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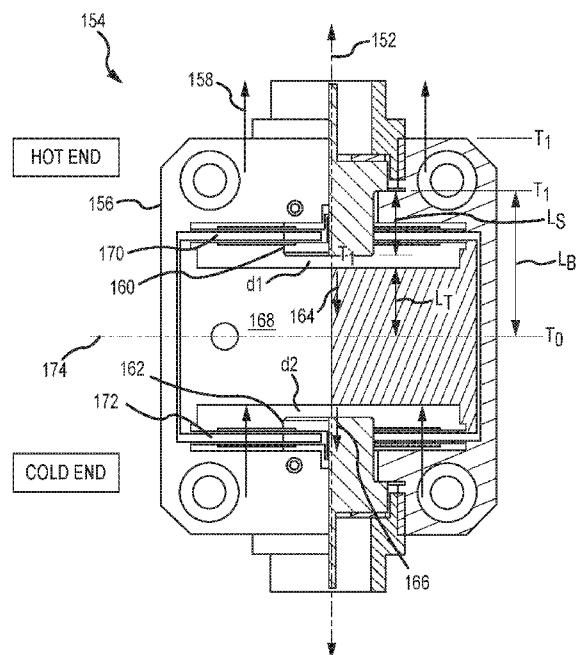


FIG. 3a

(57) Abstract: An athermal open-loop hung mass accelerometer configures the CTE of the sensor heads such that any growth by the body in response to a body temperature gradient along the longitudinal axis is offset by the growth of the sensor heads in the equal and opposite direction to null the effects of the temperature gradient. In many configurations, the sensor head CTE is strictly less than the body CTE and typically between 60-80% of the body CTE to null the effects of the predicted body temperature gradient.

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5 **ATHERMAL HUNG MASS ACCELEROMETER WITH REDUCED
SENSITIVITY TO LONGITUDINAL TEMPERATURE GRADIENTS**

BACKGROUND OF THE INVENTION

10 **Field of the Invention**

 This invention relates to accelerometers and more particularly to a class of open-loop hung mass accelerometers that use differential Eddy current sensing to provide improved sensitivity at lower cost and with higher reliability.

15 **Description of the Related Art**

 The basic, open-loop accelerometer consists of a proof mass attached to a spring or flexure. The mass is constrained to move only in-line with the spring. Acceleration causes deflection of the mass. The displacement of the mass is measured. The acceleration is derived from the values of displacement, mass, and the spring constant. The system must not be driven at a resonance that would cause it to exceed its travel limits and bottom out. One way to achieve this is to damp the system. Another way is to mount the accelerometer on an isolation system. A closed-loop accelerometer typically achieves higher performance by using a feedback loop to cancel the deflection, thus keeping the mass nearly stationary. Whenever the mass deflects, the feedback loop causes an electric coil to apply an equally
25 negative force on the mass, canceling the motion. Acceleration is derived from the amount of negative force applied. Because the mass barely moves, the sensitivity to non-linearities of the spring and damping system are greatly reduced. In addition, this accelerometer provides for increased bandwidth past the natural frequency of the sensing element. (Excerpted from Wikipedia “Inertial Navigation System” and “Accelerometer”).

30 Conceptually, an accelerometer behaves as a damped mass on a spring. When the accelerometer experiences acceleration, the mass is displaced to the point that the spring is able to accelerate the mass at the same rate as the accelerometer body. The displacement is then measured to give the acceleration.

 The performance of an accelerometer is primarily a combination of its bias stability
35 and scale factor error. Bias stability is the acceleration measured by the device when the

actual acceleration is zero. This is caused by mechanical imperfections in the device and noise in the electronics. The scale factor error reflects the error as proportional to the actual acceleration. If for example the device is accelerating at 1 g (32 feet/sec/sec) [1g is either 32.2 ft/sec/sec or 9.8 meters / sec/sec] and the device reads out 1.1 g, the scale factor error is 10%.

U.S. Patent No. 9,121,865 issued September 1, 2015 entitled “Hung Mass Accelerometer with Differential Eddy Current Sensing” and assigned to Raytheon Company introduced a new class of open-loop accelerometer that provides improved performance at lower cost and with higher reliability. As illustrated in Figures 5a and 5b and as described in the corresponding text of that patent, an embodiment of an open-loop hung mass accelerometer **100** sans the electronics comprises a single piece of metal **101** (e.g. Ti 6Al-4V or 17-4PH stainless steel) machined to form a body **102**, top and bottom flexures **104** and **106** and a proof mass **108** suspended between the flexures inside an internal cavity **109** to deflect along a longitudinal axis **110** through the center of the body. Each flexure includes three flexure legs that are spaced at 120°. Each flexure leg is attached in the axial direction between the proof mass **108** and the body **102**. Eddy current sensor heads **112** and **114** are mounted on the body and extend through the flexures along longitudinal axis **110** on opposite sides of the proof mass **108** at distances d1 and d2. Each sensor head comprises a coil of copper wire epoxied to the end of a hollow stainless steel cylinder typically .25 to .5 inches long.

SUMMARY OF THE INVENTION

The following is a summary of the invention in order to provide a basic understanding of some aspects of the invention. This summary is not intended to identify key or critical elements of the invention or to delineate the scope of the invention. Its sole purpose is to present some concepts of the invention in a simplified form as a prelude to the more detailed description and the defining claims that are presented later.

Testing of Raytheon’s open-loop hung mass accelerometer revealed that tight thermal control of this original design was required to achieve desired bias stability and scale factor error performance. In particular, body temperature gradients along the longitudinal axis could produce false acceleration readings.

The present invention provides an athermal open-loop hung mass accelerometer that

addresses thermal limitations of the original design. In different embodiments, the sensor heads (formed of one or more materials) exhibit effective coefficients of thermal expansion (CTEs) such that the growth of the sensor heads along the longitudinal axis is approximately equal and opposite the growth of the body along the longitudinal axis in response to a predicted body temperature gradient to approximately null the effects of such a temperature gradient. If the predicted body temperature gradient is symmetric, the sensor head geometry and CTE are the same. If the predicted body gradient is asymmetric, the sensor heads may exhibit different CTEs to offset the body growth. Even if the actual applied temperature gradient is not the predicted body temperature gradient for which the sensor heads are configured, the effects of the applied temperature gradient can be lessened.

In an embodiment of the accelerometer, the length (L_s) of the sensor head is greater than one-half the body length (L_B) and less than L_B . The proof mass is thermally isolated from the body by the flexures and remains at an approximately constant temperature (subject to changes in bulk temperature) although the body sees the predicted body temperature gradient. In such configurations the sensor head CTEs are strictly less than the body CTE in order to null the response. Furthermore, the sensor head CTEs lie between 60%-80% of the body CTE.

In an embodiment, the body, first and second flexures and proof mass are integrally formed from a single piece of machined metal such as titanium or stainless steel. Titanium has a CTE of approximately $9e-6/^{\circ}C$ and stainless steel has a CTE of approximately $16e-6/^{\circ}C$. The sensor heads may be formed from materials such as alumina (CTE of $6.5e-6/^{\circ}C$), glass bonded mica (CTE of $11.25e-6/^{\circ}C$), Beryllia (CTE of $8.7e-6/C$) or any other non-ferrous ceramic of appropriate CTE

In an embodiment, the accelerometer is implemented with a proof mass of at least 0.01 Kg and exhibits a bias less than 10 micro-g's and scale factor error less than 10 ppm without tight thermal control.

In an embodiment, the accelerometer is mounted on another structure. A plate formed of the same material as the accelerometer body is placed between the accelerometer and the structure. For example, bolts may extend through the corners of the accelerometer and the plate to mount the accelerometer to the structure. The plate provides an intermediate surface having the same CTE as the body, which has the effect of eliminating stresses at this interface over temperature changes.

