TANK TYPE Pressurant MOUNT Tabs LOCATION Girth NORTHROP GRUMMAN

This is a spherical pressure vessel constructed of 6AL-4V titanium. Mounting is accomplished on four (4) lateral tabs parallel with & adjacent to the sphere mid-plane.

Part Number 80333-1

Cleanliness Verification

Acceptance Tests

Burst Test

SIZE: 23.16-inch OD Sphere SIZE: 588-MM OD Sphere

ISO 9001 & AS 9100 REGISTERED

APPLICABLE DOCUMENTS

Acceptance Test Procedure	50-000321
Qualification Test Procedure	50-000322
Reliability Analysis Report	54-000079
FMECA Summary	54-000080
Configuration Item Data List	54-000083
Qualification Test Report	56-000133
Fracture Control Plan	54-000078
Cleaning	CPP 3645

Notes:

- 1: Tooling belongs to Northrop Grumman
- 2: Metric Anchor Nut supplied by Customer
- 3: Fracture mechanics proof pressure
- 4: Tubing supplied by customer

TANK CHARACTERISTICS

4,060	Total Volume, ci	6,450
4,872	Prop Volume, ci	NA
6,876	Max Design Wt, lbs	76.00
6,090	Minimum Wall, inch	0.240
	4,872 6,876	4,872 Prop Volume, ci 6,876 Max Design Wt, lbs

TANK CHARACTERISTICS (Metrics)

Operating Pressure, bar	279.92	Total Volume, I	105.70
Proof Pressure, bar	335.91	Prop Volume, I	
Cryo Proof, bar	NO	Max Design Wt, kg	34.47
Burst Pressure, bar	419.88	Minimum Wall, MM	6.096

FORGINGS

FORGINGS P/N	SUPPLIER	Die
80-323061-1 (2)		
RING FORGING	RING SIZE, (Ro	ugh Machined)
80-323065-1, Tab	23.87 +.13 ODx22.25 +/06	IDx4.0 +.25 Lg

TUBE TYPE AND SIZE

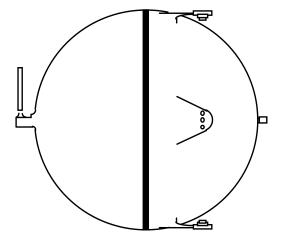
TITANIUM	SIZE
80-333040-5 (2)	.250 OD x .026 Wall
Note 4	

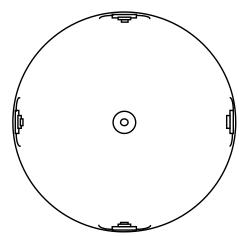
ACCEPTANCE TESTS

Preliminary Examination of Product
External Leakage
Pre-Proof Volume
Proof Pressure
Cryogenic Proof Pressure
Post-Proof Volume
Radiographic and Penetrant Inspection
External Leakage
Penetrant Inspection
Weight Determination
Center of Gravity
Final Examination of Product

QUALIFICATION TESTS

Proof Pressure Cycles
External Leakage
Pre-Proof Volume
Proof Pressure
Post-Proof Volume
Radiographic and Penetrant
External Leakage
Vibration
Radiographic and Penetrant
External Leakage
Proof Pressure Cycles
Pressure Cycles
Radiographic and Penetrant
External Leakage





6033 East Bandini Boulevard Commerce, California 90040 Telephone (323) 722-0222

Facsimile (323) 721-6002