

<b>TANK TYPE</b> Spinner	<b>MOUNT</b> Bosses	<b>LOCATION</b> Off Axis
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This tank is a 13-inch Conosphere (Hemisphere & Cone) constructed of 6AL-4V titanium.  
Mounting is by off-axis bosses.

**Part Number 80321-1**

**SIZE: 13.65-inch ID Conosphere**  
**SIZE: 347-MM ID Conosphere**

**ISO 9001 & AS 9100 REGISTERED**

APPLICABLE DOCUMENTS	TANK CHARACTERISTICS	ACCEPTANCE TESTS
Acceptance Test Procedure 50-000301	Operating Pressure, psig 435 Total Volume, ci 1,391	Preliminary Examination of Product
Qualification Test Procedure 50-000302	Proof Pressure, psig 655 Prop Volume, ci NA	Pre-Proof Volume
Protoflight Test Report 56-000117	Cryo Proof, psig No Max Design Wt, lbs 3.64	Post Proof Volume
Cleaning CPP 3600	Burst Pressure, psig 870 Minimum Wall, inch 0.019	Radiographic Inspection
		Penetrant Inspection
		External Leakage
		Vibration
		External Leakage
		Thermal Cycling
		Final Examination of Product
		Cleanliness Verification

**Notes:**

- 1: Tooling owned by Northrop Grumman
- 2: This is a re-design of P/N 80210-1
- 3: Thermal cycle is included in acceptance test
- 4: Resonance search before & after vibration
- 5: Space Astrometry Mission

**TANK CHARACTERISTICS (Metrics)**

Operating Pressure, bar 29.99	Total Volume, l 22.79
Proof Pressure, bar 45.16	Prop Volume, l
Cryo Proof, bar NO	Max Design Wt, kg 1.65
Burst Pressure, bar 59.98	Minimum Wall, MM 0.483

**FORGINGS**

FORGINGS P/N	SUPPLIER	Die
80-210061-1, Hemi		
80-210063-1, Cone		

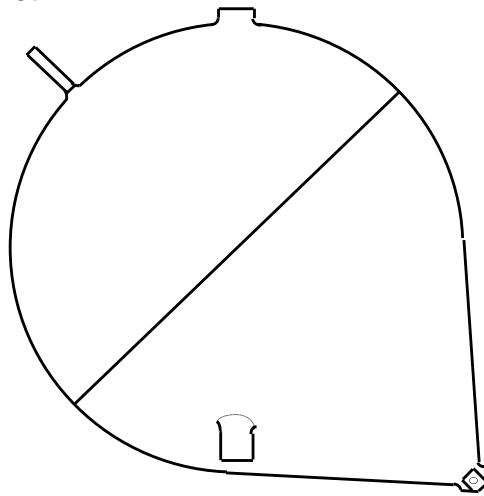
**QUALIFICATION TESTS**

Preliminary Examination of Product
Internal Vacuum
Pre-Proof Volume
Proof Pressure
Post-Proof Volume
Radiographic Inspection
Penetrant Inspection
External Leakage
Vibration
External Leakage
Temperature Extremes
Thermal Cycling
Weight & Center of Mass Determination
Final Examination of Product
Cleanliness Verification

**TUBE TYPE AND SIZE**

TITANIUM	SIZE
80-321030-3, Inlet	.282 OD x .015 Wall
80-321090-3, Outlet	.282 OD x .015 Wall

Inlet



Outlet

