



<u>TANK TYPE</u>	<u>MOUNT</u>	<u>LOCATION</u>
Spinner	Bosses	Polar

The tank is a 23-inch spherical pressure vessel constructed from 6AL-4V titanium. Mounting is accomplished on polar bosses. One tube is provided for fuel outlet operation and one (1) tube for tank draining. A smaller version of this tank exists P/N 80182 19".

ATK Part Number 80280-103

SIZE: 23.1-inch ID Sphere
SIZE: 586.7-mm

ISO 9001 & AS 9100 REGISTERED

APPLICABLE DOCUMENTS

Acceptance Test Procedure	50-000273
Cleaning	CPP 3718

Notes:

- 1: Tooling owned by TRW/Govt.
- 2: This is a TRQ designed tank
- 3: This tank has no internal device for expelling the propellant and is therefore used as a spinner tank
- 4: Qual by similarity on 80280-1
- 5: ATP and QTP performed on 80280-1.

TANK CHARACTERISTICS

Operating Pressure, psig	600	Total Volume, ci	6.428
Proof Pressure, psig	900	Prop Volume, ci	4.875
Cryo Proof, psig	1,400	Max Design Wt, lbs	23.5
Burst Pressure, psig	1,200	Minimum Wall, inch	0.052

TANK CHARACTERISTICS (Metrics)

Operating Pressure, bar	41.37	Total Volume, l	105.34
Proof Pressure, bar	62.05	Prop Volume, l	79.89
Cryo Proof, bar	96.53	Max Design Wt, Kg	10.66
Burst Pressure, bar	82.74	Minimum Wall, MM	1.321

FORGINGS

<u>FORGINGS P/N</u>	<u>SUPPLIER</u>	<u>Die</u>
80-280061-1 (2)		

TUBE TYPE AND SIZE

<u>TRANSITION</u>	<u>SIZE</u>
80-280001-1, Drain	.250 OD x .016 Wall
80-280002-1, Outlet	.250 OD x .016 Wall

ACCEPTANCE ENVIRONMENTAL TESTS

Cryogenic Proof

QUALITY TESTS

Qual by similarity on 80280-1

ACCEPTANCE TESTS

Acceptance by similarity on 80280-1