

REV.
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AS1005

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FEDERAL SUPPLY CLASS

4730

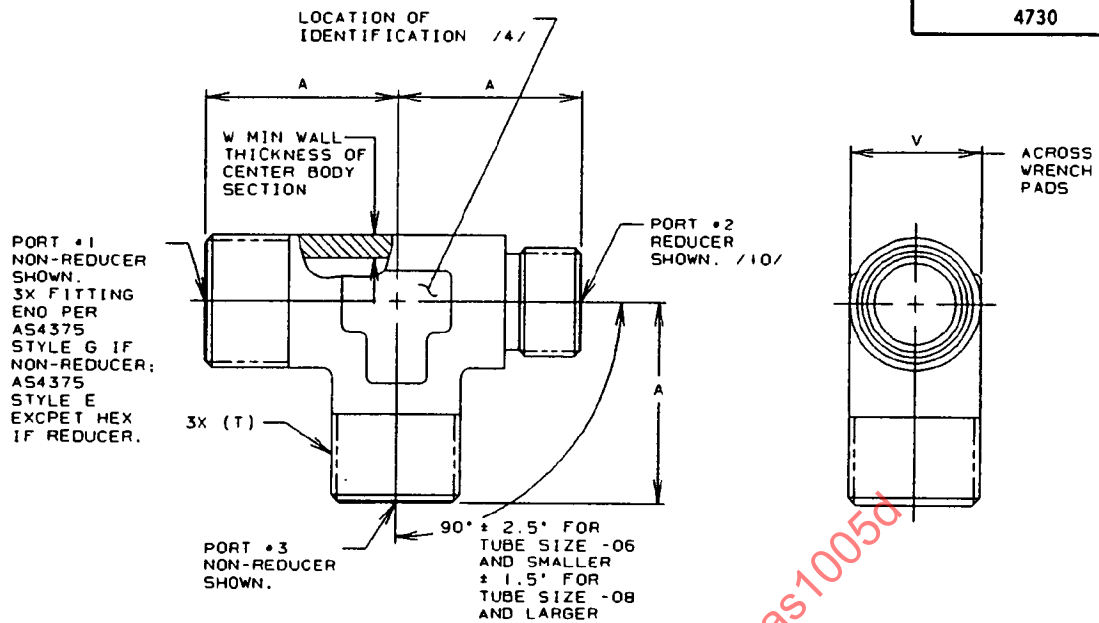
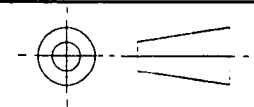


FIGURE 1 - TEE, FLARELESS

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO.			LB/EA	LB/EA	LB/EA
AS1005			MAX	MAX	MAX
/11/ /17/					
SIZE CODE	V	W	ALUM	CRES	TI
02	.312	.090	.014	.040	.023
03	.375	.100	.019	.051	.029
04	.438	.110	.024	.069	.039
05	.500	.120	.035	.098	.056
06	.562	.120	.043	.119	.068
08	.750	.150	.083	.269	.137
10	.875	.170	.120	.356	.205
12	1.062	.45	.195	.550	.317
14	1.188	.200	---	---	---
16	1.312	.205	.296	.800	.461
20	1.625	.240	.490	1.330	.767
24	1.875	.252	.591	1.690	.975
32	2.562	.350	---	---	---

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-38

PROCUREMENT SPECIFICATION: /3/ MIL-F-18280

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400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARD

TEE,
STANDARD AND REDUCER,
FLARELESS TUBE

AS1005

SHEET 1 OF 4

REV.**D**

TABLE 2 - LEG LENGTH A

SIZE OF PORT	FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING		FORGING	
	SIZE	/11/	SIZE	/11/	SIZE	/11/	SIZE	/11/	SIZE	/11/	SIZE	/11/	SIZE	/11/	SIZE	/11/	SIZE	/11/	SIZE	/11/	SIZE	/11/	SIZE	/11/
02	.773	.789	.820	.883	.961	1.086	1.180	1.272	1.398	1.429	1.585	1.710	2.148											
03	---	.836	.867	.930	1.008	1.133	1.226	1.320	1.445	1.476	1.632	1.757	2.159											
04	---	---	.898	.961	1.039	1.164	1.258	1.351	1.476	1.507	1.663	1.788	2.226											
05	---	---	---	.961	1.039	1.164	1.258	1.351	1.476	1.507	1.663	1.788	2.226											
06	---	---	---	---	1.055	1.180	1.274	1.367	1.492	1.523	1.679	1.804	2.242											
08	---	---	---	---	---	1.273	1.367	1.460	1.585	1.616	1.772	1.897	2.335											
10	---	---	---	---	---	---	1.430	1.523	1.648	1.679	1.835	1.960	2.398											
12	---	---	---	---	---	---	---	1.586	1.742	1.742	1.898	2.023	2.461											
14	---	---	---	---	---	---	---	---	1.680	1.742	1.898	2.023	2.461											
16	---	---	---	---	---	---	---	---	---	1.742	1.898	2.023	2.461											
20	---	---	---	---	---	---	---	---	---	---	1.898	2.023	2.461											
24	---	---	---	---	---	---	---	---	---	---	---	2.023	2.461											
32	---	---	---	---	---	---	---	---	---	---	---	---	2.461											

TABLE 3 - TUBE SIZE AND CORRESPONDING THREAD

PORT SIZE	(NOMINAL TUBE SIZE)		T THREAD PER MIL-S-8879
02	.125		.3125-24UNJF
03	.188		.3750-24UNJF
04	.250		.4375-20UNJF
05	.312		.5000-20UNJF
06	.375		.5625-18UNJF
08	.500		.7500-16UNJF
10	.625		.8750-14UNJF
12	.750		1.0625-12UNJ
14	.875		1.1875-12UNJ
16	1.000		1.3125-12UNJ
20	1.250		1.6250-12UNJ
24	1.500		1.8750-12UNJ
32	2.000		2.5000-12UNJ

NOTES:

/1/ MATERIAL:

- a. CODE LETTER D: 2014T6 ALUMINUM ALLOY FORGING PER AMS 4133 OR QQ-A-367; OR 2024T6 ALUMINUM ALLOY BAR PER AMS 4112 OR QQ-A-225/6; OR 2024T851 ALUMINUM ALLOY BAR PER QQ-A-225/6.
- b. CODE LETTER F: 4130 STEEL FORGING OR BAR PER AMS 6370 OR MIL-S-6758.
- c. CODE LETTER J: 30304 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS 5639 OR 304 CORROSION RESISTANT STEEL PER QQ-S-763.
- d. CODE LETTER K: 30316 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS 5648 OR 316 CORROSION RESISTANT STEEL PER QQ-S-763.
- e. CODE LETTER R: 30321 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS 5645 OR 321 CORROSION RESISTANT STEEL PER QQ-S-763. /7/
- f. CODE LETTER S: 30347 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS 5646 OR 347 CORROSION RESISTANT STEEL PER QQ-S-763. /8/
- g. CODE LETTER T: 6AL4V TITANIUM ALLOY FORGING OR BAR PER AMS 4928.
- h. CODE LETTER W: 7075T73 ALUMINUM ALLOY FORGING PER AMS 4141 OR QQ-A-367; OR 7075T7351 ALUMINUM ALLOY BAR PER AMS 4124; OR 7075T73 ALUMINUM ALLOY BAR PER QQ-A-225/9.

2. FINISH:

- a. MATERIAL CODE LETTER D: ANODIZE PER AMS 2472 OR MIL-A-8625, TYPE II, CLASS 2. DYE GREEN, SIMILAR TO COLOR 14187 OF FED-STD-595.
- b. MATERIAL CODE LETTER F: CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2.
- c. MATERIAL CODE LETTER J: PASSIVATE PER QQ-P-35, TYPE VI OR VII.
- d. MATERIAL CODE LETTER K: PASSIVATE PER QQ-P-35, TYPE VI OR VII.
- e. MATERIAL CODE LETTER R: PASSIVATE PER QQ-P-35, TYPE VI OR VII.
- f. MATERIAL CODE LETTER S: PASSIVATE PER QQ-P-35, TYPE VI OR VII.
- g. MATERIAL CODE LETTER T: FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486.
- h. MATERIAL CODE LETTER W: ANODIZE PER AMS 2472 OR MIL-A-8625, TYPE II, CLASS 2. DYE BROWN, SIMILAR TO COLOR 10080 OF FED-STD-595.