

REV.
D

AS895™

FEDERAL SUPPLY CLASS
4730

RATIONALE

"INACTIVE" STATUS REPLACED BY "NOT RECOMMENDED." ALTERNATE MATERIAL ADDED TO NOTE 1.b. SPECIFICATION CALLOUTS UPDATED TO CURRENT ISSUE. "INTENDED USE" NOTE REVISED. QML STATEMENT REVISED.

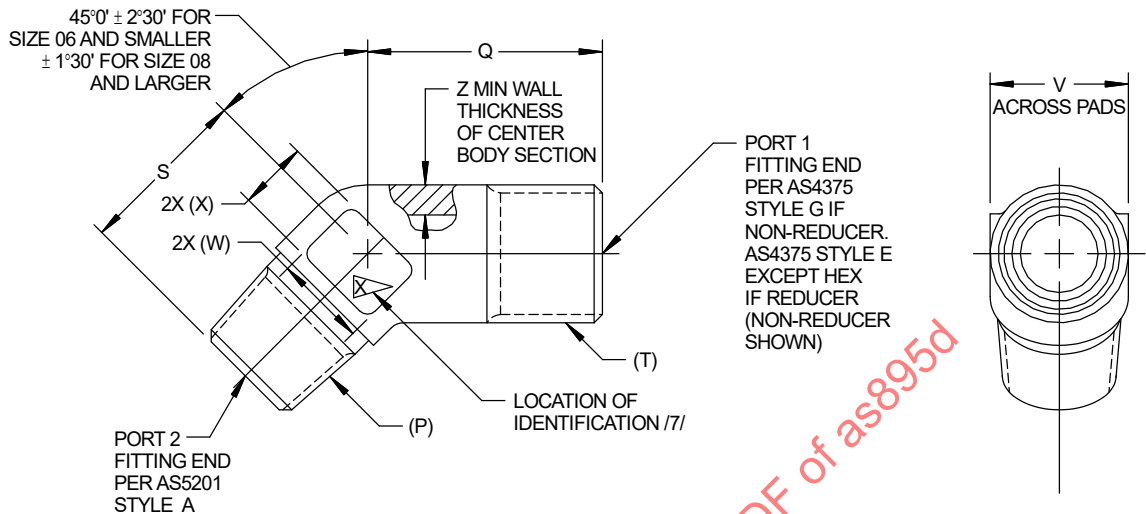
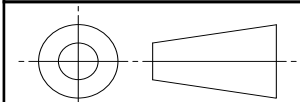


FIGURE 1 - FITTING, ELBOW, 45°, STANDARD AND REDUCER, FLARELESS TUBE TO PIPE, EXTERNAL THREAD

NOT RECOMMENDED IN PART /4/

For more information on this standard, visit
<https://www.sae.org/standards/content/AS895D>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS4842/2 /6/



AEROSPACE STANDARD

FITTING, ELBOW, 45°, STANDARD AND REDUCER,
FLARELESS TUBE TO PIPE,
EXTERNAL THREAD

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TABLE 1 - FORGING SIZE /8/

SIZE OF PORT 2	SIZE OF PORT 1 02	SIZE OF PORT 1 03	SIZE OF PORT 1 04	SIZE OF PORT 1 05	SIZE OF PORT 1 06	SIZE OF PORT 1 08	SIZE OF PORT 1 10	SIZE OF PORT 1 12	SIZE OF PORT 1 16	SIZE OF PORT 1 20	SIZE OF PORT 1 24	SIZE OF PORT 1 32
02	03	03	04	05	06	08	10	12	16	20	24	32
04	06	06	06	06	06	08	10	12	16	20	24	32
06	08	08	08	08	08	08	10	12	16	20	24	32
08	10	10	10	10	10	10	10	12	16	20	24	32
12	12	12	12	12	12	12	12	12	16	20	24	32
16	16	16	16	16	16	16	16	16	16	20	24	32
20	20	20	20	20	20	20	20	20	20	20	24	32
24	24	24	24	24	24	24	24	24	24	24	24	32
32	32	32	32	32	32	32	32	32	32	32	32	32

