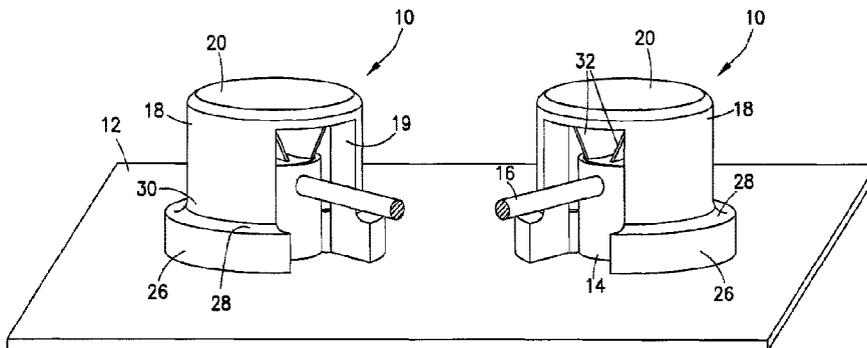




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(57) **Abrégé/Abstract:**

A holder for attaching an acoustic emission sensor to a non-metallic and non-magnetic material has a tubular body with a closed top end and an open bottom end through which the sensor is insertable into the tubular body. The closed top end has a plurality of unitary flexible flaps angularly extending inwardly from an inner surface of the enclosed top end. An inner surface of the tubular body has a plurality of spacers extending radially inward proximate the bottom end of the tubular body. The unitary flexible flaps and the spacers fix the sensor within the tubular body. The tubular body may also have a plurality of capture tabs extending outwardly from an exterior surface thereof proximate the open bottom end that are slidably and removably engageable with an engagement keyway in a retainer bracket that is affixed to a non-metallic and non-magnetic material.

## **ABSTRACT**

A holder for attaching an acoustic emission sensor to a non-metallic and non-magnetic material has a tubular body with a closed top end and an open bottom end through which the sensor is insertable into the tubular body. The closed top end has a plurality of unitary flexible flaps angularly extending inwardly from an inner surface of the enclosed top end. An inner surface of the tubular body has a plurality of spacers extending radially inward proximate the bottom end of the tubular body. The unitary flexible flaps and the spacers fix the sensor within the tubular body. The tubular body may also have a plurality of capture tabs extending outwardly from an exterior surface thereof proximate the open bottom end that are slidably and removably engageable with an engagement keyway in a retainer bracket that is affixed to a non-metallic and non-magnetic material.

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## ACOUSTIC EMISSION SENSOR HOLDER

### TECHNICAL FIELD

This disclosure generally relates to holders for maintaining the positioning and  
5 surface contact of sensors on an article during testing, and more particularly to  
acoustic emission sensor holders for use during environmental testing of non-  
metallic and non-magnetic materials, such as composite or ceramic materials.

### BACKGROUND

10 Environmental conditions may affect materials used to make vehicles and  
other types of structures intended for outdoor use or for use in extreme  
environments, such as aerospace structures that experience dynamic and various  
environmental changes throughout their service history (i.e., dry to wet, cold to hot).  
Environmental testing of such materials at less than 0°F and greater than 100°F, and  
15 from 0-100% humidity, is desired to identify, quantify and monitor the properties of  
such materials before, during and/or after one or more uses to determine if any  
damage to the materials has occurred.

One type of sensor that has been used for environmental testing, acoustic  
emission (or AE) sensors, interprets the radiation of acoustic (or elastic) waves in  
20 solid materials into usable AE waveforms that help understand how the materials  
behave. Such acoustic (or elastic) waves occur when a material undergoes changes  
in its internal structure, for example as a result of crack formation or plastic  
deformation due to aging, temperature gradients or external mechanical forces. The

waves generated by sources of acoustic emission are of practical interest in the fields of structural health monitoring, quality control, system feedback, process monitoring, analysis validation, and others, and may be used to detect, locate and characterize damage to the material. Acoustic emission sensors are therefore useful  
5 for detecting flaws and failures in materials and structures, and determining how to apply remedial solutions and repairs to resolve structural issues. In the aerospace field, acoustic emission sensing has been identified as a technology that can be scaled for enhanced fleet inspection from the laboratory setting, to the depot and to field applications. The focus is driven by the need to identify the existence of  
10 damage as a function of service hours for the fleet in order to make critical decisions regarding remaining life.

Acoustic emission sensors have been used to monitor aerospace and other structures. Traditional approaches for attaching acoustic emission sensors to the structure to be tested include using hot glue or magnetic clamping fixtures. Many  
15 commercially available holders for acoustic emission sensors are magnetic because acoustic emission has predominantly been done on metallic surfaces. Such magnetic holders will not function with non-metallic and non-magnetic composite materials. Hot glue does not have universal application, and does not work during environmental testing at temperatures less than **-65°F** and greater than **160°F** due to  
20 poor surface adhesion. Another solution has been to permanently attach acoustic emission sensors to a test article, but this approach is not feasible when testing large numbers of test articles due to expense and extended dwell time (greater than **10** hours per sensor) for curing an adhesive to affix the sensors to the test article.

Non-metallic and non-magnetic materials, such as composite materials, are now used in the manufacture of a wide variety of structures due to their high strength and rigidity, low weight, corrosion resistance and other favorable properties. For example, composite materials have become widely used to manufacture aerospace structures and component parts for aerospace structures such as aircraft ribs, spars, panels, fuselages, wings, wing boxes, fuel tanks, tail assemblies and other component parts of an aircraft because they are lightweight and strong, and therefore provide fuel economy and other benefits. The traditional approaches for attaching acoustic emission sensors to such non-metallic and non-magnetic materials are not effective.

Accordingly, there is a need for improved means for holding or attaching acoustic emission sensors to non-metallic and non-magnetic materials, such as composites and ceramics, during environmental testing of such materials that may provide advantages over known acoustic emission sensor holders.

## **SUMMARY**

The foregoing purposes, as well as others, may be achieved by an acoustic emission sensor holder that aligns and maintains the acoustic emission sensor flush with a surface of a non-metallic and non-magnetic material and is compatible with current ASTM standard test methods and test fixtures. The sensor holder may provide the capability of keeping the sensor in contact with the material during extreme conditions, and therefore may provide a pathway to obtain data across a wide range of environmental conditions that may be advantageous in progressive

damage structural analysis, field inspection, material characterization and laboratory level experimental validation.

In accordance with one embodiment, a holder for attaching an acoustic emission sensor to a non-metallic and non-magnetic material is disclosed. The holder is comprised of a tubular body having a closed top end and an open bottom end through which the sensor may be inserted into the tubular body. The closed top end is provided with a plurality of unitary flexible flaps angularly extending inwardly from an inner surface of the closed top end. An inner surface of the tubular body has a plurality of partial cylindrically-shaped spacers extending radially inward and upward from the open bottom end of the tubular body. The unitary flexible flaps and the spacers act together to fix the sensor within the tubular body and maintain its positioning within the holder.

The closed top end may have two of the unitary flexible flaps, each of the unitary flexible flaps extending angularly inwardly toward each other to provide a downward force onto a top surface of the sensor when the sensor is installed into the holder.

