pilot primary passage 155 in the supply conduit 105 (see FIG. 3, for example). Similarly, the secondary pilot flow passage 502 in the distributor 300 is in flow communication with a corresponding pilot secondary passage 157 in the supply conduit 105 (see FIG. 3, for example).

[0058] Referring to FIG.17, the primary pilot flow passage 402 in the distributor ring body 301 comprises a primary pilot entry 401 which serves as the receiving location for the primary pilot fuel, such as, for example, from the pilot primary passage 155 in the supply conduit 105. The primary pilot flow passage 402 further comprises a primary pilot flow in-flow passage 403 and a circumferential portion 404 that is oriented in a circumferential direction with respect to the distributor axis 11. In the exemplary embodiment shown in FIG.17, the primary pilot flow in-flow passage 403 is shown as having a generally axial direction with respect to the distributor axis 11. Other orientations may also be used for the primary pilot flow in-flow passage 403. The primary pilot fuel flow from in-flow passage 403 enters the circumferential portion 404 of the primary flow passage 402 and flows in a circumferential direction, as indicated by the flow direction arrow shown as item 406 in FIG. 17. The cooler pilot fuel flow in the primary pilot flow passage 402 provides cooling for the distributor ring body 301 and the fuel flow passages located within the

distributor 300 to reduce the adverse effects of exposure to high temperatures described before. Referring to FIG. 18, the primary pilot fuel flow (see item 406) from the circumferential flow passage 404 enters a primary pilot flow out-flow passage 405 located in the distributor 300. In the exemplary embodiment shown in FIG. 18, the primary pilot flow out-flow passage 405 is shown as having a generally axial direction with respect to the distributor axis 11. Other orientations may also be used for the primary pilot flow out-flow passage 405. In the exemplary embodiment shown in FIG. 18, the distributor 300 comprises a primary pilot supply tube portion 154 in flow communication with the out-flow passage 405 and orients the primary pilot fuel radially inboard towards the distributor axis 11 and towards a primary fuel outlet 162. The primary pilot fuel exits the distributor ring body 301 through the primary pilot fuel outlet 162 and ejected from the fuel nozzle by a primary pilot fuel injector 163. In the exemplary embodiment shown in FIG. 15, the circumferential portion 404 of the primary pilot flow passage 402 is located in the distributor ring body 301 at an axially forward location from the main flow passages 304, 305. In alternative embodiments, the circumferential portion 404 of the primary pilot flow passage 402 may be located at an axially aft location from the main flow passages 304, 305.

[0059] Referring to FIGS. 15 and 19, an exemplary embodiment of the present invention includes a secondary pilot flow passage 502. A secondary pilot fuel flows through the secondary pilot flow passage 502 as shown by the flow direction arrow 506 in FIG. 19. The secondary pilot flow passage 502 located in the distributor ring body 301 comprises a secondary pilot entry portion 507 which serves as the receiving location for the secondary pilot fuel, such as, for example, from the pilot secondary passage 157 in the supply conduit 105. The secondary pilot flow passage 502 further comprises a secondary pilot flow in-flow passage 503 and a circumferential portion 504 that is oriented in a circumferential direction with respect to the distributor axis 11. In the exemplary embodiment shown in FIG. 19, the secondary pilot flow in-flow passage 503 is shown as having a generally axial direction with respect to the distributor axis 11. Other orientations may also be used for the secondary pilot flow in-flow passage 503. The secondary pilot fuel flow from in-flow passage 503 enters the circumferential portion 504 of the secondary flow

passage 502 and flows in a circumferential direction, as indicated by the flow direction arrow shown as item 506 in FIG. 19. The cooler pilot fuel flow in the secondary pilot flow passage 502 provides cooling for the distributor ring body 301 and the fuel flow passages located within the distributor 300 to reduce the adverse effects of exposure to high temperatures described before. Referring to FIG. 19, the secondary pilot fuel flow (see item 506) from the circumferential flow passage 504 enters a secondary pilot flow out-flow passage 505 located in the distributor 300. In the exemplary embodiment shown in FIG. 19, the secondary pilot flow out-flow passage 505 is shown as having a generally axial direction with respect to the distributor axis 11. Other orientations may also be used for the secondary pilot flow out-flow passage 505. In the exemplary embodiment shown in FIGS. 15-20, the circumferential portion 504 of the secondary pilot flow passage 502 is located in the distributor ring body 301 at an axially aft location from the main flow passages 304, 305. In alternative embodiments, the circumferential portion 504 of the secondary pilot flow passage 502 may be located at an axially forward location from the main flow passages 304, 305. Referring to FIGS. 17 and 19, the primary pilot fuel flow direction 406 in the circumferential direction is counter-clockwise and the secondary pilot fuel flow direction 506 in the circumferential direction is clockwise. In alternative embodiments of the present invention, the flow directions for the primary and secondary fuel paths may have different orientations or may be in the same direction.

[0060] In one aspect of the present invention, the primary pilot flow passage 404 and the secondary pilot flow passage 504 in the distributor ring 301 are protected by insulation gaps such as shown, for example, as item 316 in FIGS. 15, 17 and 19. Similarly, insulation gaps, such as shown, for example, as item 516 in FIG. 15 and 18 are provided around at least a portion of the pilot injectors. These insulation gaps provide at least some protection for the fuel flow paths from the high temperatures experienced by the distributor ring body 301 and help to reduce the incidence of coking and/or blockage in the flow paths and injectors. In the exemplary embodiments shown, the insulation gaps have widths between about 0.015 inches and 0.025 inches. In another aspect of the present invention, the insulation gaps, such as items 316, 516 and 616 in FIGS. 15-24 can be made integrally within a distributor

ring body 301 having a unitary construction, using methods described subsequently herein.

[0061] An exemplary embodiment of the present invention having a single pilot flow passage 602 for a fuel nozzle having a single pilot injector 663 is shown in FIGS. 21-24. This exemplary embodiment of a fuel distributor 100 comprises a distributor body 601 having main flow passages 603, 604 fuel posts 610, main fuel outlet 661, a forward heat shield portion 612, an aft heat shield portion 614 and insulation gaps 616, similar to those described previously herein. The forward and aft heat shield portions may be combined into a single piece heat shield 611 (see FIG. 23). A pilot injector 663 receives pilot fuel flow from a pilot supply tube 654 (see FIG. 22). The pilot fuel flow path has a circumferential portion as described previously herein, for flowing the pilot fuel to cool the distributor ring body 601. The exemplary embodiment shown in FIGS. 21-24 further comprises insulation gaps 616 such as shown, for example, in FIG. 22, that protect the fuel passages from adverse high temperatures. In one aspect of the present invention, the exemplary embodiment of the distributor 300 shown in FIG. 21 has a unitary construction using methods described subsequently herein.

[0062] In another aspect of the present invention, the distributor 300 has an annular ring 670 (see FIGS. 15, 21, 23) located at the forward end of the distributor ring body 301 and coaxially located with it. The annular ring 670 comprises an annular ring wall 672 and extends axially forward from the distributor ring body 301. In one aspect of the present invention, the annular ring 670 has a slot 674 that extends in the axial and circumferential directions. The axial slot 674 engages with other parts of a fuel nozzle during assembly and provides a means to ensure the correct orientation of the distributor 300 during assembly within a fuel nozzle. In another aspect of the present invention, impingement cooling holes 680 are provided extending through the annular ring wall 672. During fuel nozzle operation, cooling air (not shown) passes through the cooling holes 680 in a radially inward direction and impinges on adjacent parts of the fuel nozzle, providing cooling for these parts. In the exemplary embodiment shown in FIG. 25, the annular ring wall has a thickness of between about 0.025 inches and 0.035 inches. Two rows of cooling holes 680 are

used, each row having between 40 and 60 holes, each hole having a diameter of between about 0.025 inches and 0.040 inches. In one aspect of the present invention, the exemplary embodiment of the distributor 300 shown in FIG. 25 has a unitary construction using methods described subsequently herein. In one exemplary embodiment, the unitary distributor 300 shown in FIG. 25 may have the cooling holes 680 and the slot 674 formed during the unitary construction.

[0063] The exemplary embodiments of the unitary distributor 300 shown in FIGS. 15-20, and the alternative embodiments of the unitary distributor 300 shown in FIGS. 21-25, can be made using rapid manufacturing processes such as Direct Metal Laser Sintering (DMLS), Laser Net Shape Manufacturing (LNSM), electron beam sintering and other known processes in the manufacturing. DMLS is a preferred method of manufacturing unitary conduits 105, unitary distributors 300 and unitary fuel distributors 100 described herein.

[0064] FIG. 26 is a flow chart illustrating an exemplary embodiment of a method 200 for fabricating unitary conduits 105, unitary distributors 300 and unitary fuel distributors 100 described herein. Method 200 includes fabricating unitary distributors 300 (shown in FIGS. 15-25) using Direct Metal Laser Sintering (DMLS). DMLS is a known manufacturing process that fabricates metal components using three-dimensional information, for example a three-dimensional computer model, of the component. The three-dimensional information is converted into a plurality of slices, each slice defining a cross section of the component for a predetermined height of the slice. The component is then "built-up" slice by slice, or layer by layer, until finished. Each layer of the component is formed by fusing a metallic powder using a laser.

[0065] Accordingly, method 200 includes the step 205 of determining three-dimensional information of a unitary distributor 300 and the step 210 of converting the three-dimensional information into a plurality of slices that each define a cross-sectional layer of the unitary distributor 300. The unitary distributor 300 is then fabricated using DMLS, or more specifically each layer is successively formed in step 215 by fusing a metallic powder using laser energy. Each layer has a size between about 0.0005 inches and about 0.001 inches. Unitary distributor 300 may be

fabricated using any suitable laser sintering machine. Examples of suitable laser sintering machines include, but are not limited to, an EOSINT.RTM. M 270 DMLS machine, a PHENIX PM250 machine, and/or an EOSINT.RTM. M 250 Xtended DMLS machine, available from EOS of North America, Inc. of Novi, Michigan. The metallic powder used to fabricate unitary distributor 300 is preferably a powder including cobalt chromium, but may be any other suitable metallic powder, such as, but not limited to, HS188 and INCO625. The metallic powder can have a particle size of between about 10 microns and 74 microns, preferably between about 15 microns and about 30 microns.

[0066] Although the methods of manufacturing unitary distributor 300 have been described herein using DMLS as the preferred method, those skilled in the art of manufacturing will recognize that any other suitable rapid manufacturing methods using layer-by-layer construction or additive fabrication can also be used. These alternative rapid manufacturing methods include, but not limited to, Selective Laser Sintering (SLS), 3D printing, such as by inkjets and laserjets, Sterolithography (SL), Direct Selective Laser Sintering (DSLS), Electron Beam Sintering (EBS), Electron Beam Melting (EBM), Laser Engineered Net Shaping (LENS), Laser Net Shape Manufacturing (LNSM) and Direct Metal Deposition (DMD).

[0067] The unitary distributor 300 for a fuel distributor 100 in a turbine engine (see FIGS. 11-25) comprises fewer components and joints than known fuel nozzles. Specifically, the above described unitary distributor 300 requires fewer components because of the use of a one-piece distributor ring body 301 having one or more flow passages such as, for example, shown as items 302, 304, 402, 403, 404, 405, 503, 505 and 602 in FIGS. 15-23 included herein. As a result, the described fuel distributor 100 provides a lighter, less costly alternative to known fuel distributors. Moreover, the described unitary construction for the distributor 300 or the fuel distributor 100 provide fewer opportunities for leakage or failure and is more easily repairable compared to known distributors.

[0068] As used herein, an element or step recited in the singular and proceeded with the word "a" or "an" should be understood as not excluding plural said elements or steps, unless such exclusion is explicitly recited. When introducing

elements/components/etc. of the methods and/or conduits 105, distributors 300 or fuel distributors 100 described and/or illustrated herein, the articles "a", "an", "the" and "said" are intended to mean that there are one or more of the element(s)/component(s)/etc. The terms "comprising", "including" and "having" are intended to be inclusive and mean that there may be additional element(s)/component(s)/etc. other than the listed element(s)/component(s)/etc. Furthermore, references to "one embodiment" of the present invention are not intended to be interpreted as excluding the existence of additional embodiments that also incorporate the recited features.

[0069] Although the methods and articles such as conduits 105, distributors 300 and fuel distributors 100 described herein are described in the context of supplying liquid fuel to a turbine engine, it is understood that the conduits 105, distributors 300 and fuel distributors 100 and methods of their manufacture described herein are not limited to fuel distributors or turbine engines. The conduit 105, distributor 300 or fuel distributor 100 components illustrated in the figures included herein are not limited to the specific embodiments described herein, but rather, these can be utilized independently and separately from other components described herein.

[0070] This written description uses examples to disclose the invention, including the best mode, and also to enable any person skilled in the art to make and use the invention. The patentable scope of the invention is defined by the claims, and may include other examples that occur to those skilled in the art in view of the specification.

