



TANK TYPE	MOUNT	LOCATION
Spinner	Bosses	Polar

This tank is a 19-inch Conosphere (Hemisphere & Cone) constructed of 6AL-4V titanium. Mounting is by polar bosses.

ATK Part Number 80365-1

SIZE: 19.52-inch Conosphere
SIZE: 496-mm

ISO 9001 & AS 9100 REGISTERED

APPLICABLE DOCUMENTS	
Acceptance Test Procedure	50-000410
Qualification Test Procedure	50-000402
Weld Qualification Report	55-000084
Qualification Test Report	56-000150
Cleaning	CPP 3718

TANK CHARACTERISTICS			
Operating Pressure, psig	363	Total Volume, ci	3.992
Proof Pressure, psig	545	Prop Volume, ci	3.992
Cryo Proof, psig	950	Max Design Wt, lbs	8.0
Burst Pressure, psig	726	Minimum Wall, inch	0.026

ACCEPTANCE TESTS
Preliminary Examination of Product
Pre-Proof Volume Determination
Proof Pressure Test
Post Proof Volume Determination
External Leakage Test
Penetrant Inspection
Radiographic Inspection
Final Examination of Product
Weight Determination
Cleanliness Verification

Notes:

- 1: Tooling owned by HAC
- 2: This tank is proprietary to HAC
- 3: Stress/Fracture analysis at HAC
- 4: These items are repeated with each new procurement
- 5: Fracture Critical

TANK CHARACTERISTICS (Metrics)			
Operating Pressure, bar	25.03	Total Volume, l	65.42
Proof Pressure, bar	37.58	Prop Volume, l	65.42
Cryo Proof, bar	65.50	Max Design Wt, Kg	3.63
Burst Pressure, bar	50.06	Minimum Wall, MM	0.660

FORGINGS		
FORGINGS P/N	SUPPLIER	Die
80-365063-1, Cone		
80-365061-1, hemi		

QUALIFICATION TESTS
Examination of Product
Proof Pressure
Pressure Cycle Tests
External Leakage Test
Penetrant Inspection
Radiographic Inspection
Burst Pressure Test
Normalization

TUBE TYPE AND SIZE	
TITANIUM	SIZE
80365-3 (2)	.206 OD x .007 Wall 5.23 x .177 mm

