APPENDIX 2

PROJECT THOROUGH REPORTS

The following draft copies of the various reports are presented in full in the order they are filed¹. Some of the pages have been cut to fit pagination.

CONFIDENTIAL ZIA DRAFT E5669/3/23 TOI C/RAD C. Best Ext. 348 then file 5826/2/2 FROM: ENGINEERING WING WEAPONS RESEARCH ESTABLISHMENT Oct by SUBJECT: PROJECT THOROUGH Communications and Electronic Engineering Division has been proceeding with the design and development of ARDF equipment for the Department of the Army. A development cost plan (appendix 1) has been prepared as requested and is stiached. Because of the urgency of this task, development has proceeded in anticipation of approval and to date approximately has been expended. A provious internal estimate of approximately \$28,000 was prepared 2. early in 1968, before the extent of the task was appreciated. It covered the manufacture of five units to the same specification as the experimental models originally supplied to the Army by W.R.E .. 3. The requirements of the Department of the Army, as stated in Military Characteristics No. 417 are for five fully engineered units to suit two different types of aircraft, for increased frequency coverage, and for the equipment to be fully tested and documented. These requirements have necessitated a substantial amount of redesign of the original circuitry and mechanical detail, and have therefore increased the estimated cost. During the course of development, a number of deficiencies have become apparent. These are noted in the development cost plan and could be the subject of a future development task.

¹ NAA D174 E5669/3/23 PART 2 Development and manufacture of an airborne direction finding system for department of the army. F21A

4. Th	e cost estimate has been prepared for three phases of	the project and
is as follows	s: (Centre Costs)	
Phase 1:	Development of Mechanical and Electrical	
	Circuitry, environmental testing, drawing	
	and documentation, and the production of	
	one prototype to suit a Cessna aircraft	\$74,620
Phase 2:	Manufacture of two subsequent Cessna	
	models and spares	\$24,668
Phase 3:	Manufacture of two subsequent models to suit	
	Porter aircraft including minor design changes	

DRAFT -2-These costs include W.R.E. salaries and overhead, materials and expenses, but exclude the cost of the commercial components of the system (which have been supplied in-sid by the Department of the Army) and any RAAF changes for assistance with installation. 5. The additional costs arise approximately as follows:-(a) Design to military specifications, incorporating increased frequency coverage, elapsed time indicator, concealed cabling, and other army requirements. \$60,000 (b) Environmental test program \$25,000 (c) Additional cost of military specification components over and above cost of components originally used (5 units and spares total) \$ 7,000 (d) Additional cost of manufacture of hardware (c) Additional cost of military specification components over and above cost of components originally used (5 units and spares total) \$ 7,000 (d) Additional cost of manufacture of hardware of new design (5 units total) \$ 8,000 (e) Additional design and testing to adapt equipment for both Cessna and Porter aircraft \$ 2,000 (f) Salary increases \$ 2,000 6. A summary of progress of this project to October 1969 is attached as Appendix II. The project has been financed to date using W.R.E. Development cost codes and the appropriate funds will be transferred when funding is approved.

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DEPUTY DIRECTOR/ENGINEERING

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APPENDIX I PROJECT THOROUGH 1379 DRAFT DEVELOPMENT COST PLAN

1. Introduction

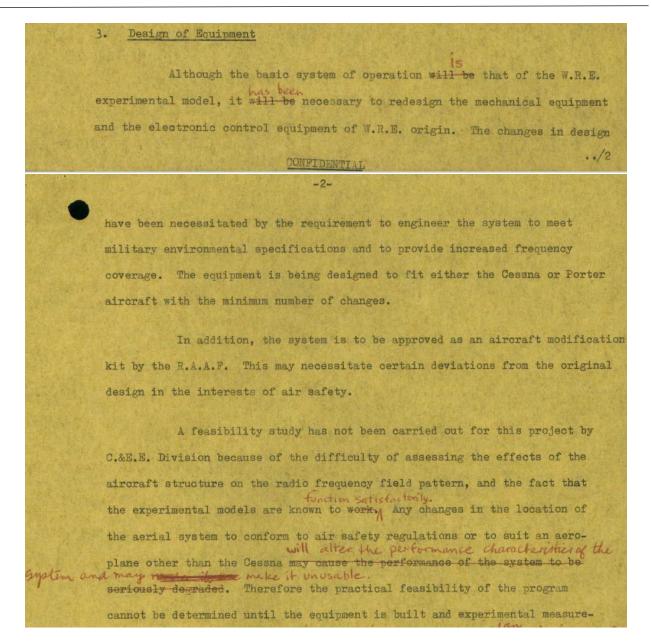
The Department of the Army urgently require five airborne radio direction finding (ARDF) sets; three to suit Cessna, and two to suit Pilatus Porter aircraft.

