

REV.
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AS1002

FEDERAL SUPPLY CLASS

4730

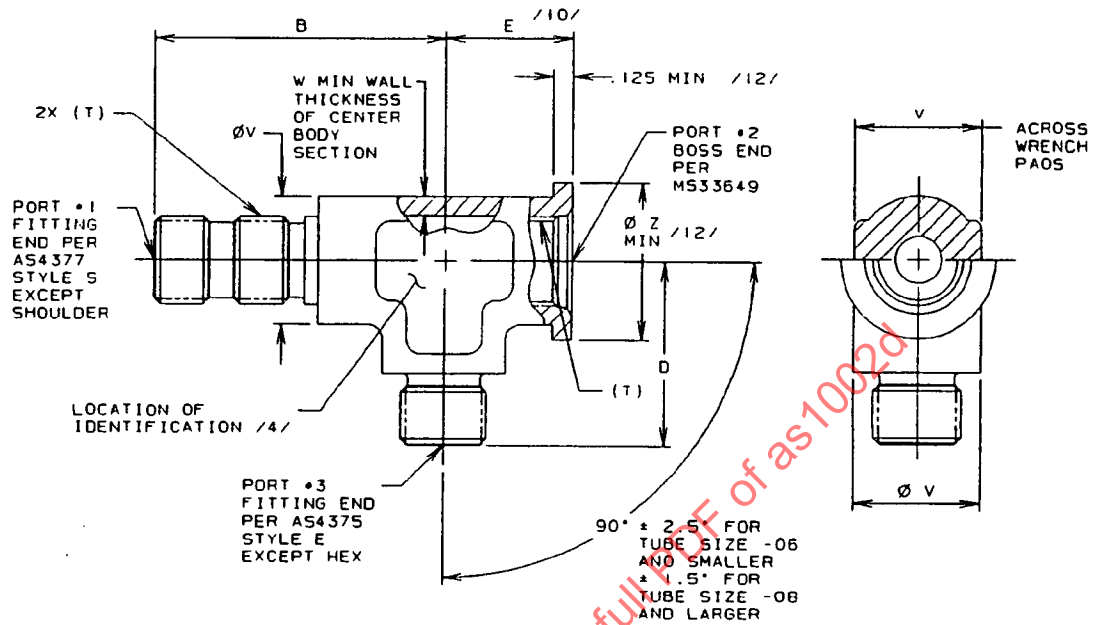


FIGURE 1 - TEE, PORT #2 SHOWN AS NONREDUCER

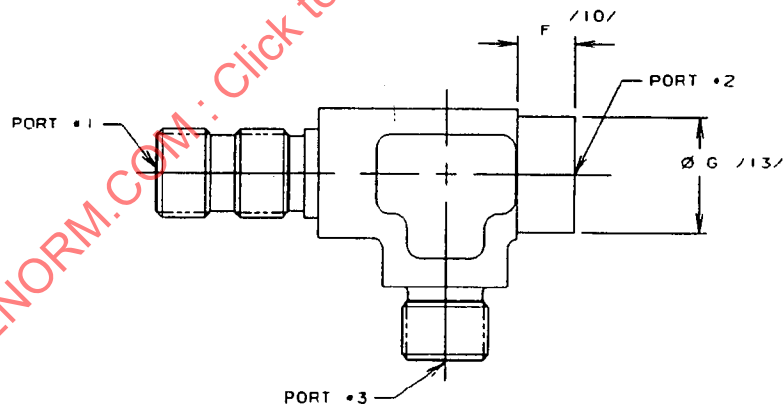
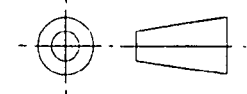


FIGURE 2 - TEE, PORT #2 SHOWN AS REDUCER

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /3/ MIL-F-18280

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400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARDTEE, STANDARD AND REDUCER,
BULKHEAD AND INTERNAL PORT ON RUN,
FLARELESS TUBE**AS1002**

