



VIEW E
SCALE: 2/1

.2110 MINOR DIA X .65 MAX DEEP
.2190 MIN DRILL POINT ANGLE
CSK 100°±5' X .28 DIA
THREAD .250-28 UNF-3B X .50 MIN DEEP
6 PLACES EQUALLY SPACED

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.2190 MIN DRILL POINT ANGLE
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6 PLACES EQUALLY SPACED

⊕ .030 DIA (A-B) (W) (R)
⊕ .014 DIA (B) (R)
.50 P MINOR DIA

⊕ .014 DIA (A) (W) (R)
⊕ .50 P MINOR DIA

SS-400-6-4AN UNION
REF

SS-400-6-4AN UNION
2 REQD FOR -11
(1 EACH END)

COMMON AXIS OF
"FUEL" AND "GAS"
TUBES TO BE
COPLANAR WITHIN 2° 0'

80-356080-1 HEAD/CENTER SECTION ASSY
1 REQD FOR -21

80-356090-1 EXPULSION ASSY
1 REQD FOR -21

- (-21) TANK, WELDMENT
1 REQD FOR -11
- (-11) TANK, MACHINED
1 REQD FOR -1

ALIGN SCRIBE LINES
WITHIN .06 PRIOR
TO WELD

TRW Pressure Systems, Inc.
LOS ANGELES, CALIFORNIA

TANK, PROPELLANT - 8482

CODE IDENT NO.	SIZE	REV.
18229	E	D
SCALE 1/2	80356	SHEET 1 OF 1