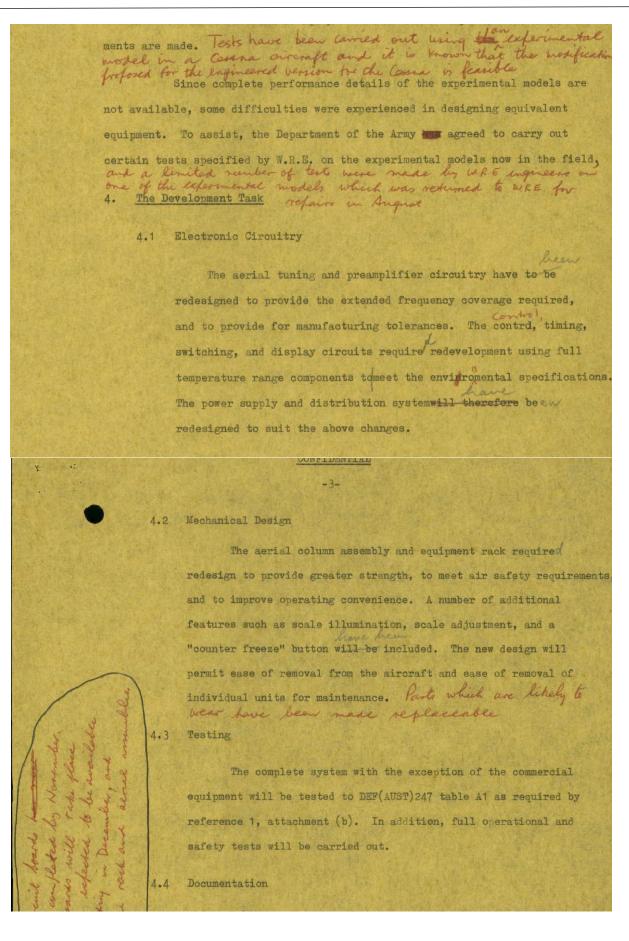
Two experimental models to suit Cessna aircraft were produced by the Chemistry and Physics Division of W.R.E. in 1967 and these have been found to operate satisfactorily. These are described in reference 4. The five models now required are to be based on the design of the experimental model B, but the sets are to be fully engineered and tested, and the frequency range is to be extended. The requirement is stated in reference 1.

2. Description of Equipment

The ARDF system consists of an antenna system mounted externally to the aircraft by means of a column which may be rotated by the operator, and a rack of electronic equipment mounted inside the aircraft within reach of the operator. The rack houses two receivers, a cathode ray oscilloscope, a tape recorder, a chart recorder, and a chassis of control equipment. The above items of equipment are of commercial origin except for the control chassis which is being developed by W.R.E. The commercial equipment is being supplied in-aid by the Department of the Army.

The equipment is operated by rotating the antenna system until two signals are balanced. The operator may then read the bearing of the selected transmitter, relative to the heading of the aircraft, from a scale on the column. The location of the aircraft can be established by measuring elapsed time from an initial map reference; the elapsed time being displayed on the control rack.





4.4 Documentation

A set of standard W.R.E. manuals will be produced and they will include a full engineering specification and reliability estimate for the equipment. Drawings and manuals will be to normal W.R.E. standards and not to Specification Army (Aust.)606 in view of the urgency of this project. Draft manuals will be submitted to Department of the Army for comments before final publication. A draft modification order of lower security classification will also be produced by W.R.E. for the R.A.A.F. who require this for modification of aircraft handbooks, service manuals, etc.