231071-19

WHAT IS CLAIMED IS:

1. A distributor comprising:
 - a main flow passage located within a distributor consisting of a single element, the single element comprising a distributor ring body and a conduit body, wherein the distributor has a unitary construction, said main flow passage having an arcuate portion oriented in a circumferential direction around a distributor axis;
 - a primary pilot flow passage having an arcuate portion located axially fwd from the arcuate portion of a main flow passage and oriented in a circumferential direction around the distributor axis; and
 - further comprising a secondary pilot flow passage having an arcuate portion located axially aft from the arcuate portion of a main flow passage oriented in a circumferential direction around the distributor axis.
2. A distributor according to claim 1, the main flow passage further comprising:
 - a first main flow passage having a first arcuate portion capable of transporting a fluid in a clock-wise direction around the distributor axis; and
 - a second main flow passage having a second arcuate portion capable of transporting a fluid in a counter-clockwise direction around the distributor axis.
3. A distributor according to claim 1 further comprising a heat shield surrounding at least a portion of the main flow passage.
4. A distributor according to claim 1 having a gap located within the distributor ring body surrounding at least a portion of the arcuate portion of the main flow passage.
5. A distributor according to claim 1 further comprising a plurality of fuel posts located in the distributor ring body arranged circumferentially around the distributor axis, each fuel post having an exit passage that is in flow communication with the main flow passage.

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6. A distributor according to claim 5 further comprising a heat shield located within the distributor ring body surrounding at least a portion of the plurality of fuel posts.

7. A distributor according to claim 5 further comprising a heat shield located within the distributor ring body surrounding at least a portion of the main flow passage.

8. A distributor according to claim 1 further comprising a gap located within the distributor ring body surrounding at least a portion of the primary pilot flow passage.

9. A distributor according to claim 1 further comprising a gap located within the distributor ring body surrounding at least a portion of the secondary pilot flow passage.

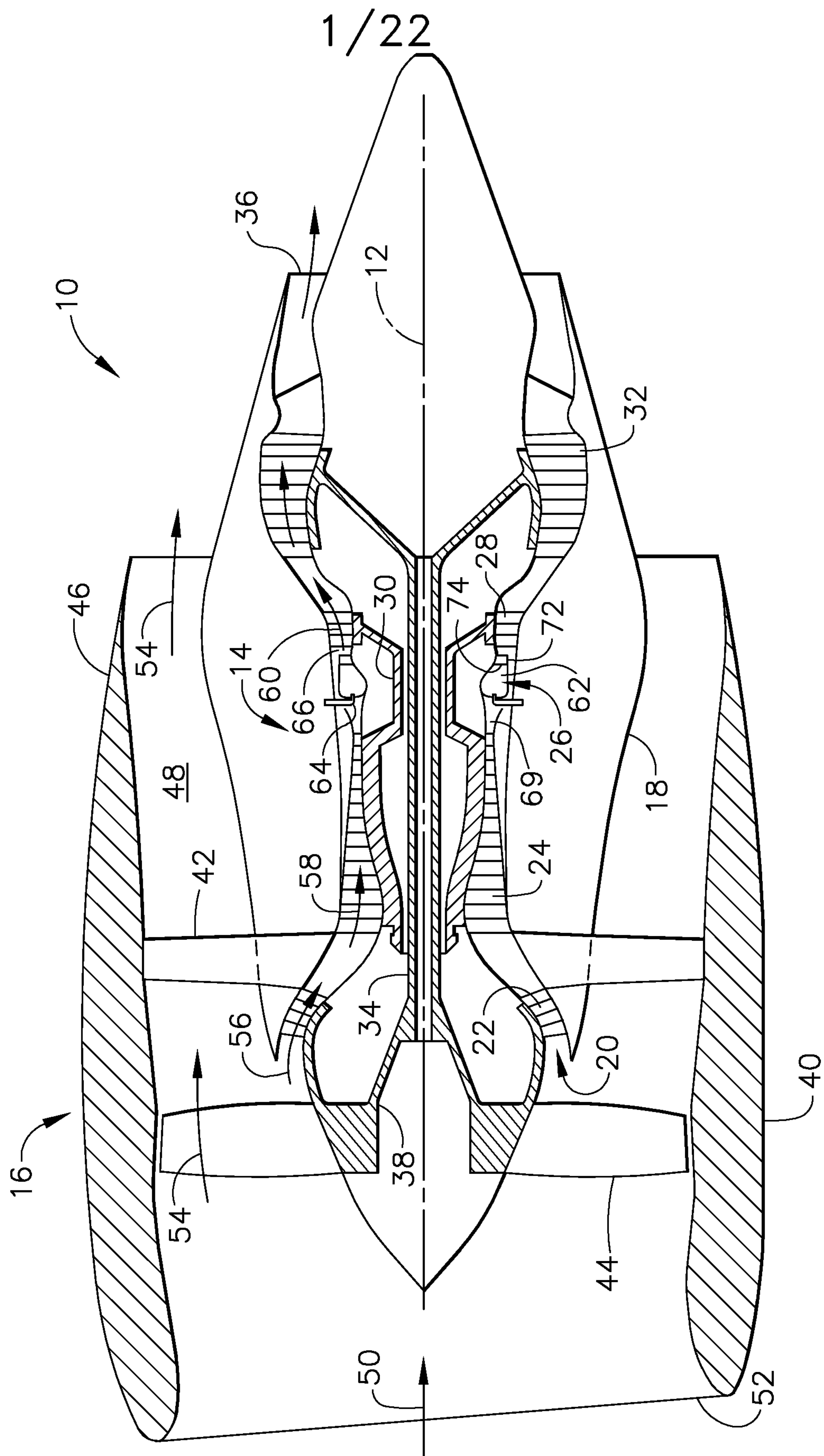
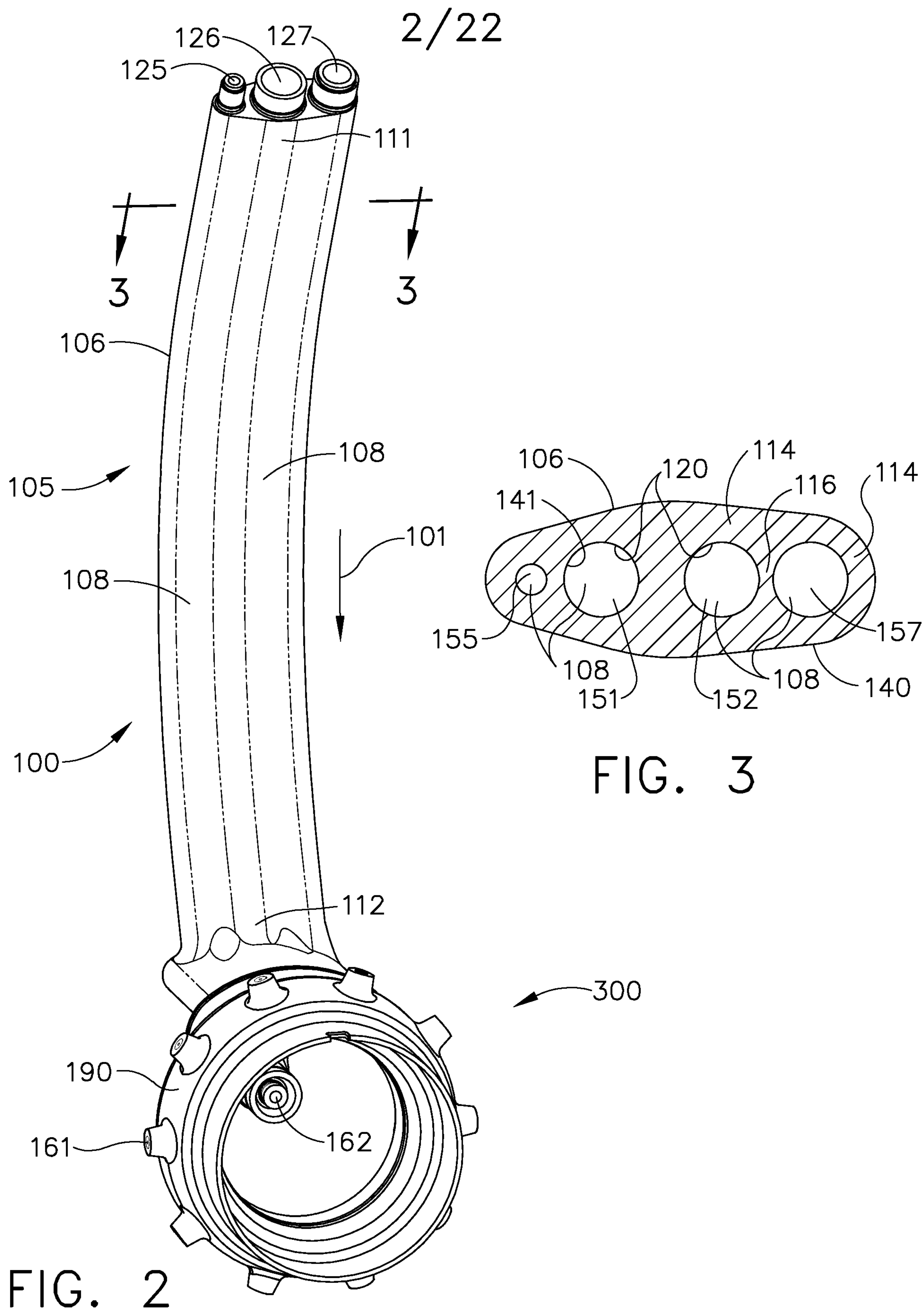
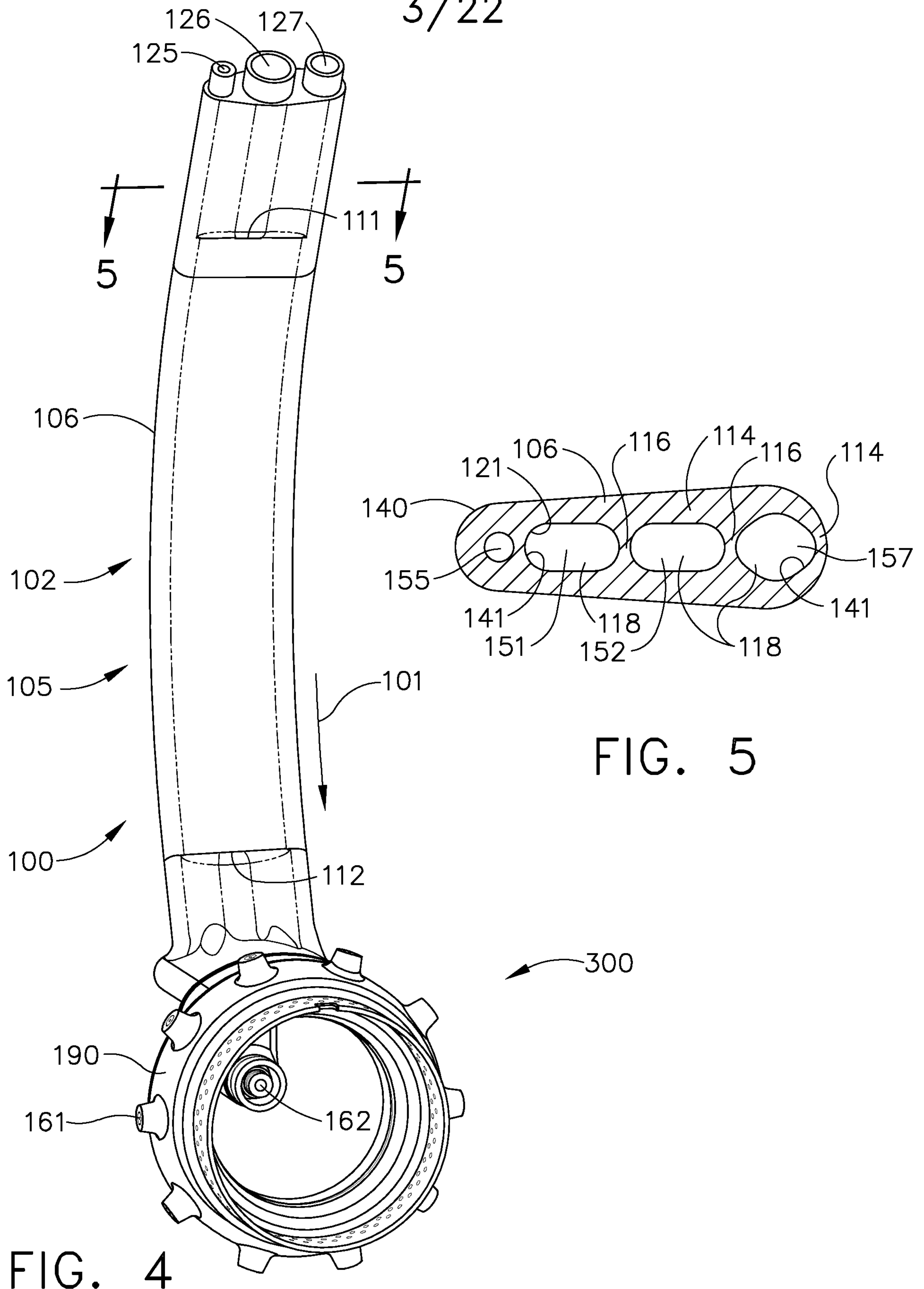


