

REV.
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AS4680

FEDERAL SUPPLY CLASS
4730

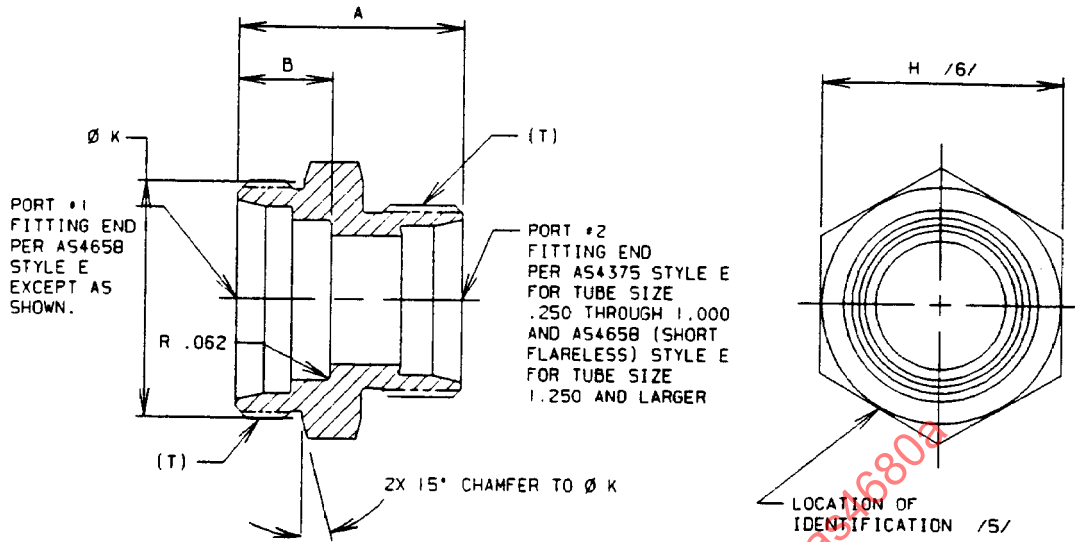
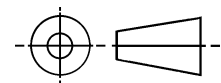


FIGURE 1 - FITTING, UNION, REDUCER

TABLE 1 - DIMENSIONS

PORT #1 SIZE /6/	A PORT #2 SIZE 04	A PORT #2 SIZE 06	A PORT #2 SIZE 08	A PORT #2 SIZE 10	A PORT #2 SIZE 12	A PORT #2 SIZE 16	A PORT #2 SIZE 20	A PORT #2 SIZE 24
20	1.291	1.307	1.400	1.463	1.526	1.526	--	--
24	--	--	--	--	1.589	1.589	1.301	--
28	--	--	--	--	--	1.589	1.364	1.364

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ MIL-F-18280

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

FITTING, UNION, REDUCER, SHORT FLARELESS
AND FLARELESS TO BOSS

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SHEET 1 OF 3

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TABLE 2 - PORT SIZES, CORRESPONDING THREADS, HEX SIZES AND HOLE DEPTH

PORT SIZE	(NOMINAL TUBE SIZE)	T THREAD PER MIL-S-8879	B	H	K
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	1.5625-12UNJ	.650	1.615-1.630	1.605
24	1.500	1.8125-12UNJ	.682	1.865-1.880	1.855
28	1.750	2.1250-12UNJ	.682	2.240-2.260	2.230

NOTES:

/1/ MATERIAL:

- a. CODE LETTER T: TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS 4928
- b. CODE LETTER V: TYPE 15-5PH CORROSION RESISTANT STEEL BAR PER AMS 5659
- c. CODE LETTER W: TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS 4124

2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER T: NONE
- b. MATERIAL CODE LETTER V: HEAT TREAT TO CONDITION H-1075 PER AMS 2759/3
- c. MATERIAL CODE LETTER W: NONE

/3/ FINISH:

- a. MATERIAL CODE LETTER T: FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486
- b. MATERIAL CODE LETTER V:
 - (1) V CODE PARTS TO BE PASSIVATED ONLY WILL HAVE NO FINISH CODE LETTER AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE: PASSIVATE PER QQ-P-35, TYPE II OR VIII.
 - (2) 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.
- c. MATERIAL CODE LETTER W: ANODIZE PER AMS 2472 OR PER MIL-A-8625, TYPE II, CLASS 2 DYED BROWN SIMILAR TO COLOR 10080 OF FED-STD-595

/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.