5           The holder may be a unitary 3-D printed structure.

There may be a recess in the tubular body that is peripherally open toward the open bottom end for receiving an electrical connection that protrudes radially from the sensor.

10          The holder may further include a base forming a lip peripherally around an exterior surface of the tubular body proximate the open bottom end to provide an interface surface for engaging the non-metallic and non-magnetic surface.

In another embodiment, there is provided a holder system for attaching an acoustic emission sensor to a non-metallic and non-magnetic material. The holder system comprises the holder described above wherein the tubular body has a plurality of capture tabs extending outwardly from an exterior surface of the tubular body proximate the open bottom end. The holder system further includes a retainer bracket having a lower surface for attachment to the non-metallic and non-magnetic material, a top capture surface, and an engagement keyway disposed between the lower surface and the capture surface. The plurality of capture tabs is configured to be slidably engageable with the engagement keyway in the retainer bracket in a rotary motion providing a removable locking engagement. This permits a user to readily install and remove a sensor from the holder, and to maintain positioning of the holder when replacing a sensor.

The holder may further comprise an attach pad positioned on the lower surface of the retainer bracket for affixing the holder to the non-metallic and non-magnetic material.

The holder and the retainer bracket may each be unitary 3-D printed structures.

5 In another embodiment, a positioning system for affixing acoustic emission sensors to a non-metallic and non-magnetic material is disclosed. In the positioning system, a plurality of the holder systems described above are retained together at a frange periphery around each of the retainer brackets in each of the holder systems. The frange periphery permits ready separation of adjacent holders by any separation means such as snapping adjacent retainer brackets apart, or cutting them apart on the border between adjacent frange peripheries.

10 The positioning system may further include at least one separator for connecting and positioning a plurality of the holder systems on the non-metallic and non-magnetic surface with predetermined spacing therebetween.

Each separator may have a plurality of arms positioned in a general X-formation.

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Ends of each of the arms in the separator may be engageable with the retainer brackets, such that each arm has a retainer bracket of the holder attached thereto.

The separator may be made from a flexible material that permits  
5 positioning of a plurality of holders on flat surfaces or surfaces having a curved or other complex shape.

A plurality of holder systems may be arranged in a desired configuration with predetermined spacing between the holder systems, and the desired configuration can then be moved from one non-metallic and non-magnetic  
10 material to another, or placed on a non-metallic and non-magnetic material to maintain positioning and permit ready replacement of sensors in the holders without disturbing the positioning of the holder systems.

In another embodiment, there is provided a method for affixing acoustic emission sensors to a non-metallic and non-magnetic material using the positioning system and holder systems, each of which is as described above. In the method, a holder system is separated from a plurality of holder systems that  
5 are retained together at a frange periphery around each of the holder systems and one or more retainer brackets of the one or more separated holder systems respectively are affixed to the non-metallic and non-magnetic material. A holder is removed from a retainer bracket by rotating the holder out of the engagement keyway in the retainer bracket. The acoustic emission sensor is inserted into the  
10 removed holder and the removed holder is installed on the retainer bracket by rotating the removed holder into the engagement keyway.

The method may further involve 3-D printing the cage and the retainer bracket.

The method may further involve engaging the retainer bracket of one of the  
15 holder systems with a respective one end of the separator and engaging the retainer bracket of another one of the holder systems at another end of the separator for positioning the plurality of the holder systems on the non-metallic and non-magnetic surface with predetermined spacing therebetween.

The lower surface of the retainer bracket of the separated holder system may be affixed to the non-metallic and non-magnetic material with, for example, vacuum bagging tape or other attachment means that can withstand environmental testing conditions. The holder may be removed from the retainer  
5 bracket prior to or after the retainer bracket is affixed to the non-metallic and non-magnetic material by rotating the holder out of the engagement keyway. A plurality of the holder systems may be positioned in various configurations on the non-metallic and non-magnetic surface with predetermined spacing therebetween by installing spacers having predetermined lengths and shapes between each of  
10 the holder systems, preferably before affixing the holder systems to the non-metallic and non-magnetic surface.

Other objects, features, and advantages of the various embodiments in the present disclosure will be explained in the following detailed description with reference to the appended drawings.

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## **BRIEF DESCRIPTION OF DRAWINGS**

**FIG. 1** is an illustration of a non-metallic and non-magnetic material having acoustic emission sensor holders and sensors affixed thereto prepared for environmental testing.

5           **FIG. 2** is an illustration of a bottom, front and right side perspective view of an acoustic emission sensor holder with an acoustic emission sensor therein.

**FIG. 3** is an illustration of another perspective view of the acoustic emission sensor holder shown in FIG. 2.

10           **FIG. 4** is an illustration of another embodiment of an acoustic emission sensor holder.

**FIG. 5** is an illustration of an arrangement of a plurality of the acoustic emission sensor holder shown in FIG. 4 as part of a system of the disclosure.

**FIG. 6** is an illustration of another embodiment of an acoustic emission sensor holder.

**FIG. 7** is an illustration of a plurality of acoustic emission sensor holders as shown in **FIG. 4** in a removable snap-fit configuration as part of a system of the disclosure.

**FIG. 8** is a block diagram of a method of the disclosure.

5       **FIGS. 9A-9D** are illustrations of alternative arrangements for a plurality of the acoustic emission sensor holders of this disclosure.

### **DETAILED DESCRIPTION**

In the following detailed description, various embodiments of acoustic  
10 emission sensor holders that maintain the positioning and contact of acoustic  
emission sensors during environmental testing (less than **0°F**, greater than **100°F**,  
and between **0-100 %** humidity) of non-metallic and non-magnetic materials  
including, but not limited to, composite or ceramic materials, are described with  
reference to aerospace structures to illustrate the general principles in the present  
15 disclosure. It will be recognized by one skilled in the art that the present disclosure  
may be practiced in other analogous applications or environments and/or with other  
analogous or equivalent variations of the illustrative embodiments. For example, the  
disclosed acoustic emission sensor holders may be used for environmental testing of  
any type of non-metallic and non-magnetic materials in any industry and may be  
20 used with non-metallic and non-magnetic materials of varying shapes, sizes and  
surface contours including test materials for environmental testing in laboratory or  
other controlled settings, and completed structures that employ such non-metallic  
and non-magnetic materials, such as aerospace structures and vehicles, and any

other structures for which environmental testing would be beneficial. Such environmental testing may be done during manufacture of the structures, after manufacture of the structures or during use of the structures. It should be noted that those methods, procedures, components, or functions which are commonly known to persons of ordinary skill in the field of the disclosure are not described in detail  
5 herein.

In FIGS. 1-3, an acoustic emission sensor holder **10** in accordance with one embodiment of the disclosure is shown affixed to a non-metallic and non-magnetic material **12** in the form of a test article or coupon (FIG. 1). The holder **10** has an  
10 acoustic emission sensor **14** installed therein with a sensor wire **16** (or electrical connection) protruding radially from the sensor **14** for connection to acoustic emission monitoring equipment (not shown). The holder **10** aligns a bottom surface **15** of the sensor **14** flush with a surface of the non-metallic and non-magnetic material **12** and permits use of current ASTM standard test methods and test  
15 equipment.