These and other features and advantages of the invention will be apparent to those skilled in the art from the following detailed description of preferred embodiments, taken together with the accompanying drawings, in which:

5 BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a schematic block diagram of an athermal open-loop hung mass accelerometer with differential Eddy current sensing in which the sensor head CTE are configured to null net displacement in response to a predicted body temperature gradient along the longitudinal axis;

10 FIGs. 2a and 2b are different views of an embodiment of an athermal open-loop hung mass accelerometer sans the electronics;

FIGs. 3a and 3b are section views of the accelerometer illustrating the geometry of the sensor heads and body and a predicted body temperature gradient along the longitudinal axis;

15 FIG. 4 is a flow diagram of an embodiment for determining the sensor head CTE to null net displacement of the sensor heads to a predicted body temperature gradient;

FIG. 5 is a plot of a sensed acceleration vs. sensor head CTE for a 1K body gradient along the longitudinal axis; and

20 FIG. 6 is a diagram of an embodiment of the accelerometer mounted through an intermediate plate to a structure.

DETAILED DESCRIPTION OF THE INVENTION

25 Testing of Raytheon's open-loop hung mass accelerometer (described in U.S. Patent 9,121,865) and herein referred to as the "original design" revealed that tight thermal control of this original design was required to achieve desired bias stability and scale factor error performance. Tight thermal control can be quite complex and expensive.

In particular, temperature gradients along the longitudinal axis could produce false accelerations. The body of the accelerometer is formed from a metal such as titanium or stainless steel. Titanium has a CTE of approximately $9\text{e-}6/^{\circ}\text{C}$ and stainless steel has a CTE of approximately $16\text{e-}6/^{\circ}\text{C}$. The sensor heads, which comprise a copper coil mounted on a stainless steel cylinder with epoxy, have a CTE of approximately $18\text{e-}6/^{\circ}\text{C}$. A change in the bulk temperature of the accelerometer causes the body and sensor heads to grow along

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the longitudinal axis in unequal and opposite directions producing a change in the nominal spacing or “gap” between the sensor heads and the proof mass. However, the change is the same for both sensor heads, and thus the net displacement is zero and does not produce a false acceleration reading. But when subjected to a body temperature gradient along the longitudinal axis, the original design exhibits unequal and opposite growth such that the changes in the nominal spacing or “gaps” are not equal, which in turn produces a net displacement that results in a false acceleration reading.

The present invention provides an athermal open-loop hung mass accelerometer that addresses the limitations of the original design with respect to longitudinal temperature gradients. The sensor heads are formed of one or more materials to have effective sensor CTEs such that the growth of the sensor heads along the longitudinal axis is approximately equal and opposite the growth of the body along the longitudinal axis in response to a predicted body temperature gradient to approximately null the effects (the “net displacement”) of such a temperature gradient. If the predicted body temperature gradient is symmetric, the sensor head geometry and CTE are the same. If the predicted body gradient is asymmetric, the sensor heads may exhibit different CTEs to offset the body growth.

In certain accelerometer configurations, the length (L_s) of the sensor head is between one-half the body length (L_B) and the body length L_B . The proof mass is thermally isolated from the body by the flexures and remains at an approximately constant temperature (subject to changes in bulk temperature) although the body sees the predicted body temperature gradient. We have found that in such configurations the CTEs of the sensor heads is strictly less than the CTE of the body of the accelerometer in order to null the response. Furthermore, the CTEs of the sensor heads lie between 60%-80% of the CTE of the body to null the net displacement.

As shown in Figure 1, an embodiment of a thermally insensitive open-loop hung mass accelerometer **10** comprises a body **12** having an internal cavity **14** oriented along a longitudinal axis **16**. First and second flexures **18** and **20** are attached to the body **12** at opposite ends of the internal cavity **14** in a collinear arrangement. The first and second flexures are compliant along the longitudinal axis. A proof mass **22** is attached between the first and second flexures to hang inside the internal cavity. The proof mass is suitably at least 0.01 kg. The proof mass is constrained to move in-line with the first and second flexure

assemblies along longitudinal axis **16**. The two flexures assemblies have known, and suitably equal, stiffness. Each flexure assembly may include a single flexure or a vertical stack of multiple flexures to provide the specified stiffness. The individual flexures are easier and less expensive to manufacture than a single flexure with the same specified stiffness. The accelerometer is suitably configured to provide a dampening of the motion of the proof mass **22** to inhibit resonance. One of the flexures may include magnets to provide magnetic dampening. Alternatively, the accelerometer may be mounted on an isolation system to ensure it is not excited in a manner that causes the motion of the proof mass exceeds its travel limits at resonance.

10 The accelerometer is suitably configured to be very stiff in the other five degrees of freedom i.e. the other two axes orthogonal to longitudinal axis **16** and the rotation around each of the three linear axes. For example, the flexures may have a stiffness that would allow displacement along longitudinal axis **16** with a 100 Hz frequency whereas the stiffness in the other five degrees of freedom may limit any motion to around a 1 kHz frequency minimizing cross-coupling of the device. Essentially the accelerometer is configured to allow motion only along longitudinal axis **16**. An accelerometer may be provided for each of the three translations or a lesser subset thereof as required by a particular application.

 The accelerometer suitably uses wire EDM manufacturing to cut the body, flexures and proof mass from a single piece of material such as titanium or stainless steel.

20 The accelerometer includes a differential Eddy current sensor to sense the displacement of the proof mass **22** along longitudinal axis **16**. The sensor comprises first and second sensor heads **26** and **28** positioned on the body **12** inside the internal cavity **14** on opposite sides of the proof mass **22** at distances d_1 and d_2 that increase and decrease in opposition as the proof mass moves along longitudinal axis **16**. The sensor heads are collinear with and extending through the flexures as shown. Alternately, the sensor heads could be collinear with and recessed behind the flexures. In this case, the proof mass would be stepped to extend through the flexures proximate the sensor heads at each end of the body. The interface between the sensor heads and the proof mass needs to be spaced away from the flexures to avoid false readings.

30 Each sensor head includes a reference coil responsive to an alternating drive signal **29** from a common oscillator **30** to produce an oscillating magnetic field **31**. The magnetic field induces Eddy currents **32** in the proof mass **22** that create an opposing magnetic field

34 that resists the magnetic field **31** generated by the reference coil. The target surface on the proof mass should be at least three times larger than the diameter of the sensor head for normal, calibrated operation; otherwise, special calibration may be required. Any change in the distance (d_1 or d_2) between the reference coil and the proof mass due to a displacement
5 d of the proof mass from a null position corresponding to no acceleration causes a change in the magnetic field interaction that alters an output signal **36**. Typically, the output signal **36** is the drive signal **29** that has been altered in phase or amplitude by the field interaction.

If the proof mass **22** is closer to the top sensor head **26** than the bottom sensor head **28**, the Eddy currents due to the top sensor head **26** are larger in the proof mass than the
10 Eddy currents due to the second sensor head **28** (which is further away). This in turn modifies the excitation in the top sensor head **26** more than the excitation in the bottom sensor head **28**. The impedances seen by the sensor heads change differentially with the displacement of the proof mass. Consequently the output signals **36** are altered differentially. In an embodiment, output signals **36** are the drive signals **29** that have been
15 differentially altered in phase or amplitude.

Accelerator electronics **40** comprise three functional blocks; oscillator **30**, a differential displacement circuit **42** and a distance-to-acceleration conversion circuit **44**. Oscillator **30** provides the common drive signal **29** to excite sensor heads **26** and **28**. Differential displacement circuit **42** compares output signals **36** from sensor heads **26** and
20 **28** to provide an output **46** proportional to the displacement d of the proof mass **22** along longitudinal axis **16**.

In an embodiment, differential displacement circuit **42** includes a tuned impedance (e.g. a series connected capacitor and resistor) that is connected in series with a reference coil of sensor head **26** to form a resonant circuit, a tuned impedance (e.g. a series connected
25 capacitor and resistor) that is connected in series with a reference coil of sensor head **28** to form a resonant circuit, and an impedance change detector. The resonant circuits may be tuned to have the same or different resonant frequencies. In an embodiment, the resonant frequency of one circuit is slightly greater than the frequency of the drive current and the resonant frequency of the other circuit is slightly less than the frequency of the drive current.