Development Plan

Development of the electronic circuitry and mechanical components rearing confliction and these licen is now in progress, financed by W.R.E. Development cost codes.

The mechanical design was submitted to R.A.A.F. for approval RAAF affronce was received on 1/7/bg and before starting manufacture. Manufacture of the first prototype will take menufacture of the first prototype is expected to be confleted approximately 6 months from receipt of approval (i.e. from 1/7/69). by January 1970. During the freepartum of detadd drawings it was found necessary to prove the design slightly for ... 14 improved aferator convenience, and to profile shorten the aerial tube (subsequent to tak) to selicity a RAAF requirement.

the first unit for the Corna arisness will be subjected to full environmental tests which are scheduled for January and are expected to take affroximately one month. He subgast two the with the Any damage resulting from these tests will be repired and the first will be available for ofendance moto acceptance texts flight tests by RAAF and operational and acceptance test by WRE and the Department of the Army

Subaport when The subsequent two units for the Cesara aircraft will be modified if found necessary by the environmental tests and subjected to an abbreviated test schedule to confirm that they their performance is equal to the design proven first model. These two units will be available fragremoely at affroximately one month intervals after the first wit.

During the manufacture of the hardware the electronic design will be completed, and the electronic sub assemblies will be manufactured and environmentally tested.

The first two complete (Cessna) prototypes will be subjected to an abbreviated test schedule similar to that proposed for the burn-in tests on subsequent prototypes. The third prototype will be subjected to the full environmental tests specified and any modifications found necessary will be incorporated in the first prototypes at a later date. This procedure has been adopted because of the urgent operational requirement for the first two prototypes. It is considered safe because the experience gained from the operation of the two experimental models in the firld for two years has revealed the major weaknesses in the design and these will be corrected.

Operational tests will be carried out on the first prototype to determine the feasibility of mounting this equipment in Porter aircraft. If the results of these tests show that the performance is satisfactory, the manufacture of the two Porter prototypes will proceed. <text><text><text>

aircraft or it in

6. Future Developments The design of the present unit has been subject to certain constraints in order to produce equipment urgently to meet an operational need. The system design therefore has been virtually that of the experimental models Diving the development of the engeneered model. a number of deficiencies in design have become afferent which could not be corrected in the time available The deficiencies are concerned with accuracy, size and weight, reliability, and the operating procedure. and the charles be consisted in These should be investigated further with the for and as much IT version should be produced. the flowers the It has been found that the accuracy the of the equipment is related to the accuracy of fixing of the equipment in the aircraft, and the drift angle of the arreraft in flight, and the ability of the pilot to fly a straight fath. Assuming the accuracy of fixing is known, the errors of ±5° a could be attributes to filet ever and atmosfleric turbelence, whelet drift errors, which are not compersated at present could be ± 15° or more. These errors could only be completely removed by using the equipment with some form of navigational equipment which would give instantaneous aircraft headings, but a simple form of drift compensation could readily be incorporated to reduce the evors. With greater accuracy worthwhile results

In addition CEE Division has fooduced an experimental version of a meter differ anything which and aural display system which we developed to indicate the direction of the transmitter. This display, which is very simple and reliable could be developed to reflace the oscilloscope and would result in considerable space, weight and hower dissifation. The meter display is considerably more sensitive than the sellorope and is capable of resolving signals affrorimately 30db lower in level. This would permit by filest to fly firsthe away from the target provided othe errors could be reduced the hacal receivers are not the most suitable and has obvion receivers for the task and should be replaced with advantage smaller, lighter and more reliable sets. The design of the antenn head, although theoretically officer to plicate operation respectively because the and it for the oftimum and cafable of better than ± 1/2° accuracy, is not suitable, because of the other system inaccuracies it that is an unrecessary complication of the operating focedure. The design shouldaccuracy, The use and a effectivenen of the signal strength measurement recorded on the son Rustrak recorder should also be investigated . The investigated and flight tests should be made on several alternative heads and leg, with I finite rodo cressed at 98 or the a combination of levote rod and whit.