The holder **10** is in the shape of a tubular body **18** having a closed top end **20** and an open bottom end **22** that forms an interface surface **24** having an aperture **25** at the open bottom end **22** of the tubular body **18**. The sensor **14** is insertable into the tubular body **18** through the aperture **25**. A recess **19** in the tubular body **18** is  
20 peripherally open toward the aperture **25** at the open bottom end **22** for receiving the sensor wire **16** (or electrical connection) that protrudes radially from the sensor **14**, and may form a rectangular shape as shown or any other shape. The tubular body **18** also has a base **26** forming a lip **28** on top of the base **26** and peripherally around

an exterior surface **30** of the tubular body **18** that expands the size of the interface surface **24** at the open bottom end **22** to provide sufficient surface area for sealant tape (described below).

The closed top end **20** has a plurality of unitary flexible flaps **32** extending  
5 angularly inwardly from an inner surface **34** of the closed top end **20**. Here, two of the unitary flexible flaps **32** are shown, each extending angularly inwardly toward each other to provide a force to push down on a top surface of the sensor **14** when the sensor **14** is installed into the holder **10**. An interior surface **36** of the tubular body **18** has a plurality of spacers **38** extending radially inward proximate the open  
10 bottom end **22**. The unitary flexible flaps **32** and the spacers **38** act together to fix the sensor **14** within the tubular body **18**, and may be formed in any shape and size that provides the ability to fix the sensor **14** within the tubular body **18**. For example, the spacers **38** may be formed in a partial cylindrical-shape protruding from the interior surface **36** of the tubular body **18** and extending upward from the open  
15 bottom end **22** as shown in the drawings, or the spacers **38** may be formed in a partial spherical-shape, oval-shape, or rectangular shape. In addition to the round cross-sectional shape of the tubular body **18** as shown, the holder **10** may also be formed to have a cross-sectional shape that is square, rectangular or another curved shape to accommodate different shaped sensors **14**.

20 The holder **10** is preferably formed with a flexible material as a unitary three-dimensional (**3-D**) printed structure. **3-D** printing, also known as stereolithography or additive manufacturing, is a printing technology that uses computer-controlled lasers to build three-dimensional structures from liquid polymers and other materials. The

holders **10** disclosed herein are preferably made from a flexible material. Because the unitary flexible flaps **32** at the closed top end **20** of the tubular body **18** and the spacers **38** are made from a flexible material, the holder **10** can accommodate sensors **14** of varying heights and diameters.

5           The flexible material that forms the holder **10** and its parts should be ductile or flexible enough that the unitary flexible flaps **32** can bend but not snap when the sensor **14** is placed into the holder **10**, and should have some stiffness to provide the downward force on the sensor **14**. The flexible material should also be lightweight and have a wide range of operating temperatures to withstand environmental testing  
 10 conditions, such as composite testing temperatures in the range from about **-60°F** to **150°F**. A flexible material having properties in the ranges shown in Table I could be used to form the holders described in the present disclosure:

TABLE I – MATERIAL PROPERTIES	
Flexural Modulus	<b>2.1 to 7.6 GPa (0.3 to 1.1 x 10<sup>6</sup> psi)</b>
Flexural Strength	<b>72 to 97 MPa (10 to 14 x 10<sup>3</sup> psi)</b>
Strength to Weight Ratio	<b>37 to 79 kN m/kg</b>
Tensile Strength: Ultimate (UTS)	<b>37 to 110 MPa (5.4 to 16 x 10<sup>3</sup> psi)</b>
Melting Temperature	Around <b>385°F</b>
Embrittlement	<b>-168°C</b>

Embrittlement is the temperature at which the material losses ductility, making it  
 15 brittle. The melting temperature and embrittlement properties may be adjusted depending on the environmental conditions being tested. One material that has

these properties and may be 3-D printed is ABS (Acrylonitrile-Butadiene-Styrene). ABS is a thermoplastic material further classified as styrenic plastic.

The holder **10** is affixed to the non-metallic and non-magnetic material **12** using vacuum bag, sealant tape, or a permanent sealant, which may be positioned  
5 on the interface surface **24** at the open bottom end **22** of the tubular body **18**. Vacuum bag or sealant tapes should be able to withstand environmental testing conditions, and have short (less than **5** minutes) adhering time. Suitable tapes for this purpose are commercially available, for example, the sealant tapes available  
10 from the Airtech Advanced Materials Group of Airtech International, Inc., Huntington Beach, California, under the trade names GS-**95**, AT-**199**, AIRSEAL **2**, AIRSEAL **3W**, AIRSEAL DB, GS-**100**, AT-**200Y**, GS-**213**, GS-**213** Tacky, GS-**333**, GS-**213-3**, GS-**43MR**, VBS-**750** and A-**800-3G**. Such sealant tapes are typically available in rolls and are easy to cut and position in desired locations. When affixing the holder **10** to the non-metallic and non-magnetic material **12**, it is also beneficial to apply  
15 vacuum grease or another coupling agent between the sensor **14** and the surface of the non-metallic and non-magnetic material **12** to couple the acoustic energy between the non-metallic and non-magnetic material **12** and the sensor **14** or more closely match the acoustic impedance of the disparate materials (e.g. to remove the air boundary by using a coupling agent).

20 An alternative holder **40** for attaching an acoustic emission sensor **14** to a non-metallic and non-magnetic material **12** and various systems **42**, **44** using the alternative holder are shown in FIGS. **4-7**. The alternative holder **40** comprises two parts – a cage **46** and a retainer bracket **48** – removably enagagable with each other

by rotating the cage **46** into and out of engagement with retainer bracket **48**. The cage **46** and the retainer bracket **48** are each unitary 3-D printed structures using the flexible materials described above, and may be manufactured individually or in groups of alternative holders **40**, as shown in FIG. 7, to have a modular assemblage **41**. In the modular assemblage **41**, the plurality of alternative holders **40** are retained together at a frange periphery **49** around each of the retainer brackets **48** in each of the alternative holders **40**. The frange periphery **49** permits separation of adjacent alternative holders **40**. Each alternative holder **40** may be readily separated from the other alternative holders **40** in the modular assemblage **41** by snapping them apart or using a knife or scissor to cut them apart. The modular assemblage **41** of alternative holders **40** shown in FIG. 7 may also be used as a group on a non-metallic and non-magnetic material **12** to provide minimum spacing between sensors **14**.

In this configuration, one or more the retainer brackets **48** may be affixed to a non-metallic and non-magnetic material **12** and a sensor **14** may be easily installed into or removed from the alternative holder **40** by simply rotating the cage **46** and removing it from the retainer bracket **48**. This permits sensors **14** to be replaced while maintaining the positioning and configuration of the retainer brackets **48** (and thus the sensors **14**) on the non-metallic and non-magnetic material **12**. There is no need to remove the retainer bracket **48** from the non-metallic and non-magnetic material **12**.