30 When each reference coil is driven by the alternating drive current **29**, an oscillating magnetic field is generated that induces Eddy currents in the proof mass **20**. The Eddy currents induced in the proof mass circulate in Eddy current impedances represented by a

parallel inductor and resistor connection in a direction to produce a secondary magnetic field opposite that of the reference coil, reducing the magnetic flux in the reference coil and thereby the reference coil inductance. The Eddy currents also dissipate energy, increasing the reference coil's effective resistance.

5 The reference coil constitutes the primary and the proof mass the (shorted) secondary of a weakly coupled air-core transformer. Displacement of the proof mass changes the coupling, and this displacement is reflected as an impedance change at the terminals of the reference coil, which in turn produces an altered drive current **36**. As the proof mass approaches the reference coil, the inductance goes down and the reflected resistance
10 increases. By electronically comparing the impedance changes in the two altered sensor head drive currents (such as amplitude and/or phase changes), the relative displacement between the two sensor heads can be determined accurately.

 Output **46** may be a voltage or current signal that represents a change in impedance measured as a phase or amplitude of the output signal (e.g. altered drive signal) proportional
15 to the displacement d . Knowing the mass of the proof mass, the spring constant (stiffness of the flexures) and any calibration coefficients, distance-to-acceleration circuit **44** converts output **46** to an acceleration **48** of the proof mass. These two functional circuits may, for example, be separate analog and digital circuits or may, for example, be a single circuit in which case output **46** may be an internal parameter.

20 Either the differential displacement circuit **42** or the distance-to-acceleration circuit **44** may perform an intermediate step of converting output **46** to a displacement d . As shown, the distance-to-acceleration circuit performs the conversion. For a given sensor head, $L_{snr}(d/r) = L_s(1 - K e^{-A(d/r)})$ where d is the coil to proof mass spacing, L_{snr} is the total sensor inductance (nominal plus Eddy current induced), L_s is the reference coil inductance when
25 the proof mass is infinitely far away ($d = \text{infinity}$), $K = 0.5$ to 0.75 (for typical proof mass materials), A is a constant depending on the proof mass material and r is the reference coil winding radius. Similarly, the total sensor resistance is $R_{snr}(d/r) = R_s(1 + C e^{-B(d/r)})$ where B and C are constants depending on the proof mass material and $B > A$ and $C < K$. The relative increase in inductance is more significant than the decrease in reflected resistance
30 for increasing d . Thus, the change in the reference coil inductance is the basis for Eddy current sensing. The differential phase or amplitude from output **46** is mapped to a change in differential impedance. This change in impedance is related to the distance d through the

above equations.

Once displacement d is known, Hooke's law can infer the force F operating on the spring, i.e. $F = kd$, where k is the spring constant. Once the force F is known, acceleration is determined through Newton's Law $F = Ma$, where M is the mass of the proof mass. As previously discussed, Hooke's Law assumes that the spring constant k is in fact constant over the possible displacement range, which strictly speaking is not true at the levels of performance required for strategic grade performance. In addition, the sensor itself has nonlinearities due to non-perfect electronics and sometimes the physics of the sensing mechanism. The differential topology of the Eddy current sensor heads has the advantage that when the proof mass is far from one sensor head it is simultaneously close to the other sensor head. Consequently, without any further compensation the system output is more linear. Furthermore, it is simpler to remove any remaining non-linearity of both the spring constant as well as the sensor through calibration and the application of calibration coefficients to compute the displacement or acceleration. Owing to the thermal stability and linearity of the differential Eddy current sensor, the acceleration **48** is substantially linear with the displacement d of the proof mass over a specified range of motion.

The sensor heads **26** and **28** are formed of one or more materials having effective CTEs such that the growth of the sensor heads along the longitudinal axis **16** is approximately equal and opposite the growth of the body **18** along the longitudinal axis **16** in response to a predicted body temperature gradient to approximately null the effects (the "net displacement") of such a temperature gradient. Reference coils **50** and **52** are attached to the ends of the sensor heads. Epoxy may be used to attach the reference coils. The epoxy is suitably applied on top of the reference coils to keep the high CTE material out of the thermal path of the coil. If the predicted body temperature gradient is symmetric, the sensor head geometry and CTE are the same. If the predicted body gradient is asymmetric, the sensor heads may exhibit different CTEs to offset the body growth.

In certain accelerometer configurations, the length (L_s) of the sensor head is greater than one-half the body length (L_B) and less than the body length L_B . The body length is measured from the attachment point of the sensor head to the centerline of the proof mass. The sensor length is measured from the same attachment point to the end of the sensor head. The proof mass is thermally isolated from the body by the flexures and remains at an approximately constant temperature (subject to changes in bulk temperature) although the

body sees the predicted body temperature gradient. The gradient does not affect the temperature of the proof mass. We have found that in such configurations the CTEs of the sensor heads is strictly less than the CTE of the body of the accelerometer in order to null the response. Furthermore, the CTEs of the sensor heads lie between 60%-80% of the CTE
5 of the body to null the net displacement.

With reference now to Figures 2a and 2b, an embodiment of an open-loop hung mass accelerometer **100** sans the electronics comprises a single piece of metal **101** (e.g. Ti 6Al-4V or 17-4PH stainless steel) machined to form a body **102**, top and bottom flexures **104** and **106** (e.g., a stack of one or more flexures) and a proof mass **108** suspended between the
10 flexures inside an internal cavity **109** to deflect along a longitudinal axis **110** through the center of the body. The flexures are rectangular with approximately the same footprint as proof mass **108** except for a hole in the middle to receive the sensor heads. The flexures allow movement of the proof mass in the compliant direction along longitudinal axis **110** at a resonance of ~100 Hz. The body restricts movement in the non-compliant directions
15 orthogonal to longitudinal axis **110** or in rotation about any of the linear axes to reduce unwanted cross coupling of transverse accelerations into the main sensing axis. These other modes are all > ~10 times the frequency of the compliant direction (in this case 100 Hz) and do not nominally result in sensed motion. The structure is about ~1.6" X 1.1" X 0.6" and weighs about ~0.10 lbs. Metal **101** is machined to form openings around and along
20 longitudinal axis **110** on either side of proof mass **108** to receive Eddy current sensor heads **112** and **114**. The sensor heads lie within and collinear with the flexures and the longitudinal axis of motion. The sensor heads exhibit an effective CTE to null the net displacement for a predicted body temperature gradient. The sensor head CTE is strictly less than the body CTE and is most typically 60-80% of the body CTE for standard accelerometer geometries.

25 With reference now to Figures 3a and 3b, a predicted body temperature gradient **150** is assumed along a longitudinal axis **152** of a hung mass accelerometer **154**. The directions of growth due to the temperature gradient **150** for a body **156** are indicated by arrows **158** and for sensor heads **160**, **162** by arrows **164**, **166**, respectively. Proof mass **168** is thermally isolated by the flexures **170** and **172**. The dimensions of the flexures, thin and narrow,
30 present a very high thermal impedance that effectively isolates the proof mass. As a consequence, the temperature of proof mass **168** is unaffected by the temperature gradient. Its temperature does move with changes in the bulk temperature.

The sensor CTE is selected such that the sensor head growth is equal and opposite the body growth to null any displacement caused by the predicted body temperature gradient **150**. The sensor CTE is a function of the predicted body temperature gradient **150**, the body CTE and the geometry (i.e., lengths) of the body and sensor head measured with respect to a centerline **174** of proof mass **168**. The sensor CTE can be estimated via a simple calculation (i.e., one that assumes a uniform temperature gradient) or an extrapolation that can incorporate more complex temperature gradients.