Appendix 2 To Annex I Australian ARDF

continuously hurther formibilities exist in an automated system. With a with a rotating the antenna, the stimesty and automatically recording the operator could be seliminated and more cuts could be altained funded be automatically recorded) could be automatically recorded & thus

	1 20	CONFIDENTIAL
		APPENDIX II
Section of the		PROJECT THOROUGH - SUMMARY OF PROGRESS
	Early 1967 27.9.68	Army requested Teleconto build serveral unto Suly, 1969 (Anguard) for fuel use. AHQ Design Study request and military characteristics issued.
52	2.12.68	(because of the delay in producing the original spee designs is waget) Letter from Secretary, Department of the Army to Secretary,
Bud	13.12.68	Department of Supply, requesting Supply to undertake task. Please commerce development in advance of official order Arepne DCP. Letter from C/R&D to DD/E. covering letter from December
att ?	23/1/69	Five In-aid C.R.O.'s received.
and a star	3/2/69	Letter from DD/E to C/R&D accepting task. OK DCP mill be produced,
all the	6/3/69	First meeting arranged between representative of Department
78 7.3		of Army and W.R.E. for detailed discussion of project.
Light P	1/3/67 to 27/3/69	Cessna and Porter aircraft stationed at Edinburgh to allow
317 5	21/3/09	Mechanical design work to proceed.
P.S. F	26/3/69 & 27/3/69	Meeting between representatives of Department of Army,
A MARINE	24/3/03	R.A.A.F., and W.R.E. for further discussions.
the t	30/4/69	Design of Timing circuitry completed.
-	30/4/69	Design of Timing circuitry completed.
	8/5/69	Five In-aid AKAI X-V tape recorders received.
First droft - DCP Dudued	9/5/69	Unofficial meeting with Major Catanagh for disucssions on
ly 6 best		Operation aspects.
Reconsille	23/5/69	Two In-aid Racal Receivers received.
job quotetur	26/5/69	Mechanical design drawings despatched to RAAF for approval.
On madere	12/6/69	Major Gower visited W.R.E. to disucss progress and difficulties
		in supply of Rustrak recorder.
	1/7/69	Approval of mechanical design drawings received from R.A.A.F.
		Preparation of detailed drawings commenced by W.R.E.
estin	de to	-post.
	and the second	Breadboard models of the redesigned electronic circuitry have
	been built	; and functionally tested with satisfactory results. Long lead
	component	items have been ordered. Preparation of manufacturing drawings has
	commenced.	It is expected that the W.R.E. control modules will be available
	by the tim	ne the column and rack are manufactured.
	Tan the	12 Charles and the second s
	22/1/	bg see next fages

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There were several iterations of a draft Interim Project Thorough Report on file. Unfortunately no final copy has been located. It is believed that the Reports may have been tabled at Progress and Technical Meetings.

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REPORT ON PROJECT THOROUGH

1. Background

Preliminary work was commenced in December 1968 by CEE Division W.R.E. in connection with the engineering development of the experimental A.R.D.F. (airborne radio direction finding) equipment which had been proved operationally successful. In March 1969 meetings were arranged between Army, W.R.E., and R.A.A.F., at which detailed requirements were agreed and the requirements of the R.A.A.F. were made known.

It was discovered at an early stage that extensive modifications would be required to the original design, both mechanical and electrical, to meet Army requirements. e.g. Environmental testing requirements suggested that the original RTL microcircuits should be replaced by DTL or TTL, the mechanical counter used should be electronic, the design of the antenna tuning circuit was not suitable for quantity production and was not adaptable to the desired wider frequency range, cabling between column and rack had to be revised, the mounting of the rack and the locking of the column had to be revised to meet air safety requirements. The design for the column was completed in June 1969 and forwarded to R.A.A.F. for approval, however after discussions with an operator and examination of the space available in a Cessna, and the safety recommendations of the R.A.A.F. a modified design was produced in October. This was subsequently modified slightly on the recommendation of Lt. Calder, Because of expected difficulties in meeting the timescale,

of Army Technical Services Unit

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the manufacture of this section of the equipment was let to Fairey Aviation by Contract. Faireys expect to complete the first unit for a Cessna on 23rd March, 1970, after which the final assembly will be carried out by W.R.E., who are manufacturing the rack and the electronics.

