TANK TYPE
 MOUNT
 LOCATION
 PMD DEVICE

 Propellant
 Polar
 Apex
 None

The Brasilsat Propellant Tank is a 29 inch inside diameter, polar boss mounted spherical pressure



The Brasilsat Propellant Tank is a 29 inch inside diameter, polar boss mounted spherical pressure vessel constructed of 6Al-4V Titanium. The tank has three interface ports, all constructed of 3Al-2.5V Titanium tubing. The pressurant port is 1/4 inch OD,

## **Part Number 80381-1**

SIZE: 29-inch ID Sphere

**SIZE: 736-MM** 

# ISO 9001 & AS 9100 REGISTERED

## APPLICABLE DOCUMENTS

Qualification Test Procedure	50-000493
Acceptance Test Procedure	50-000494
Cleaning	CPP 3823

Operating Pressure, psig	270	Total Volume, ci	12,770
Proof Pressure, psig	315	Prop Volume, ci	
Cryo Proof, psig	441	Max Design Wt, Ibs	12.0
Burst Pressure, psig		Minimum Wall, inch	

**TANK CHARACTERISTICS (Metrics)** 

30.41

Prop Volume, I

Max Design Wt, Kg

Minimum Wall, MM

5.44

TANK CHARACTERISTICS

## **ACCEPTANCE TESTS**

Examination of Product (Preliminary)
Pre-Proof Volume Determination

Proof Pressure Test

1 10011 1000dic 100t

Post-Proof Volume Determination

Cryogenic Proof Pressure Test

External Leakage Test

Radiographic and Penetrant Inspection

Examination of Product (Final) & Weight determination

Cleanliness Verification

#### Notes:

1: Tooling belongs to

2: Tubing material (3AL-2.5V)

Furnished by HAC & is per SCGMS 10031

3: Tube protectors are SK 1429 & SK 1430

4: Fracture Critical

#### **FORGINGS**

Forging P/N	SUPPLIER	Die No
80-381061-1		

#### **TUBE TYPE AND SIZE**

Proof Pressure, psig

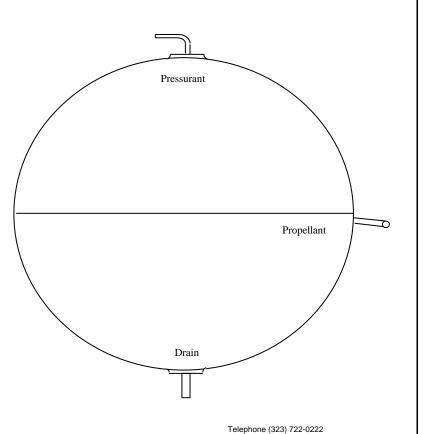
Burst Pressure, psig

Cryo Proof, psig

TITANIUM	SIZE
80-381003-1, Inlet	250 OD x .020 Wall x 4.12 Long (6.35 x .5 x 104.6 MM)
80-381003-3, Outlet	.375 OD x .020 Wall x 3.75 Long (9.52 x .5 x 95.2 MM)







Facsimile (323) 721-6002