

REV.
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AS1004

FEDERAL SUPPLY CLASS

4730

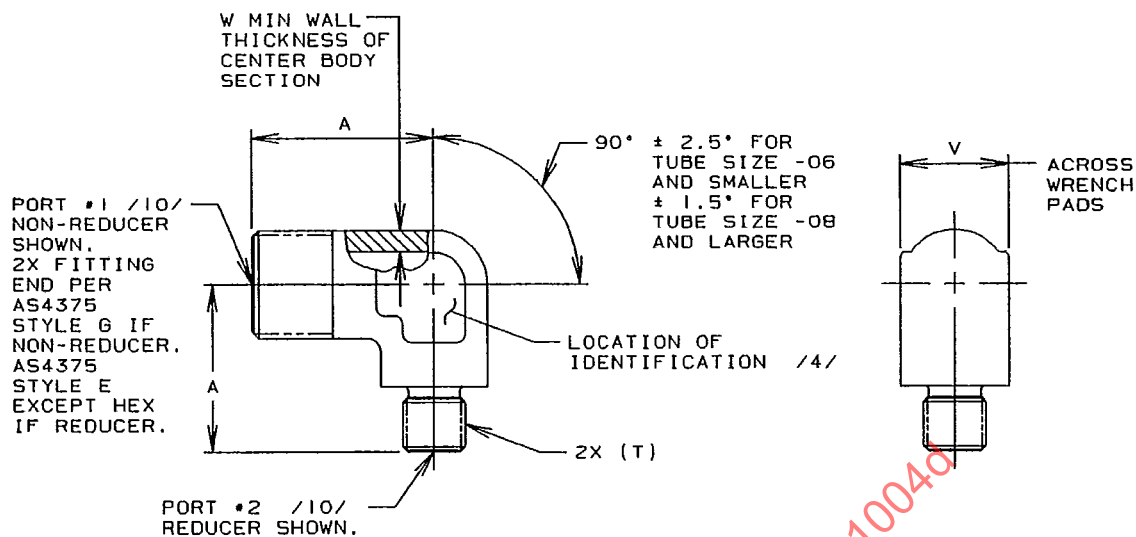
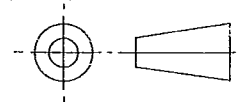


FIGURE 1 - ELBOW, 90°

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS1004 /11/ /17/ SIZE CODE	V	W	LB/EA MAX ALUM	LB/EA MAX CRES	LB/EA MAX TI
02	.312	.090	.014	.040	.023
03	.375	.100	.020	.056	.032
04	.438	.110	.022	.062	.035
05	.500	.120	.031	.086	.049
06	.562	.120	.037	.104	.060
08	.750	.150	.064	.191	.110
10	.875	.170	.087	.258	.148
12	1.062	.185	.135	.402	.231
14	1.188	.200	---	---	---
16	1.312	.205	.200	.535	.308
20	1.625	.240	.265	.792	.456
24	1.875	.250	.463	1.262	.728
32	2.562	.350	1.125	3.062	1.766

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /3/ MIL-F-18280

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INTERNATIONAL

400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARDELBOW, 90°,
STANDARD AND REDUCER,
FLARELESS TUBE**AS1004**

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

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TABLE 2 - LEG LENGTH A

SIZE OF PORT #2	FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING	
	SIZE /11/	02	SIZE /11/	03	SIZE /11/	04	SIZE /11/	05	SIZE /11/	06	SIZE /11/	08	SIZE /11/	10	SIZE /11/	12	SIZE /11/	14	SIZE /11/	16	SIZE /11/	20	SIZE /11/	24	SIZE /11/	32
02	.773		.789		.820		.883	.961	1.086	1.180	1.272	1.398	1.429	1.585	1.710	2.148										
03	---		.836		.867		.930	1.008	1.133	1.226	1.320	1.445	1.476	1.632	1.757	2.195										
04	---		---		.898		.961	1.039	1.164	1.258	1.351	1.476	1.507	1.663	1.788	2.226										
05	---		---		---		.961	1.039	1.164	1.258	1.351	1.476	1.507	1.663	1.788	2.226										
06	---		---		---		---	1.055	1.180	1.274	1.367	1.492	1.523	1.679	1.804	2.242										
08	---		---		---		---	---	1.273	1.367	1.460	1.585	1.616	1.772	1.897	2.335										
10	---		---		---		---	---	---	1.430	1.523	1.648	1.679	1.835	1.960	2.398										
12	---		---		---		---	---	---	---	1.586	1.742	1.742	1.898	2.023	2.461										
14	---		---		---		---	---	---	---	---	1.680	1.742	1.898	2.023	2.461										
16	---		---		---		---	---	---	---	---	---	---	---	---	---										
20	---		---		---		---	---	---	---	---	---	---	---	---	---										
24	---		---		---		---	---	---	---	---	---	---	---	---	---										
32	---		---		---		---	---	---	---	---	---	---	---	---	---										

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AEROSPACE STANDARD

ELBOW, 90°
STANDARD AND REDUCER,
FLARELESS TUBE

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TABLE 3 - 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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