FIG. 1



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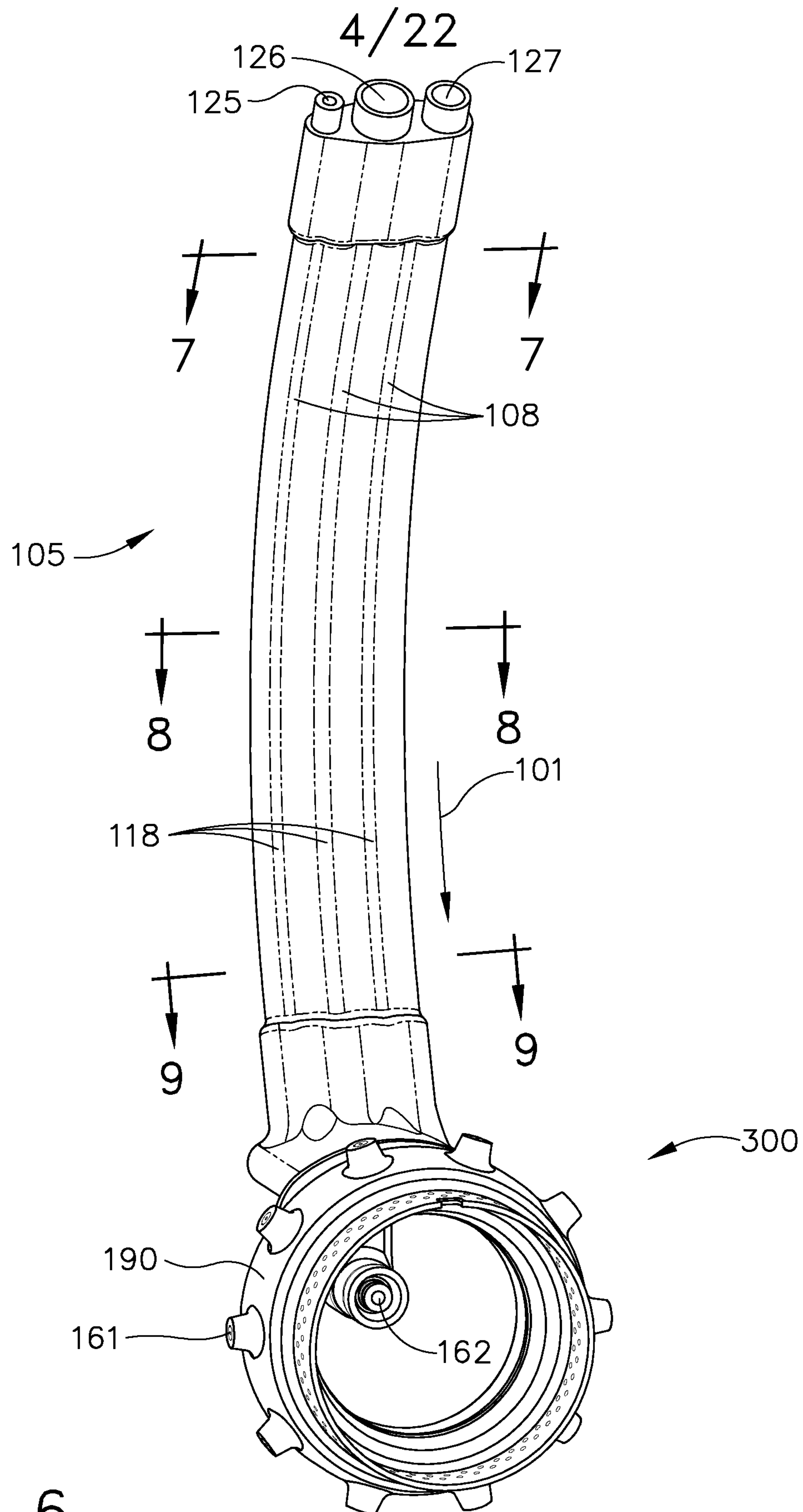


FIG. 6

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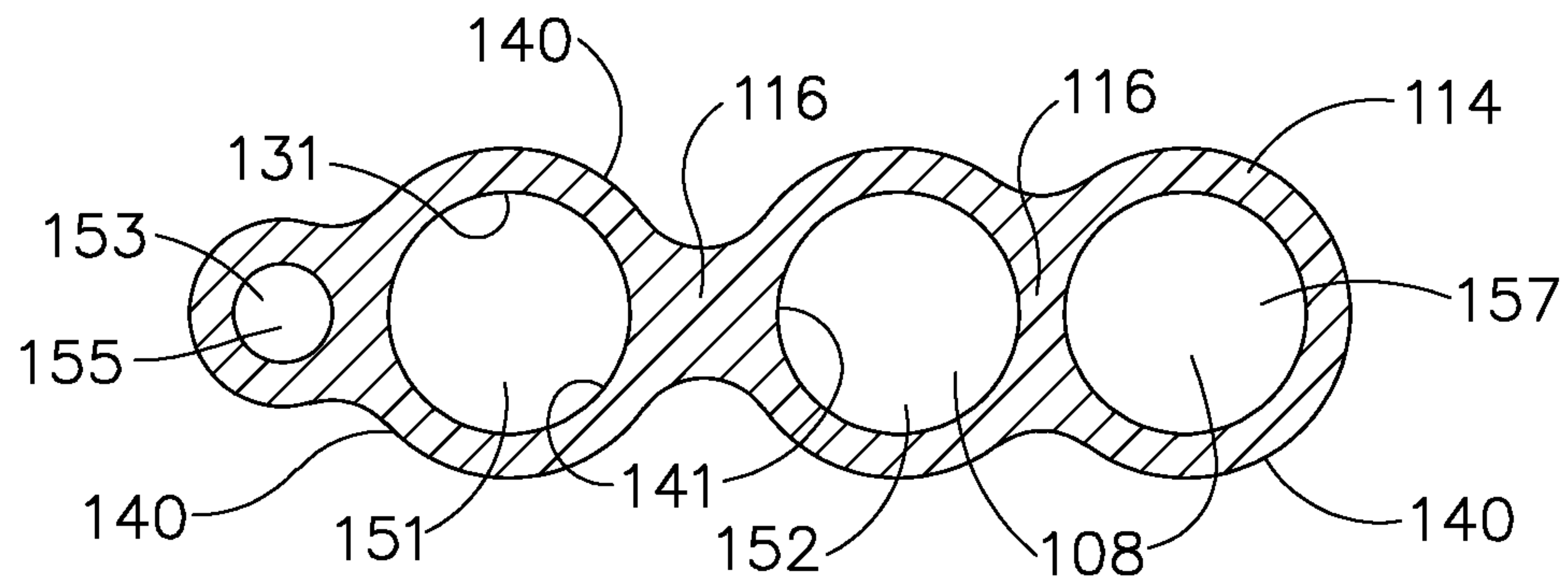


