

TABLE 1A - THREADS AND DIMENSIONS A-E

BASIC NO. AS1300 /12/ SIZE CODE	(TUBE OD)	T THREAD		A MIN	B MIN	C	D	E
		AS8879 CLASS-3B	MINOR DIA MOD					
02	.125	.2160-28UNJF	.1827- .1857	.408	.50	.381- .384	.254- .256	.088-.098
03	.188	.2500-28UNJF	.2167- .2197	.478	.62	.448- .451	.286- .288	.088-.098
04	.250	.3125-24UNJF	.2734- .2764	.524	.68	.495- .498	.339- .341	.088-.098
05	.312	.3750-24UNJF	.3359- .3389	.635	.79	.601- .604	.401- .403	.088-.098
06	.375	.4375-20UNJF	.3903- .3933	.710	.85	.675- .678	.464- .466	.103-.113
08	.500	.5625-18UNJF	.5099- .5129	.826	1.04	.784- .787	.582- .584	.103-.113
10	.625	.6875-24UNJEF	.6484- .6514	1.052	1.17	1.015-1.018	.725- .727	.103-.113
12	.750	.8125-20UNJEF	.7653- .7683	1.182	1.42	1.139-1.142	.899- .901	.103-.113
14	.875	.9375-20UNJEF	.8903- .8933	1.354	1.54	1.311-1.314	1.030-1.032	.103-.113
16	1.000	1.1250-18UNJEF	1.0714-1.0744	1.471	1.67	1.427-1.430	1.162-1.164	.103-.113
20	1.250	1.3125-18UNJEF	1.2599-1.2629	1.795	1.98	1.750-1.753	1.387-1.389	.130-.140
24	1.500	1.6250-18UNJEF	1.5724-1.5754	2.045	2.23	2.000-2.005	1.664-1.666	.130-.140
32	2.000	2.1250-16UNJ	2.0627-2.0657	2.561	2.86	2.516-2.521	2.202-2.204	.130-.140

TABLE 1B - DIMENSIONS F-M AND TOOLING

BASIC NO. AS1300 /12/ SIZE CODE	F	G	H	J	K MIN	L	M	TOOLING /4/	
								(PORTING TOOL NO.)	(BASIC BROACH TOOL NO.)
02	.153-.158	.296-.301	.507	24	.061	.418	.032	RPT02	RFOPB5002
03	.153-.158	.296-.301	.568	26	.061	.488	.032	RPT03	RFOPB5003
04	.153-.158	.296-.301	.568	30	.061	.534	.032	RPT04	RFOPB5004
05	.153-.158	.296-.301	.594	36	.061	.645	.032	RPT05	RFOPB5005
06	.168-.173	.311-.316	.631	36	.073	.720	.035	RPT06	RFOPB5006
08	.168-.173	.311-.316	.672	40	.073	.831	.035	RPT08	RFOPB5008
10	.168-.173	.311-.316	.693	38	.073	1.062	.035	RPT10	RFOPB5010
12	.168-.173	.343-.348	.763	40	.073	1.192	.035	RPT12	RFOPB5012
14	.168-.173	.343-.348	.800	50	.073	1.364	.035	RPT14	RFOPB5014
16	.168-.173	.343-.348	.806	36	.073	1.481	.035	RPT16	RFOPB5016
20	.195-.200	.375-.380	.838	56	.093	1.805	.042	RPT20	RFOPB5020
24	.195-.200	.375-.380	.877	81	.093	2.055	.042	RPT24	RFOPB5024
32	.236-.241	.416-.421	1.050	102	.093	2.571	.042	RPT32	RFOPB5032

NOTES:

1. THE DRILL AND PORTING TOOL METHOD OF PREPARING THE MACHINED CAVITY IS MANDATORY FOR USE WITH RING-LOCKED FITTING INSTALLED IN ACCORDANCE WITH AS1301. DRILL .015-.030 SMALLER THAN MINOR DIA MODIFIED SPECIFIED. THE PORTING TOOL WILL SIZE THE MINOR DIA AND PROVIDE BALANCE OF CAVITY CONFIGURATION READY FOR BROACHING SERRATION.

/2/ AFTER SERRATIONS ARE BROACHED, CHIP REMOVAL IS REQUIRED.