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TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO.						LB/EA	LB/EA	LB/EA	
AS1002									
/11/	/19/	E	F		Z	MAX	MAX	MAX	
SIZE	CODE	/10/	/10/	V	W	/12/	ALUM	CRES	TI
02		.648	---	.500	.090	.562	.018	.051	.029
03		.711	---	.562	.100	.625	.039	.105	.060
04		.773	.375	.750	.110	---	.067	.206	.118
05		.773	.375	.750	.120	.750	.075	.230	.132
06		.836	.375	.875	.120	---	.112	.283	.163
08		1.023	.469	1.062	.150	---	.148	.360	.207
10		1.180	.625	1.062	.170	1.125	.179	.450	.259
12		1.367	.688	1.312	.185	1.375	.284	.850	.490
14		1.507	.706	1.562	.200	---	---	---	---
16		1.555	.719	1.625	.205	1.625	.410	1.100	.634
20		1.742	.781	1.875	.240	1.938	.600	1.540	.888

TABLE 2 - LEG LENGTH B

SIZE OF PORT	FORGING SIZE /11/	FORGING SIZE /11/	FORGING SIZE /11/	FORGING SIZE /11/	FORGING SIZE /11/	FORGING SIZE /11/	FORGING SIZE /11/	FORGING SIZE /11/	FORGING SIZE /11/	FORGING SIZE /11/	FORGING SIZE /11/
#1	02	03	04	05	06	08	10	12	14	16	20
02	1.398	1.430	1.585	1.585	1.758	1.727	1.804	1.683	2.040	2.102	2.242
03	---	1.477	1.632	1.632	1.805	1.774	1.851	1.930	2.087	2.149	2.289
04	---	---	1.695	1.695	1.868	1.837	1.914	1.993	2.150	2.212	2.352
05	---	---	---	1.695	1.868	1.837	1.914	1.993	2.150	2.212	2.352
06	---	---	---	---	1.914	1.883	1.960	2.039	2.196	2.258	2.398
08	---	---	---	---	---	2.055	2.132	2.211	2.368	2.430	2.570
10	---	---	---	---	---	---	2.273	2.352	2.509	2.571	2.711
12	---	---	---	---	---	---	---	2.461	2.618	2.680	2.820
14	---	---	---	---	---	---	---	---	2.618	2.680	2.820
16	---	---	---	---	---	---	---	---	---	2.680	2.820
20	---	---	---	---	---	---	---	---	---	---	2.820

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TABLE 3 - LEG LENGTH D

SIZE OF PORT #2	FORGING SIZE /11/ 02	FORGING SIZE /11/ 03	FORGING SIZE /11/ 04	FORGING SIZE /11/ 05	FORGING SIZE /11/ 06	FORGING SIZE /11/ 08	FORGING SIZE /11/ 10	FORGING SIZE /11/ 12	FORGING SIZE /11/ 14	FORGING SIZE /11/ 16	FORGING SIZE /11/ 20
02	.867	.883	1.039	1.039	1.086	1.180	1.273	1.351	1.492	1.554	1.695
03	---	.930	1.086	1.086	1.133	1.227	1.320	1.398	1.593	1.601	1.742
04	---	---	1.117	1.117	1.164	1.258	1.351	1.429	1.570	1.632	1.773
05	---	---	---	1.117	1.164	1.258	1.351	1.429	1.570	1.632	1.773
06	---	---	---	---	1.180	1.274	1.364	1.445	1.586	1.648	1.789
08	---	---	---	---	---	1.367	1.460	1.538	1.679	1.741	1.882
10	---	---	---	---	---	---	1.523	1.601	1.724	1.804	1.945
12	---	---	---	---	---	---	---	1.664	1.867	1.867	2.008
14	---	---	---	---	---	---	---	---	1.867	1.867	2.008
16	---	---	---	---	---	---	---	---	---	1.867	2.008
20	---	---	---	---	---	---	---	---	---	---	2.008