2.

the column and vadome

The design of the electronics and breadboard construction was completed in September (with the exception of the antenna card). Drawings were then prepared for the circuits and chassis hardware. Manufacture of the chassis and electronic circuit cards commenced on 3rd February, 1970, and will be complete and functionally tested by the time they are required for assembly. An antenna card was manufactured with characteristics similar to those of the experimental model A, and used in a refurbished experimental model in Vietnam. The sensitivity of this circuit, however, proved inadequate and a considerable development work has been done to improve performance.

After assembly, the first unit will be installed by R.A.A.F. in a Cessna to be stationed (probably at Edinburgh) by the Army, Flight tested by R.A.A.F., and subsequently operationally tested and calibrated by W.R.E. The will not be publicled to environme tusting because it integrated my with de

The second and third units are expected to be ready for assembly of an on 20th April, 1970. Environmental tests will be carried out on the second unit and the third unit will be held in order to incorporate any modifications found necessary.

 Specifications for functional, environmental and operational tests are at present being written. Writing of Handbooks and workshop manuals has been commenced.
 Army Inspection Service, Adelaide are carrying out surveillance of the manufacture.

91 · K.B. :M.A. 3.3.70 CONTROLLER, VCRE E5669/3/23 RESEARCH & DEVELOPMENT. K.B. Breynard, Ext. 6335 FROM: WEAPONS RESEARCH ESTABLISHMENT, SALISBURY. SUBJECT: PROJECT THOROUGH - COST ANALYSIS On 1st May, 1969, a cost estimate was provided to the Superintendent, Propulsion and Marine Physics Division, for the manufacture of five ARDF units to a design already produced by the Telecommunications Group of Weapons Research and Development Wing. The cost of the work at that time was estimated to be \$27, 382. Subsequent to this original estimate various modifications occurred in the programme and the present estimated cost is \$ 214,151. 2. The following significant factors have contributed to the increase in cost over the first estimate :-2.1 The requirement is now for seven units rather than five. 2.2 Since the original estimate wages have risen and the establishment overhead rates have been increased. These factors make up 20 percent of the final total 1970 estimate. 2.3 The original unit was to be fitted to a Cessna only. The requirement to fit a Porter has increased design cost and environmental testing cost. 2.4 The equipment is now to be designed to meet military specifications whereas the original estimate was based on a laboratory design. DETAILED COST COMPARISON 3. DESIGN COSTS

	ASPECT	1968 ESTI- MATE	PRESENT ESTIMATE	REASONS FOR VARIATION
· I. (1)	Mechanical design and drawing for column, rack and radome	\$2,000	\$20,000	Cabling, Ease of installation. Weather sealing, Air safety requirements. Late modification after original lack of knowledge of requirement.
۴. (۱)	Electronics design and drawing	\$5,000 (drafting)	\$34,000	Not requested in 1968 estimate. Found to be necessary because of : - Redewign for environment spe- cified in MC417. - Engineering of antenna head for wider frequency range and quantity production. - Late mods. because of lack of specs. for experimental models.
3 (0)	Environmental Testing		\$23,500	Not requested in 1968, but called for in MC417.

