

REV.
B

SAE AS4680

FEDERAL SUPPLY CLASS
4730

RATIONALE

CANCELED MILITARY STANDARD NUMBERS HAVE BEEN REPLACED. PRI-QPL NOTE HAS BEEN UPDATED AND CADMIUM WARNING NOTE ADDED. OTHER UPDATES.

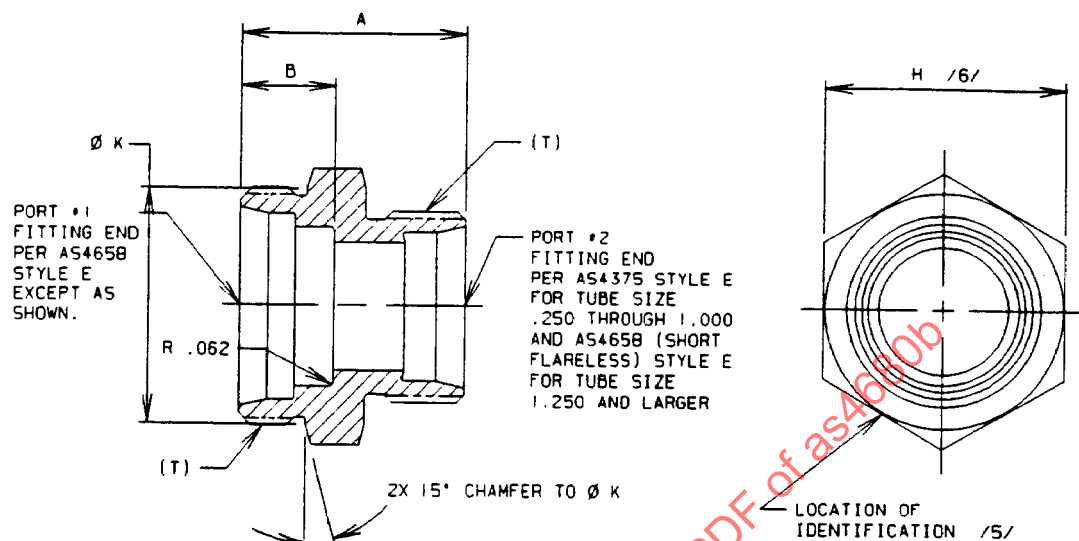


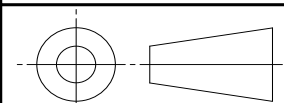
FIGURE 1 - FITTING, UNION, REDUCER

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

SAE values your input. To provide feedback
on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS4680B>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS18280

SAE Aerospace
An SAE International Group

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

SAE AS4680
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REV.
B

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

PORT SIZE	(NOMINAL TUBE SIZE)	T THREAD PER AS8879 CLASS 3A	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:

NOTICE

THIS DOCUMENT REFERENCES A PART WHICH CONTAINS CADMIUM AS A PLATING MATERIAL. CONSULT LOCAL OFFICIALS IF YOU HAVE QUESTIONS CONCERNING CADMIUM'S USE.

/1/ MATERIAL:

- a. CODE LETTER T: TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS4928
- b. CODE LETTER V: TYPE 15-5PH CORROSION RESISTANT STEEL BAR PER AMS5659
- c. CODE LETTER W: TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS4124

2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER T: NONE
- b. MATERIAL CODE LETTER V: HEAT TREAT TO CONDITION H-1075 PER AMS2759/3
- c. MATERIAL CODE LETTER W: NONE

/3/ FINISH:

- a. MATERIAL CODE LETTER T - FLUORIDE PHOSPHATE CONVERSION COAT PER AMS2486
- 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 AMS2700 TYPE 2 OR 8.
 - (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 AMS-QQ-P-416, TYPE II, CLASS 2.
- c. MATERIAL CODE LETTER W: ANODIZE PER AMS2472 OR PER MIL-A-8625, TYPE II, CLASS 2 DYED BROWN SIMILAR TO COLOR 10080 OF FED-STD-595