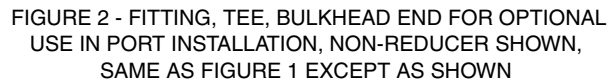


SAE reviews each technical report at least every five years at which time it may be reaffirmed, revised, or cancelled. SAE invites your written comments and suggestions.



PROCUREMENT SPECIFICATION: /4/ AS18280

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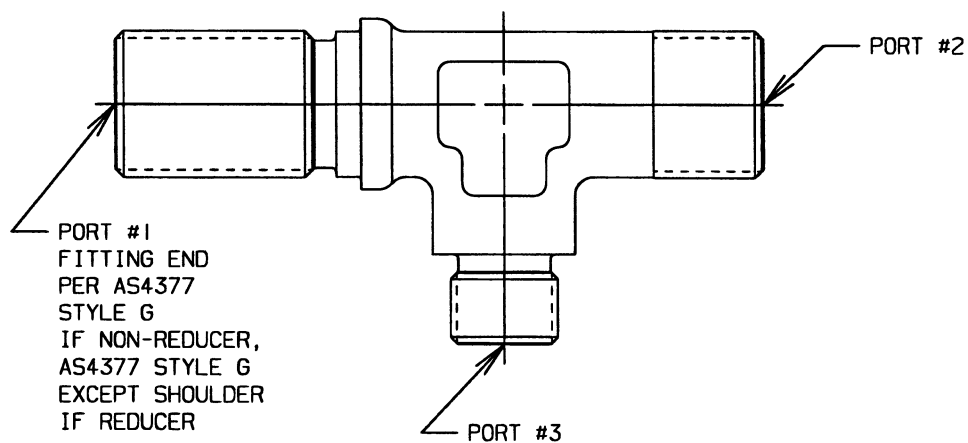


FIGURE 3 - FITTING, TEE, BULKHEAD END NOT FOR USE IN PORT INSTALLATION, PORT #3 SHOWN AS REDUCER, SAME AS FIGURE 1 EXCEPT AS SHOWN

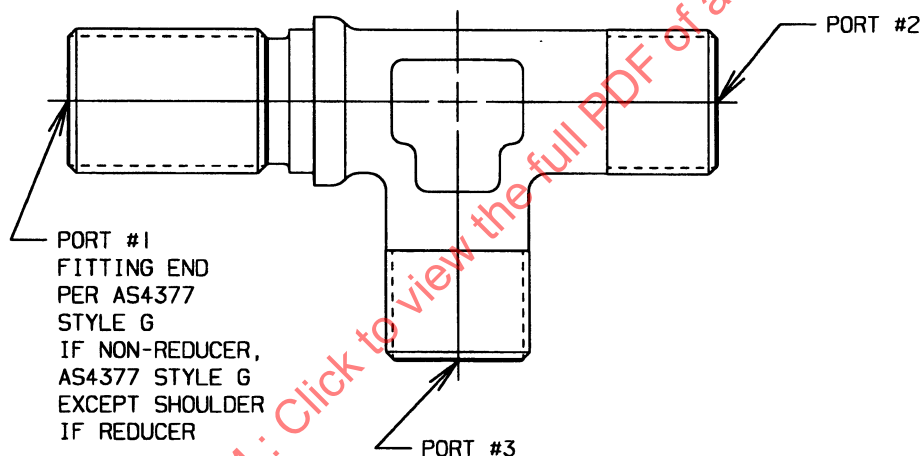


FIGURE 4 - FITTING, TEE, BULKHEAD END NOT FOR USE IN PORT INSTALLATION, NON-REDUCER SHOWN, SAME AS FIGURE 2 EXCEPT AS SHOWN

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AS1003

TABLE 1 - DIMENSIONS AND WEIGHTS /13/

BASIC NO. AS1003 /12/ /21/ SIZE CODE	V	W	LB/EA APPROX REF ALUM	LB/EA APPROX REF STEEL	LB/EA APPROX REF TI
02	.297- .314	.090	.0185	.0531	.0293
03	.360- .377	.100	.0289	.0830	.0458
04	.423- .440	.110	.0373	.107	.0591
05	.485- .502	.120	.0498	.143	.0789
06	.547- .565	.120	.0612	.176	.0969
08	.735- .753	.150	.125	.358	.198
10	.860- .878	.170	.162	.466	.257
12	1.047-1.065	.185	.277	.798	.440
14	1.173-1.191	.200	.372	1.07	.590
16	1.292-1.317	.205	.400	1.15	.634
20	1.605-1.630	.240	.701	2.01	1.11
24	1.855-1.880	.250	.908	2.61	1.44
32	2.542-2.572	.350	1.95	5.60	3.09

