

Control of Pyrotechnic Burn Rate

B. J. and K. L. Kosanke

ABSTRACT

There may be many times when a fireworks manufacturer will want to adjust the burn rate of pyrotechnic compositions. Sometimes this may be for matters of esthetics and other times for safety. For example, all of the following are unacceptable:

- *Strobe stars that flash with so low a frequency that they fall to the ground still burning.*
- *Color stars that burn so rapidly that they occasionally explode when a shell flowerpots.*
- *Rockets that fail to lift-off because their thrust is too low.*
- *Rockets that explode upon firing because internal pressures exceed the casing strength.*
- *Salmes that burn like fountains instead of exploding with violence.*
- *Flash powder that explodes when unconfined, even in small quantity.*

In each case, taking action to adjust burn rate should solve the problem.

Depending somewhat on how they are counted, there are at least 15 factors that control pyrotechnic burn rate. A manufacturer that understands how these factors act to affect burn rate may better anticipate when product performance difficulties will occur. Also, such a manufacturer will be better prepared to modify product formulations to correct any problems that do occur. Each of the burn rate control factors act by affecting one or more of the following: activation energy, heat of reaction, and efficiency of energy feedback. In this paper, the 15 factors are presented, explained and examples given.

Introduction

In the burning of most pyrotechnic compositions it is necessary to balance competing processes to achieve the maximum desired effect. For example, when flame temperature of a color star is too low, the result can be low light output be-

cause there are an insufficient number of electrons reaching excited states. However, conversely, when flame temperature is too high, the result can be bright but washed-out colors because the color producing molecules have thermally decomposed. In addition to aesthetic ramifications, safe performance can also require a balance between too little and too much output. For example, when the thrust produced by a fireworks rocket is too low, the result can be an explosion of the rocket at ground level because the rocket failed to fly into the air. Conversely, when the thrust is too high, the result can again be an explosion at ground level because the internal pressure exceeded the strength of the motor casing.

One mechanism, useful in adjusting pyrotechnic output, is the control of burn rate. Burn rate determines the rate of energy release, and thus to some extent the flame temperature of a star. More directly, burn rate determines the rate of gas production from a propellant, and thus the thrust from and internal pressure within a rocket motor. Accordingly, an understanding of the ways in which burn rate can be adjusted, can be useful in modifying pyrotechnic formulations to maximize their performance and safety. In this article, after a brief theoretical discussion, which forms the basis for understanding how each factor acts to modify burn rate, 15 factors that affect burn rate are presented, discussed and examples given.

Pyrotechnic Ignition

Pyrotechnic materials are said to exist in a "meta-stable" state. That is to say, under normal circumstances they are stable (they do not spontaneously ignite); however, once ignited, the combustion reaction is self-sustaining producing an excess of thermal energy. The reason pyrotechnic materials do not spontaneously ignite under normal conditions is that ignition requires the input of energy into the composition. Once ignited, however, the pyrotechnic material burns thus producing energy. This two step energy relationship is illustrated in Figure 1, which is an attempt to

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Table of Contents Control Of Pyrotechnic Burn Rate

1. Understanding the eBook Control Of Pyrotechnic Burn Rate
 - The Rise of Digital Reading Control Of Pyrotechnic Burn Rate
 - Advantages of eBooks Over Traditional Books
2. Identifying Control Of Pyrotechnic Burn Rate
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Control Of Pyrotechnic Burn Rate
 - User-Friendly Interface
4. Exploring eBook Recommendations from Control Of Pyrotechnic Burn Rate
 - Personalized Recommendations

- Control Of Pyrotechnic Burn Rate User Reviews and Ratings
- Control Of Pyrotechnic Burn Rate and Bestseller Lists
- 5. Accessing Control Of Pyrotechnic Burn Rate Free and Paid eBooks
 - Control Of Pyrotechnic Burn Rate Public Domain eBooks
 - Control Of Pyrotechnic Burn Rate eBook Subscription Services
 - Control Of Pyrotechnic Burn Rate Budget-Friendly Options
- 6. Navigating Control Of Pyrotechnic Burn Rate eBook Formats
 - ePub, PDF, MOBI, and More
 - Control Of Pyrotechnic Burn Rate Compatibility with Devices
 - Control Of Pyrotechnic Burn Rate Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Control Of Pyrotechnic Burn Rate
 - Highlighting and Note-Taking Control Of Pyrotechnic Burn Rate
 - Interactive Elements Control Of Pyrotechnic Burn Rate
- 8. Staying Engaged with Control Of Pyrotechnic Burn Rate
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Control Of Pyrotechnic Burn Rate
- 9. Balancing eBooks and Physical Books Control Of Pyrotechnic Burn Rate
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Control Of Pyrotechnic Burn Rate
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Control Of Pyrotechnic Burn Rate
 - Setting Reading Goals Control Of Pyrotechnic Burn Rate
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Control Of Pyrotechnic Burn Rate
 - Fact-Checking eBook Content of Control Of Pyrotechnic Burn Rate

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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