The cage **46** of the alternative holder **40** has a similar configuration to the holder **10** with a tubular body **18** having a closed top end **20** and an open bottom

end **22** through which the sensor **14** is inserted into the tubular body **18**. The closed top end **20** of the tubular body **18** has a plurality of unitary flexible flaps **32** angularly extending inwardly from an inner surface **34** of the closed top end **20**, and an interior surface **36** of the tubular body **18** has a plurality of partial cylindrically-shaped spacers **38** extending radially inward and upward from the open bottom end **22** of the tubular body **18**, for fixing the sensor **14** within the tubular body **18**. As in the holder **10** shown in FIGS. 1-3, FIGS. 4-7 show a closed top end **20** with two of the unitary flexible flaps **32**, each of the unitary flexible flaps **32** extending angularly inwardly toward each other to provide a downward force onto a top surface of the sensor **14** when the sensor is installed into the alternative holder **40**.

The exterior surface **30** of the tubular body **18** near the open bottom end **22** of the cage **46** of the alternative holder **40** has a different configuration than that shown in the holder **10**. Instead of the base **26**, the cage **46** in the alternative holder **40** has a plurality of capture tabs **50** extending outwardly from the exterior surface **30** of the tubular body **18** to provide a generally flat surface **52** in a plane generally perpendicular to the plane of the tubular body **18** proximate the open bottom end **22**. The capture tabs **50** are used to removably engage the cage **46** to the retainer bracket **48**. FIG. 4 shows three capture tabs **50** positioned around the exterior surface **30** of the tubular body **18**, but any number can be used depending on the diameter of the cage **46**.

The retainer bracket **48** has a lower surface **54** for attachment to the non-metallic and non-magnetic material **12**, a top capture surface **56** and an engagement keyway **58** disposed between the lower surface **54** and the capture surface **56** in an

aperture **60** through the retainer bracket **48**. The plurality of capture tabs **50** of the cage **46** are slidably engagable with the engagement keyway **58** in the retainer bracket **48** in a rotary motion (in the direction shown by arrow A in FIG. 4) to provide a removable locking engagement between the cage **46** and the retainer bracket **48**.

5 A stop may be provided in the engagement keyway **58** to provide notice to the user that the cage **46** is locked into the retainer bracket **48**. In other embodiments, the cage **46** may be configured to snap into the retainer bracket **48** without rotating, and provide removal by squeezing the sides of the tubular body **18** or other means for removing a snap-fitted part.

10 The lower surface **54** of the retainer bracket has the form of an attach pad or leg. A sealant tape as described above is adhered to the lower surface **54** of the retainer bracket **48** for affixing the alternative holder **40** to a non-metallic and non-magnetic material **12**.

In the systems **42**, **44** shown in FIGS. 5-6 the alternative holders **40** are separated from the modular assemblage **41** shown in FIG. 7 and arranged in an array with predetermined spacing. The predetermined spacing between each of the alternative holders **40** is provided by a separator **62** having a plurality of arms **64** positioned, for example, in an X-formation generally perpendicular to each other. Configurations other than X-formations may also be used, such as a straight separator without a crossing arm, or a separator configured to have a spider shape, a triangle, a circular pattern or a free-form pattern. Examples of such alternative patterns are shown in FIGS. 9A-9D. The shape, size and configuration options should be adaptive to the structural requirements. For example, when a repair patch

is used for aerospace structures comprising a non-metallic and non-magnetic material **12**, the repair patch is typically in the form of an ellipsoidal or circular geometry. The separators **62** could be configured to provide a network extending around the perimeter to bound the patch. There are multiple array geometries that  
5 may be conceived wherein the density of sensors in a particular area may be adjusted based on structural need, which may be due to known damage morphology or size, structure features and geometry, or the need for quick modifications of the sensor network during use. The systems **42**, **44** and variations thereof that are disclosed herein are readily adaptive to meet such structural needs. In another  
10 example, a long strip or rope of sensors, as shown in FIG. **9D**, may be provided to wrap along a wing, spar, rib, skin of an aircraft or any other type of surface, and be positioned in any desired configuration.

Ends **66** of each of the arms **64** are engageable with a plurality of retainer brackets **48** for positioning a plurality of the alternative holders **40** on the non-  
15 metallic and non-magnetic material **12** with predetermined spacing therebetween. A plurality of separators **62** is used with a plurality of alternative holders **40** to make a wide variety of configurations for the array of alternative holders **40**. The separators **62** comprise a flexible material (as described above) that permits positioning of the plurality of alternative holders **40** with predetermined spacing on flat surfaces, curved  
20 surfaces or surfaces of a non-metallic and non-magnetic material **12** with complex geometric shapes, and permits the entire configuration of sensors to actuate and move with the surface (for example, during fatigue loading, or during actual service use, or such that the entire configuration of sensors may be used between two parts

that actuate with respect to each other) The separators **62** may be attached to the alternative holders **40** in any way known for attaching flexible materials together. For example, adhesives may be used, the ends **66** of the arms **64** can be configured to snap together or to mate together in other ways. The system of FIG. **5** shows an embodiment that uses an adhesive to affix the ends **66** of the arms **64** to corners of the frange periphery **49** of the retainer brackets **48**. The system of FIG. **6** shows an embodiment that uses a snap-fit attachment means where the corners of the retainer bracket **48** have a bulbous cutout **67** that accommodates a bulbous end **68** of the arms **64** of the separator **62**.

10 In a method **100** for affixing acoustic emission sensors to a non-metallic and non-magnetic material, referring to FIG. **8**, a plurality of alternative holders **40** are used with a plurality of separators **62** to form a sensor holder array that is affixed to a non-metallic and non-magnetic material **12**, which may be a test article or a completed structure, before, during or after manufacture and use of such structure.

15 In step **102** of the method, an alternative holder **40** is separated from a plurality of alternative holders **40** that are retained together in a modular assemblage **41** at a frange periphery **49** around the retainer brackets **48** of each of the alternative holders **40**. In step **104**, the retainer bracket **48** of the separated alternative holder is affixed to the non-metallic and non-magnetic material with a sealant tape as described above. In step **106**, the cage **46** of the alternative holder **40** is removed

20 from the retainer bracket **48** by rotating the cage **46** out of the engagement keyway **58**. A sensor **14**, such as an acoustic emission sensor, is then inserted into the tubular body **18** of the cage **46** in step **108** and, in step **110**, the cage **46** with the

installed sensor **14** is engaged with the retainer bracket **48** by rotating the cage into the engagement keyway **58** in the direction shown by the arrow A in FIG. **4**.

In a further embodiment of the method **100**, the step **103** may be added to create an array of sensor holders with predetermined spacing between each sensor holder. In step **103A**, the retainer bracket **48** of one of the alternative holders **40** is engaged with one end **66** of a separator **62** having a plurality of arms **64** positioned in an X-formation, and the retainer bracket **48** of another of the alternative holders **40** is engaged at another end **66** of the separator **62**. The array of alternative holders **40** with predetermined spacing is then affixed to the non-metallic and non-magnetic material **12** in step **104**.

A kit may be provided that includes a plurality of alternative holders **40** connected together in a modular assemblage **41**, at least one separator **62** and sealant tape.

