

REV.
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AS1008

FEDERAL SUPPLY CLASS

4730

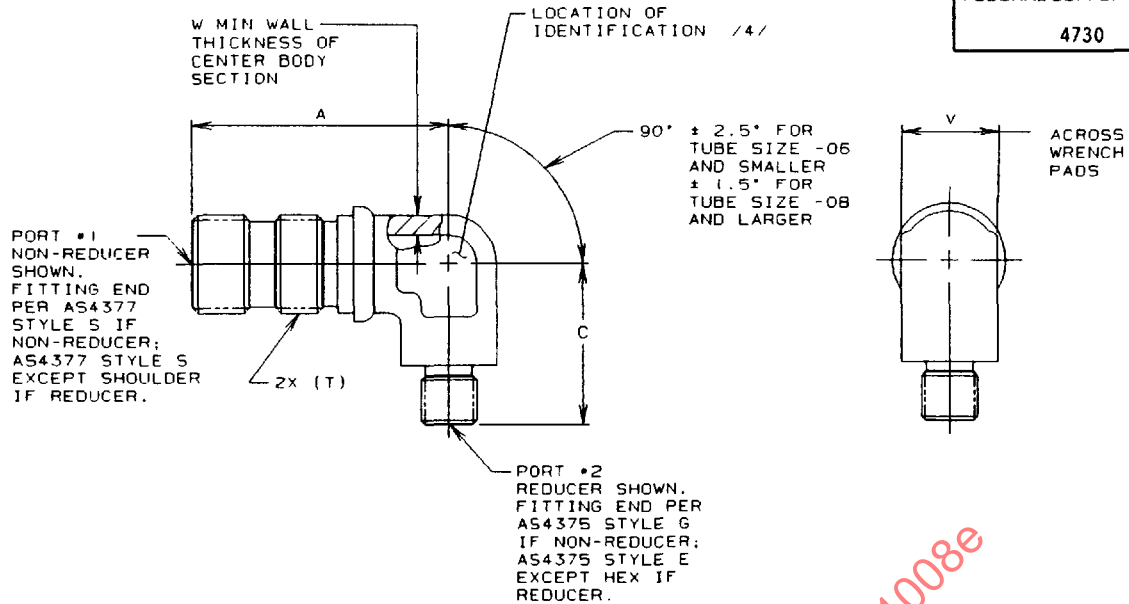
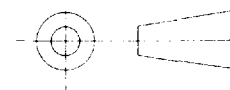


FIGURE 1 - ELBOW, 90°, BULKHEAD

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO.				LB/EA		LB/EA		LB/EA	
AS1008				MAX		MAX		MAX	
/10/ /16/				ALUM		CRES		TI	
SIZE	CODE	V	W						
02		.312	.090	.017		.048		.027	
03		.375	.100	.023		.064		.036	
04		.438	.110	.025		.071		.040	
05		.500	.120	.038		.102		.058	
06		.562	.120	.054		.123		.070	
08		.750	.150	.091		.237		.136	
10		.875	.170	.133		.400		.230	
12		1.062	.185	.190		.560		.305	
14		1.188	.200	---		---		---	
16		1.312	.205	.310		.920		.530	
20		1.625	.240	.524		1.330		.757	
24		1.875	.250	.700		1.960		1.130	
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

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FLARELESS TUBE

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TABLE 2 - LEG LENGTH A

SIZE OF PORT #1	FORGING SIZE /10/ 02	FORGING SIZE /10/ 03	FORGING SIZE /10/ 04	FORGING SIZE /10/ 05	FORGING SIZE /10/ 06	FORGING SIZE /10/ 08	FORGING SIZE /10/ 10	FORGING SIZE /10/ 12	FORGING SIZE /10/ 14	FORGING SIZE /10/ 16	FORGING SIZE /10/ 20	FORGING SIZE /10/ 24	FORGING 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	---	---	---	---	---	---	---	---	---	---	---	3.180	3.570
32	---	---	---	---	---	---	---	---	---	---	---	---	3.773

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TABLE 3 - LEG LENGTH C

SIZE OF PORT #1	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		.977		.992		1.149		1.274		1.335		1.398		1.429		1.710	
03	---		.930		1.024		1.039		1.196		1.320		1.383		1.445		1.476		1.757	
04	---		---		1.055		1.070		1.227		1.352		1.414		1.476		1.507		1.788	
05	---		---		1.055		1.070		1.227		1.352		1.414		1.476		1.507		1.788	
06	---		---		---		1.086		1.243		1.368		1.430		1.492		1.523		1.804	
08	---		---		---		---		1.336		1.461		1.523		1.585		1.616		1.897	
10	---		---		---		---		---		1.524		1.586		1.648		1.679		1.960	
12	---		---		---		---		---		---		1.649		1.742		1.742		2.023	
14	---		---		---		---		---		---		---		1.693		1.742		2.023	
16	---		---		---		---		---		---		---		---		1.742		2.023	
20	---		---		---		---		---		---		---		---		---		2.023	
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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