

Technical drawing of a mechanical part, likely a valve or fitting, showing a side view and a cross-section view.

Side View Dimensions and Features:

- Dimensions:** A, B, J, 2X D, 2X (T), 2X R.060/.015, 2X 45°, 90° ± 0° 30'.
- Features:** LOCATION OF IDENTIFICATION /5/, PORT #1, PORT #2, PORT #3, AS4701 RETAINING WIRE, AS4702 RETAINED NUT /9/, R.030-.125 /8/.
- Notes:** PORT #1 2X FITTING END PER AS4658 STYLE E EXCEPT AS SHOWN.

Cross-Section View Dimensions and Features:

- Dimensions:** J, 2X D, 2X (T), 2X R.060/.015, 2X 45°, 3X ØJ.
- Features:** ACROSS WRENCH PADS, H MIN WALL THICKNESS OF CENTER BODY SECTION.

VIEW A ENLARGED: A detailed view of a corner of the part, showing a 90° ± 0° 30' angle.

FIGURE 1 - TEE ASSEMBLY

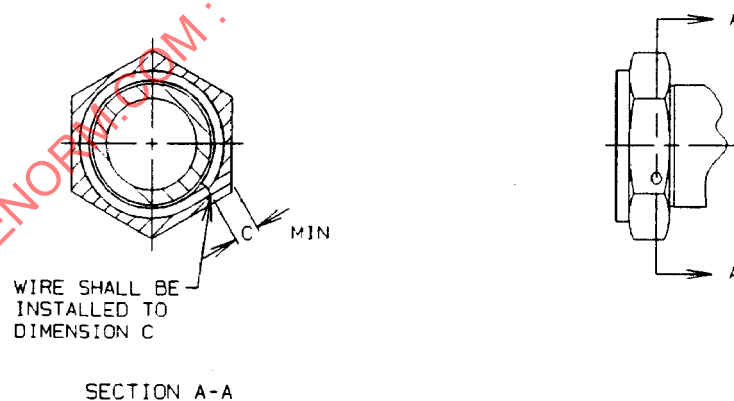


FIGURE 2 - INSTALLATION, RETAINED NUT AND RETAINING WIRE

PROCUREMENT SPECIFICATION: /4/ MIL-F-18280

AS4675
SHEET 1 OF 4

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4675	(NOMINAL TUBE SIZE)	T THREAD PER MIL-S-8879	A	B	C	D	H	J +.005/- .020	LB/EA MAX ALUM	LB/EA MAX CRES	LB/EA MAX TI
/10/ /16/ SIZE CODE											
20	1.250	1.5625-12UNJ	1.678	1.603	.155	.517	.124	1.375	.395	1.146	.666
24	1.500	1.8125-12UNJ	1.803	1.756	.180	.614	.156	1.688	.570	1.651	.954

NOTES:

/1/ MATERIAL:

a. CODE LETTER T:

- (1) BODY: TYPE 6AL-4V TITANIUM ALLOY PER AMS 4928
- (2) NUT: CODE LETTER T OF AS4702 REFERENCE (TYPE 6AL-4V TITANIUM ALLOY)
- (3) WIRE: PER AS4701 REFERENCE (CLASS 302 OR 305 CORROSION RESISTANT STEEL)

b. CODE LETTER V:

- (1) BODY: TYPE 15-5PH CORROSION RESISTANT STEEL PER AMS 5659
- (2) NUT: CODE LETTER V OF AS4702 REFERENCE (TYPE 15-5PH CORROSION RESISTANT STEEL)
- (3) WIRE: PER AS4701 REFERENCE (CLASS 302 OR 305 CORROSION RESISTANT STEEL)

c. CODE LETTER W:

- (1) BODY: TYPE 7075-T73 ALUMINUM ALLOY FORGING PER AMS 4141 OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS 4124
- (2) NUT: CODE LETTER W OF AS4702 REFERENCE (TYPE 7075-T73 ALUMINUM ALLOY)
- (3) WIRE: PER AS4701 REFERENCE (CLASS 302 OR 305 CORROSION RESISTANT STEEL)