The geometric and thermal variables for the accelerometer are defined as follows:
 $L_S \equiv$ sensor length from point of attachment of the sensor head to the body to the coil at the end of the sensor head;
 $L_B \equiv$ Body length from point of attachment of the sensor head to the body to the center line of the proof mass;
 $L_T \equiv$ target length is the thickness of the proof mass from the center line;
 $\alpha_S \equiv$ sensor CTE;
 $\alpha_B \equiv$ body CTE;
 $T_0 \equiv$ initial temperature of the body temperature gradient (physically coincident with the center line of the proof mass but not necessarily the temperature of the proof mass which is thermally isolated);
 $\Delta T_B \equiv$ effective temperature change due to the body gradient; and
 $\Delta T_S \equiv$ temperature change of the sensor.

The thermoelastic temperature growth of a material is defined by:
 (1) $\Delta L = \alpha L \Delta T$.
 Ignoring the effects of bulk temperature changes, which cancel and do not effect the net displacement, to maintain a consistent gap between the sensor head and target due to a body temperature gradient along the longitudinal axis, it is desired that:

$$(2) \Delta L_B = \Delta L_S.$$

Therefore:

$$(3) \alpha_B L_B \Delta T_B = \alpha_S L_S \Delta T_S \text{ and}$$

$$(4) \frac{\alpha_S}{\alpha_B} = \frac{L_B \Delta T_B}{L_S \Delta T_S}$$

Assuming a linear conduction gradient over length L_B :

$$(5) \Delta T_B = \frac{T_1 + T_0}{2} - T_i = \frac{T_1 - T_0}{2}$$

Assuming a uniform temperature change of the sensor:

$$(6) \Delta T_s = T_1 - T_0$$

Relationship (4) then simplifies to:

$$(7) \frac{\alpha_s}{\alpha_B} = 0.5 \frac{L_B}{L_s}$$

The above calculation simplifies the temperature distribution into regions of constant
 5 temperature or linear gradients. The use of finite element software is the most accurate way
 to predict more real world potential temperature gradient and the consequential
 thermoelastic growth of the accelerometer body and sensor head.

Geometry may be constrained to a limited range by other design requirements. A
 minimum sensor length is needed to protrude past the flexure blades. The sensor length is
 10 also governed by the specific gap needed between the sensor and the target. Target height
 is defined in part by the size/mass of the proof mass needed to achieve the 100Hz bandwidth.
 L_B is necessarily greater than L_s given the target height and gap. With only minimal
 flexibility in the geometry permitted, and the temperature profile dictated, variation in
 relative CTE's (α_s/α_B) between the body and sensor head is used to maintain a consistent
 15 gap between the sensor tip and the target.

Best operation of the eddy current sensor requires that the sensor head extend beyond
 the flexure blades. In one embodiment, design that gave $L_B/L_s=1.2$. The effective gradient
 ΔT of the body was roughly 60% that of the sensor head. This gives $\alpha_s/\alpha_B = 1.2*0.6=72\%$.
 The geometry can be manipulated to increase $\Delta T_B/\Delta T_s$. This is done by increasing the body
 20 length L_B so as to decrease the relative length over which the gradient mostly occurs. To
 maintain the same gap between the sensor head and proof mass, L_s increases by the same
 amount. The ratio L_B/L_s gets closer to 1. Now for example $L_B/L_s=1.1$ and $\Delta T_B/\Delta T_s=65\%$
 then $\alpha_s/\alpha_B = 1.1*0.65=71.5\%$ and the ideal sensor CTE does not change significantly. In
 summary, $\Delta T_B/\Delta T_s$ increases by altering the body geometry, typically increasing L_B .
 25 Increasing lengths decreases L_B/L_s for the same sensor head gap. The variation in these two
 ratios counteract each other so α_s/α_B is not particularly sensitive. For some exemplary
 accelerometers in which $0.5*L_B < L_s < L_B$ and the proof mass is thermally isolated from the
 body, $0.6\alpha_B < \alpha_s < 0.8\alpha_B$ or equivalent α_s is 60-80% of α_B .

In order to achieve the specified sensor CTE for a given accelerometer design and
 30 body temperature gradient, the sensor head may need to be fabricated from multiple
 materials of lengths $L_1, L_2, \dots, L_n$ and CTEs $\alpha_1, \alpha_2, \dots$. The effective CTE of the sensor head
 is given by:

$$\alpha_{eff} = \frac{(\alpha_1 L_1 + \alpha_2 L_2 + \dots \alpha_n L_n)}{L_1 + L_2 + \dots L_n}$$

If the predicted body temperature gradient is asymmetric, embodiments can include either a symmetric sensor head design that accommodates the asymmetry as best possible or different CTEs for the sensor heads to optimize each side of the accelerometer.

5 Another approach for determining the sensor CTE is given by the design flow of Fig. 4. Provide an accelerometer design including the flexure, body and sensor head geometries to satisfy proof mass mass requirements, flexure shape and sensor head-to-proof mass gap requirements (step **200**). Provide a predicted body temperature gradient for the accelerometer along the longitudinal axis (step **202**). For a given material for the
10 body/flexure/proof mass, calculate the net thermoelastic displacement (change in the sensor head-to-proof mass gap) for two different sensor head CTEs (step **204**). The two sensor head CTEs can be selected arbitrarily or based on a priori knowledge of similar designs. Extrapolate the relationship between the sensor head CTE and net displacement to calculate an ideal sensor head CTE to null the net displacement (step **206**). A sensor head substrate
15 or combination of substrates (length and CTE) are selected to approximate the ideal CTE (step **208**). If the design meets the performance specification, the design is complete (step **210**). If not, modify the geometry of the accelerometer (step **212**) and repeat until a satisfactory design is produced.

By way of comparison, an accelerometer manufactured from a block of titanium has
20 a body CTE of 9e-6°C. A predicted body temperature gradient having a variation of 1 degree is compared. The stainless steel and epoxy sensor heads of the original design have a CTE of 18e-6°C. This produced a false acceleration reading of approximately 1,000 µGs. A tuned alumina sensor head has a CTE of approximately 6.5e-6°C. As shown in Fig. 5, the false acceleration reading **300** is quite sensitive to sensor head CTE. The matched
25 sensor head CTE produced a false acceleration reading **302** of less than 5 µGs, more than a 200x improvement over the original design. If the sensor head CTE is not properly matched, the false acceleration reading increases rapidly. The plot further shows that simply forming the sensor head of materials with near zero CTE is not effective to null out the effects of a body temperature gradient along the longitudinal axis.

30 As shown in Fig. 6, an accelerometer **400** is mounted to another structure **402**. A plate **404** formed of the same material as the accelerometer body is placed between the

accelerometer and the structure. The plate forms a mounting surface for the accelerometer. Bolts extend through the corners of the accelerometer and the plate to mount the accelerometer to the structure. The plate provides an intermediate surface having the same CTE as the body, which has the effect of eliminating stresses at this interface over
5 temperature changes. Further design techniques can be used when mounting this intermediate plate to a greater structure of differing CTE. These techniques might include but are not limited to the use of a single fastener connection at the plate center serving to kinematically mount the plate and minimize conduction gradients across the plate by way of a single, centered contact point.

10 While several illustrative embodiments of the invention have been shown and described, numerous variations and alternate embodiments will occur to those skilled in the art. Such variations and alternate embodiments are contemplated, and can be made without departing from the spirit and scope of the invention as defined in the appended claims.

