



<b>TANK TYPE</b> Diaphragm	<b>MOUNT</b> Pedestal	<b>LOCATION</b> Apex
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**PSI Part Number 80276-1**

**SIZE: 16.5-inch ID Sphere**  
**SIZE: 419-MM**

PSI Analysis **Stress Fracture**

**ISO 9001 (1994) REGISTERED**

APPLICABLE DOCUMENTS	
Acceptance Test Procedure	50-000220
Qualification Test Procedure	50-000221
Qualification Test Report	56-000081
Traceability	60-000042
Powder Blast	65-000030
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
Heat Treat	90-000082
Closed Die Forging	90-000083
Penetrant Inspection, Note 3	90-000086
Pre-Penetrant Etch, Note 3	90-000088
Radiographic, Note 3	90-000103
Weld, Electron Beam	AMS 2681
Cleaning	CPP 3441

TANK CHARACTERISTICS			
Operating Pressure, psig	<b>320</b>	Total Volume, ci	<b>2,300</b>
Proof Pressure, psig	<b>478</b>	Prop Volume, ci	<b>1,840</b>
Cryo Proof, psig	<b>NA</b>	Max Design Wt, lbs	<b>9.5</b>
Burst Pressure, psig	<b>682</b>	Minimum Wall, inch	<b>0.020</b>

ACCEPTANCE ENVIRONMENTAL TESTS
Random Vibration

DIAPHRAGM INFORMATION	
Diaphragm P/N	80-271007-1
Diaphragm Mold P/N	SK 666
Diaphragm Gross Wt	0.88
Diaphragm Matl Type	AF-E-332
Diaphragm, Material	<b>Note 2</b> 90-000075
Diaphragm Processing	<b>Note 2</b> 90-000087
N-Ray Inspection Procedure	1002

PROGRAM INFORMATION	
Program	ECS
Customer	ERNO
Customer P/N	SK 01066
Original Job No	7908
Customer Installed Device	No
Customer Controlled Design	No

- Notes:**
- 1: Tooling owned by PSI
  - 2: Proprietary Document
  - 3: Fracture Critical

FORGINGS		
FORGINGS P/N	SUPPLIER	Die No
80011-63, Pressurant	ARCTURUS	2272
80-276061-1, Propellant	ARCTURUS	2849A
RING FORGING		RING SIZE. (Rough Machined)
80-214065-1, Retainer	16.75 +.06 OD x 15.5 -.06 ID x 1.4 +/- .06 Lg	
80-276065-1, Base	9.5 +.09 OD x 7.03 -.09 ID x 1.38 +.09 Lg	

TUBE TYPE AND SIZE	
TITANIUM	SIZE
80-276080-3 (2)	

All dimensions are in inches