2. HEAT TREATMENT:

a. MATERIAL CODE LETTER T:

- (1) BODY, NUT, AND WIRE: NONE

b. MATERIAL CODE LETTER V:

- (1) BODY: HEAT TREAT TO CONDITION H-1075 PER AMS 2759/3
- (2) NUT: MATERIAL CODE LETTER V OF AS4702 REFERENCE (HEAT TREAT TO CONDITION H-1075)
- (3) WIRE: NONE

c. MATERIAL CODE LETTER W:

- (1) BODY, NUT, AND WIRE: NONE

/3/ FINISH:

a. MATERIAL CODE LETTER T:

- (1) BODY: FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486
- (2) NUT: CODE LETTER T OF AS4702 OR AS1790 WITH SUFFIX N REFERENCE (FLUORIDE PHOSPHATE CONVERSION COAT AND COAT WITH DRY LUBRICANT ON ID)
- (3) WIRE: PER AS4701 OR AS1791 REFERENCE (PASSIVATE AND COAT WITH DRY LUBRICANT)

NOTES (Continued):

b. MATERIAL CODE LETTER V:

(1) BODY:

- (a) V CODE PARTS TO BE PASSIVATED ONLY WILL HAVE NO FINISH CODE LETTER AFTER THE PART NUMBER. THE FINISH WILL BE: PASSIVATE PER QQ-P-35, TYPE II OR VIII.
- (b) V CODE PARTS TO BE CADMIUM PLATED ONLY WILL HAVE THE FINISH CODE LETTER "P" AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE: CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2.

(2) NUT: CODE LETTER V OF AS4702 OR AS1790 REFERENCE

- (a) NO FINISH CODE LETTER AT END OF PART NUMBER: PASSIVATE AND COAT WITH DRY FILM LUBRICANT ON ID
- (b) FINISH CODE LETTER P AT END OF PART NUMBER: CADMIUM PLATE

(3) WIRE: PER AS4701 OR AS1791 REFERENCE (PASSIVATE AND COAT WITH DRY LUBRICANT)

c. MATERIAL CODE LETTER W:

- (1) BODY: ANODIZE PER AMS 2472 DYED BROWN, SIMILAR TO COLOR 10080 OF FED-STD-595
- (2) NUT: CODE LETTER W OF AS4702 OR AS1790 WITH SUFFIX N REFERENCE (ANODIZE DYED BROWN AND COAT WITH DRY LUBRICANT)
- (3) WIRE: PER AS4701 OR AS1791 REFERENCE. FINISH CODE LETTER P AT END OF PART NUMBER (CADMIUM PLATE)

/4/ PROCUREMENT SPECIFICATION: MIL-F-18280 EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION AS APPLICABLE IN A COMPLETE ASSEMBLY. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.

/5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B. MANUFACTURER'S NAME, TRADEMARK OR CAGE CODE, BASIC PART NUMBER AND MATERIAL CODE LETTER.

6. THIS PART IS DESIGNED FOR USE IN SYSTEMS WITH OPERATING PRESSURES AS FOLLOWS:

- a. SIZES -20 AND -24 TITANIUM ALLOY AND CORROSION RESISTANT STEEL AT 3000 psi
- b. SIZES -20 AND -24 ALUMINUM ALLOY AT 600 psi

7. WHEN MACHINED FROM BAR OR OVERSIZED FORGINGS THE CENTER BODY SECTION SHALL CONFORM TO AS1376, TABLE 10

/8/ RADIUS APPLICABLE FOR TITANIUM PARTS ONLY.

/9/ ASSEMBLE AS4702 RETAINED NUT TO FITTING BODY WITH AS4701 RETAINING WIRE AS SHOWN IN FIGURE 2. THE NUT SHALL BE FREE TO ROTATE AFTER ASSEMBLY.

/10/ THIS IS A NONREDUCER FITTING. ALL PORTS OF ANY GIVEN PART WILL BE THE SAME SIZE. FOR REDUCERS USE AS4692.

11. INTERPRETATION OF DRAWING PER ARP4296.

12. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36; REQUIREMENTS PER ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 μ in Ra.

13. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.