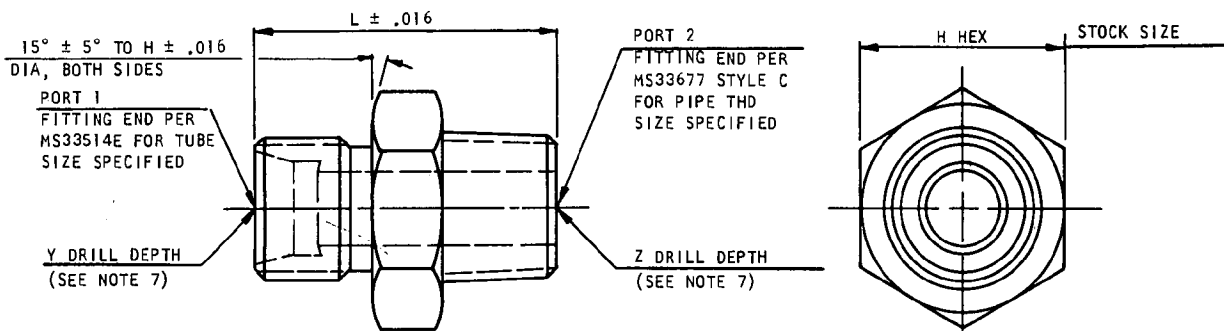


NIPPLE, FLARELESS TUBE TO MALE PIPE

Issued 1-15-76
Revised



438	438	500	562	625	812	938	1,125	1,375	1,688	2,000	2,625	H HEX		
1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2	2	#1 PORT TUBE SIZE	#1 PORT DASH NO.	
2	3	4	5	6	8	10	12	16	20	24	32	#2 PORT DASH NO.	#2 PORT PIPE SIZE	H. HEX
DIMENSION L OVERALL LENGTH														
.938	.984	1.031	1.062	1.094	1.188	1.266	1.344	1.375	1.406	1.469	1.578	2	1/8	.438
1.156	1.219	1.250	1.250	1.281	1.406	1.469	1.562	1.594	1.625	1.688	1.781	4	1/4	.562
1.203	1.250	1.281	1.281	1.281	1.406	1.516	1.594	1.625	1.656	1.703	1.812	6	3/8	.750
1.391	1.438	1.469	1.469	1.469	1.594	1.688	1.781	1.799	1.828	1.875	1.969	8	1/2	.875
1.438	1.500	1.531	1.531	1.547	1.609	1.719	1.781	1.812	1.844	1.891	1.984	12	3/4	1.125
1.656	1.703	1.734	1.734	1.750	1.844	1.906	2.000	2.000	2.094	2.094	2.156	16	1	1.375
1.750	1.797	1.828	1.828	1.844	1.938	2.000	2.094	2.094	2.094	2.125	2.203	20	1 1/4	1.688
1.812	1.859	1.891	1.891	1.906	2.000	2.062	2.188	2.188	2.188	2.187	2.219	24	1 1/2	2.000
1.938	1.984	2.016	2.016	2.031	2.125	2.218	2.250	2.250	2.250	2.250	2.256	32	2	2.625

DRILL DEPTH Y ± .016												#1 PORT DASH NUMBER		
2	3	4	5	6	8	10	12	16	20	24	32			
THRU	THRU	THRU	.516	.531	.578	.656	.672	.641	.609	.594	.562	2		
THRU	THRU	THRU	THRU	.516	.609	.641	.688	.656	.625	.625	.578	4		
THRU	THRU	THRU	THRU	THRU	.625	.703	.766	.703	.672	.656	.625	6		
THRU	THRU	THRU	THRU	THRU	THRU	THRU	.766	.734	.688	.672	.625	8		
THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	.766	.734	.703	.672	12		
THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	.844	.766	.688	16		
THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	.844	.781	20		
THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	.859	24		
THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	32		

DRILL DEPTH Z ± .016												#1 PORT DASH NUMBER		
2	3	4	5	6	8	10	12	16	20	24	32			
.422	.406	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	2		
.609	.625	.641	.656	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	4		
.625	.625	.641	.641	.656	THRU	THRU	THRU	THRU	THRU	THRU	THRU	6		
.766	.766	.797	.797	.797	.844	.875	THRU	THRU	THRU	THRU	THRU	8		
.766	.781	.797	.797	.797	.812	.859	.891	THRU	THRU	THRU	THRU	12		
.922	.906	.938	.938	.969	.969	.984	1.047	1.094	THRU	THRU	THRU	16		
.922	.922	.938	.953	.969	.984	.984	1.047	1.094	1.109	THRU	THRU	20		
.906	.906	.938	.938	.953	.969	.969	1.078	1.125	1.141	1.203	THRU	24		
.906	.906	.922	.938	.953	.969	1.031	1.000	1.062	1.078	1.141	1.609	32		

NOTES:

- MATERIAL, FINISH, AND MANUFACTURE SHALL BE IN ACCORDANCE WITH MIL-F-18280B, MARCH 7, 1963 OR LATER ISSUE AUTHORIZED BY PURCHASER.
 - MATERIAL CODE: IN PLACE OF FIRST DASH, ADD CODE LETTERS AS FOLLOWS:
NO LETTER INDICATES STEEL (USE DASH "-")
LETTER "D" INDICATES ALUMINUM ALLOY
LETTER "C" INDICATES CORROSION RESISTANT STEEL, CLASS 304
LETTER "3" INDICATES CORROSION RESISTANT STEEL, CLASS 347
LETTER "K" INDICATES CORROSION RESISTANT STEEL, CLASS 316
 - SPECIFY END SIZES IN THIS ORDER: FLARELESS TUBE END FIRST, PIPE THREAD END SECOND.
 - LARGEST END SHALL DETERMINE THE HEX SIZE WHEN BOTH PORTS ARE EQUAL, USE LARGEST HEX SPECIFIED FOR APPLICABLE DASH NUMBERS.
 - EXAMPLE OF PART NUMBER
AS896D1012
(OVER ALL LENGTH PER DIMENSION L, 1.719, HEX SIZE PER DIMENSION H, (1.125))
- BASIC PART NUMBER
- ALUMINUM ALLOY
- FLARELESS TUBE END PER MS33514E10
- DRILL DEPTH PER DIMENSION Y, THRU
- PIPE END PER MS33677-12 STYLE C
- DRILL DEPTH PER DIMENSION Z, .859
- (OR SMALLER DIAMETER MAY BE DRILLED THRU, SEE NOTE 7)
- PREPARED BY
SAE COMMITTEE G-3B, AEROSPACE FITTINGS
- REMOVE ALL BURRS AND BREAK ALL SHARP EDGES
 - AT THE OPTION OF THE MANUFACTURER, THE SMALLER DIA MAY BE DRILLED THRU THE FITTING FROM END TO END
 - ALL MACHINED SURFACES SHALL BE SMOOTH TO 125 MICROINCHES AA MAX PER ANSI B46.1.
 - FOR USE ON OXYGEN SYSTEMS AND GROUND SERVICE EQUIPMENT ONLY.