

<b>TANK TYPE</b> Cone	<b>MOUNT</b> Boss	<b>LOCATION</b> Polar
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This tank is a 13-inch Conosphere (Hemisphere & Cone) constructed of 6AL-4V titanium. Mounting is by polar bosses.

**Part Number 80148-1**

**SIZE:12.69-inch ID Conosphere**  
**SIZE:322.3-MM**

**ISO 9001 (1994) REGISTERED**

Customer	<b>Stress</b>	<b>By TRW</b>
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APPLICABLE DOCUMENTS	
Acceptance Test Procedure	50-000106
Qualification Test Procedure	50-000107
Forging Qualification Report	55-000033
Qualification Test Report	56-000037
Packaging	60-000040
Configuration Management Plan	60-000045
Fusion Welding, TIG	90-000003
Radiographic Acceptance STD	90-000004
Radiographic Inspection	90-000006
Pre-Weld Cleaning	90-000022
Identification	90-000047
Electrochemical Etch	90-000049
Closed Die Forging	90-000083
Penetrant Insp, Type I, Method B	MIL-I-6866
Forging Material, Comp 6	MIL-T-9047
Cleaning	CPP 3281

TANK CHARACTERISTICS			
Operating Pressure, psig	585	Total Volume, ci	1,100
Proof Pressure, psig	1,002	Prop Volume, ci	830
Cryo Proof, psig	NA	Max Design Wt, lbs	3.50
Burst Pressure, psig	1,332	Minimum Wall, inch	0.020

ACCEPTANCE ENVIRONMENTAL TEST	
None	

TANK CHARACTERISTICS			
Operating Pressure, Bar	40.33	Total Volume, l	18.03
Proof Pressure, Bar	69.08	Prop Volume, l	13.60
Cryo Proof, Bar	NA	Max Design Wt, Kg	1.59
Burst Pressure, Bar	91.84	Minimum Wall, MM	0.508

FORGINGS		
FORGINGS P/N	SUPPLIER	Die No
80148-61	Arcturus	2814
80148-63	Arcturus	2813

- Notes:**
- 1: Tooling belongs to Northrop Grumman
  - 2: Tubing per AMS 4942 OR ASTM B 338-65

PROGRAM INFORMATION	
Program	777
Customer	TRW
Customer P/N	404601-1
Original Job No	6930
Customer Installed Device	No
Customer Controlled Design	No

TUBE TYPE AND SIZE	
TITANIUM	SIZE
80-148002-1, Outlet	.375 OD x .035 Wall
Inlet Tube	.375 OD x .016 Wall x 1.75

TUBE TYPE AND SIZE (Metrics)	
TITANIUM	SIZE
80-148002-1, Outlet	9.52 OD x .88 Wall
Inlet Tube	9.52 OD x .40 Wall x 44.19

