

TANK TYPE Pressurant	MOUNT Strap	LOCATION Other
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Part Number 80198-1

This tank is a 13-inch spherical pressure vessel constructed of 6Al-4V titanium. Mounting is by the strap method. A single tube is provided for inlet and outlet operation.

SIZE: 13.386-inch OD N₂ Tank

ISO 9001 (1994) REGISTERED

Stress
PSI Analysis **X**

APPLICABLE DOCUMENTS	TANK CHARACTERISTICS	ACCEPTANCE ENVIRONMENTAL TESTS
Acceptance Test Procedure 50-000138	Operating Pressure, psig 3,625 Total Volume, ci 1,147	
Qual Test Procedure 50-000139	Proof Pressure, psig 6,208 Prop Volume, ci NA	
Qual Test Report 56-000056	Cryo Proof, psig _____ Max Design Wt, lbs 16.9	
Qual Test Report 56-000056	Burst Pressure, psig 8,268 Minimum Wall, inch 0.172	
QA Program Plan 60-000078	Actual Burst Pressure 9,400	
Fusion Welding, TIG 90-000003	Normalized Burst Pres. 8,829	
Radiographic Acceptance STD 90-000004		
Radiographic Inspection 90-000006		
Pre-Weld Cleaning 90-000022		
Identification 90-000047		
Electrochemical Etch 90-000049		
Weld Configuration, Note 3 90-000057		
Cleaning CPP 3348		
	PROGRAM INFORMATION	FORGINGS
	Program COS-B	FORGINGS P/N SUPPLIER Die No
	Customer British Aerospace (BAe)	80-198061-1 (2) ARCTURUS 2970
	Customer P/N 310.4DX2.004	
	Customer P/N 7208	
	Customer Installed Device No	
	Customer Controlled Design No	
		TUBE TYPE AND SIZE
		TITANIUM SIZE
		80198-31 .250 OD x .020 Wall

Notes:

- 1: Tooling owned by Northrop Grumman
- 2: Seamless tubing per HAC spec HMS20-1630, C-1
- 3: Proprietary Document

SKETCH NOT TO SCALE

