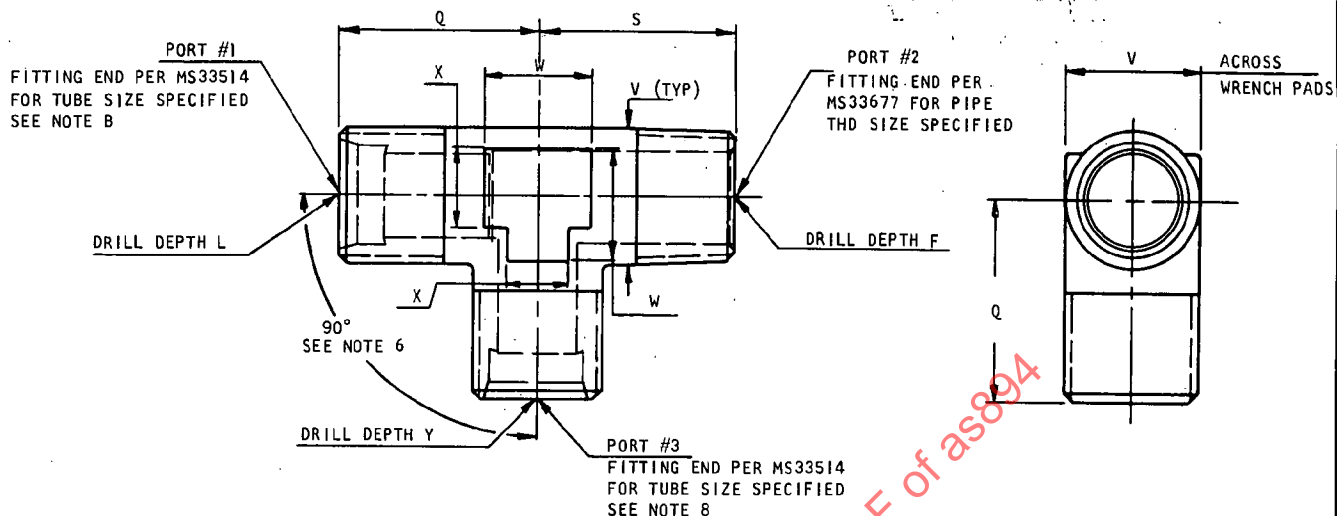


TEE, FLARELESS TUBE TO MALE PIPE ON RUN

Issued 1-15-76
Revised



NOTES:

1. MATERIAL, FINISH AND MANUFACTURE SHALL BE IN ACCORDANCE WITH MIL-F-18280B, MARCH 7, 1963 OR LATER ISSUE AUTHORIZED BY PURCHASER.
2. MATERIAL CODE: IN PLACE OF 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: FLARELESS TUBE END ON RUN FIRST (PORT #1), PIPE END SECOND (PORT #2), FLARELESS TUBE END ON SIDE THIRD (PORT #3).
4. USE FORGING SIZE AS DETERMINED FROM TABLE
5. EXAMPLE OF PART NUMBER:

AS894-061204

BASIC PART NUMBER

STEEL

FLARELESS TUBE END (PORT #1) PER MS33514E6
LEG LENGTH PER DIMENSION Q, 1.367
DRILL DEPTH PER DIMENSION L, 1.734

PIPE END (PORT #2) PER MS33677, 3/4" PIPE SIZE
LEG LENGTH PER DIMENSION S, 1.585
DRILL DEPTH PER DIMENSION F, 1.953

FLARELESS TUBE END (PORT #3) PER MS33514E4
LEG LENGTH PER DIMENSION Q, 1.351
DRILL DEPTH PER DIMENSION Y, 1.391

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 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.

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