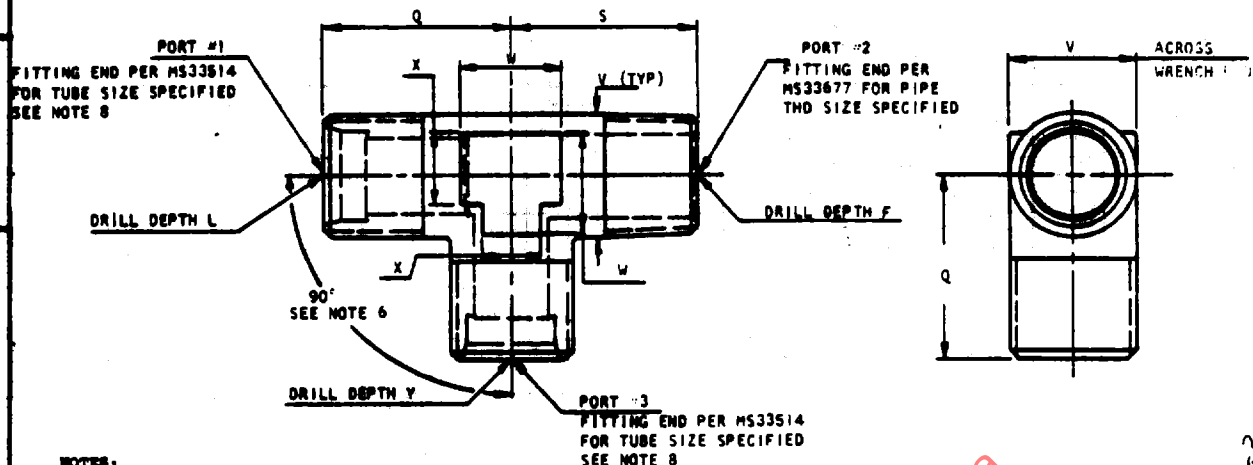


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Rev. A  
AS 894

FEDERAL SUPPLY CLASS  
4730



NOTES:

- Δ 1. PARTS SHALL CONFORM WITH APPLICABLE REQUIREMENTS OF MIL-F-18280, LATEST REVISION, UNLESS OTHERWISE SPECIFIED BY PROCURING ACTIVITY.
- Δ 2. MATERIAL CODE: IN PLACE OF 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: 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 1.
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:  $\pm 2 1/2^\circ$  FOR DASH 6 AND SMALLER,  $\pm 1 1/2^\circ$  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.
- Δ 10. ALL MACHINED SURFACES SHALL BE SMOOTH TO 125 MICROINCHES  $R_a$  MAX PER ANSI B46.1.
- Δ 11. PARTS FOR OXYGEN SERVICE SHALL BE FURNISHED CLEANED, PACKAGED, AND LABELED PER AIR 1176 (OR OTHER CUSTOMER SPECIFIED DOCUMENT) WHEN SPECIFIED BY PROCURING ACTIVITY.
- Δ 12. IDENTIFY PER MIL-F-18280 EXCEPT SUBSTITUTE AS OR AS894 MARKING IN PLACE OF MS OR MSXXXXX AS APPLICABLE.
- Δ 13. FOR DESIGN FEATURE PURPOSES THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.

1983 CHANGE DESIGNATED BY Δ

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

**SAE** The Engineering Council for  
Advancing Mobility

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AEROSPACE STANDARD

TEE, FLARELESS TUBE TO  
MALE PIPE ON RUN

AS 894

SHEET 1 OF 2

Rev. A

REAFFIRMED

April 1993

ISSUED 1-15-76 REVISED 12-1-83