TABLE 2 - DIMENSIONS V - Z

BASIC NO. AS895 /8/ /15/ SIZE CODE					V	W	X	Z
03	.360-	.377	.219	.188	.090			
04	.423-	.440	.312	.219	.110			
05	.485-	.502	.312	.219	.120			
06	.547-	.565	.375	.250	.120			
08	.735-	.753	.500	.375	.150			
10	.860-	.878	.625	.375	.170			
12	1.047-	1.065	.812	.438	.185			
16	1.292-	1.317	.938	.438	.205			
20	1.605-	1.630	1.250	.688	.240			
24	1.855-	1.880	1.500	.750	.250			
32	2.542-	2.572	2.000	.875	.350			



AEROSPACE STANDARD

FITTING, ELBOW, 45°, STANDARD AND REDUCER,
FLARELESS TUBE TO PIPE,
EXTERNAL THREAD

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TABLE 3 - LEG LENGTH Q

FORGING SIZE	SIZE OF PORT 1 02	SIZE OF PORT 1 03	SIZE OF PORT 1 04	SIZE OF PORT 1 05	SIZE OF PORT 1 06	SIZE OF PORT 1 08	SIZE OF PORT 1 10	SIZE OF PORT 1 12	SIZE OF PORT 1 16	SIZE OF PORT 1 20	SIZE OF PORT 1 24	SIZE OF PORT 1 32
03	.633	.680										
04	.633	.680	.711									
05	.664	.711	.742	.742								
06	.742	.789	.820	.820	.836							
08	.805	.852	.883	.883	.899	.992						
10	.836	.883	.914	.914	.930	1.023	1.086					
12	.960	1.007	1.038	1.038	1.054	1.147	1.210	1.273				
16	1.054	1.101	1.132	1.132	1.148	1.241	1.304	1.367	1.367			
20	1.148	1.195	1.226	1.226	1.242	1.335	1.398	1.461	1.461	1.461		
24	1.242	1.289	1.320	1.320	1.336	1.429	1.492	1.555	1.555	1.555	1.555	
32	1.523	1.570	1.601	1.601	1.617	1.710	1.773	1.836	1.836	1.836	1.836	1.836

TABLE 4 - LEG LENGTH S $\pm .031$

FORGING SIZE	SIZE OF PORT 2 02	SIZE OF PORT 2 04	SIZE OF PORT 2 06	SIZE OF PORT 2 08	SIZE OF PORT 2 12	SIZE OF PORT 2 16	SIZE OF PORT 2 20	SIZE OF PORT 2 24	SIZE OF PORT 2 32
03	.500								
04	.625								
05	.625								
06	.641	.844							
08	.719	.922	.938						
10	.766	.969	.984	1.156					
12	.781	.984	1.000	1.172	1.188				
16	.875	1.078	1.094	1.266	1.281	1.469			
20	1.031	1.234	1.250	1.422	1.438	1.625	1.656		
24	1.172	1.375	1.391	1.562	1.578	1.766	1.797	1.812	
32	1.442	1.625	1.641	1.813	1.828	2.016	2.047	2.062	2.094

TABLE 5 - TUBE SIZE AND CORRESPONDING THREAD

PORT SIZE	NOMINAL TUBE SIZE	T THREAD PER AS8879	P THREAD PER AS71051 ANPT
02	.125	.3125-24 UNJF-3A	1/8 -27
03	.188	.3750-24 UNJF-3A	----
04	.250	.4375-20 UNJF-3A	1/4 -18
05	.312	.5000-20 UNJF-3A	----
06	.375	.5625-18 UNJF-3A	3/8 -18
08	.500	.7500-16 UNJF-3A	1/2 -14
10	.625	.8750-14 UNJF-3A	----
12	.750	1.0625-12 UNJ-3A	3/4 -14
16	1.000	1.3125-12 UNJ-3A	1 -11 1/2
20	1.250	1.6250-12 UNJ-3A	1 1/4 -11 1/2
24	1.500	1.8750-12 UNJ-3A	1 1/2 -11 1/2
32	2.000	2.5000-12 UNJ-3A	2 -11 1/2