FIG. 7

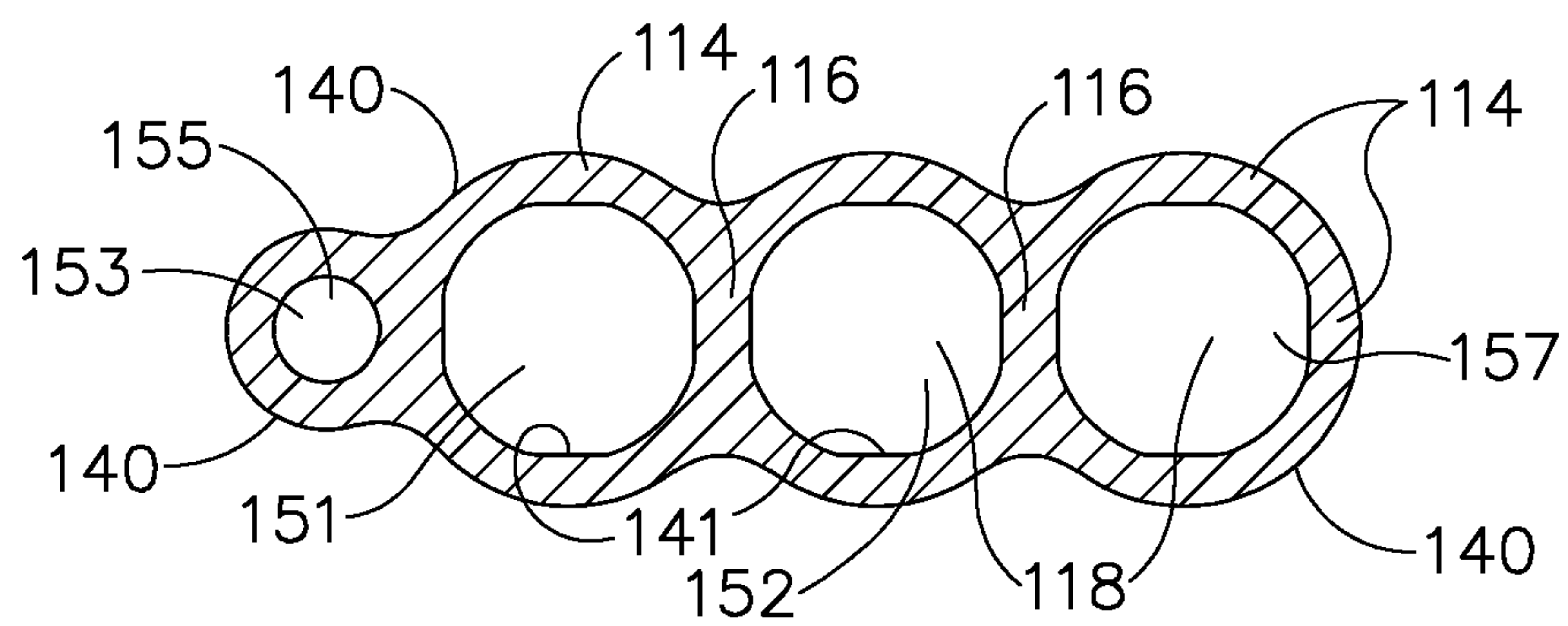


FIG. 8

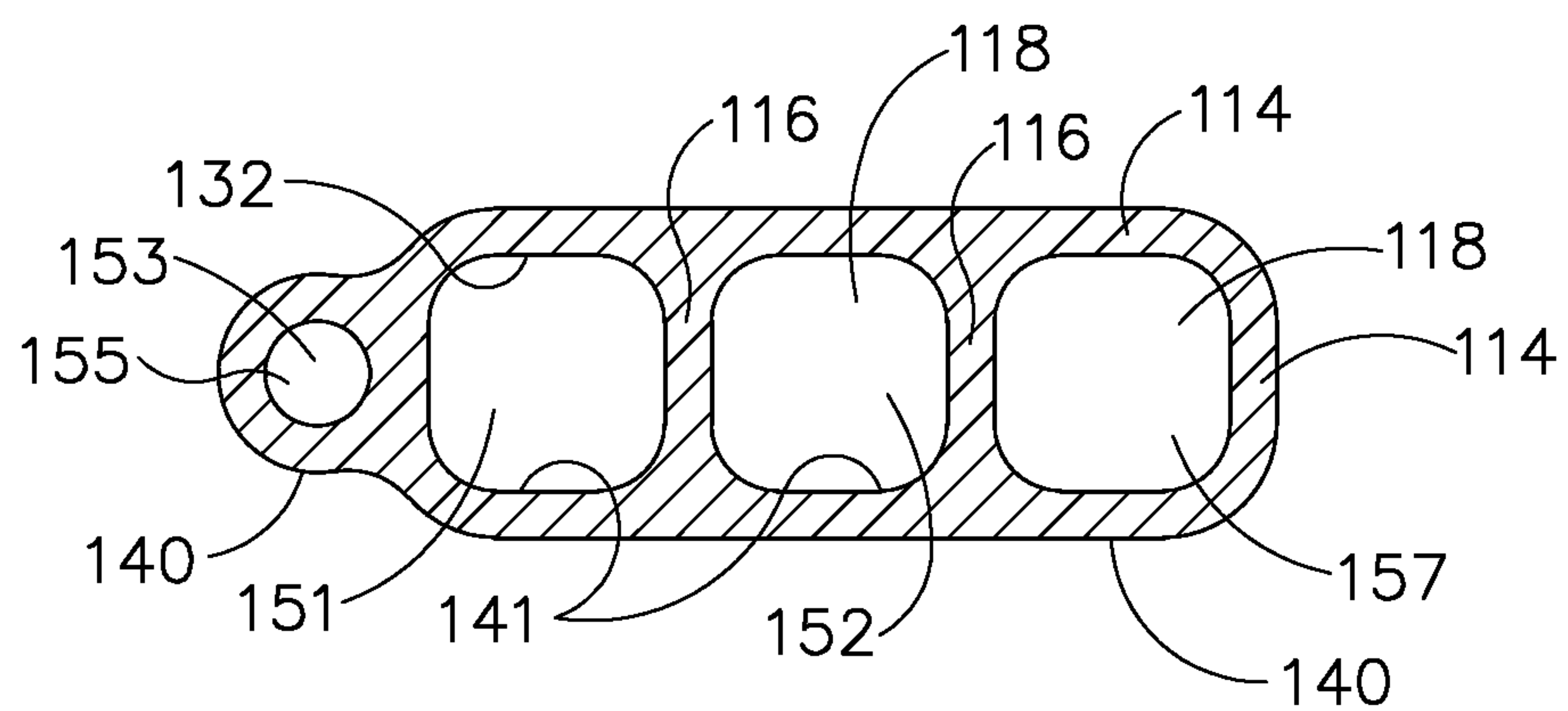


FIG. 9

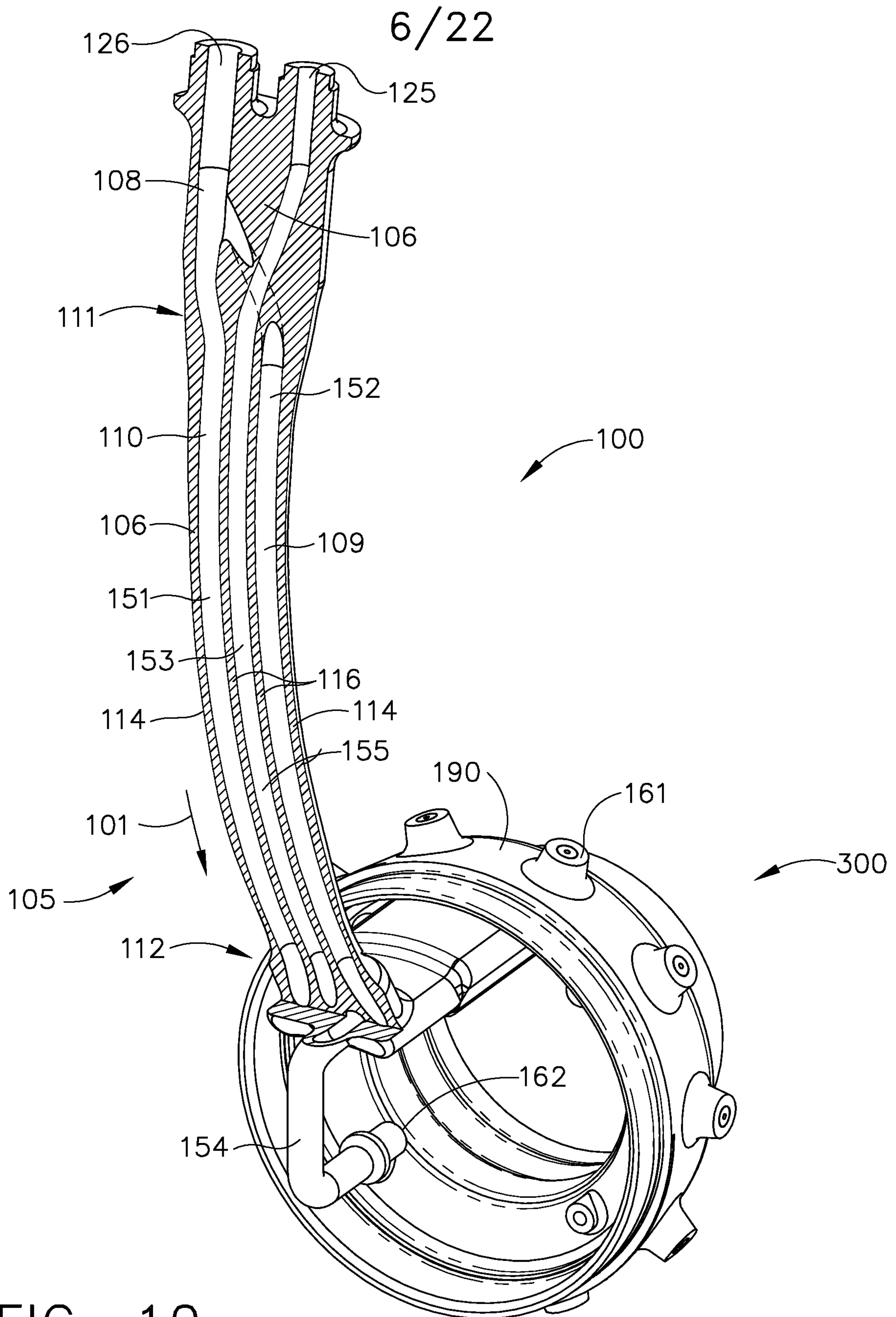


FIG. 10

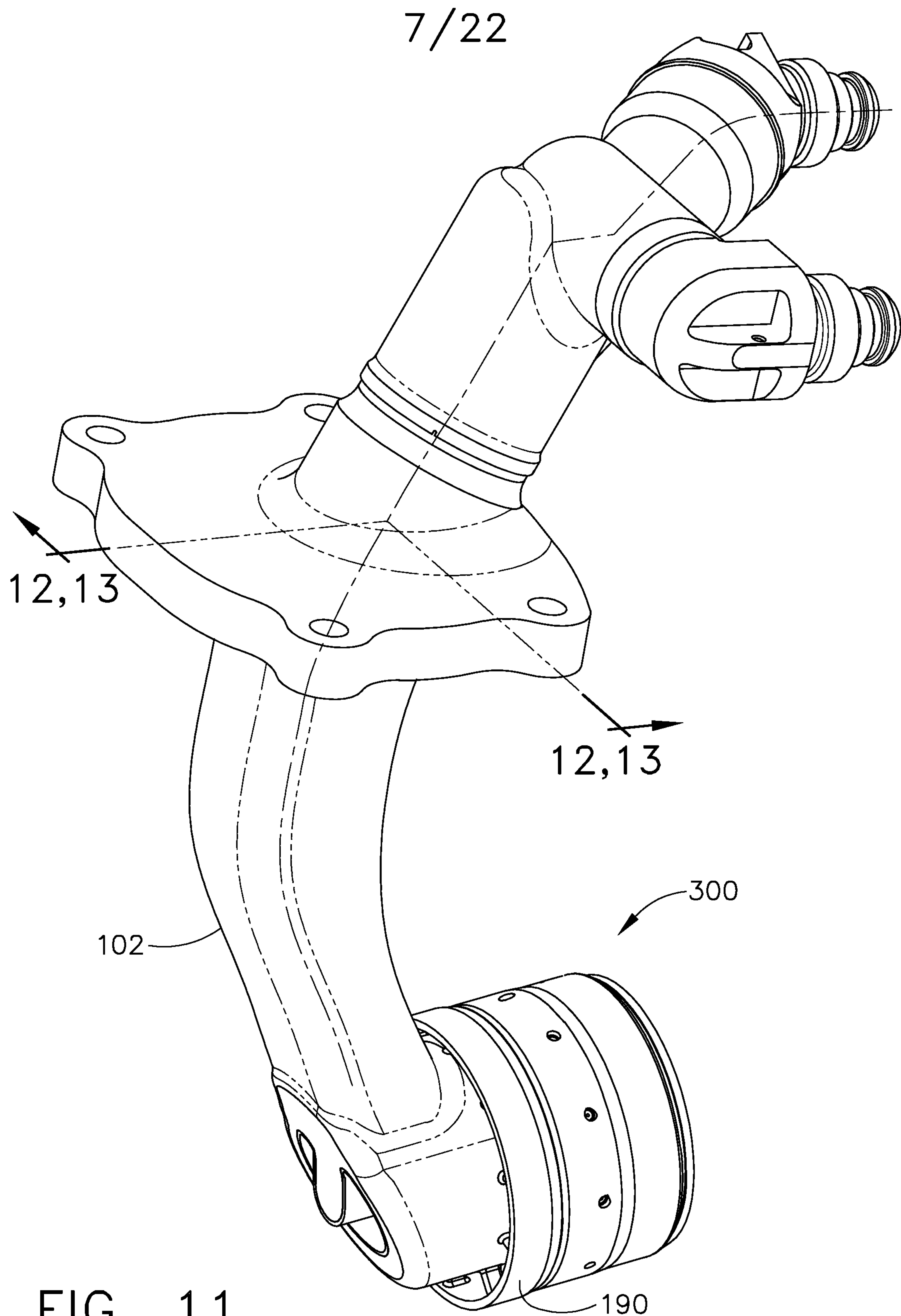
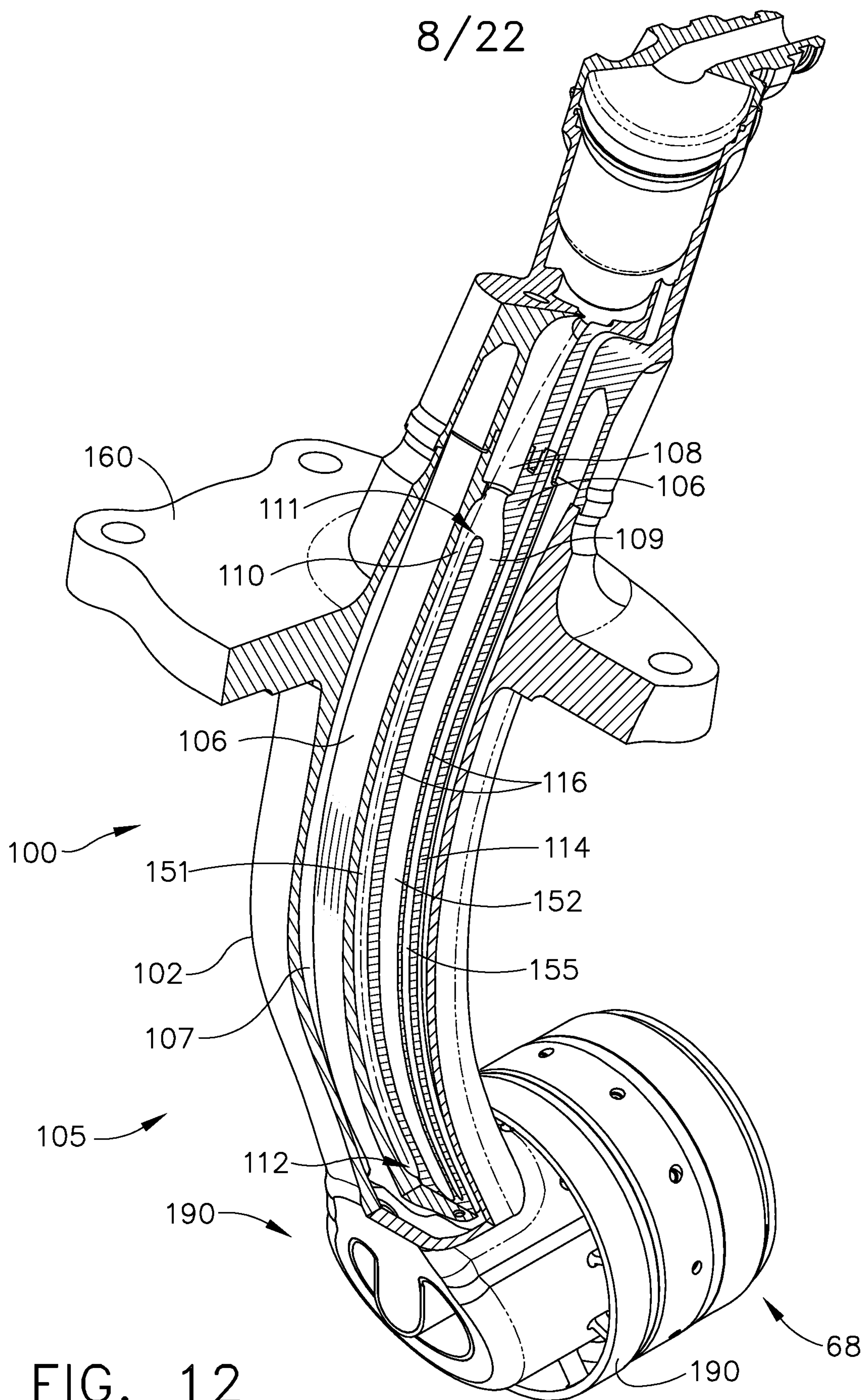
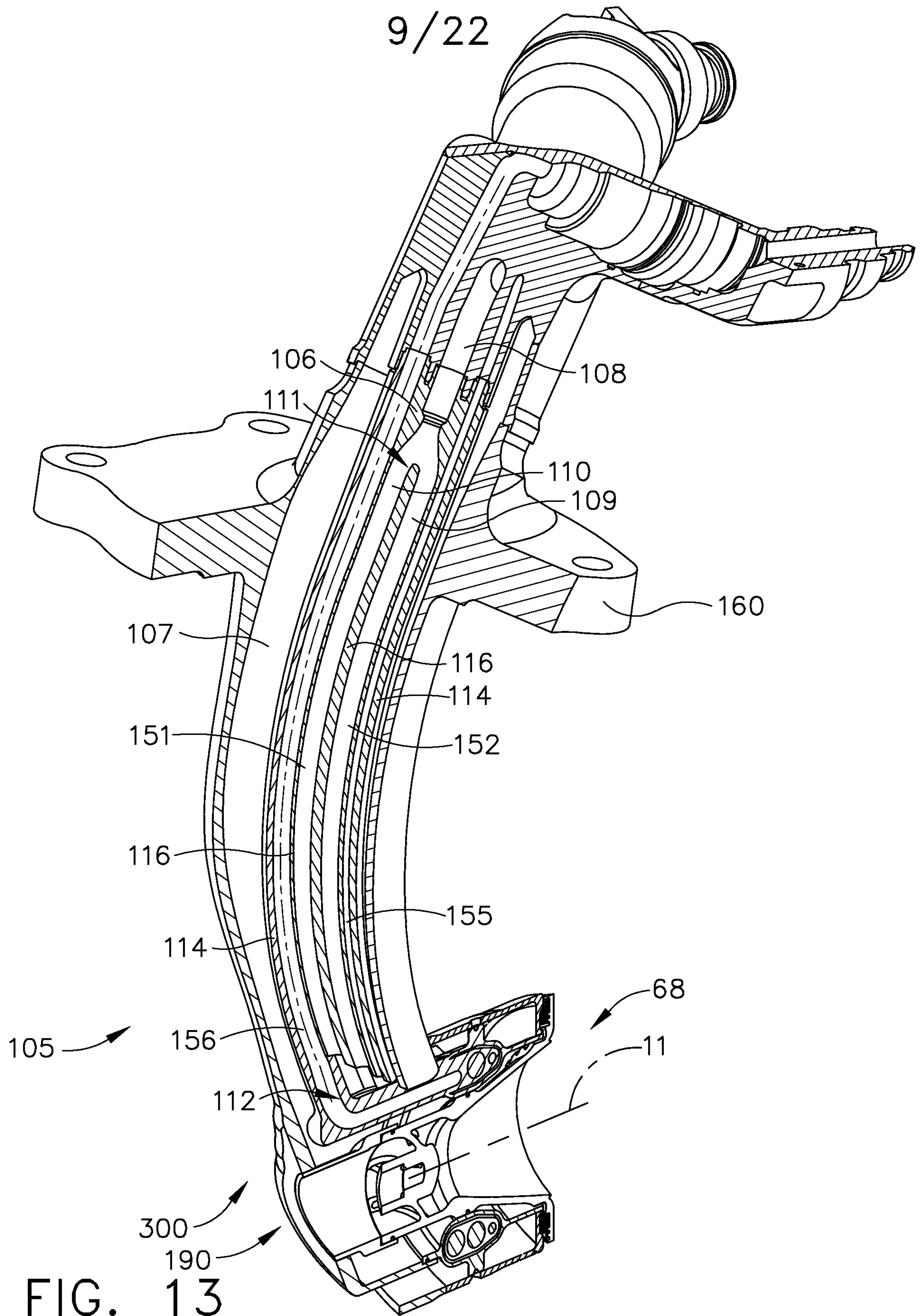


