

REV.
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AS1006

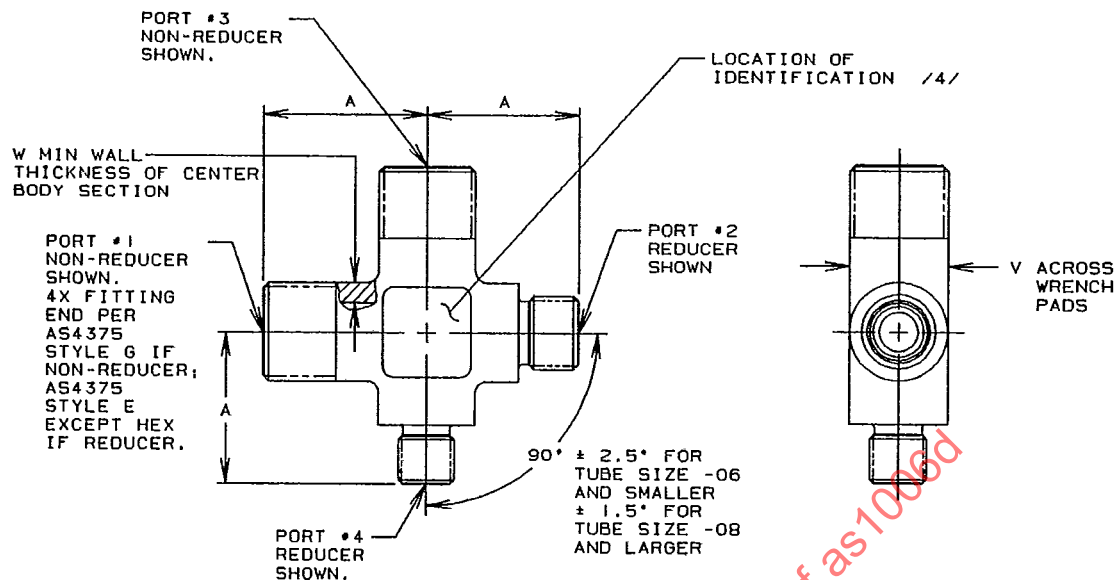
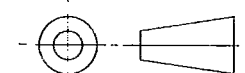
FEDERAL SUPPLY CLASS
4730

FIGURE 1 - CROSS, FLARELESS

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS1006			LB/EA	LB/EA	LB/EA
/11/ /17/			MAX	MAX	MAX
SIZE CODE	V	W	ALUM	CRES	TI
02	.312	.090	.020	.056	.032
03	.375	.100	.025	.071	.040
04	.438	.110	.030	.085	.049
05	.500	.120	.045	.115	.066
06	.562	.120	.055	.134	.077
08	.750	.150	.115	.315	.181
10	.875	.170	.160	.450	.259
12	1.062	.185	.240	.680	.392
14	1.188	.200	---	---	---
16	1.312	.205	.351	1.000	.577
20	1.625	.240	.600	1.595	.920
24	1.875	.250	.727	1.980	1.142
32	2.562	.350	---	---	---

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /3/ MIL-F-18280

SAE The Engineering Society
For Advancing Mobility
Land Sea Air and Space
INTERNATIONAL

400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARD

CROSS,
STANDARD AND REDUCER,
FLARELESS TUBE

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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	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/ 24	SIZE /11/ 24	SIZE /11/ 24	SIZE /11/ 24	SIZE /11/ 24	SIZE /11/ 24	SIZE /11/ 24	
02	.773	.789	.820	.883	.961	1.086	1.180	1.272	1.398	1.429	1.585	1.710	1.710	1.710	1.710	1.710	1.710	1.710	1.710	
03	---	.836	.867	.930	1.008	1.133	1.226	1.320	1.445	1.476	1.632	1.757	1.757	1.757	1.757	1.757	1.757	1.757	1.757	
04	---	---	.898	.961	1.039	1.164	1.258	1.351	1.476	1.507	1.663	1.788	1.788	1.788	1.788	1.788	1.788	1.788	1.788	
05	---	---	---	.961	1.039	1.164	1.258	1.351	1.476	1.507	1.663	1.788	1.788	1.788	1.788	1.788	1.788	1.788	1.788	
06	---	---	---	---	1.055	1.180	1.274	1.367	1.492	1.523	1.679	1.804	1.804	1.804	1.804	1.804	1.804	1.804	1.804	
08	---	---	---	---	---	1.273	1.367	1.460	1.585	1.616	1.772	1.897	1.897	1.897	1.897	1.897	1.897	1.897	1.897	
10	---	---	---	---	---	---	1.430	1.523	1.648	1.679	1.835	1.960	1.960	1.960	1.960	1.960	1.960	1.960	1.960	
12	---	---	---	---	---	---	---	1.586	1.747	1.742	1.898	2.023	2.023	2.023	2.023	2.023	2.023	2.023	2.023	
14	---	---	---	---	---	---	---	---	1.680	1.742	1.898	2.023	2.023	2.023	2.023	2.023	2.023	2.023	2.023	
16	---	---	---	---	---	---	---	---	---	1.742	1.898	2.023	2.023	2.023	2.023	2.023	2.023	2.023	2.023	
20	---	---	---	---	---	---	---	---	---	---	1.898	2.023	2.023	2.023	2.023	2.023	2.023	2.023	2.023	
24	---	---	---	---	---	---	---	---	---	---	---	2.023	2.023	2.023	2.023	2.023	2.023	2.023	2.023	
32	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	

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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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