		2,		
	ASPECT	1968 ESTI- MATE	PRESENT ESTIMATE	REASONS FOR VARIATION
67	OPerational Testing	State 7	\$6,000	Not envisaged in 1968 estimate.
CD	Supervision and Ligison	- 1	\$5,000 ^	Results from additional work lis- ted above.
(II)	Packaging Design		\$1,000 -	Not requested in 1968 estimate but a called for in NG417.
01F1	Column, Radome, Rack	\$6875	\$40,000	Complexity of column. Radome design changed.
1.3	Electronics manuf.	\$2,600	\$27,500	Manufacture by Workshop rather
43	parte	\$4,000	\$14,000	than T.A.'s and to A.I.S. standard. Complexity of Chassis design. Greater use of plugs and sockets. Use of mil spec. components.
	Pack and Transport	\$1,100	\$5,000	Transit cases requested in MC417.
	Testing	\$2,200	\$5,000	Originally expected minimum func- tional testing. Now proposing extended functional tests for A.I.S and burn-in tests.
	Supervision	\$3,000	\$10,000 i	and burn-in tests. John of reader
3)	Design War mods. for installation in 2nd type of aircraft	-	\$13,000	Additional drawing, environmental testing and changes to documentation Not requested in previous estimate.
	Documentation	(inc. in Supervisio	\$10,000 om)	Requested by Army in MC417.
	4. Current expendi	ture and com	mitmonto.	Allen & Chief
	4.1 Expanditur	ACCOMPANY OF	And the Party of the Party of	
	4.2 Outstandin	g commitment	s to 24/2/70	, \$21,800. nd consists of :-
	\$16	\$8,00		lumns, reals and radomes. committed externally to
	8 5	,600 - Manuf	A Manual And And	ectronics.
	\$21	,800		

SHEET A	
TASK DESCRIPTION	A STATE OF THE STA
. TASK DESCRIPTION NO. :	
Up to the preparation of this document, sarried out under No. RD71 Task 69/2.	work on this Task has been
2. TITLE	
Development of Airborne Radio Direction for the Department of the Army - Project Thorough	
B. DEFENCE SIGNIFICANCE AND/OR RELEVANCE TO OTH SIMILAR MATURE	ER R.&D. PROGRAMME TIEMS OF
This equipment is required for the local stations.	tion of HF transmitting
. SECURITY CLASSIFICATION	
Confidential.	
5. SPONSOR	
Department of the Army.	
This Task has been identified as Task N the Army.	o. L379 by the Department of
5. ESTABLISHMENTS	
Weapons Research Establishment, Enginee	ring Wing.
7. AGREED REQUIREMENTS	「「「「「「「「「」」」
Undertake engineering development and m production airborne HF direction finding sets for production sets for Pilatus Porter aircraft, and set of spare equipment each to suit Cessna and Po	a Cessna aircraft, two pre- the production of one complete
The design is based on an experimental W.R.E. Design of the equipment other than commer sign shall be to the requirements specified in Mi	cial items embodied in the de-
Documentation for manufacture together handbooks will be produced for the pre-production	
The following items of "in aid" equipme	mt will be provided by the Army:-
1. EF Receiver Racal Type RA217	-10
2. Recorders Rustrak Type 2146	-5
3. Tape Recorders Akai Type X-V	-5
4. Oscilloscope Tektronix Type 422	-5
5. Head Sets including microphone	-5

8.

The detailed requirements for the equipment to be mounted in the Porter Aircraft have not yet been fully specified by the Department of the Army. <u>DESIRED TIMESCALE</u> : Fhase 1 -Delivery of the first preproduction unit (fully tested) for Cessna by June, 1970.

2.

Phase 2 -Completion of subsequent two preproduction sets for Cessna by July, 1970.

Phase 3 -

Completion of two preproduction sets for Pilatus Porter, one by August, 1970, the second by September, 1970.

9. ARRANGEMENTS FOR REPORTING :

Progress Meetings with the Sponsor should be held at monthly intervals or more frequently, if significant issues arise. Quarterly reports will be submitted to Controller R&D, in accordance with the requirement of Research & Development Instruction Nc. 14.

10. FINANCIAL ARRANGEMENTS :

Design, development and testing of existing experimental models together with appropriate documentation for manufacture of preproduction units to be funded by the Department of Supply.

Estimated cost\$89,278.

The cost of the five preproduction models for Cessna and Porter, and the two spare equipments should be borne by the Department of the Army.

The estimated Cost is \$1124,073.

11. RESPONSIBILITIES :

1. Department of the Army will be responsible for providing Military Characteristics for the ARDF equipment and advising the standards of inspection. After prototype installations have been made in the aircraft and approved by the R.A.A.F., the Army will be responsible for the installation of subsequent sets.