The holders and separators disclosed herein provide a cost and time efficient system and method for affixing sensors, such as acoustic emission sensors, to a non-metallic and non-magnetic material. The holders do not require additional assembly such as springs and screws, and the systems are scalable to account for variations in sensor size and test configurations, and may be used in a wide range of temperature conditions suitable for environmental testing at testing scales ranging from test article or coupon level to complete structures, such as aircraft, and any testing condition, from laboratory to field/depot, thus providing acoustic emission data from diverse environmental conditions.

Many other modifications and variations may of course be devised given the above description of various embodiments for implementing the principles in the present disclosure. For example, and without limitation, the geometry of the sensor holder **10** and the cage **46** and retainer bracket **48** of the alternative sensor holder **40** may be designed to conform to the size and geometry of any type of acoustic sensor **14**. The retainer bracket **48** may be fabricated and unitized in any modular assembly to provide different group assemblages, the separator lengths may be altered to form any array shape or geometry to cover targeted structural areas with higher or lower density of sensor placement. The adherent (such as vacuum tape etc.) may be pre-applied to the retainer bracket **48** on an individual or on a group basis and sealed so as to preserve the tacky/sticky end for adhering to a surface of a non-metallic and non-magnetic material **12**. – This embodiment would be provided as a pre-packaged kit containing all required parts for rapid use. The arms **64** of the separators **62** may be designed so as to snap, clip, press, into place into the retainer bracket **48**. In other embodiments, the retainer bracket **48** and cage **46** could be a monolithic/1-piece construction to reduce the number of parts for a specific acoustic sensor type/geometry. The width and geometry of the separator **62** may be further designed to provide non-symmetric configurations of any network or array geometry (such as spider-web, circular, triangular, diamond, linear, or curved as shown in FIGS. **9A-9D**, or any other configuration). Such non-symmetric configurations may be designed to cover a desired structural geometry/configuration (e.g. to cover the surface area of a doubler, the perimeter of a known damage region, or boundaries of a repair patch), with a mix of cages **46** and retainer brackets **48** available to create a

network of multiple sensor sizes. The separator **62** and retainer bracket **48** may also be formed as a monolithic/**1**-piece unit. It is intended that all such modifications and variations be considered as within the spirit and scope of this disclosure, as defined in the following claims.

5

**EMBODIMENTS IN WHICH AN EXCLUSIVE PROPERTY OR PRIVILEGE IS CLAIMED ARE DEFINED AS FOLLOWS:**

1. A holder for attaching an acoustic emission sensor to a non-metallic and non-magnetic material, the holder comprising a tubular body having a closed top end and an open bottom end through which the sensor is insertable into the tubular body, the closed top end having a plurality of unitary flexible flaps angularly extending inwardly from an inner surface of the enclosed top end, an inner surface of the tubular body having a plurality of spacers extending radially inward proximate the bottom end of the tubular body, the unitary flexible flaps and the spacers fixing the sensor within the tubular body.
2. The holder of claim 1, wherein the closed top end has two of the unitary flexible flaps, each of the unitary flexible flaps extending angularly inwardly toward each other to provide a downward force onto a top surface of the sensor when the sensor is installed into the holder.
3. The holder of claim 1, wherein the holder is a unitary 3-D printed structure.
4. The holder of claim 1, further comprising a recess in the tubular body that is peripherally open toward the open bottom end for receiving an electrical connection that protrudes radially from the sensor.
5. The holder of claim 1, further comprising a base forming a lip peripherally around an exterior surface of the tubular body proximate the open bottom end to provide an interface surface for engaging the non-metallic and non-magnetic surface.

**6.** A holder system for attaching an acoustic emission sensor to a non-metallic and non-magnetic material, the system comprising:

5           the holder of any one of claims **1** to **3** wherein the tubular body of the holder has a plurality of capture tabs extending outwardly from an exterior surface of the tubular body proximate the open bottom end; and

10           a retainer bracket having a lower surface for attachment to the non-metallic and non-magnetic material, a top capture surface and an engagement keyway disposed between the lower surface and the capture surface;

15           the plurality of capture tabs slidably engageable with the engagement keyway in the retainer bracket in a rotary motion providing a removable locking engagement.

20           **7.** The holder system of claim **6**, further comprising an attach pad positioned on the lower surface of the retainer bracket for affixing the holder to the non-metallic and non-magnetic material.

**8.** The holder system of claim **6**, wherein the holder and the retainer bracket are each unitary **3-D** printed structures.

25           **9.** A positioning system for affixing acoustic emission sensors to a non-metallic and non-magnetic material, the positioning system comprising a plurality of the holder systems of any one of claims **6** to **8** retained together at a frange

periphery around each of the retainer brackets of each of the holder systems, the frange periphery permitting separation of adjacent holders.

5 **10.** The positioning system of claim **9**, further comprising a separator engageable with the retainer brackets of a plurality of the holder systems, for positioning a plurality of the holders on the non-metallic and non-magnetic surface with predetermined spacing therebetween.

10 **11.** The positioning system of claim **10**, wherein the separator comprises a flexible material that permits positioning of the plurality of holders with predetermined spacing on a flat or curved surface of the non-metallic and non-magnetic material.

15 **12.** A method for affixing acoustic emission sensors to a non-metallic and non-magnetic material comprising the steps of:

separating one or more holder systems, each of which is as claimed in any one of claims **6** to **11**, from a plurality of such systems retained together at a frange periphery around each of the systems;

20 affixing one or more of the retainer brackets of one or more separated systems respectively, to the non-metallic and non-magnetic material;

removing a holder from a retainer bracket by rotating the holder out of the engagement keyway in the retainer bracket;

25 inserting the acoustic emission sensor into the removed holder; and

installing the removed holder on the retainer bracket by rotating the removed holder into the engagement keyway.

- 5    **13.** The method of claim **12**, further comprising the steps of **3-D** printing the holder and the retainer bracket.
- 10    **14.** The method of claim **12**, when claim **12** is dependent on claim **10** or **11** further comprising the step of engaging the retainer bracket of one of the holder systems with a respective one end of the separator and engaging the retainer bracket of another one of the holder systems at another end of the separator for positioning the plurality of the holder systems on the non-metallic and non-magnetic surface with predetermined spacing therebetween.
- 15    **15.** The method of claim **13**, when claim **13** is dependent on claim **10** or **11**, further comprising the step of engaging the retainer bracket of one of the holder systems with a respective one end of the separator and engaging the retainer bracket of another one of the holder systems at another end of the separator for positioning the plurality of the holder systems on the non-metallic and non-magnetic surface with predetermined spacing therebetween.
- 20