WE CLAIM:

1. A hung mass accelerometer, comprising:
 - a body having an internal cavity oriented along a longitudinal axis, said body formed of one or more materials having an effective body coefficient of thermal expansion (CTE);
 - 5 first and second flexures attached to the body at opposite ends of the internal cavity, said first and second flexures compliant along the longitudinal axis;
 - a proof mass between the first and second flexures to hang inside the internal cavity, said proof mass allowed to move along the longitudinal axis in an open-loop configuration;
 - 10 first and second sensor heads mounted on the body on opposite ends of the internal cavity along the longitudinal axis on opposite sides of the proof mass at distances d_1 and d_2 that increase and decrease in opposition as said proof mass moves along the longitudinal axis, each said sensor head having a reference coil responsive to an alternating drive signal to produce an oscillating primary magnetic field that induces
 - 15 Eddy currents in the proof mass that create an opposing secondary magnetic field that resists the primary magnetic field generated by the reference coil, any change in the distance between the reference coil and the proof mass causing a change in the magnetic field interaction that produces differential alterations to the alternating drive signal,
 - said first and second sensor heads formed of one or more materials having
 - 20 effective first and second sensors CTEs such that the growth of said first and second sensor heads along the longitudinal axis is approximately equal and opposite the growth of said body along the longitudinal axis in response to a predicted body temperature gradient along the longitudinal axis to approximately null the effects on the alternating drive signal.
 - 25
2. The hung mass accelerometer of claim 1, wherein the effective first and second CTEs of said first and second sensor heads are configured based on the geometries of the first and second sensor heads and the body, the body CTE and the predicted body temperature gradient.

3. The hung mass accelerometer of claim 1, wherein said effective first and second CTEs of said first and second sensor heads are each less than the effective body CTE.
4. The hung mass accelerometer of claim 1, wherein said effective first and second CTEs of said first and second sensor heads are between 60% and 80% of the effective body CTE.
5. The hung mass accelerometer of claim 4, wherein $0.5 \cdot L_B < L_S < L_B$ where L_B is the length of the body measurement from an attachment point of the sensor head to a centerline of the proof mass and L_S is the length of the sensor head from the attachment point, wherein the proof mass is substantially thermally isolated from the body by the first and second flexures.
6. The hung mass accelerometer of claim 1, wherein the proof mass has a mass of at least 0.01 kg and the measured acceleration has a bias less than 10 micro-g's and a scale factor error less than 10 parts per million in an environment in which the predicted body temperature gradients are less than 1 Kelvin.
7. The hung mass accelerometer of claim 1, wherein the predicted body temperature gradient is asymmetric about the proof mass, wherein said effective first and second sensor CTEs are different.
8. The hung mass accelerometer of claim 1, wherein the body, the first and second flexures and the proof mass are integrally formed from a single piece of metal.
9. The hung mass accelerometer of claim 1, wherein the first and second flexures and the proof mass have a rectangular footprint.
10. The hung mass accelerometer of claim 1, further comprising a mounting plate formed of the same material as the accelerometer body and attached to the accelerometer body to form a mounting surface of the accelerometer.

11. The hung mass accelerometer of claim 1, further comprising electronics including
- an oscillator that generates the alternating drive signal;
 - a first electrical circuit configured to compare the altered drive signals from the
 - 5 first and second sensor heads to provide an output proportional to the displacement of the proof mass along the axis; and
 - a second electrical circuit configured to convert the output to a measured acceleration of the body knowing the mass of the proof mass and the stiffness of the first and second flexure assemblies.
12. A hung mass accelerometer, comprising:
- a body having an internal cavity oriented along a longitudinal axis, said body formed of one or more materials having an effective body coefficient of thermal expansion (CTE);
 - 5 first and second flexures attached to the body at opposite ends of the internal cavity, said first and second flexures compliant along the longitudinal axis;
 - a proof mass between the first and second flexures to hang inside the internal cavity, said proof mass allowed to move along the longitudinal axis in an open-loop configuration;
 - 10 first and second sensor heads mounted on the body on opposite ends of the internal cavity along the longitudinal axis on opposite sides of the proof mass at distances d_1 and d_2 that increase and decrease in opposition as said proof mass moves along the longitudinal axis, each said sensor head having a reference coil responsive to an alternating drive signal to produce an oscillating primary magnetic field that induces
 - 15 Eddy currents in the proof mass that create an opposing secondary magnetic field that resists the primary magnetic field generated by the reference coil, any change in the distance between the reference coil and the proof mass causing a change in the magnetic field interaction that produces differential alterations to the alternating drive signal,
 - said first and second sensor heads formed of one or more materials having
 - 20 effective first and second sensors CTEs of 60-80% of the body CTE to approximately null the effects on the alternating drive signal of a body temperature gradient along the longitudinal axis.

13. The hung mass accelerometer of claim 12, wherein the body, the first and second flexures and the proof mass are integrally formed from a single piece of metal.

14. The hung mass accelerometer of claim 12, further comprising a mounting plate formed of the same material as the accelerometer body and attached to the accelerometer body to form a mounting surface of the accelerometer.

15. A hung mass accelerometer, comprising:

a body having an internal cavity oriented along a longitudinal axis, said body formed of one or more materials having an effective body coefficient of thermal expansion (CTE);

5 first and second flexures attached to the body at opposite ends of the internal cavity, said first and second flexures compliant along the longitudinal axis;

a proof mass between the first and second flexures to hang inside the internal cavity, said proof mass allowed to move along the longitudinal axis in an open-loop configuration, wherein said body, said first and second flexures and said proof mass are
10 integrally formed from a single piece of metal of either titanium or stainless steel;

first and second sensor heads mounted on the body on opposite ends of the internal cavity along the longitudinal axis on opposite sides of the proof mass at distances d_1 and d_2 that increase and decrease in opposition as said proof mass moves along the longitudinal axis, each said sensor head having a reference coil responsive to
15 an alternating drive signal to produce an oscillating primary magnetic field that induces Eddy currents in the proof mass that create an opposing secondary magnetic field that resists the primary magnetic field generated by the reference coil, any change in the distance between the reference coil and the proof mass causing a change in the magnetic field interaction that produces differential alterations to the alternating drive signal,

20 said sensor heads having a length L_s measure from an attachment point of the sensor head to the body that is between one-half a body length L_B and a full body length measured from the attachment point to a center line of the proof mass;

said first and second flexures configured to substantially thermally isolate the proof mass from the body;

25 said first and second sensor heads formed of one or more materials having effective first and second sensors CTEs of 60-80% of the body CTE such that the growth of said first and second sensor heads along the longitudinal axis is approximately equal and opposite the growth of said body along the longitudinal axis in response to a predicted body temperature gradient along the longitudinal axis to approximately null the effects on the alternating drive signal.

16. The hung mass accelerometer of claim 15, wherein the body, the first and second flexures and the proof mass are integrally formed from a single piece of metal.

17. The hung mass accelerometer of claim 15, further comprising a mounting plate formed of the same material as the accelerometer body and attached to the accelerometer body to form a mounting surface of the accelerometer.

