

TANK TYPE Pressurant	MOUNT Strap
--------------------------------	-----------------------

This tank is a 15-inch spherical pressure vessel constructed of 6AL-4V titanium. Mounting is by strap. A single ported boss provides for inlet and outlet operation.

Part Number 80186-1

SIZE: 14.95-inch ID Sphere

ISO 9001 (1994) REGISTERED

Stress
PSI Analysis **x**

APPLICABLE DOCUMENTS	
Sterer Qual Test Procedure	22491-1
Membrane Analysis	54-000022
Burst Test Report	56-000046
Powder Blast	65-000030
Heat Treat	90-000002
Fusion Welding, TIG	90-000003
Radiographic Acceptance STD	90-000004
Radiographic Inspection	90-000006
Identification	90-000047
Electrochemical Etch	90-000049
Closed Die Forging	90-000083
Penetrant Insp, Type I, Method B	MIL-I-6866
Ultrasonic Insp, Class AA	MIL-STD-2154
Qual Test Report	Note 3
Acceptance Test Procedure	PSI Dwg
Cleaning	CPP 3336

TANK CHARACTERISTICS			
Operating Pressure, psig	3,620	Total Volume, ci	1,750
Proof Pressure, psig	5,440	Prop Volume, ci	NA
Cryo Proof, psig	NA	Max Design Wt, lbs	23.30
Burst Pressure, psig	Note 2	Minimum Wall, inch	0.177

ACCEPTANCE ENVIRONMENTAL TESTS
NONE

PROGRAM INFORMATION	
Program	European
Customer	Sterer
Customer P/N	22491-1
Original Job No.	7118
Customer Installed Device	No
Customer Controlled Design	No

FORGINGS P/N	SUPPLIER	Die No
80074-61	ARCTURUS	3300

Notes:
 1: Tooling belongs to Northrop Grumman
 2: Actual Burst 7900, Normalized 7717
 3: Qualification is based on similarity to 80088-1. Reference Report No. 56-000014



