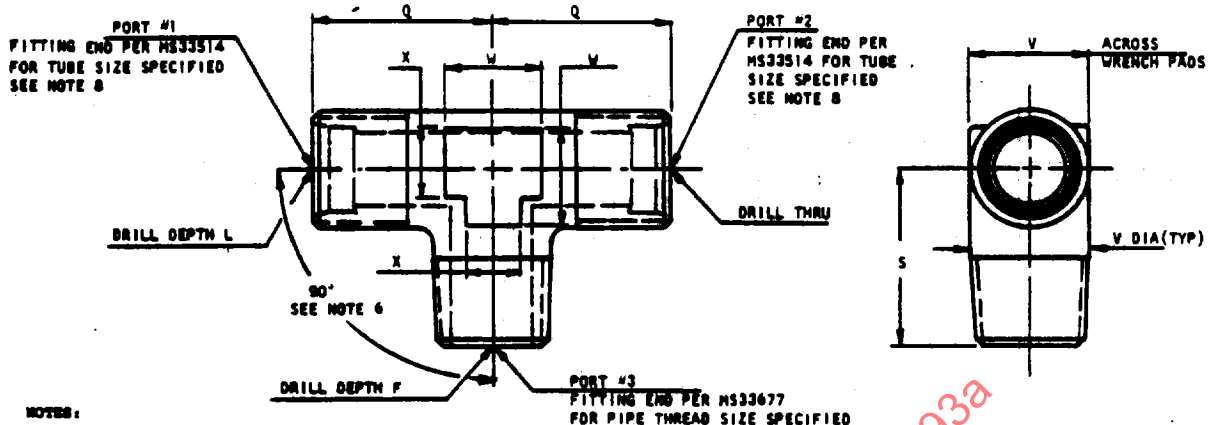


AN AMERICAN NATIONAL STANDARD

Rev. A

AS 893

FEDERAL SUPPLY CLASS
4730



NOTES:

- Δ1. PARTS SHALL CONFORM WITH APPLICABLE REQUIREMENTS OF MIL-F-18280, LATEST REVISION, UNLESS OTHERWISE SPECIFIED BY PROCURING ACTIVITY.
- Δ2. MATERIAL CODE: IN PLACE OF FIRST DASH IN PART NUMBER, ADD MATERIAL CODE AS FOLLOWS:

NO LETTER INDICATES STEEL (USE DASH "--")
 LETTER "D" INDICATES TYPE 2014-T6 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
 LETTER "W" INDICATES TYPE 7075-T73 ALUMINUM ALLOY

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:

BASIC PART NUMBER

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 8 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 ONIT HEX.
9. AT OPTION OF MANUFACTURER, THE FLUID PASSAGE MAY CONFORM TO THE SMALLER DIAMETER HOLE ON ALL PORTS.
- Δ10. ALL MACHINED SURFACES SHALL BE SMOOTH TO 125 MICROINCHES R_a MAX PER ANSI B46.1.
- Δ11. PARTS FOR OXYGEN SERVICE SHALL BE FURNISHED CLEANED, PACKAGED, AND LABELED PER AIR 1176 (OR OTHER CUSTOMER SPECIFIED DOCUMENT) WHEN SPECIFIED BY PROCURING ACTIVITY.
- Δ12. IDENTIFY PER MIL-F-18280 EXCEPT SUBSTITUTE AS OR AS893 MARKING IN PLACE OF MS OR MEXXXX AS APPLICABLE.
- Δ13. FOR DESIGN FEATURE PURPOSES THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.

1983 CHANGED DESIGNATED BY Δ

PREPARED BY SAE SUBCOMMITTEE G-3B, AEROSPACE FITTINGS, OF SAE COMMITTEE G-3, AEROSPACE FITTINGS, HOSE, & TUBING ASSEMBLIES

SAE Technical Engineering
 Standards Board
 Warrendale, PA 15090

495 Commonwealth Drive
 Warrendale, PA 15090

AEROSPACE STANDARD

TEE, FLARELESS TUBE TO
 MALE PIPE ON SIDE

AS 893

SHEET 1 OF 2

Rev.
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REAFFIRMED
 APRIL 1993