TABLE 4 - TURNED DIA G /13/

SIZE OF PORT #1	FORGING SIZE /11/ 03	FORGING SIZE /11/ 04	FORGING SIZE /11/ 05	FORGING SIZE /11/ 06	FORGING SIZE /11/ 08	FORGING SIZE /11/ 10	FORGING SIZE /11/ 12	FORGING SIZE /11/ 14	FORGING SIZE /11/ 16	FORGING SIZE /11/ 20
02	---	.594	.594	.594	.594	.594	.594	.594	.594	.594
03	---	.656	.656	.656	.656	.656	.656	.656	.656	.656
04	---	---	---	.719	.719	.719	.719	.719	.719	.719
05	---	---	---	.781	.781	.781	.781	.781	.781	.781
06	---	---	---	---	.844	.844	.844	.844	.844	.844
08	---	---	---	---	---	---	1.062	1.062	1.062	1.062
10	---	---	---	---	---	---	---	1.188	1.188	1.188
12	---	---	---	---	---	---	---	1.438	1.438	1.438
14	---	---	---	---	---	---	---	---	1.562	1.562
16	---	---	---	---	---	---	---	---	---	1.688

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FLARELESS TUBE

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TABLE 5 - TUBE SIZE AND CORRESPONDING THREAD

PORT SIZE	(NOMINAL TUBE SIZE)	
	T THREAD PER MIL-S-8879	
02	.125	.3125-24UNJF
03	.188	.3750-24UNJF
04	.250	.4375-20UNJF
05	.312	.5000-20UNJF
06	.375	.5625-18UNJF
08	.500	.7500-16UNJF
10	.625	.8750-14UNJF
12	.750	1.0625-12UNJ
14	.875	1.1875-12UNJ
16	1.000	1.3125-12UNJ
20	1.250	1.6250-12UNJ

NOTES:

1. MATERIAL:

- a. CODE LETTER D: 2014T6 ALUMINUM ALLOY FORGING PER AMS 4133 OR QQ-A-367; OR 2024T6 ALUMINUM ALLOY BAR PER AMS 4112 OR QQ-A-225/6; OR 2024T851 ALUMINUM ALLOY BAR PER QQ-A-225/6.
- b. CODE LETTER F: 4130 STEEL FORGING OR BAR PER AMS 6370 OR MIL-S-6758.
- c. CODE LETTER J: 30304 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS 5639 OR 304 CORROSION RESISTANT STEEL PER QQ-S-763.
- d. CODE LETTER K: 30316 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS 5648 OR 316 CORROSION RESISTANT STEEL PER QQ-S-763.
- e. CODE LETTER R: 30321 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS 5645 OR 321 CORROSION RESISTANT STEEL PER QQ-S-763. /7/
- f. CODE LETTER S: 30347 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS 5646 OR 347 CORROSION RESISTANT STEEL PER QQ-S-763. /8/
- g. CODE LETTER T: 6AL4V TITANIUM ALLOY FORGING OR BAR PER AMS 492B.
- h. CODE LETTER W: 7075T73 ALUMINUM ALLOY FORGING PER AMS 4141 OR QQ-A-367; OR 7075T7351 ALUMINUM ALLOY BAR PER AMS 4124; OR 7075T73 ALUMINUM ALLOY BAR PER QQ-A-225/9.

2. FINISH:

- a. MATERIAL CODE LETTER D: ANODIZE PER AMS 2472 OR MIL-A-8625, TYPE II, CLASS 2. DYE GREEN, SIMILAR TO COLOR 14187 OF FED-STD-595.
- b. MATERIAL CODE LETTER F: CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2.
- c. MATERIAL CODE LETTER J: PASSIVATE PER QQ-P-35, TYPE VI OR VII.
- d. MATERIAL CODE LETTER K: PASSIVATE PER QQ-P-35, TYPE VI OR VII.
- e. MATERIAL CODE LETTER R: PASSIVATE PER QQ-P-35, TYPE VI OR VII.
- f. MATERIAL CODE LETTER S: PASSIVATE PER QQ-P-35, TYPE VI OR VII.
- g. MATERIAL CODE LETTER T: FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486.
- h. MATERIAL CODE LETTER W: ANODIZE PER AMS 2472 OR MIL-A-8625, TYPE II, CLASS 2. DYE BROWN, SIMILAR TO COLOR 10080 OF FED-STD-595.

- /3/ PROCUREMENT SPECIFICATION: MIL-F-18280 EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION IN A COMPLETE ASSEMBLY. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.