FIG. 11





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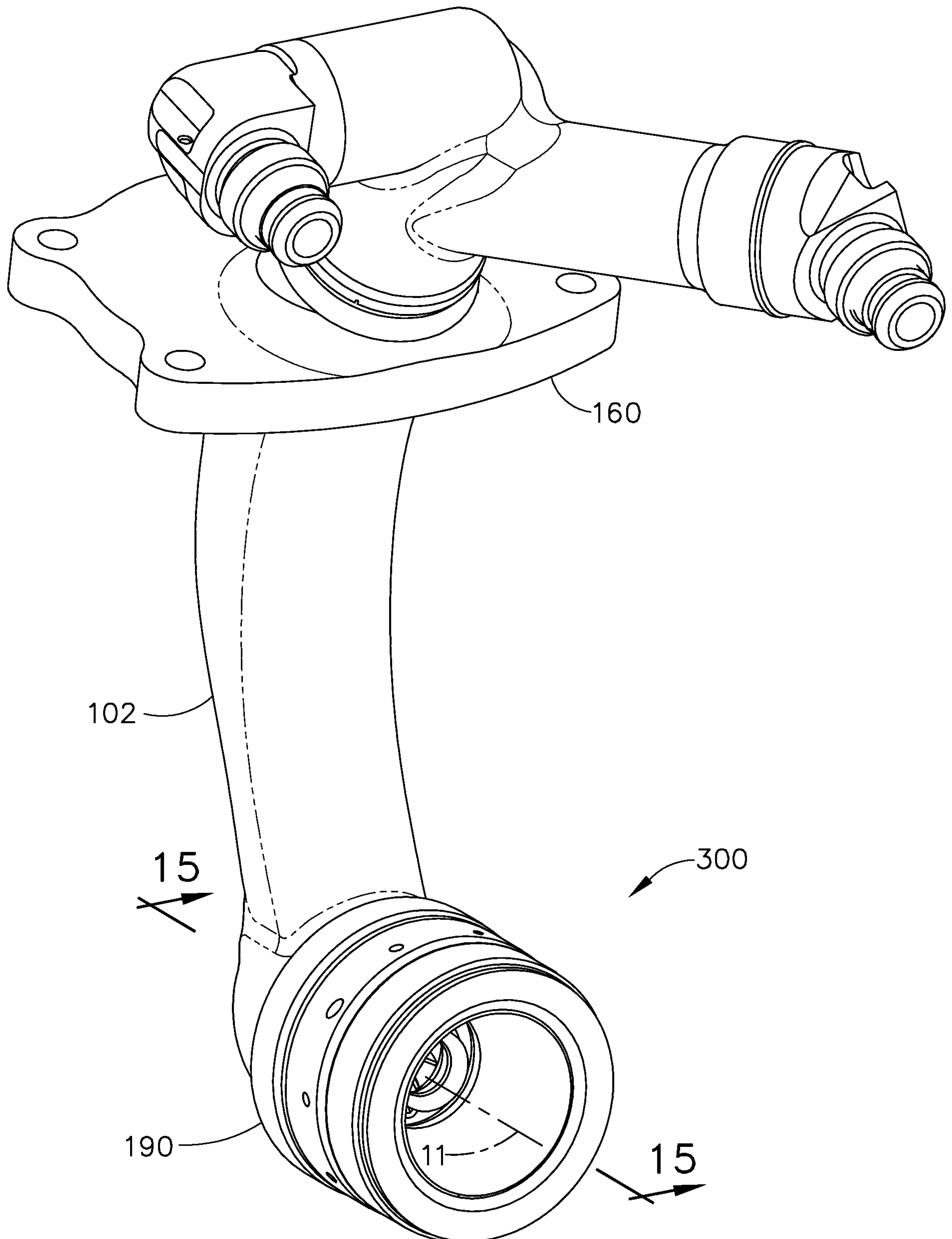


FIG. 14

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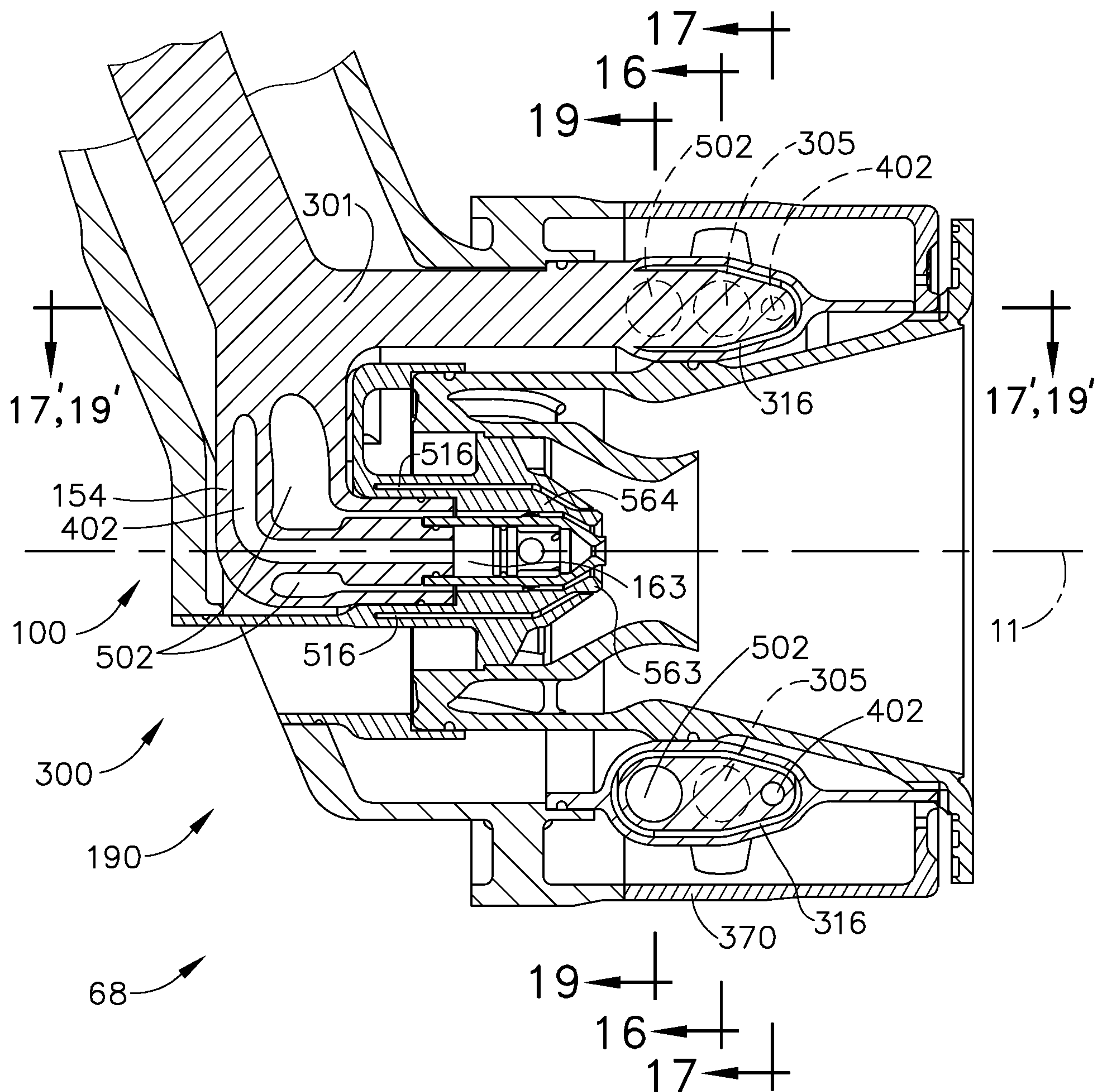


FIG. 15

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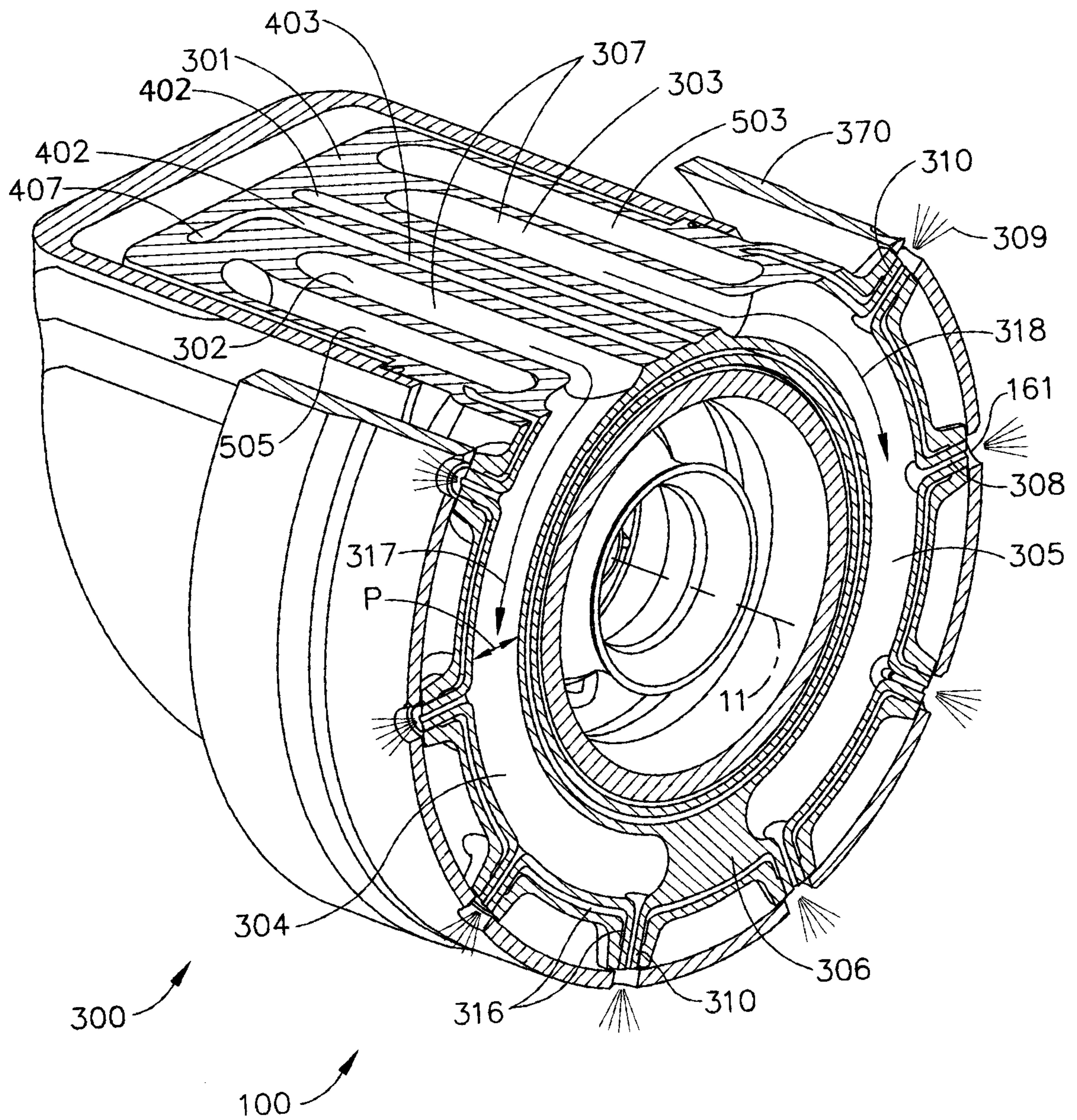


