

AS4681

FEDERAL SUPPLY CLASS
4730

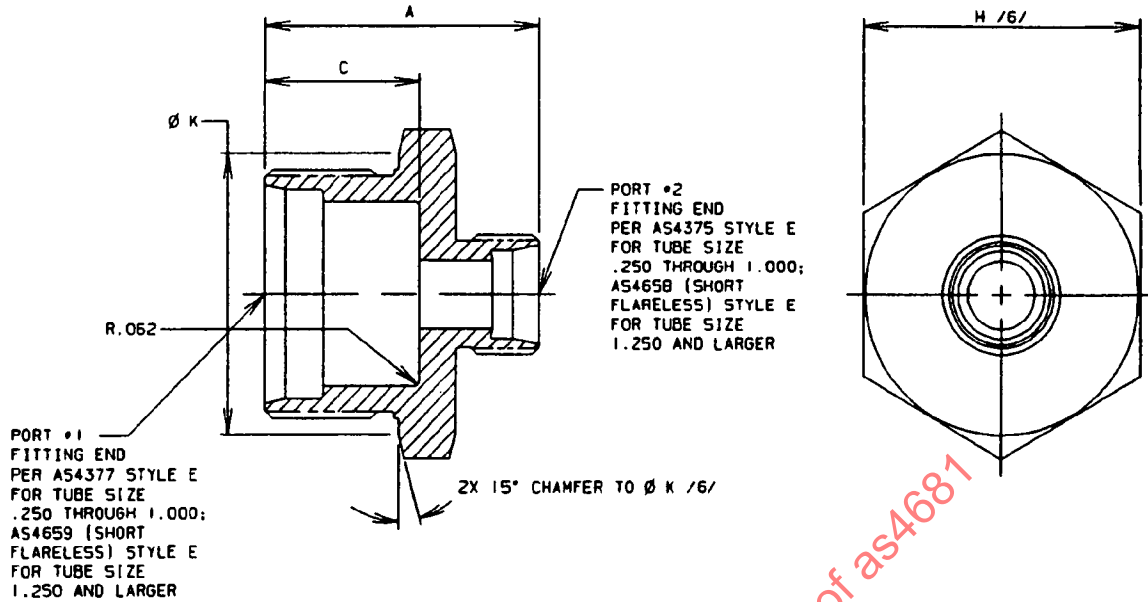


FIGURE 1 - UNION, REDUCER, BULKHEAD, FLARELESS END SHOWN AS REDUCER

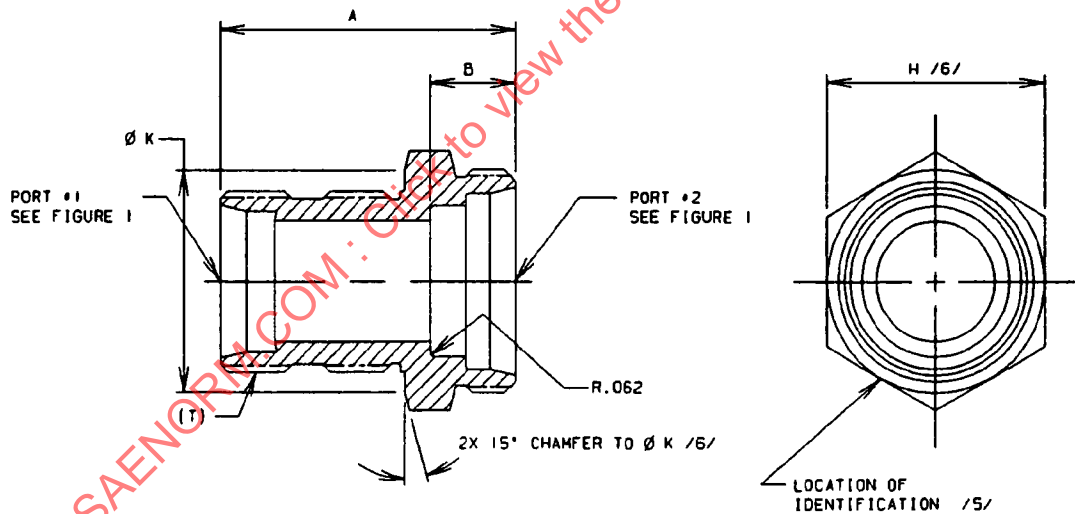
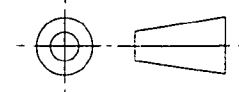


FIGURE 2 - UNION, EXPANDER, BULKHEAD, BULKHEAD END SHOWN AS REDUCER

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ MIL-F-18280

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400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARD

UNION, REDUCER, EXPANDER
BULKHEAD, FLARELESS AND
SHORT FLARELESS

AS4681

SHEET 1 OF 3

ISSUED 1992-07-15 REVISED

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TABLE 1 - PORT SIZES, CORRESPONDING THREADS, HEX SIZES AND DRILL DEPTH

PORT SIZE	(NOMINAL TUBE SIZE)	T THREAD PER MIL-S-8879	B	C	H1	H2	K1	K2
04	.250	.4375-20UNJF	--	--	--	--	--	--
06	.375	.5625-18UNJF	--	--	--	--	--	--
08	.500	.7500-16UNJF	--	--	--	--	--	--
10	.625	.8750-14UNJF	--	--	--	--	--	--
12	.750	1.0625-12UNJ	--	--	--	--	--	--
16	1.000	1.3125-12UNJ	--	--	--	--	--	--
20	1.250	1.5625-12UNJ	.650	1.284	1.865-1.880	1.615-1.630	1.885	1.605
24	1.500	1.8125-12UNJ	.682	1.312	2.115-2.130	1.865-1.880	2.042	1.855
28	1.750	2.1250-12UNJ	.682	1.312	2.365-2.385	2.240-2.260	2.355	2.230

TABLE 2 - DIMENSIONS

PORT #1 SIZE	A PORT #2 SIZE FLARELESS /6/ 04	A PORT #2 SIZE FLARELESS /6/ 06	A PORT #2 SIZE FLARELESS /6/ 08	A PORT #2 SIZE FLARELESS /6/ 10	A PORT #2 SIZE FLARELESS /6/ 12	A PORT #2 SIZE FLARELESS /6/ 16	A PORT #2 SIZE FLARELESS /6/ 20	A PORT #2 SIZE FLARELESS /6/ 24	A PORT #2 SIZE FLARELESS /6/ 28
04	--	--	--	--	--	--	1.914	--	--
06	--	--	--	--	--	--	1.960	--	--
08	--	--	--	--	--	--	2.101	--	--
10	--	--	--	--	--	--	2.242	--	--
12	--	--	--	--	--	--	2.351	2.414	--
16	--	--	--	--	--	--	2.351	2.414	2.414
20	1.952	1.968	2.061	2.125	2.187	2.187	--	2.025	2.025
24	--	--	--	--	2.250	2.250	2.025	--	2.025
28	--	--	--	--	--	2.250	2.025	2.025	--