

REV.
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AS1003

FEDERAL SUPPLY CLASS

4730

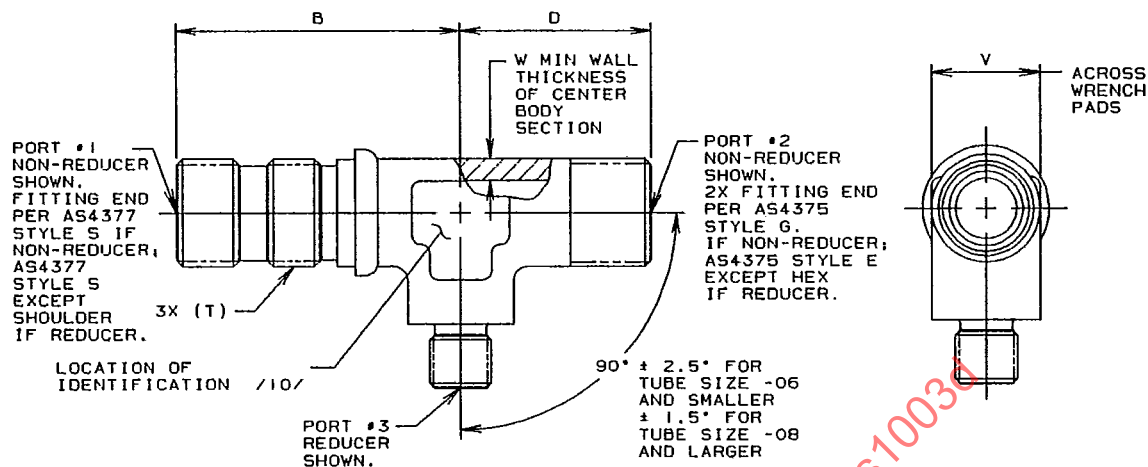
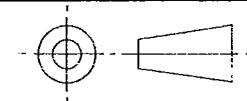


FIGURE 1 - TEE, BULKHEAD ON RUN

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS1003 /10/ /16/ SIZE CODE	V	W	LB/EA MAX ALUM	LB/EA MAX CRES	LB/EA MAX TI
02	.312	.090	.023	.064	.036
03	.375	.100	.026	.074	.042
04	.438	.110	.033	.091	.052
05	.500	.120	.048	.126	.072
06	.562	.120	.056	.155	.089
08	.750	.150	.112	.290	.167
10	.875	.170	.166	.455	.262
12	1.062	.185	.245	.677	.390
14	1.188	.200	---	---	---
16	1.312	.205	.342	.962	.555
20	1.625	.240	.635	1.600	.923
24	1.875	.250	---	---	---
32	2.562	.350	---	---	---

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 STANDARD

TEE, STANDARD AND REDUCER,
BULKHEAD ON RUN,
FLARELESS TUBE

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ISSUED 1966-03-15 REVISED 1992-09-29 (D)

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TABLE 2 - LEG LENGTH B

SIZE OF PORT #1	FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING	
	SIZE /10/ 02	SIZE /10/ 03	SIZE /10/ 04	SIZE /10/ 05	SIZE /10/ 06	SIZE /10/ 08	SIZE /10/ 10	SIZE /10/ 12	SIZE /10/ 14	SIZE /10/ 16	SIZE /10/ 20	SIZE /10/ 24	SIZE /10/ 32	SIZE /10/ 02	SIZE /10/ 03	SIZE /10/ 04	SIZE /10/ 05	SIZE /10/ 06	SIZE /10/ 08	SIZE /10/ 10	SIZE /10/ 12	SIZE /10/ 14	SIZE /10/ 16	SIZE /10/ 20	SIZE /10/ 24	SIZE /10/ 32
02	1.336	1.367	1.413	1.445	1.555	1.664	1.804	1.914	2.024	2.039	2.320	2.602	2.992													
03	---	1.414	1.460	1.492	1.602	1.711	1.851	1.961	2.071	2.086	2.367	2.649	3.039													
04	---	---	1.523	1.555	1.665	1.774	1.914	2.024	2.134	2.149	2.430	2.712	3.102													
05	---	---	---	1.555	1.665	1.774	1.914	2.024	2.134	2.149	2.430	2.712	3.102													
06	---	---	---	---	1.711	1.820	1.960	2.070	2.180	2.195	2.476	2.758	3.148													
08	---	---	---	---	---	1.992	2.132	2.242	2.352	2.367	2.648	2.930	3.320													
10	---	---	---	---	---	---	2.273	2.383	2.493	2.508	2.789	3.071	3.461													
12	---	---	---	---	---	---	---	2.492	2.617	2.617	2.898	3.180	3.570													
14	---	---	---	---	---	---	---	---	2.543	2.617	2.898	3.180	3.570													
16	---	---	---	---	---	---	---	---	---	2.617	2.898	3.180	3.570													
20	---	---	---	---	---	---	---	---	---	---	2.898	3.180	3.570													
24	---	---	---	---	---	---	---	---	---	---	---	---	3.570													
32	---	---	---	---	---	---	---	---	---	---	---	---	---													

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TABLE 3 - LEG LENGTH D

SIZE OF PORT #2 OR #3	FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING	
	SIZE	/10/	SIZE	/10/	SIZE	/10/	SIZE	/10/	SIZE	/10/	SIZE	/10/	SIZE	/10/	SIZE	/10/	SIZE	/10/	SIZE	/10/
02	.804	.883	.883	.977	.992	1.149	1.274	1.335	1.398	1.429	1.476	1.476	1.476	1.476	1.476	1.476	1.476	1.476	1.476	1.476
03	---	.930	.930	1.024	1.039	1.196	1.320	1.383	1.445	1.476	1.476	1.476	1.476	1.476	1.476	1.476	1.476	1.476	1.476	1.476
04	---	---	---	1.055	1.070	1.227	1.352	1.414	1.476	1.507	1.507	1.507	1.507	1.507	1.507	1.507	1.507	1.507	1.507	1.507
05	---	---	---	1.055	1.070	1.227	1.352	1.414	1.476	1.507	1.507	1.507	1.507	1.507	1.507	1.507	1.507	1.507	1.507	1.507
06	---	---	---	---	1.086	1.243	1.368	1.430	1.492	1.523	1.523	1.523	1.523	1.523	1.523	1.523	1.523	1.523	1.523	1.523
08	---	---	---	---	---	1.336	1.461	1.523	1.585	1.616	1.616	1.616	1.616	1.616	1.616	1.616	1.616	1.616	1.616	1.616
10	---	---	---	---	---	---	1.524	1.586	1.648	1.679	1.679	1.679	1.679	1.679	1.679	1.679	1.679	1.679	1.679	1.679
12	---	---	---	---	---	---	---	1.649	1.742	1.742	1.742	1.742	1.742	1.742	1.742	1.742	1.742	1.742	1.742	1.742
14	---	---	---	---	---	---	---	---	2.023	2.023	2.023	2.023	2.023	2.023	2.023	2.023	2.023	2.023	2.023	2.023
16	---	---	---	---	---	---	---	---	---	1.742	1.742	---	---	---	---	---	---	---	---	---
20	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---
24	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---
32	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---

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TABLE 4 - 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
24	1.500	1.8750-12UNJ
32	2.000	2.5000-12UNJ

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 4928.
- 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.

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