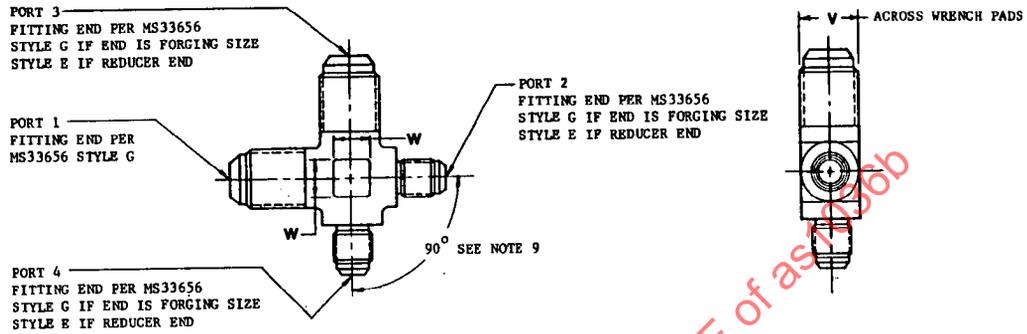
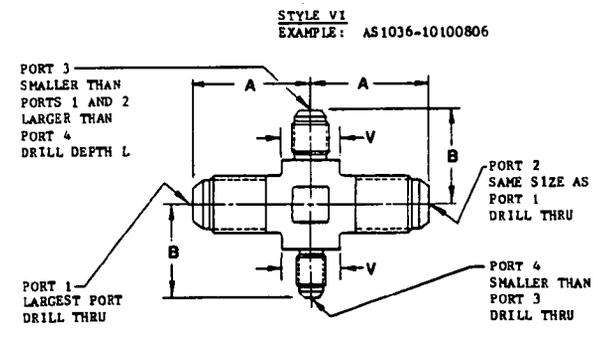
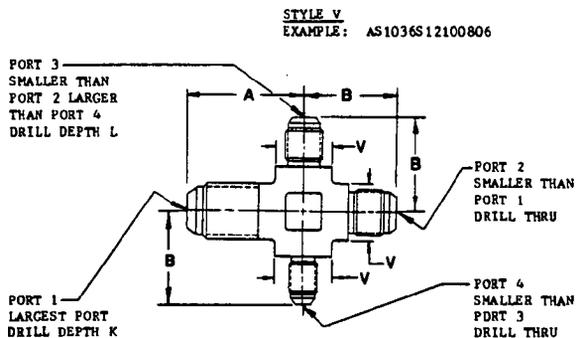
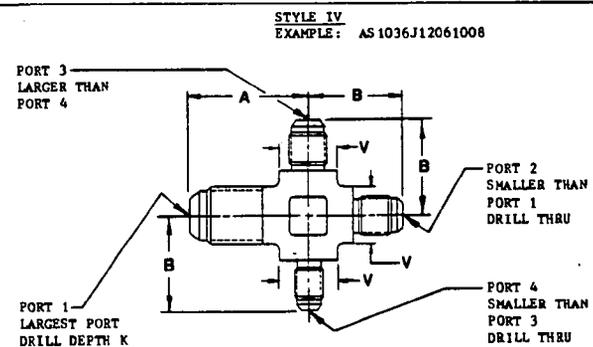
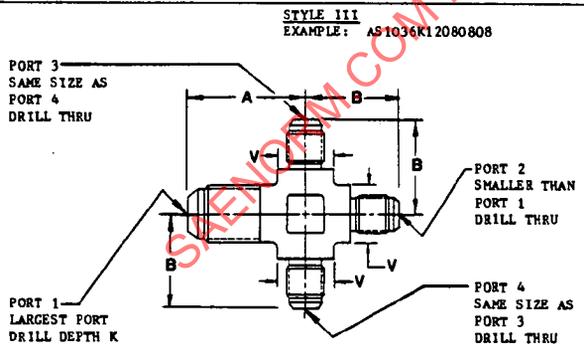
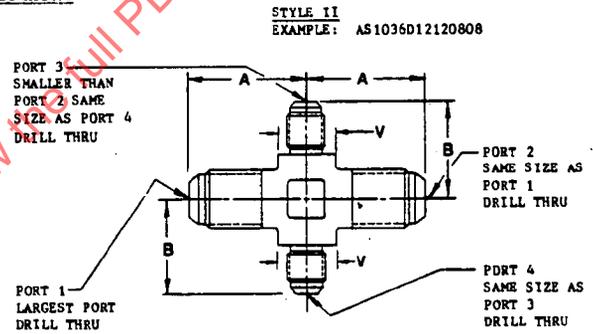
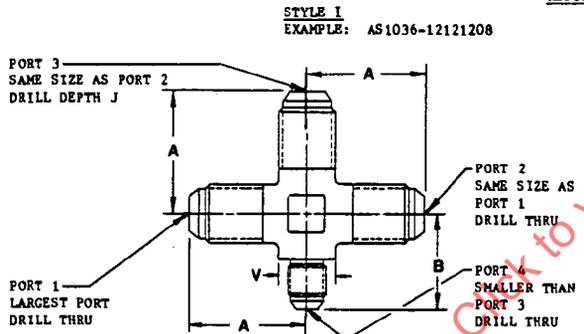