AEROSPACE STANDARD

FITTING, ELBOW, 45°, STANDARD AND REDUCER,
FLARELESS TUBE TO PIPE,
EXTERNAL THREAD

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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. DASH AS CODE LETTER - TYPE 4130 STEEL FORGING OR BAR PER AMS-S-6758 OR AMS6370.
- b. CODE LETTER D - TYPE 2014-T6 ALUMINUM ALLOY FORGING PER AMS4133 OR AMS-QQ-A-367, OR TYPE 2024-T6 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6, OR TYPE 2024-T851 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6 OR AMS4339. /4/
- c. CODE LETTER J - TYPE 304 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5639.
- d. CODE LETTER K - TYPE 316 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5648.
- e. CODE LETTER R - TYPE 321 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5645.
- f. CODE LETTER S - TYPE 347 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5646. /4/
- g. CODE LETTER W - TYPE 7075-T73 ALUMINUM ALLOY FORGING PER AMS-QQ-A-367 OR AMS4141, OR TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9, OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS4124.

2. FINISH:

- a. DASH AS CODE LETTER - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
- b. MATERIAL CODE LETTER D - ANODIZE PER AMS2472 OR MIL-A-8625, TYPE II, CLASS 2 DYED GREEN SIMILAR TO COLOR 14187 OF AMS-STD-595.
- c. MATERIAL CODE LETTER J - PASSIVATE PER AMS2700, TYPE 6 OR 7.
- d. MATERIAL CODE LETTER K - PASSIVATE PER AMS2700, TYPE 6 OR 7.
- e. MATERIAL CODE LETTER R - PASSIVATE PER AMS2700, TYPE 6 OR 7.
- f. MATERIAL CODE LETTER S - PASSIVATE PER AMS2700, TYPE 6 OR 7.
- g. MATERIAL CODE LETTER W - ANODIZE PER AMS2472 OR MIL-A-8625, TYPE II, CLASS 2 DYED BROWN, SIMILAR TO COLOR 10080 OF AMS-STD-595.

/3/ INTENDED USE: THIS PART IS DESIGNED FOR USE IN OXYGEN SYSTEMS AND GROUND SUPPORT EQUIPMENT ONLY WITH OPERATING PRESSURES AS SPECIFIED IN THE PROCUREMENT SPECIFICATION. PARTS FOR OXYGEN SYSTEMS SHALL BE IDENTIFIED IN THE PART NUMBER AS CODE "A" AND SHALL BE FURNISHED CLEANED, PACKAGED, AND LABELED IN ACCORDANCE WITH AIR 1176 TO A PROCESS APPROVED BY THE USER. /15/

/4/ RECOMMENDED MATERIAL CODE CHANGE:

- a. PART NUMBERS WITH MATERIAL CODE LETTER "D" ARE NOT RECOMMENDED FOR NEW DESIGN AS OF 06-2008. USE PART NUMBERS WITH MATERIAL CODE LETTER "W" FOR NEW DESIGN.
- b. PART NUMBERS WITH MATERIAL CODE LETTER "S" ARE NOT RECOMMENDED FOR NEW DESIGN AS OF 03-1996. USE PART NUMBERS WITH MATERIAL CODE LETTER "R" FOR NEW DESIGN.

5. WHEN MACHINED FROM BAR STOCK OR OVERSIZED FORGINGS THE CENTER BODY DIMENSIONS SHALL CONFORM TO AS1376, TABLE 1.

	AEROSPACE STANDARD	AS895™ SHEET 4 OF 5	REV. D
	FITTING, ELBOW, 45°, STANDARD AND REDUCER, FLARELESS TUBE TO PIPE, EXTERNAL THREAD		