FIG. 16

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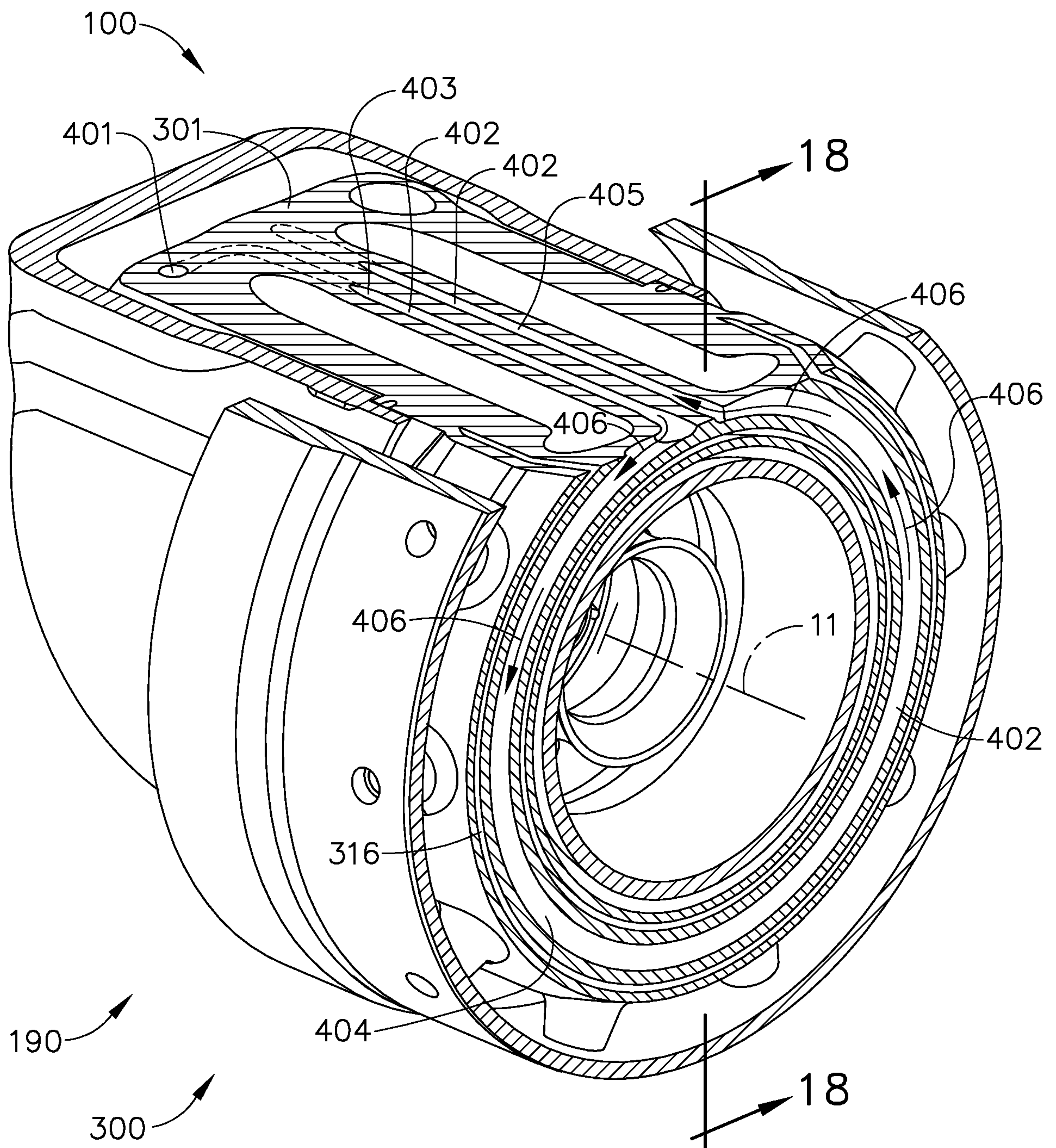


FIG. 17

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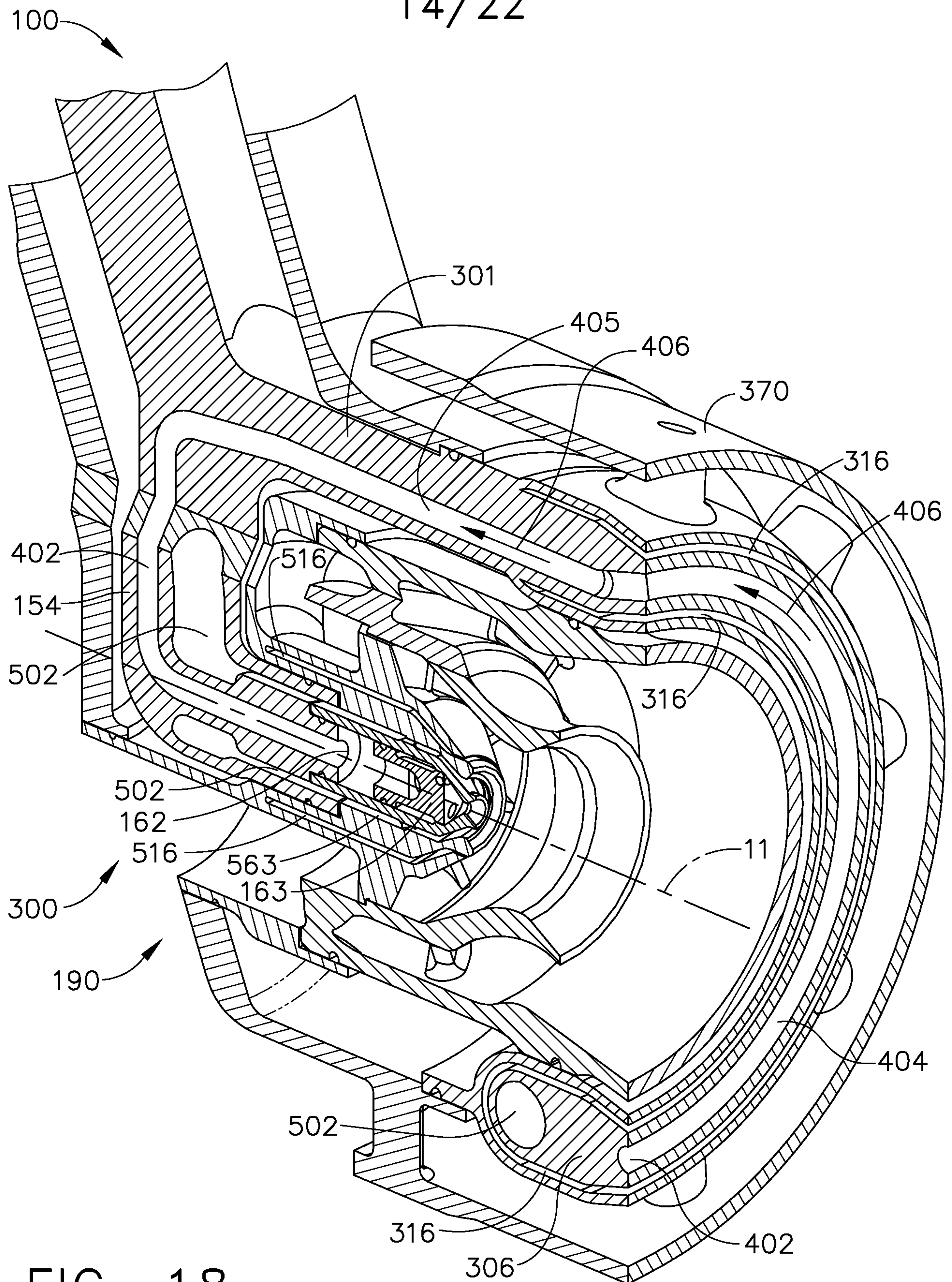


FIG. 18

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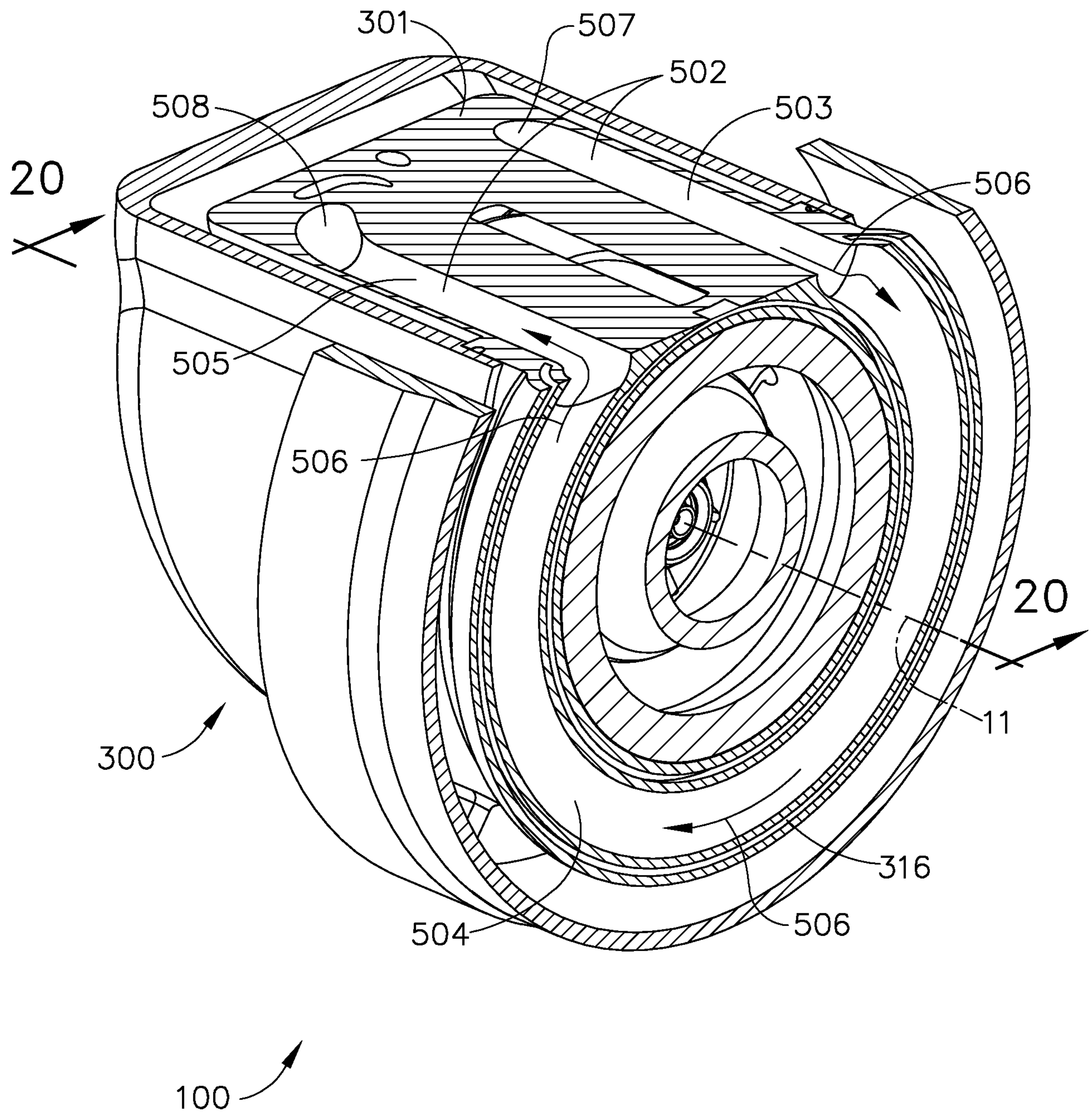