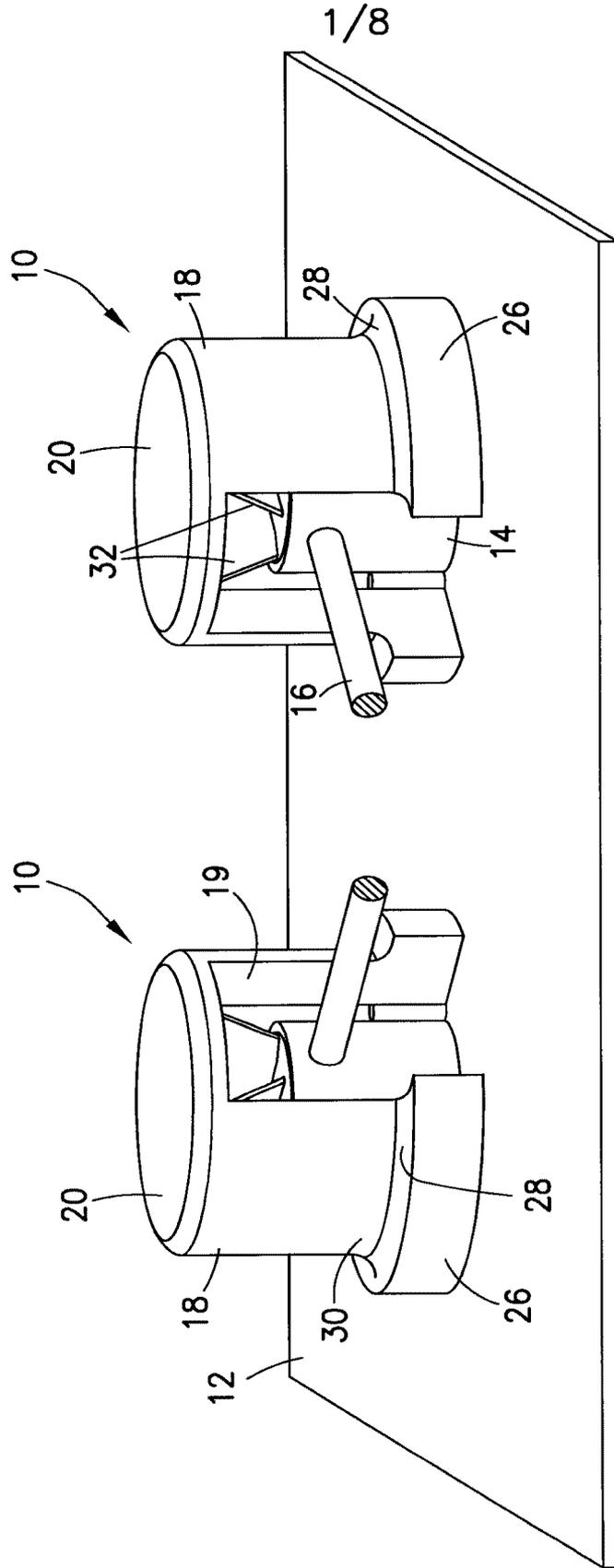


FIG. 1

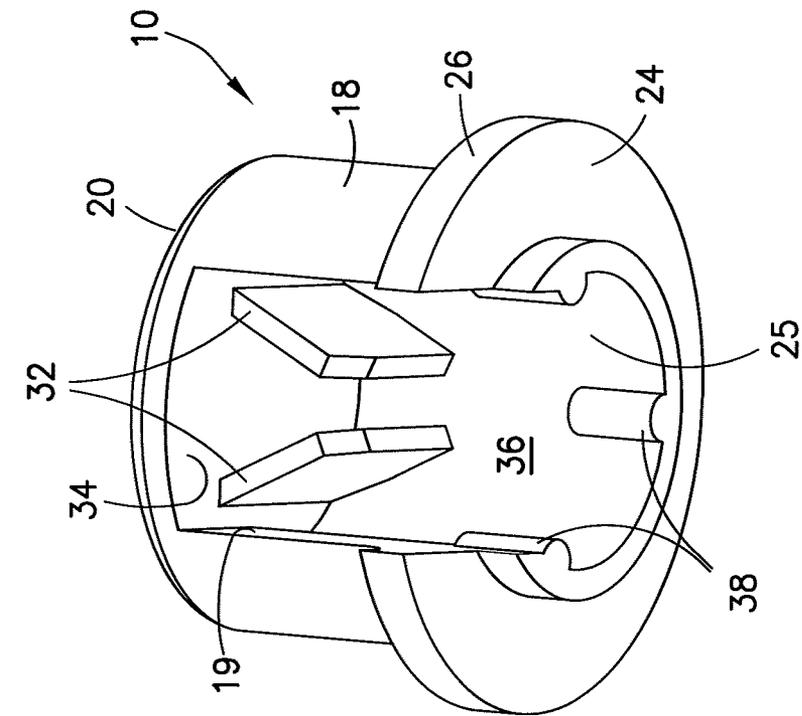


FIG. 2

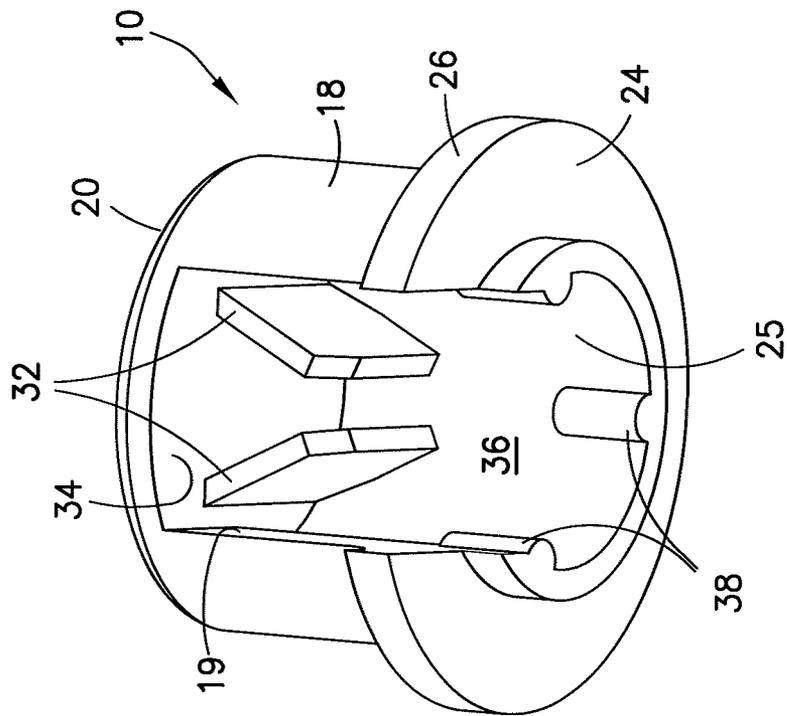


FIG. 3

