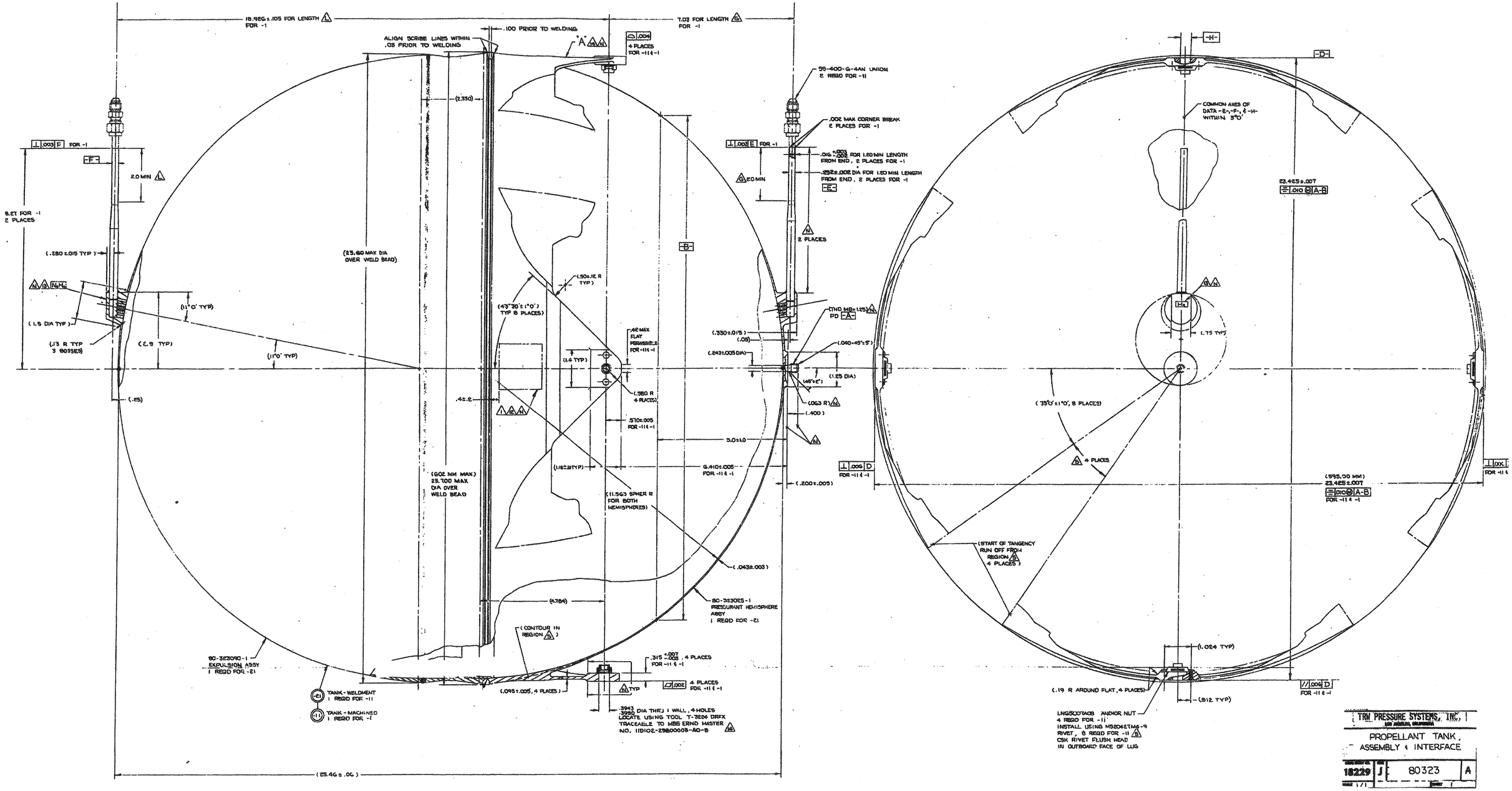

18.926±.105 FOR LENGTH FOR -1
7.03 FOR LENGTH FOR -1
.100 PRIOR TO WELDING
ALIGN SCRIBE LINES WITHIN .03 PRIOR TO WELDING
4 PLACES FOR -11 & -1
55-400-G-4AN UNION 2 REQD FOR -11
.002 MAX CORNER BREAK 2 PLACES FOR -1
.016 +.003 -.002 FOR 1.20 MIN LENGTH FROM END, 2 PLACES FOR -1
.252±.002 DIA FOR 1.20 MIN LENGTH FROM END, 2 PLACES FOR -1
2.0 MIN
8.27 FOR -1 2 PLACES
(25.60 MAX DIA OVER WELD BEAD)
(.280±.015 TYP)
(1.5 DIA TYP)
(.13 R TYP 3 BOSSES)
(11°0' TYP)
(2.9 TYP)
(.25)
(43°30'±1°0') TYP 8 PLACES)
(.50±.12 R TYP)
.42 MAX FLAT PERMISSIBLE FOR -11 & -1
(1.4 TYP)
(.580 R 4 PLACES)
.570±.005 FOR -11 & -1
(.602 MM MAX) 23.700 MAX DIA OVER WELD BEAD
(11.563 SPHER R FOR BOTH HEMISPHERES)
(.043±.003)
(4.784)
80-323025-1 PRESSURANT HEMISPHERE ASSY 1 REQD FOR -21
(CONTOUR IN REGION 5)
80-323090-1 EXPULSION ASSY 1 REQD FOR -21
TANK-WELDMENT 1 REQD FOR -11
TANK-MACHINED 1 REQD FOR -1
.315 +.007 -.003, 4 PLACES FOR -11 & -1
(.095±.005, 4 PLACES)
4 PLACES FOR -11 & -1
.3943 .3950 DIA THRU 1 WALL, 4 HOLES LOCATE USING TOOL T-3284 DRFX TRACEABLE TO MBB ERND MASTER NO. 11D102-25800003-AO-B
(25.46±.06)
(THD MB=1.25) PD -A-
(.330±.015)
(.05)
(.243±.005 DIA)
(.040+45°±5°)
(1.25 DIA)
(.063 R)
(.400)
5.0±1.0
6.410±.005 FOR -11 & -1
(.200±.005)
(.75 TYP)
(35°0'±1°0', 8 PLACES)
4 PLACES
(START OF TANGENCY RUN OFF FROM REGION 5 4 PLACES)
(1.024 TYP)
(.19 R AROUND FLAT, 4 PLACES)
(.512 TYP)
LNG5007A08 ANCHOR NUT 4 REQD FOR -11 INSTALL USING MS20427M4-9 RIVET, 8 REQD FOR -11 CSK RIVET FLUSH HEAD IN OUTBOARD FACE OF LUG
COMMON AXES OF DATA -E-, -F-, & -H- WITHIN 3°0'
23.425±.007
(595.00 MM) 23.425±.007
FOR -11 & -1
TRW PRESSURE SYSTEMS, INC.
PROPELLANT TANK, ASSEMBLY & INTERFACE
18229
J
80323
A
1/1