

TANK TYPE	MOUNT	LOCATION
Pressurant	Pedestal	Apex

The Pressurant tank is a spherical pressure vessel constructed of 6AL-4V Titanium. Mounting is accomplished by a base mount welded to the Pressurant compartment. Connection is made to pressurant compartment through a tube stub.

Part Number 80448-1

ISO 9001 & AS 9100 REGISTERED

SIZE: 15.38-inch ID Sphere
SIZE: 390.6-mm

APPLICABLE DOCUMENTS		TANK CHARACTERISTICS		ACCEPTANCE TESTS
Qual Test Procedure	50-000604	Operating Pressure, psig	415	Preliminary Examination of Product Pre-Proof Volume Determination Proof Pressure Test Post-Proof Volume Determination External Leakage Test Penetrant Inspection Radiographic Inspection Weight Determination Final Examination of Product Cleanliness Verification
Acceptance Test Procedure	50-000603	Proof Pressure, psig	529	
Fracture Analysis plan	54-000205	Cryo Proof, psig	NA	
Qualification Test Report	56-000203	Burst Pressure, psig	600	
Cleaning	CPP 3940	Actual Burst Pressure	1,048	
		Total Volume, ci	1,904	

- Notes:**
- 1: Tooling owned by Northrop Grumman
 - 2: Proprietary Document
 - 3: This tank is a redesign 80389-1.
 - 4: Tube protector is SK 1553

TANK CHARACTERISTICS (Metrics)			
Operating Pressure, Bar	28.61	Total Volume, l	31.20
Proof Pressure, Bar	36.47	Prop Volume, l	22.53
Cryo Proof, Bar	NA	Max Design Wt, Kg	2.16
Burst Pressure, Bar	41.37	Minimum Wall, MM	0.483
Actual Burst, Bar	72.26		

FORGINGS		
FORGINGS P/N	SUPPLIER	Die No
80-225061-1, (2)		
RING FORGING		RING SIZE, (Rough Machined)
80-225065-1, Base	9.5 +.09 OD x 7.12 -.09 ID x 2.2 +.09 Lg	

TUBE TYPE AND SIZE (inch)	
TRANSITION	SIZE
80-448001-1	1.6 L x .028 Wall x .250 OD

TUBE TYPE AND SIZE (mm)	
80-448001-1	40.64 x .71 x 6.35 mm

QUALIFICATION TESTS
Acceptance Test Verification Random Vibration Tests Proof Pressure Cycling Tests MEOP Pressure Cycling Tests External Leakage Tests Radiographic Inspection Dye Penetrant Inspection Burst Pressure Test Visual Inspection Final Data Review