FIG. 19

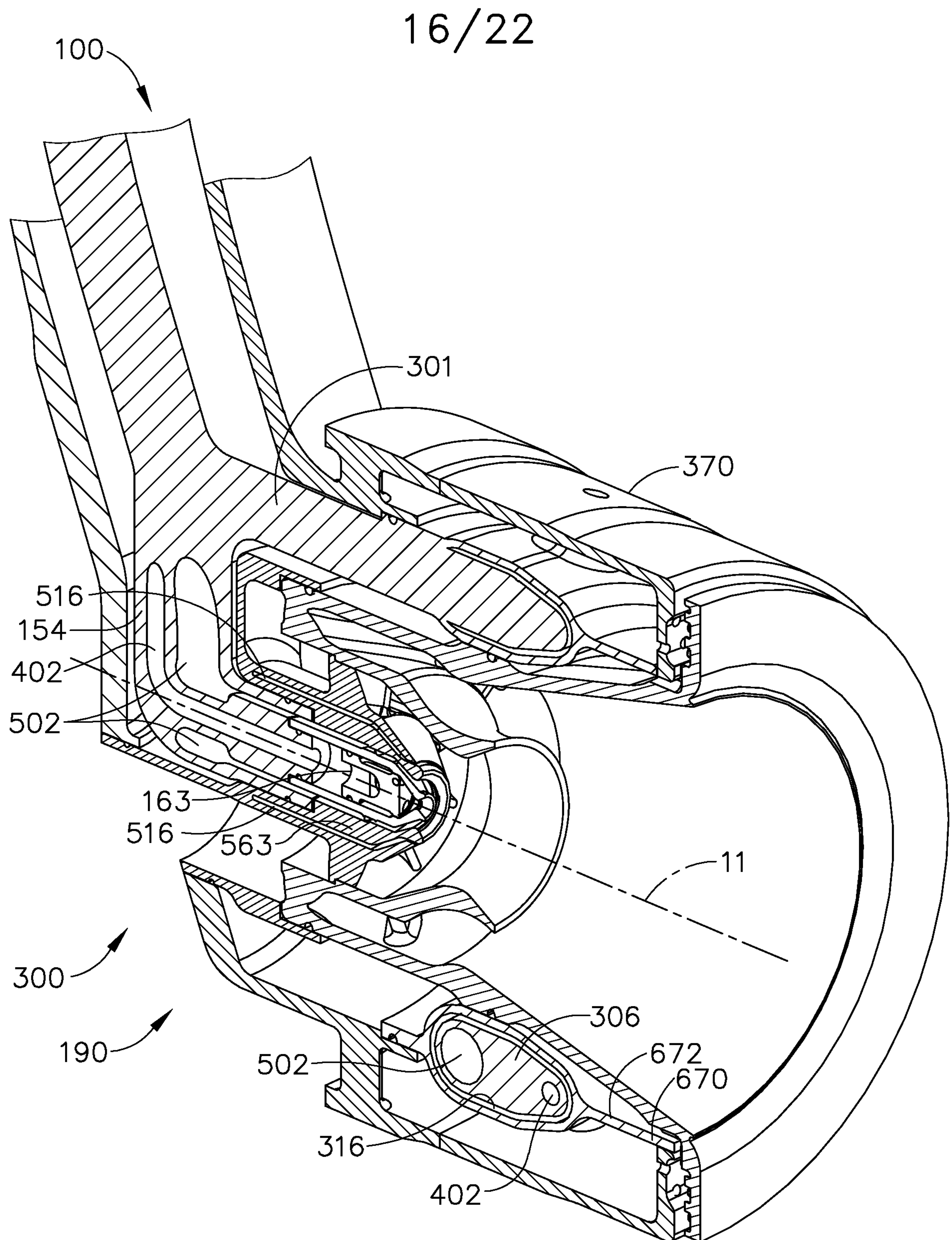


FIG. 20

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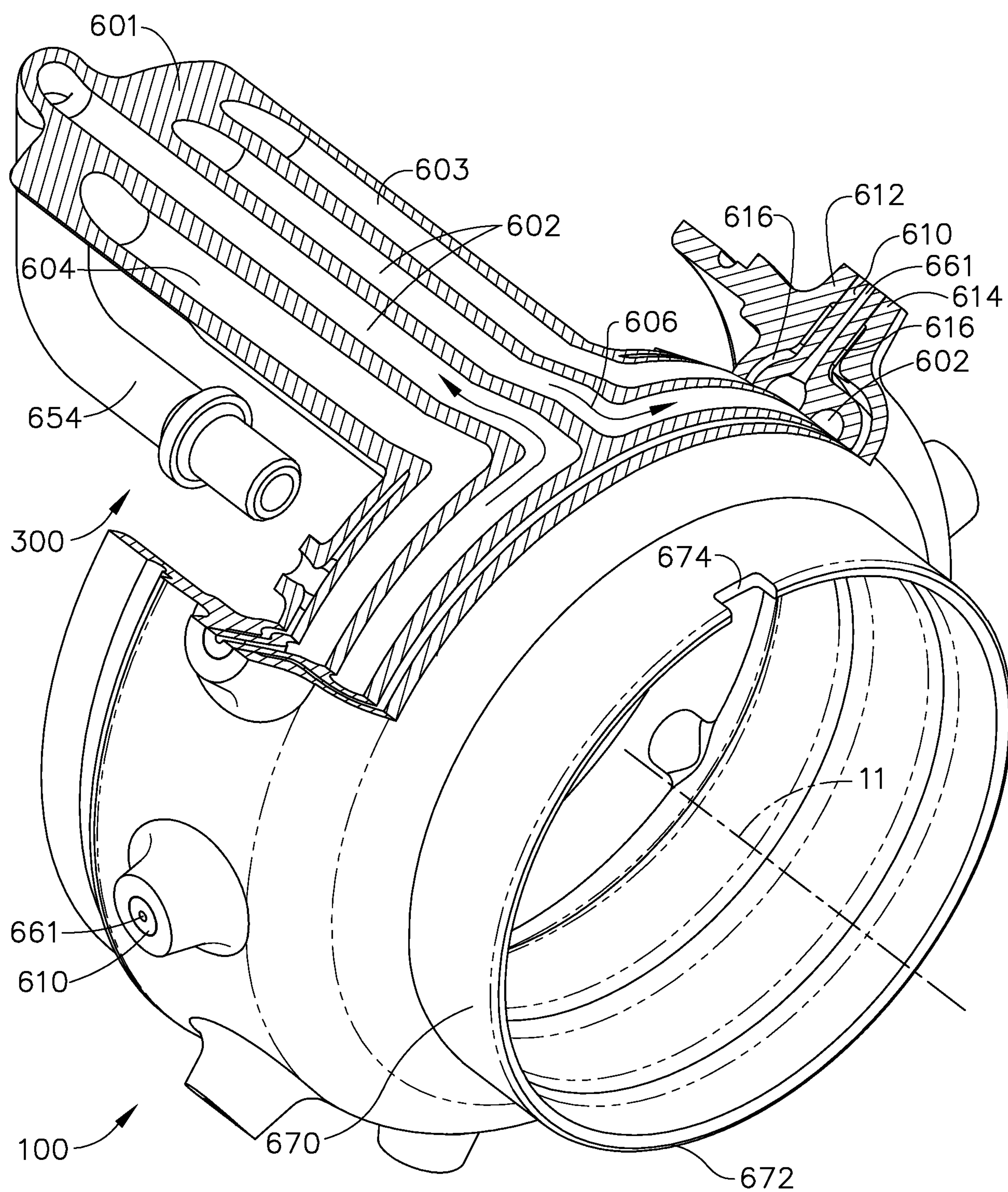


FIG. 21

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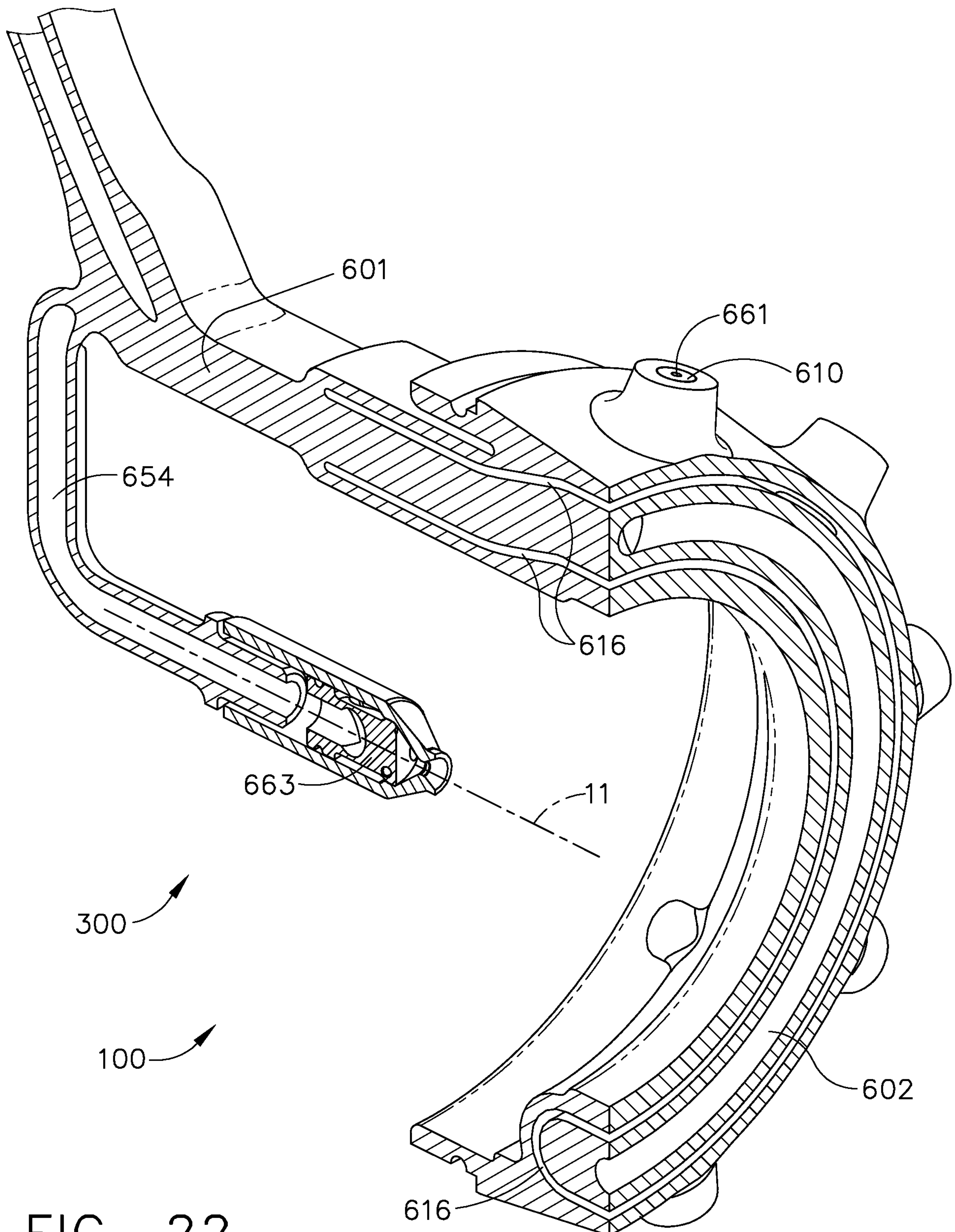


FIG. 22

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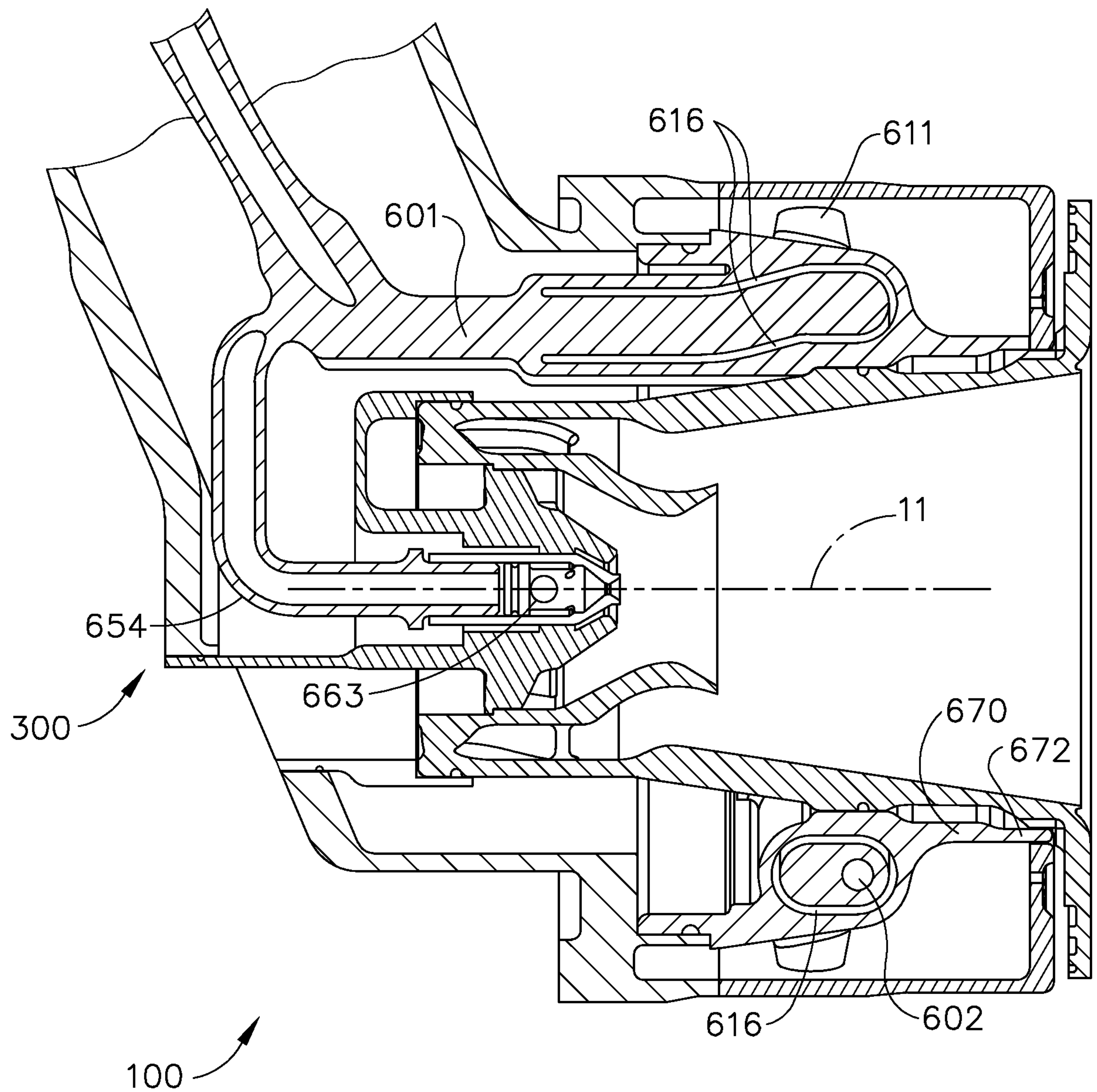