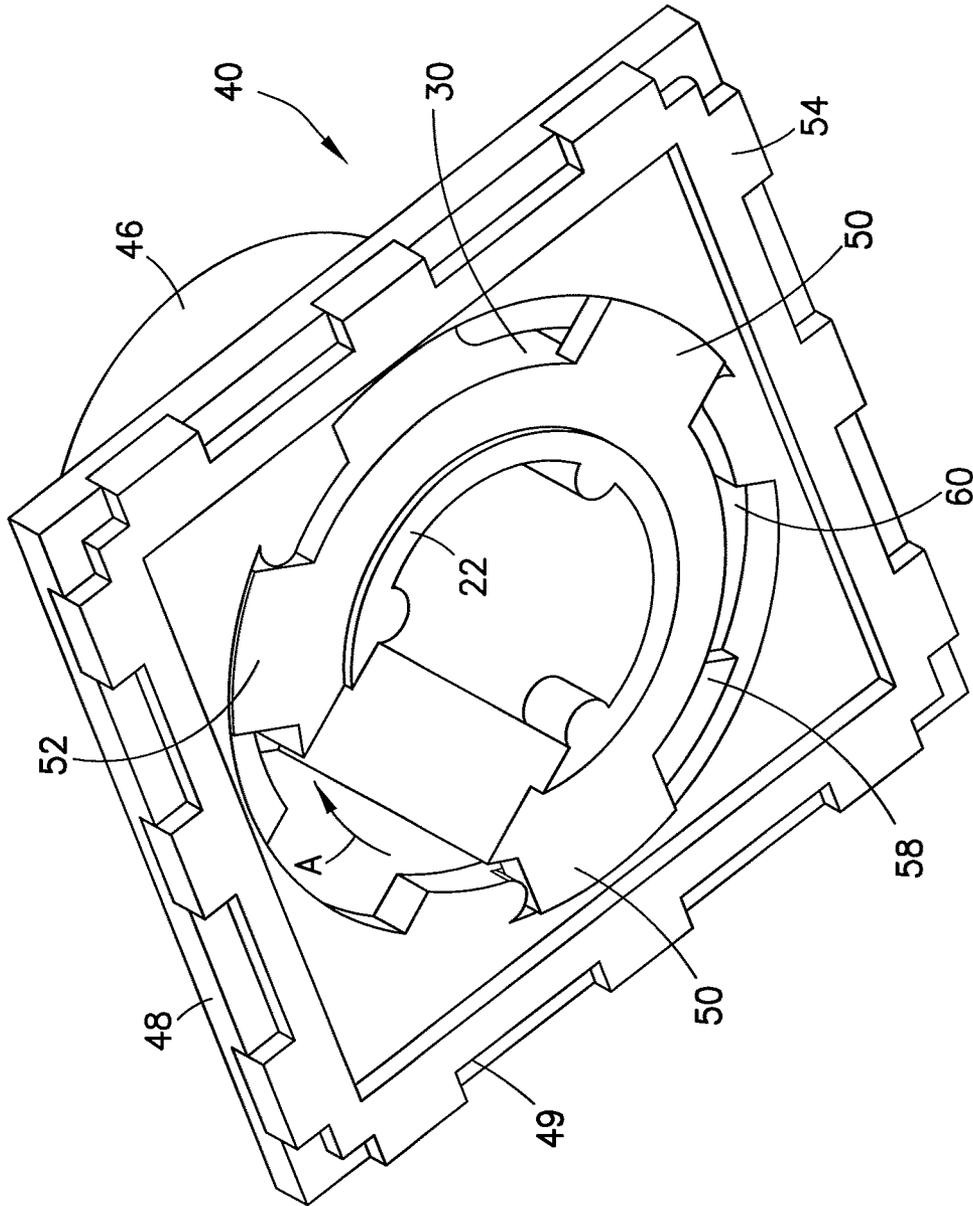


FIG.4

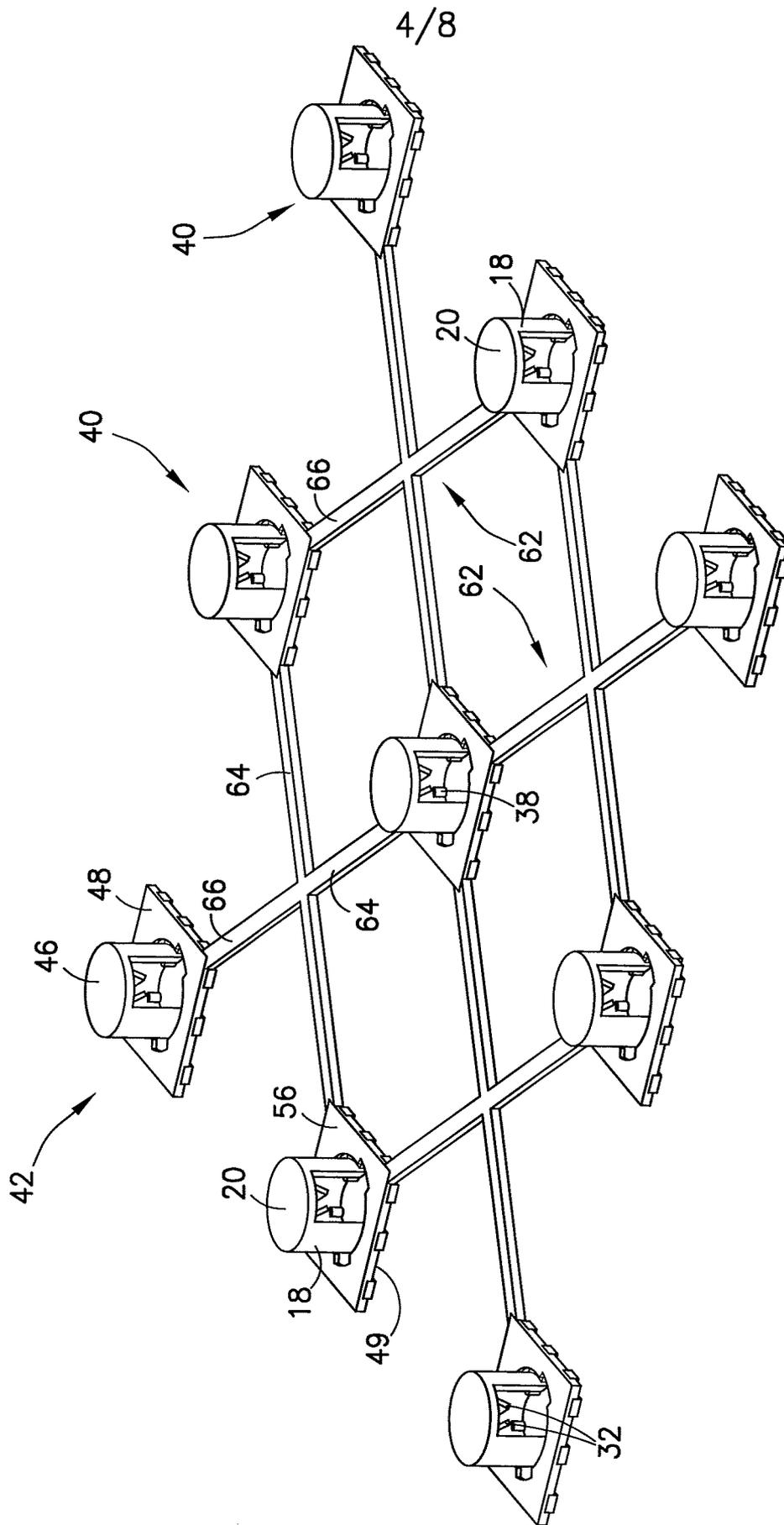


FIG.5





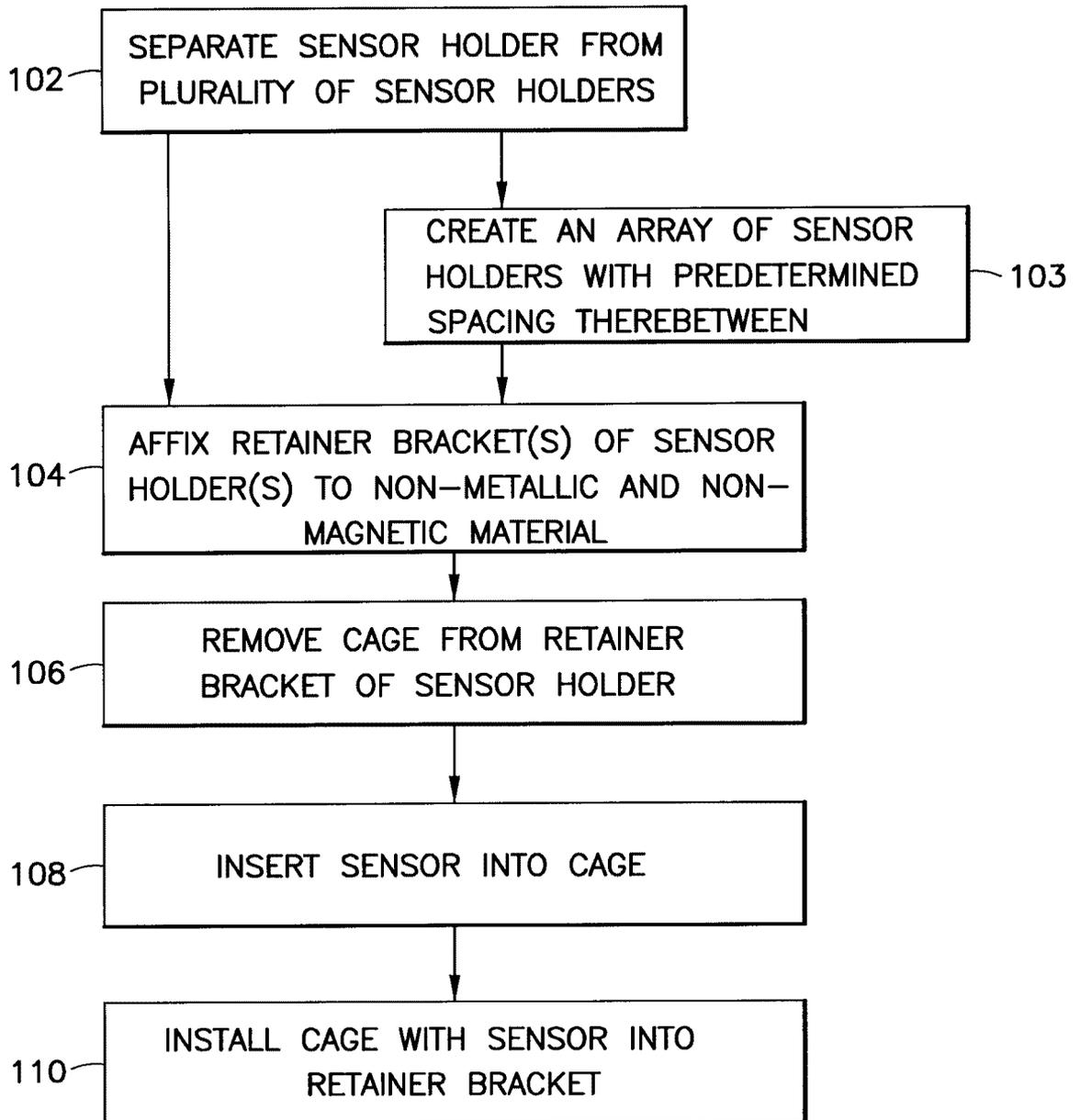


FIG.8

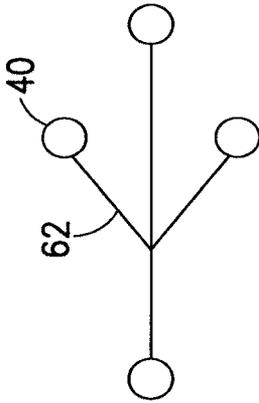