- 2.
- Deputy Director/Engineering, W.R.E., will be responsible for :-

(1) (11)	Carrying out design and development work. Preparation of production drawings and manuals.
(111)	In co-operation with the Department of the Army, the preparation of environmental and performance specifications.
(iv)	Manufacturing and testing prototype and preproduction sets.
(v) (vi)	Preparing instructions for aircraft modification. With the assistance of the R.A.A.F., fitting one prototype to each type of aircraft.
(vii)	Assisting Army in carrying out operational acceptance tests.
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J.
A. The R.A.A.F. will be responsible for carrying out stress maly sis associated with the installation of this equipment in both type of aircraft and for the approval and authorisation of aircraft.
J. MENDEMENTS FOR LIAISON LITE SPONSOF :
Mage Result in Item 9 above, it is proposed to hold monthly settings with this Sponsor to follow progress on this Project.
Major F.A. Gover of the Department of the Army has been spointed Project Officer, and is currently carrying out liaison with the sponsor data output of the Army has been spointed Project Officer, and is currently carrying out liaison with the sponsor data output of the Army has been spointed Project Officer, and is currently carrying out liaison with the sponsor data output of the Army has been spointed Project Officer, and is currently carrying out liaison with the sponsor data output of the Army has been sponsor.

CONFIDENTIAL SHEET B TECHNICAL COST PLAN 1. TASK DESCRIPTION : Development of airborne radio direction finding equipment (ARDF) for the Department of the Army. This Project involves the manufacture of five preproduction airborne HF direction finding sets for installation in light aircraft. 2. PLAN TO MEET THE TASK DESCRIPTION : Design, development and manufacturing of the preproduction models will be carried out in W.R.E. Engineering Wing except where it is more expedient to have some mechanical work let to outside contract. Fitting of the first of each type of unit to the aircraft will be carried out at Edinburgh by the RAAF with Engineering Wing participation. Subsequent fittings will be carried out by the Army. The original request from Depart-ment of Army asked for completion of the Cessna units by September 1969. This timescale was based on the work consisting of the manufacture of a second unit similar to the laboratory model already supplied to the Army. This approach however will not be practical owing to difficulties with the original design and some engineering development is necessary. This model is now expected to be completed by June, 1970. This slip is reflected into the delivery of later units and therefore the whole program has slipped by 6 months. This equipment has an operational role in the field now and therefore the project should be considered as urgent and any effort should be made to avoid further delays. The Army are at present using two experimental models continuously in Vietnam and these are themselves in a poor mechanical state. A detailed breakdown of activities is shown in the flow chart attached. (C29078) This figure also shows estimated running costs. 3. ESTIMATED STAFFING REQUIREMENTS : T Total RS R Estimated Effort 520 1120 1640 Man days 2 3 5 Staff to be deployed

4. SPECIAL FACILITIES REQUIRED :

- (a) Buildings and plant Nil.
- Nil (b) External facilities

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	2.					
ESTIMA	TED COSTS :					
	Labour, Mat & Capital E	erials xpenditure	External Facilities	Travel	Total	
(1)	Design & Development and testing for existing experimental models together with approp- riate documentation for manufacture of pre- production units.	\$89,278	Nil	Nil	\$89,278	
(11)	Manufacture of 3 pre- production units for Gessna aircraft and preparation of user handbooks.	\$43, 249	\$8,500	Nil	\$51,749	
(111)	Production of 2 pre- production models for Porter aircraft including minor design charges from the original system & full environmental testing.	\$37,974	\$5,750	Nil	\$43,724	
(iv)	Cost of 2 spare equipments (complete units) 1 for Cessna and 1 for Porter. (Method of manu- facture uncertain)				\$29,400	

6. PROPOSALS FOR MEETING TIME SCHEDULE :

The task has been given urgent priority throughout the design phase and will continue to be treated as urgent.

Co-operation has been established with the RAAF enabling installation and testing to be carried out locally at Edinburgh.

Environmental testing will be carried out on the second unit in parallel with operational testing of the first unit manufactured; any modifications found necessary will be incorporated in the first unit at a later date.

7. REPORTING :

In accordance with RDI instruction No. 14.

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