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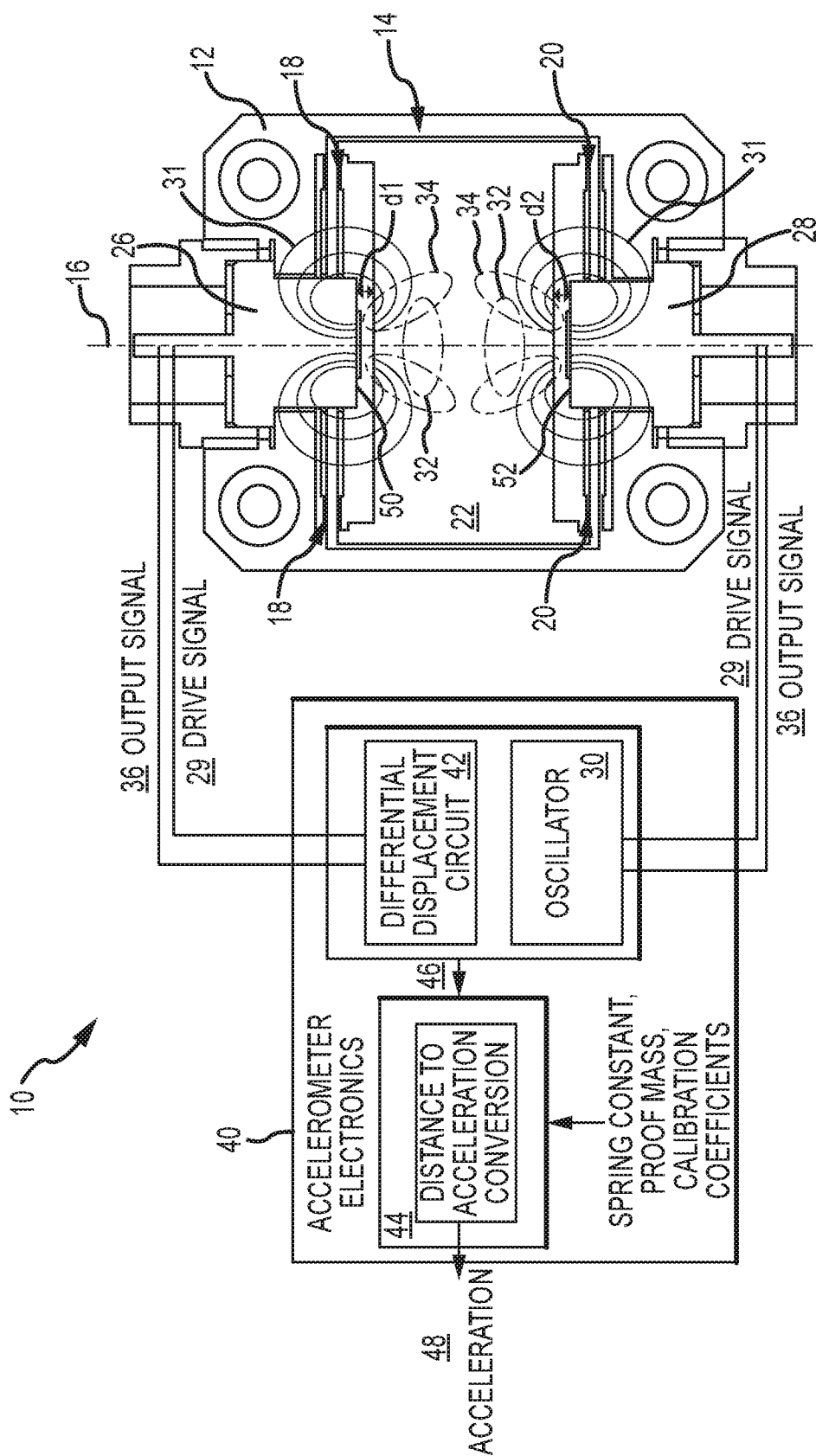


FIG.1

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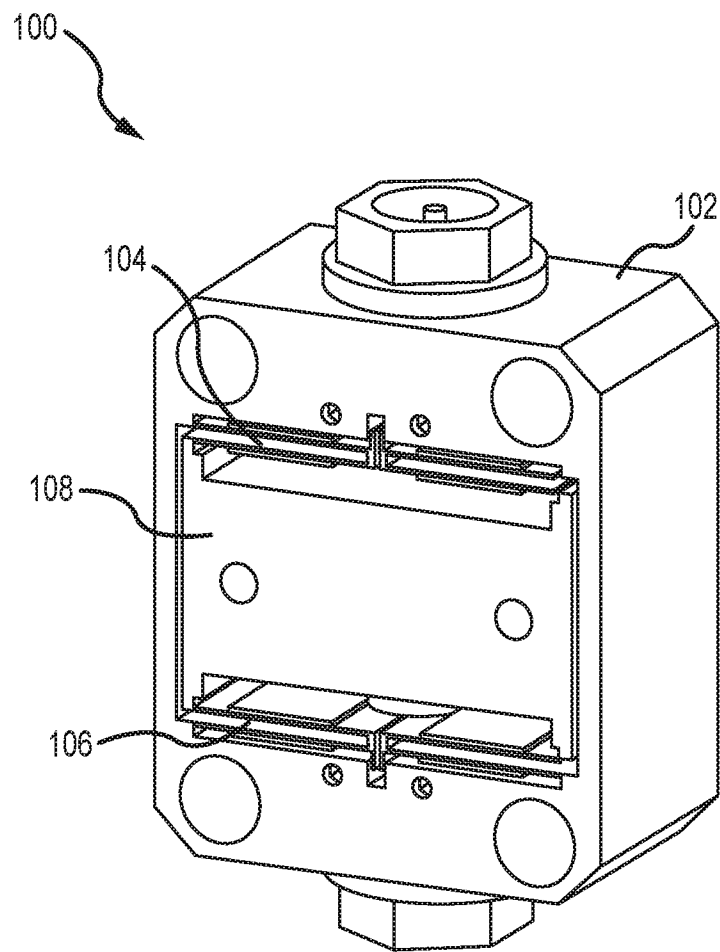


FIG.2a

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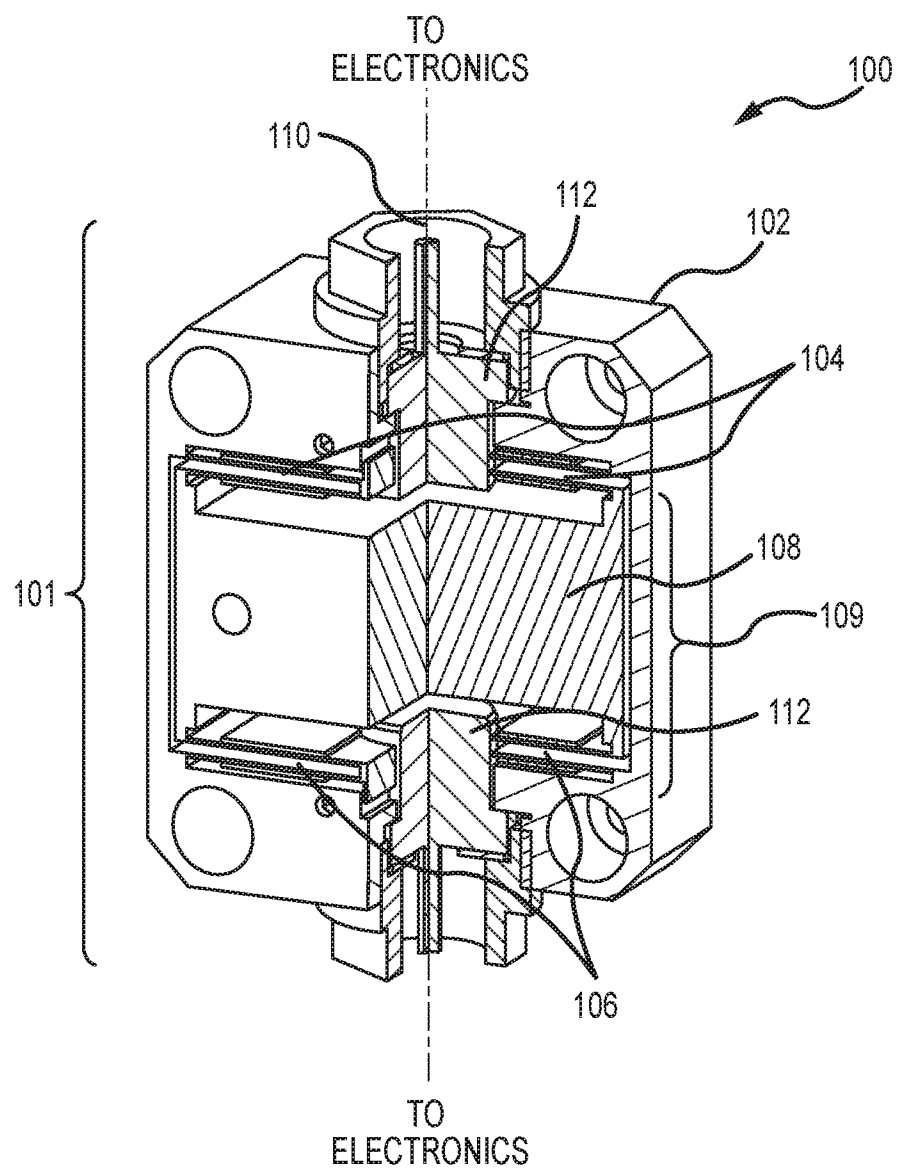