FIG. 9A

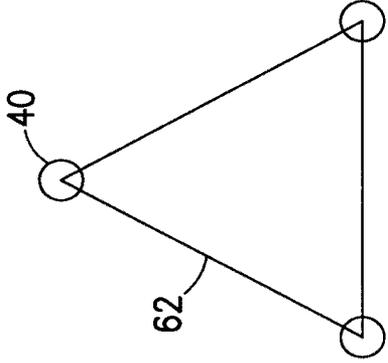


FIG. 9C

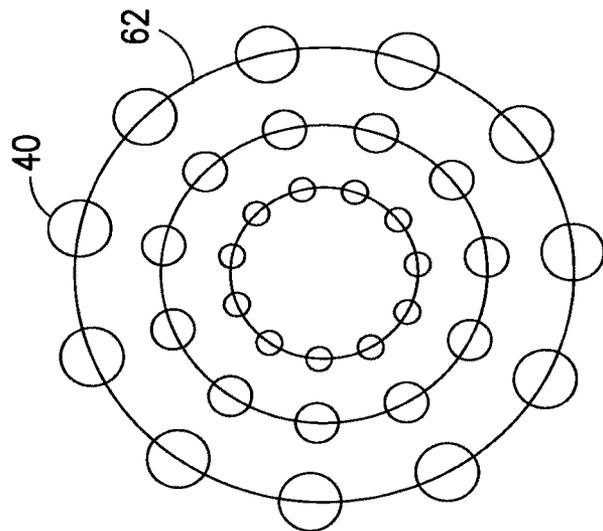


FIG. 9B

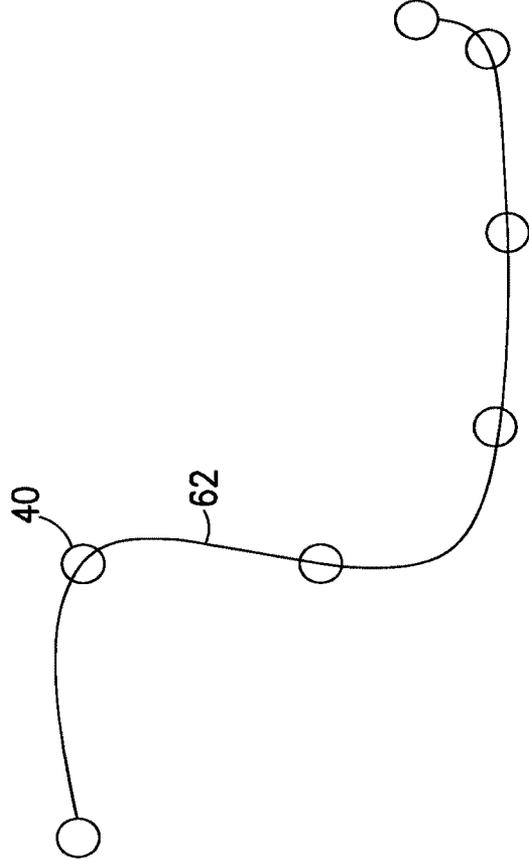


FIG. 9D

