



TANK & FUEL TYPE	MOUNT	LOCATION	PMD DEVICE
Simple Pmd MMH & NTO	Tabs	Girth	Vane, Trap & Sponge

This tank assembly is a hemispherical pressure vessel. It is mounted by 32 circumferential tabs with nut plates located on one of the hemispheres near the girth weld joint. The tank contains an internally-mounted Propellant Management Device, with perforated sheet & woven screen, fabricated to maintain separation of liquid propellant expulsion from the tank under low or zero gravity conditions.

ATK Part Number 80501-1

ISO 9001 & AS 9100 REGISTERED

SIZE: 48.9-inch ID Sphere X 57.8 Long
SIZE: 1242 X 1468-mm

APPLICABLE DOCUMENTS

Bubble Point Test Procedure	50-000584
Acceptance Test Procedure	50-000674
Protoflight Test Procedure	50-000675
Protoflight Test Report	56-000235
Cleaning	CPP 3849
Qual by Similarity Report	56-000232
Fracture Analysis	54-000259

TANK CHARACTERISTICS

Operating Pressure, psig	250	Total Volume, ci	77,805
Proof Pressure, psig	313	Prop Volume, ci	77,805
Cryo Proof, psig	430	Max Design Wt, lbs	87.6
Burst Pressure, psig	375	Minimum Wall, inch	0.031

ACCEPTANCE TESTS

- Preliminary Inspection of Product
- Mass Measurement
- Pre-Proof Volumetric Capacity
- Ambient Proof Pressure
- Visual Inspection
- Post-Proof Volumetric Capacity
- Cryogenic Proof Pressure
- Visual Inspection
- Post-Proof Volumetric Capacity
- External Leakage Test
- Tank Assembly Bubble Point Test
- Sine Vibration Test and
- Visual Inspection
- Pressure Drop Test
- Tank Assembly Bubble Point Test
- External Leakage Test
- Radiographic Inspection
- Dye Penetrant Inspection
- Cleanliness Check and
- Visual Inspection
- Data Review

TANK CHARACTERISTICS (Metrics)

Operating Pressure, Bar	17.24	Total Volume, l	1,275
Proof Pressure, Bar	21.58	Prop Volume, l	1,275
Cryo Proof, Bar	29.65	Max Design Wt, Kg	39.74
Burst Pressure, Bar	25.85	Minimum Wall, MM	0.787

Notes:

- 1: Tooling owned by ATK
 - 2: Tank shell is similar to P/N 80403-1
 - 3: PMD design is by PMD Technology
 - 4: Cryogenic Fixture: T-4647
 - 5: Tube protectors are SK 1353 & SK 1354
 - 6: Vibration Fixture: T-4646.
- Only the axial axis & one lateral axis to be tested.
- 7: Fracture Critical

FORGINGS

FORGINGS P/N	SUPPLIER	Die
80-363061-1, (2)		
RING FORGING		
RING SIZE, (Rough Machined)		
80-363065-1, Tab	49.75 +/- .06 OD x 48.31 +/- .06 ID x 3.19 +/- .09 Long	
80-380063-1, Trap Base	12.75+ .13, -.00 OD x 6.18+ .00, -.13 ID x 1.38+ .13, -.00 Long	
80-422144-1, Support Plate	13.42+ .13, -.00 OD x 6.62+ .00, -.13 ID x .93+ .13, -.00 Long	
80-380065-1, Platform	13.42+ .13, -.00 OD x 6.62+ .00, -.13 ID x 1.25+ .13, -.00 Long	
80-363063-1, Center Section	49.57+/- .09, OD x 48.4 +/- .09, ID x 9.37 +/- .06, Long	

TUBE TYPE AND SIZE

TRANSITION	SIZE
80-380002-1 (2)	.375" OD x .020" Wall

QUALIFICATION TESTS

Qual by similarity on 80403-1

TUBE TYPE AND SIZE (Metrics)

TRANSITION	SIZE
80-380002-1 (2)	9.525 OD x .5 mm