FIG.2b

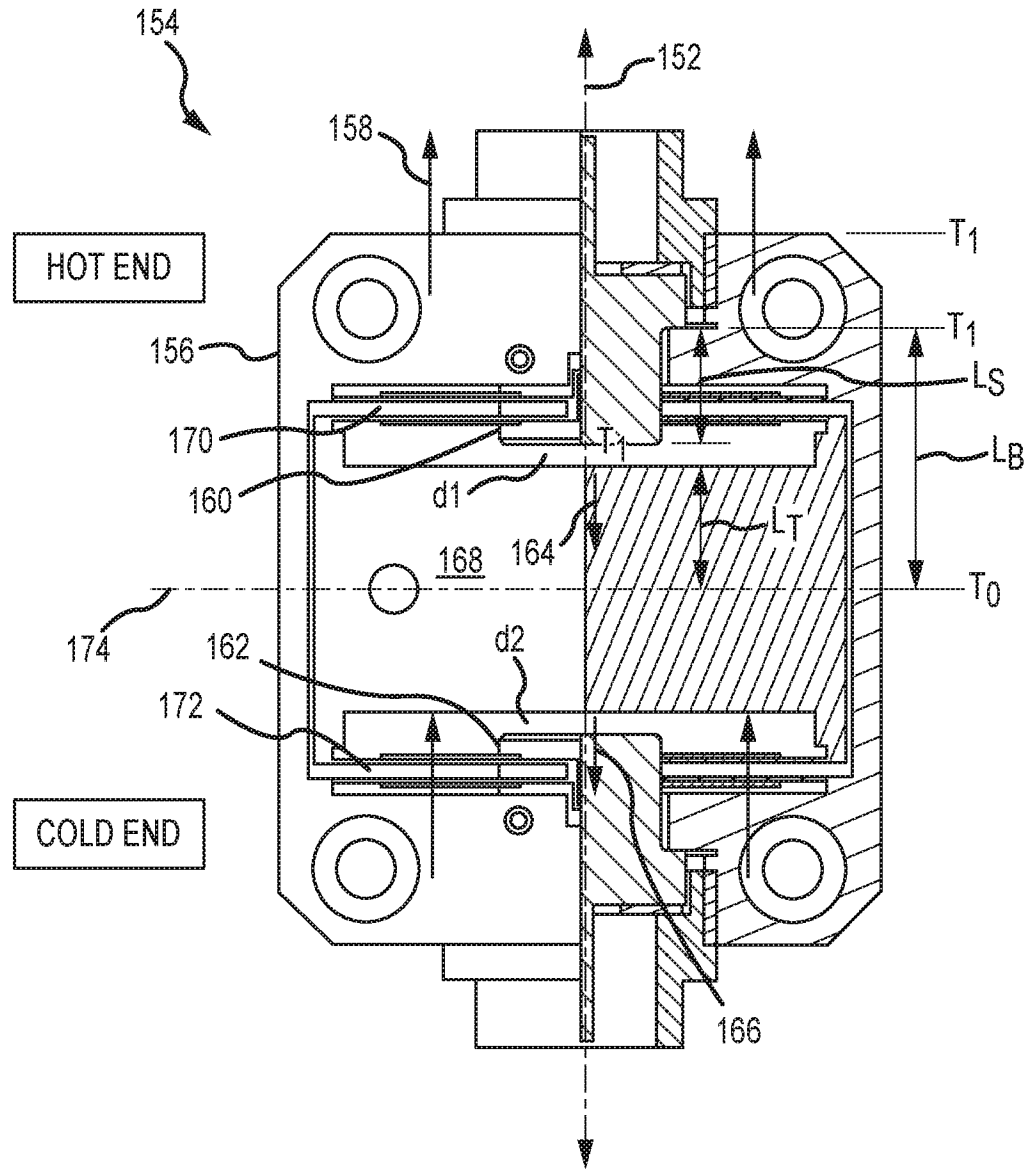


FIG.3a

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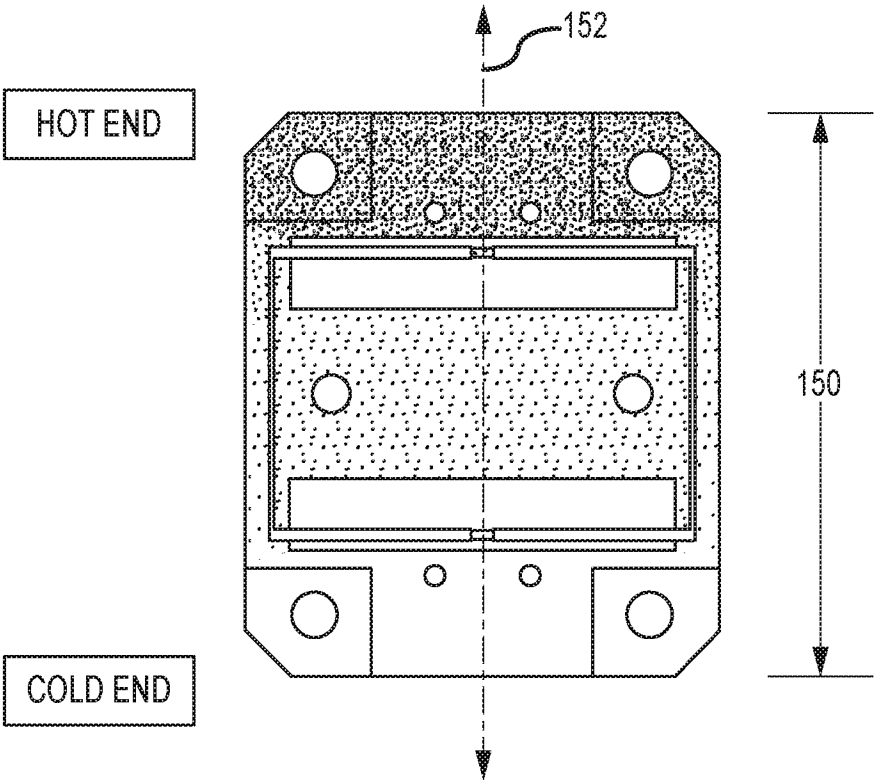