TABLE 2 - LEG LENGTH B /14/

FORGING SIZE /12/	TUBE SIZE OF PORT #1 02	TUBE SIZE OF PORT #1 03	TUBE SIZE OF PORT #1 04	TUBE SIZE OF PORT #1 05	TUBE SIZE OF PORT #1 06	TUBE SIZE OF PORT #1 08	TUBE SIZE OF PORT #1 10	TUBE SIZE OF PORT #1 12	TUBE SIZE OF PORT #1 14	TUBE SIZE OF PORT #1 16	TUBE SIZE OF PORT #1 20	TUBE SIZE OF PORT #1 24	TUBE SIZE OF PORT #1 32
02	1.336	-	-	-	-	-	-	-	-	-	-	-	-
03	1.367	1.414	-	-	-	-	-	-	-	-	-	-	-
04	1.413	1.460	1.523	-	-	-	-	-	-	-	-	-	-
05	1.445	1.492	1.555	1.555	-	-	-	-	-	-	-	-	-
06	1.555	1.602	1.665	1.665	1.711	-	-	-	-	-	-	-	-
08	1.664	1.711	1.774	1.774	1.820	1.992	-	-	-	-	-	-	-
10	1.804	1.851	1.914	1.914	1.960	2.132	2.273	-	-	-	-	-	-
12	1.914	1.961	2.024	2.024	2.070	2.242	2.383	2.492	-	-	-	-	-
14	2.024	2.071	2.134	2.134	2.180	2.352	2.493	2.617	2.543	-	-	-	-
16	2.039	2.086	2.149	2.149	2.195	2.367	2.508	2.617	2.617	2.617	-	-	-
20	2.320	2.367	2.430	2.430	2.476	2.648	2.789	2.898	2.898	2.898	2.898	-	-
24	2.602	2.649	2.712	2.712	2.758	2.930	3.071	3.180	3.180	3.180	3.180	3.180	-
32	2.992	3.039	3.102	3.102	3.148	3.320	3.461	3.570	3.570	3.570	3.570	3.570	3.773

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AS1003

TABLE 3 - LEG LENGTH D /14/

FORGING SIZE /12/	TUBE SIZE OF PORT #2 OR #3 02	TUBE SIZE OF PORT #2 OR #3 03	TUBE SIZE OF PORT #2 OR #3 04	TUBE SIZE OF PORT #2 OR #3 05	TUBE SIZE OF PORT #2 OR #3 06	TUBE SIZE OF PORT #2 OR #3 08	TUBE SIZE OF PORT #2 OR #3 10	TUBE SIZE OF PORT #2 OR #3 12	TUBE SIZE OF PORT #2 OR #3 14	TUBE SIZE OF PORT #2 OR #3 16	TUBE SIZE OF PORT #2 OR #3 20	TUBE SIZE OF PORT #2 OR #3 24	TUBE SIZE OF PORT #2 OR #3 32
02	.804	-	-	-	-	-	-	-	-	-	-	-	-
03	.883	.930	-	-	-	-	-	-	-	-	-	-	-
04	.883	.930	.961	-	-	-	-	-	-	-	-	-	-
05	.977	1.024	1.055	1.055	-	-	-	-	-	-	-	-	-
06	.992	1.039	1.070	1.070	1.086	-	-	-	-	-	-	-	-
08	1.149	1.196	1.227	1.227	1.243	1.336	-	-	-	-	-	-	-
10	1.274	1.320	1.352	1.352	1.368	1.461	1.524	-	-	-	-	-	-
12	1.335	1.383	1.414	1.414	1.430	1.523	1.586	1.649	-	-	-	-	-
14	1.398	1.445	1.476	1.476	1.492	1.585	1.648	1.742	2.023	-	-	-	-
16	1.429	1.476	1.507	1.507	1.523	1.616	1.679	1.742	1.742	-	-	-	-
20	1.710	1.757	1.788	1.788	1.804	1.897	1.960	2.023	2.023	2.023	2.023	-	-
24	1.898	1.945	1.976	1.976	1.992	2.085	2.148	2.211	2.211	2.211	2.211	2.211	-
32	2.085	2.132	2.163	2.163	2.179	2.272	2.335	2.398	2.398	2.398	2.398	2.398	2.398

TABLE 4 - TUBE SIZE AND CORRESPONDING THREAD

PORT SIZE	(NOMINAL TUBE SIZE)	T THREAD PER AS8879 CLASS 3A
02	.125	.3125-24 UNJF
03	.188	.3750-24 UNJF
04	.250	.4375-20 UNJF
05	.312	.5000-20 UNJF
06	.375	.5625-18 UNJF
08	.500	.7500-16 UNJF
10	.625	.8750-14 UNJF
12	.750	1.0625-12 UNJ
14	.875	1.8750-12 UNJ
16	1.000	1.3125-12 UNJ
20	1.250	1.6250-12 UNJ
24	1.500	1.8750-12 UNJ
32	2.000	2.5000-12 UNJ