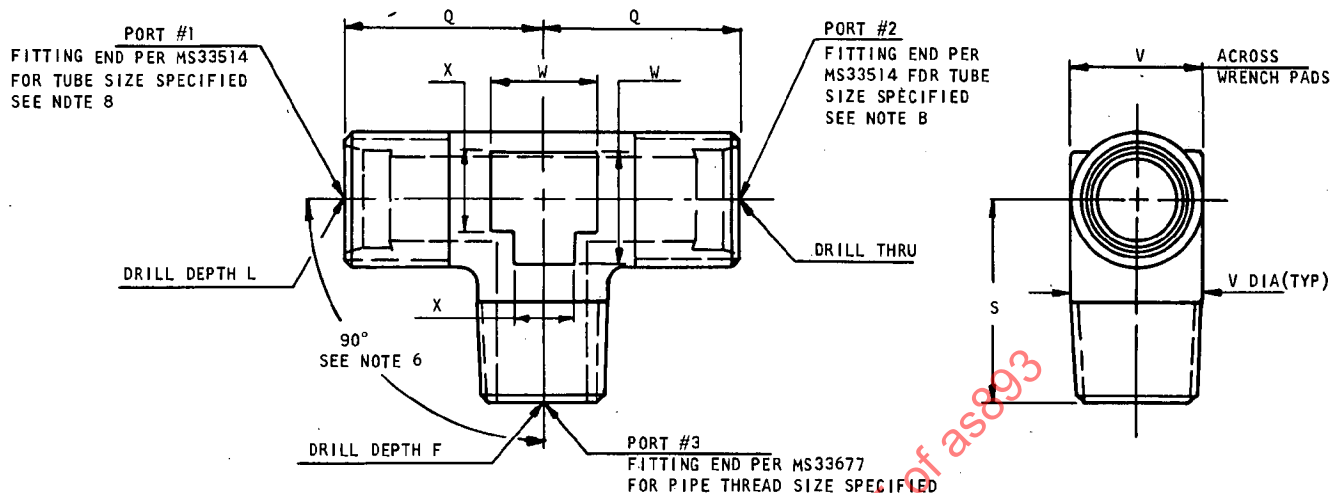


TEE, FLARELESS TUBE TO MALE PIPE ON SIDE

Issued 1-15-76
Revised



NOTES:

1. MATERIAL, FINISH AND MANUFACTURE SHALL BE IN ACCORDANCE WITH MIL-F-18280.
2. MATERIAL CODE: IN PLACE OF FIRST DASH IN PART NUMBER, ADD MATERIAL CODE AS FOLLOWS:
NO LETTER INDICATES STEEL (USE DASH "-")
LETTER "D" INDICATES ALUMINUM ALLOY
LETTER "J" INDICATES CORROSION RESISTANT STEEL, CLASS 304
LETTER "K" INDICATES CORROSION RESISTANT STEEL, CLASS 316
LETTER "S" INDICATES CORROSION RESISTANT STEEL, CLASS 347
3. SPECIFY END SIZES IN THIS ORDER: LARGEST END ON RUN FIRST (PORT #1), OPPOSITE END SECOND (PORT #2), PIPE END THIRD (PORT #3).
4. USE FORGING SIZE AS DETERMINED FROM TABLE 1.
5. EXAMPLE OF PART NUMBER:

AS893J100612

BASIC PART NUMBER	AS893J100612
CLASS 304 CORROSION RESISTANT STEEL	
FLARELESS TUBE END (PORT #1) PER MS33514E10 LEG LENGTH PER DIMENSION Q, 1.523 DRILL DEPTH PER DIMENSION L, 1.922	
FLARELESS TUBE END (PORT #2) PER MS33514E6 LEG LENGTH PER DIMENSION Q, 1.367 DRILL DEPTH - THRU	
PIPE END (PORT #3) PER MS33677, 3/4" PIPE SIZE LEG LENGTH PER DIMENSION S, 1.585 DRILL DEPTH PER DIMENSION F, 1.625	

6. TOLERANCE ON 90° ANGLE: $\pm 2 \frac{1}{2}^\circ$ FOR DASH 6 AND SMALLER, $\pm 1 \frac{1}{2}^\circ$ FOR DASH B AND LARGER.
7. REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
8. FITTING END PER MS33514 SHALL CONFORM TO STYLE G WHEN NORMAL THREAD SIZE EQUALS NORMAL FORGING SIZE. USE STYLE E WHEN THREAD SIZE IS SMALLER THAN FORGING SIZE, EXCEPT OMIT HEX.
9. AT OPTION OF MANUFACTURER, THE FLUID PASSAGE MAY CONFORM TO THE SMALLER DIAMETER HOLE ON ALL PORTS.
10. ALL MACHINED SURFACES SHALL BE SMOOTH TO 125 MICROINCHES AA MAX PER ANSI B46.1.
11. FOR USE ON OXYGEN SYSTEMS AND GROUND SERVICE EQUIPMENT ONLY.