

FEDERAL SUPPLY CLASS

4730

REV.
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AS1004

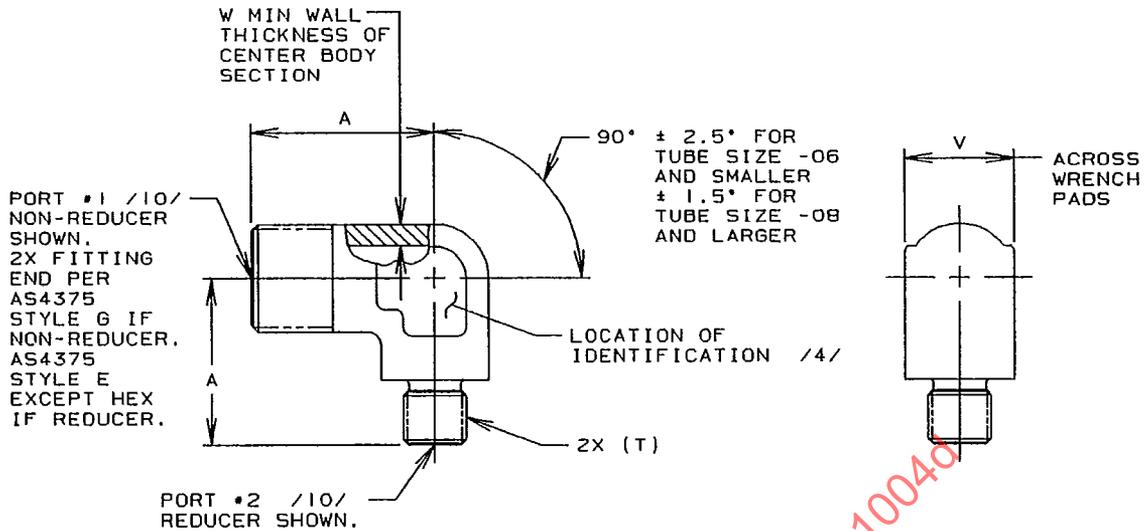
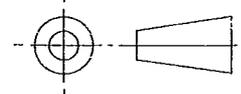


FIGURE 1 - ELBOW, 90°

TABLE 1 - DIMENSIONS AND WEIGHTS

| BASIC NO. AS1004 /11/ /17/ SIZE CODE | V | W | LB/EA | | LB/EA TI |
|---|-------|------|-------------|-------------|-------------|
| | | | MAX ALUM | MAX CRES | |
| 02 | .312 | .090 | .014 | .040 | .023 |
| 03 | .375 | .100 | .020 | .056 | .032 |
| 04 | .438 | .110 | .022 | .062 | .035 |
| 05 | .500 | .120 | .031 | .086 | .049 |
| 06 | .562 | .120 | .037 | .104 | .060 |
| 08 | .750 | .150 | .064 | .191 | .110 |
| 10 | .875 | .170 | .087 | .258 | .148 |
| 12 | 1.062 | .185 | .135 | .402 | .231 |
| 14 | 1.188 | .200 | --- | --- | --- |
| 16 | 1.312 | .205 | .200 | .535 | .308 |
| 20 | 1.625 | .240 | .265 | .792 | .456 |
| 24 | 1.875 | .250 | .463 | 1.262 | .728 |
| 32 | 2.562 | .350 | 1.125 | 3.062 | 1.766 |

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /3/ MIL-F-18280

SAE The Engineering Society
For Advancing Mobility
Land Sea Air and Space
INTERNATIONAL

460 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARD

ELBOW, 90°,
STANDARD AND REDUCER,
FLARELESS TUBE

AS1004

SHEET 1 OF 4

REV.

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ISSUED 1966-03-15

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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. //
- 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.

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