FIG. 23

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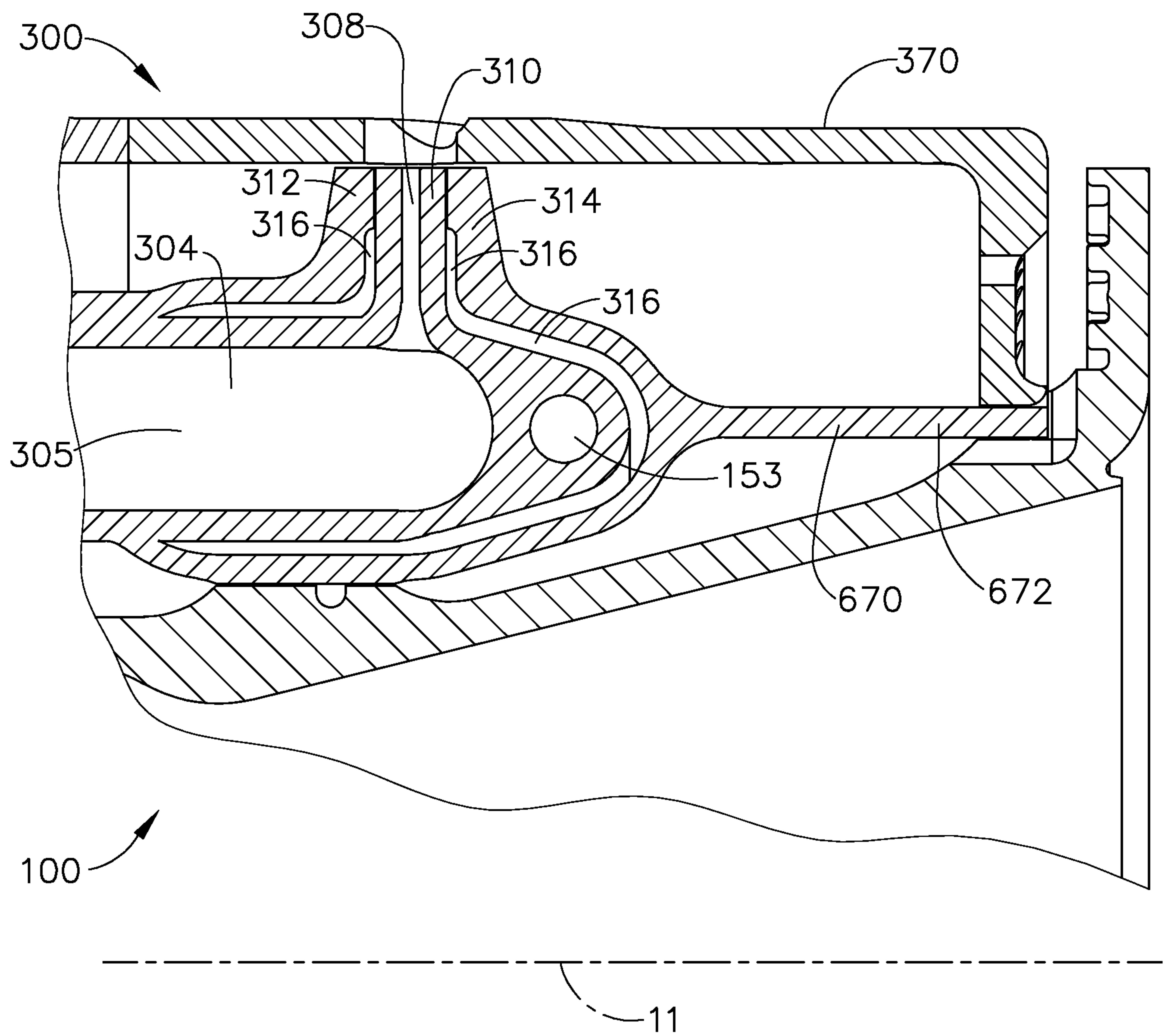


FIG. 24

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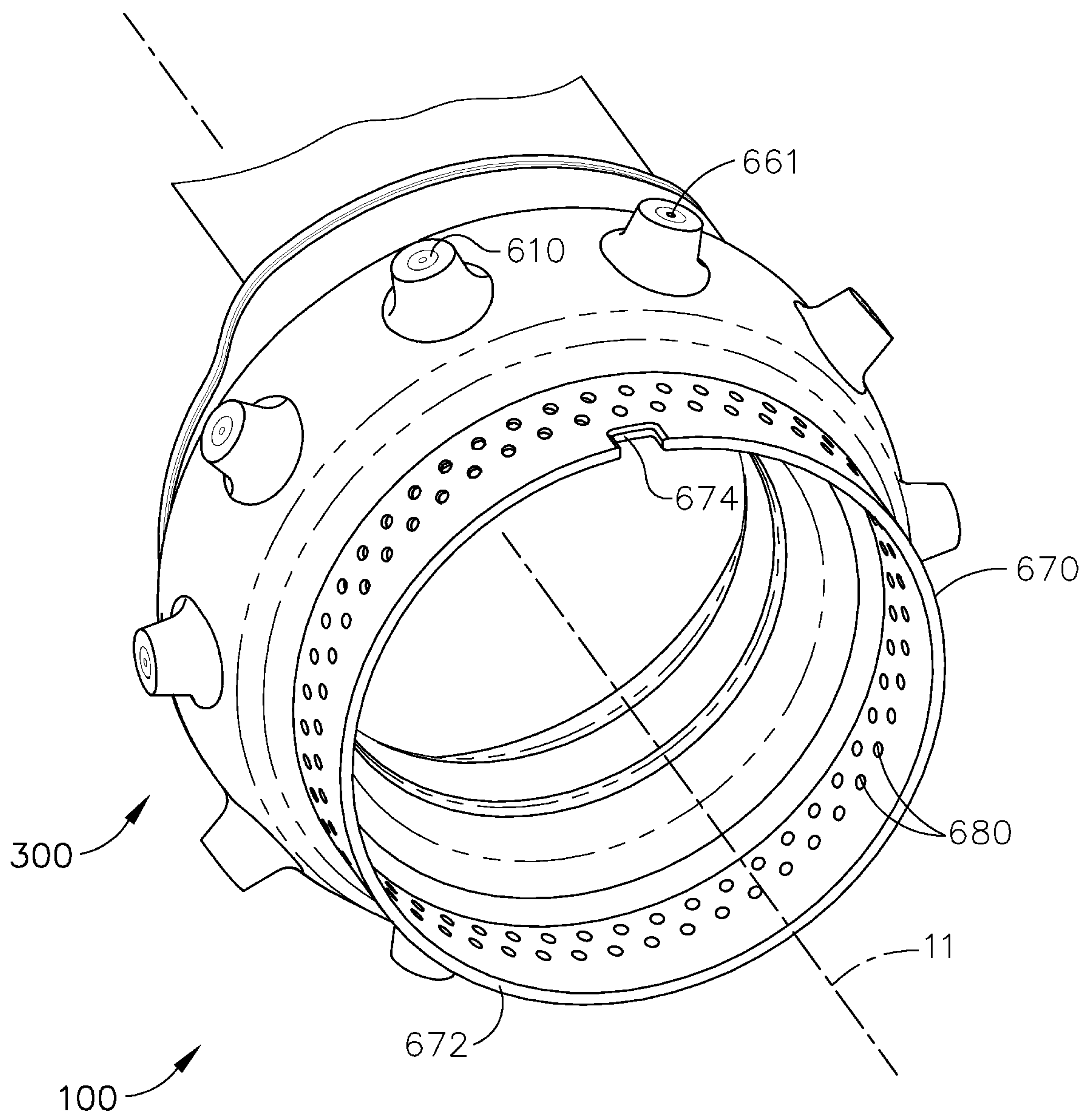


FIG. 25

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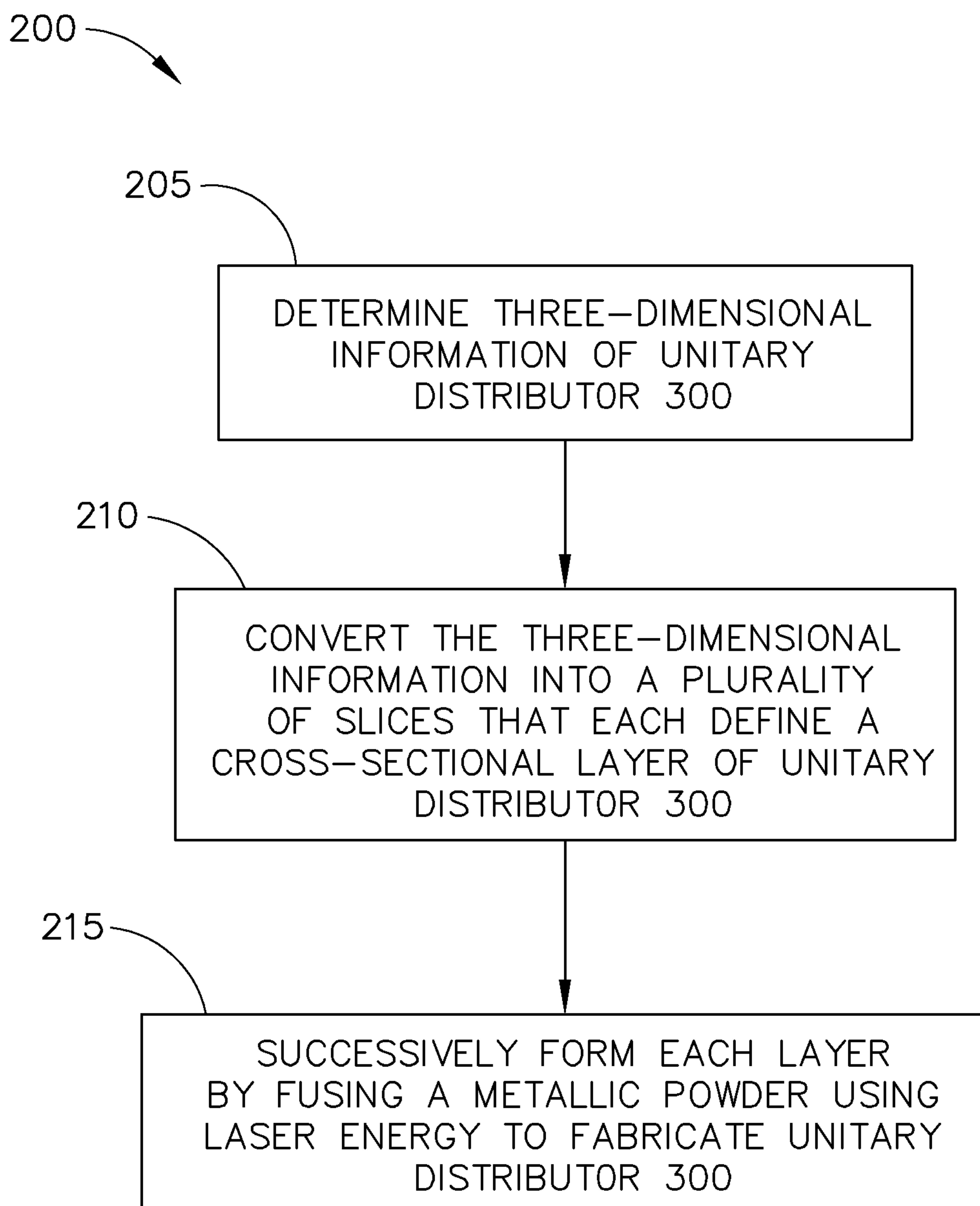


FIG. 26