FIG.3b

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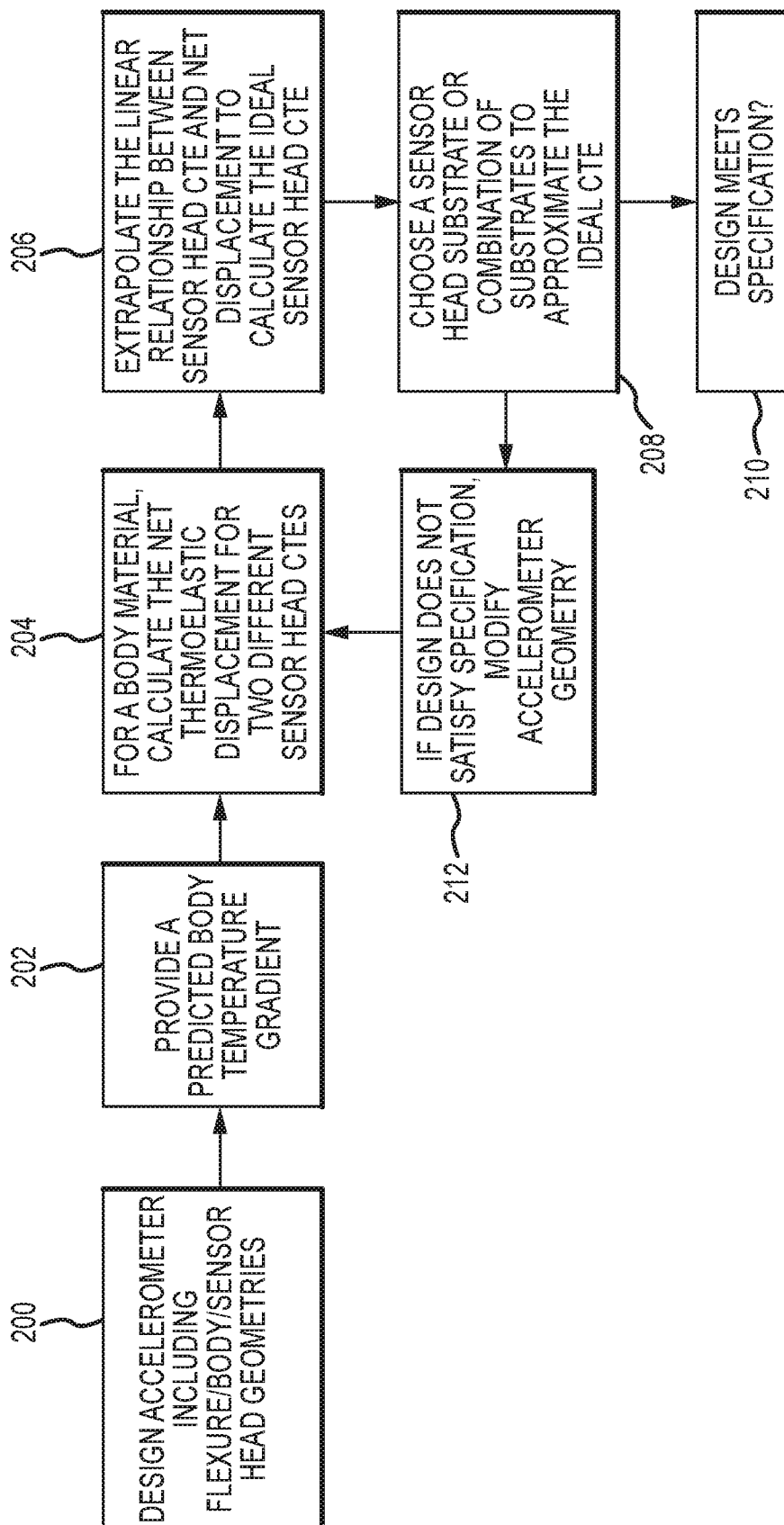


FIG.4

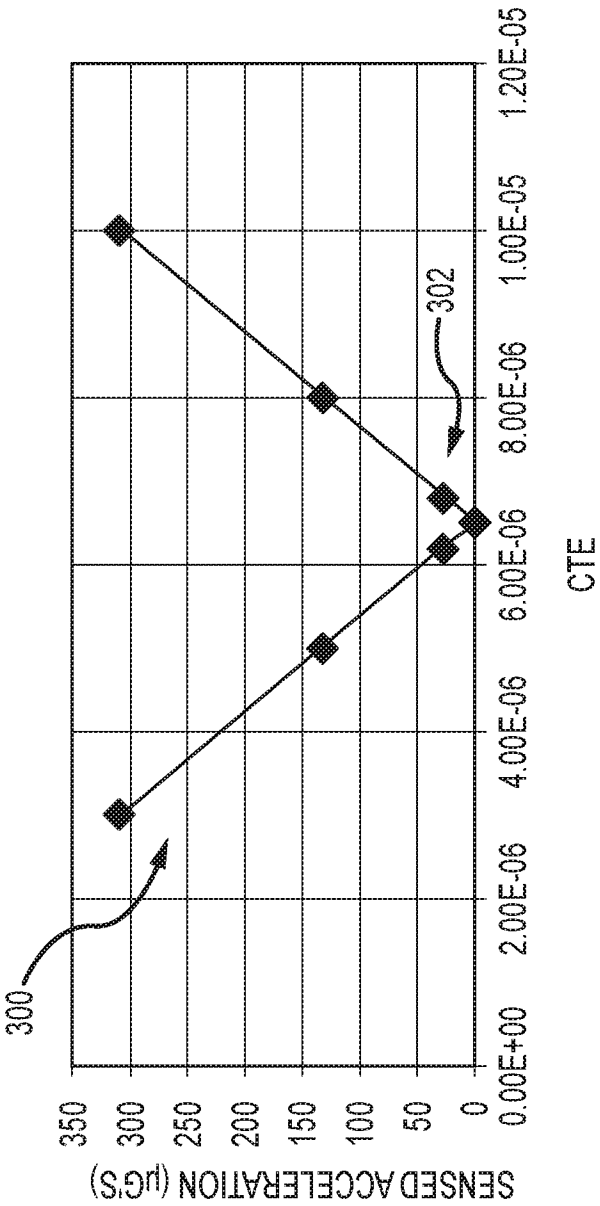


FIG.5

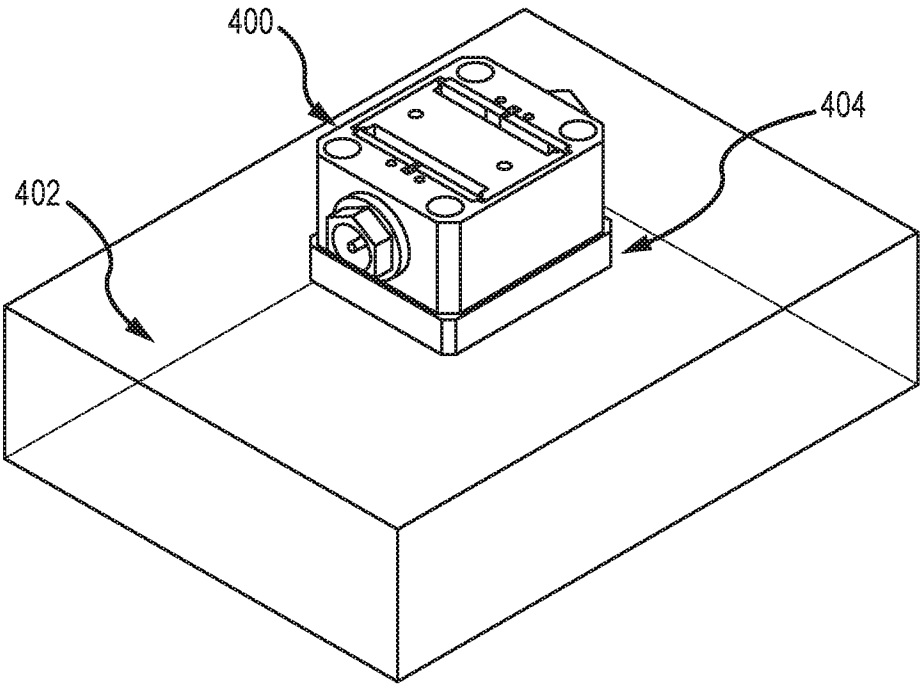


FIG.6

INTERNATIONAL SEARCH REPORT

International application No
PCT/US2017/030816

A. CLASSIFICATION OF SUBJECT MATTER
INV. G01P15/00 G01P15/11
ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
G01P

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EP0-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 2014/157897 A1 (ANAGNOST JOHN JOSEPH [US] ET AL) 12 June 2014 (2014-06-12) the whole document -----	1-17
Y	US 3 453 573 A (KYLE JAMES C) 1 July 1969 (1969-07-01) the whole document -----	1-17
A	US 2003/071612 A1 (DAALMANS GABRIEL [DE] ET AL) 17 April 2003 (2003-04-17) page 2, paragraph 19 - page 3, paragraph 32; figures 3, 4 -----	1-17
A	EP 0 816 855 A1 (VOLKSWAGEN AG [DE]) 7 January 1998 (1998-01-07) the whole document -----	1-17

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Further documents are listed in the continuation of Box C.

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See patent family annex.

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"&" document member of the same patent family

Date of the actual completion of the international search

5 July 2017

Date of mailing of the international search report

14/07/2017

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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/US2017/030816

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
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