

REV.
A

SAE AS6048

RATIONALE

FEDERAL SUPPLY CLASS
4730

THREAD SPEC CORRECTED
MATERIAL CODE LETTER W HEAT TREATMENT CORRECTED
MATERIAL CODE LETTER W ANODIZE CORRECTED

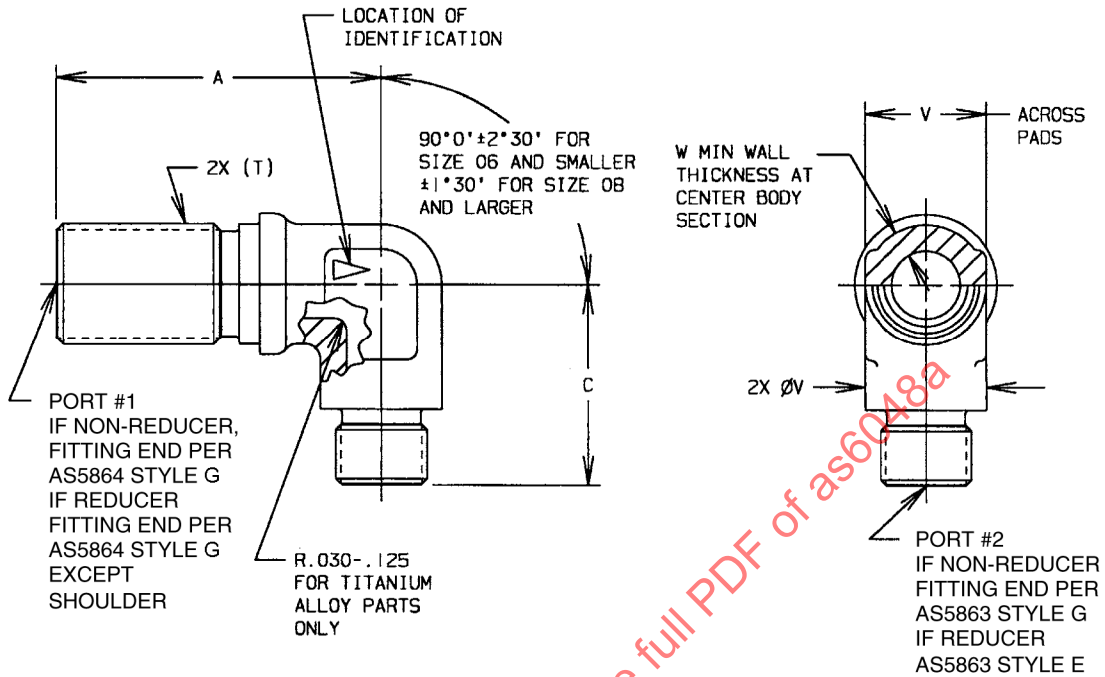


FIGURE 1 - FITTING, ELBOW, 90 DEGREE, BULKHEAD END, PORT #2 SHOWN AS REDUCER

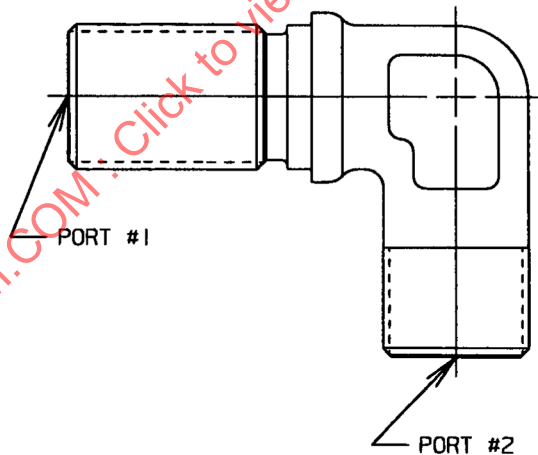
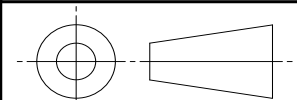


FIGURE 2 - FITTING, ELBOW, 90 DEGREE, BULKHEAD END, SHOWN AS NON-REDUCER, SAME AS FIGURE 1 EXCEPT AS SHOWN

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS6048A>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /5/ AS18280

SAE Aerospace
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AEROSPACE STANDARD

FITTING, ELBOW, 90 DEGREE,
STANDARD AND REDUCER,
BULKHEAD, FLARELESS, PRECISION TYPE

SAE AS6048
SHEET 1 OF 4

REV.
A

TABLE 1 - DIMENSIONS AND WEIGHTS /9/ /10/

BASIC NO. AS6048 /19/ SIZE CODE	V	W	LB/EA APPROX REF ALUM	LB/EA APPROX REF STEEL	LB/EA APPROX REF TI
02	.297- .314	.090	.0153	.0432	.0243
03	.360- .377	.100	.0207	.0576	.0324
04	.423- .440	.110	.0225	.0639	.0360
05	.485- .502	.120	.0342	.0918	.0522
06	.547- .565	.120	.0486	.111	.0630
08	.735- .753	.150	.0819	.213	.122
10	.860- .878	.170	.120	.360	.207
12	1.047-1.065	.185	.171	.504	.274
14	1.173-1.191	.200	-	-	-
16	1.292-1.317	.205	.279	.828	.477
20	1.605-1.630	.240	.472	1.20	.681
24	1.855-1.880	.250	.630	1.76	1.02
32	2.542-2.572	.350	-	-	-

TABLE 2 - LEG LENGTH A /9/ /11/

FORGING SIZE	02	03	04	05	06	08	10	12	14	16	20	24	32
02	1.336	-	-	-	-	-	-	-	-	-	-	-	-
03	1.367	1.414	-	-	-	-	-	-	-	-	-	-	-
04	1.413	1.460	1.523	-	-	-	-	-	-	-	-	-	-
05	1.445	1.492	1.555	1.555	-	-	-	-	-	-	-	-	-
06	1.555	1.602	1.665	1.665	1.711	-	-	-	-	-	-	-	-
08	1.664	1.711	1.774	1.774	1.820	1.992	-	-	-	-	-	-	-
10	1.804	1.851	1.914	1.914	1.960	2.132	2.273	-	-	-	-	-	-
12	1.914	1.961	2.024	2.024	2.070	2.242	2.383	2.492	-	-	-	-	-
14	2.024	2.071	2.134	2.134	2.180	2.352	2.493	2.617	2.543	-	-	-	-
16	2.039	2.086	2.149	2.149	2.195	2.367	2.508	2.617	2.617	2.617	-	-	-
20	2.320	2.367	2.430	2.430	2.476	2.648	2.789	2.898	2.898	2.898	2.898	-	-
24	2.602	2.649	2.712	2.712	2.758	2.930	3.071	3.180	3.180	3.180	3.180	3.180	-
32	2.992	3.039	3.102	3.102	3.148	3.320	3.461	3.570	3.570	3.570	3.570	3.570	3.773

TABLE 3 - LEG LENGTH C /9/ /11/

FORGING SIZE	02	03	04	05	06	08	10	12	14	16	20	24	32
02	.804	-	-	-	-	-	-	-	-	-	-	-	-
03	.883	.930	-	-	-	-	-	-	-	-	-	-	-
04	.883	.930	.961	-	-	-	-	-	-	-	-	-	-
05	.977	1.024	1.055	1.055	-	-	-	-	-	-	-	-	-
06	.992	1.039	1.070	1.070	1.086	-	-	-	-	-	-	-	-
08	1.149	1.196	1.227	1.227	1.243	1.336	-	-	-	-	-	-	-
10	1.274	1.320	1.352	1.352	1.368	1.461	1.524	-	-	-	-	-	-
12	1.335	1.383	1.414	1.414	1.430	1.523	1.586	1.649	-	-	-	-	-
14	1.398	1.445	1.476	1.476	1.492	1.585	1.648	1.742	1.693	-	-	-	-
16	1.429	1.476	1.507	1.507	1.523	1.616	1.679	1.742	1.742	1.742	-	-	-
20	1.710	1.757	1.788	1.788	1.804	1.897	1.960	2.023	2.023	2.023	2.023	-	-
24	1.898	1.945	1.976	1.976	1.992	2.085	2.148	2.211	2.211	2.211	2.211	2.211	-
32	2.085	2.132	2.163	2.163	2.179	2.272	2.335	2.398	2.398	2.398	2.398	2.398	2.398

TABLE 4 - TUBE SIZE AND CORRESPONDING THREAD

PORT SIZE	(NOMINAL TUBE SIZE)	T THREAD PER AS8879
02	.125	.3125-24 UNJF
03	.188	.3750-24 UNJF
04	.250	.4375-20 UNJF
05	.312	.5000-20 UNJF
06	.375	.5625-18 UNJF
08	.500	.7500-16 UNJF
10	.625	.8750-14 UNJF
12	.750	1.0625-12 UNJ
14	.875	1.1875-12 UNJ
16	1.000	1.3125-12 UNJ
20	1.250	1.6250-12 UNJ
24	1.500	1.8750-12 UNJ
32	2.000	2.5000-12 UNJ

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 PER PROCUREMENT SPECIFICATION
- B. CODE LETTER V – TYPE 15-5PH, CORROSION RESISTANT STEEL PER PROCUREMENT SPECIFICATION
- C. CODE LETTER W – TYPE 7075-T73 ALUMINUM ALLOY BAR OR FORGING, OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER PROCUREMENT SPECIFICATION

2. HEAT TREATMENT:

- A. MATERIAL CODE LETTER T – ANNEALED PER PROCUREMENT SPECIFICATION
- B. MATERIAL CODE LETTER V – AGE TO CONDITION H1075 PER PROCUREMENT SPECIFICATION
- C. MATERIAL CODE LETTER W – ELECTRICAL CONDUCTIVITY AND HARDNESS PER PROCUREMENT SPECIFICATION

/3/ FINISH:

- A. MATERIAL CODE LETTER T – ANODIZE OR FLUORIDE PHOSPHATE CONVERSION COAT PER PROCUREMENT SPECIFICATION
- 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 PROCUREMENT SPECIFICATION.
 - 2. V CODE PARTS TO BE CADMIUM PLATED ONLY SHALL HAVE THE FINISH CODE LETTER "P" AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE: CADMIUM PLATE PER PROCUREMENT SPECIFICATION.
- C. MATERIAL CODE LETTER W – ANODIZE PER PROCUREMENT SPECIFICATION

/4/ OXYGEN SYSTEM AND COMPONENT CLEANING, SUFFIX LETTER A /19/:

- A. MATERIAL CODE LETTER P – CLEAN AND PACKAGE PER ARP1176 CATEGORY 1C
- B. MATERIAL CODE LETTER W – CLEAN AND PACKAGE PER ARP1176 CATEGORY 2