CROSS, REDUCER, FLARED TUBE



REDUCER COMBINATIONS



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AS 1036B

LEG LENGTH B ±.016

FORGING SIZE											SIZE OF #2 OR #4 PORT
3	4	5	6	8	10	12	16	20	24	32	
.789	.789	.843	.946	1.033	1.135	1.232	1.341	1.544	1.685	2.169	2
	.811	.874	.977	1.064	1.166	1.263	1.372	1.575	1.716	2.200	3
		.945	1.048	1.135	1.237	1.334	1.443	1.646	1.787	2.271	4
			1.048	1.135	1.237	1.334	1.443	1.646	1.787	2.271	5
				1.141	1.243	1.340	1.499	1.652	1.793	2.277	6
					1.344	1.441	1.550	1.753	1.894	2.378	8
						1.542	1.651	1.854	1.995	2.479	10
							1.757	1.960	2.101	2.585	12
								2.007	2.148	2.632	16
									2.195	2.679	20
										2.804	24

FORGING SIZE	A ±.016	J ±.016	V ±.016	W APP
3	.820	.922	.375	.375
4	.822	1.000	.438	.375
5	.945	1.094	.500	.469
6	1.054	1.234	.562	.500
8	1.242	1.469	.750	.688
10	1.445	1.719	.875	.781
12	1.648	1.984	1.062	.906
16	1.804	2.266	1.312	1.094
20	2.054	2.625	1.625	1.312
24	2.320	3.016	1.875	1.500
32	3.054	3.984	2.562	2.031

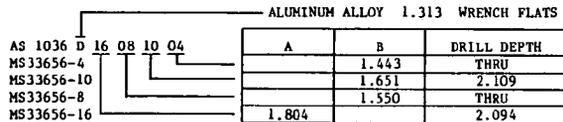
DRILL DEPTH K ±.016

FORGING SIZE											SIZE OF #3 PORT
3	4	5	6	8	10	12	16	20	24	32	
.891	.953	1.016	1.125	1.312	1.516	1.719	1.875	2.125	2.391	3.125	2
	.984	1.047	1.156	1.344	1.547	1.750	1.906	2.156	2.422	3.156	3
		1.062	1.172	1.359	1.562	1.766	1.922	2.172	2.438	3.172	4
			1.203	1.391	1.594	1.797	1.953	2.203	2.469	3.203	5
				1.422	1.625	1.828	1.984	2.234	2.500	3.234	6
					1.672	1.875	2.031	2.281	2.547	3.281	8
						1.922	2.078	2.328	2.594	3.328	10
							2.141	2.391	2.656	3.391	12
								2.516	2.781	3.516	16
									2.891	3.625	20
										3.750	24

DRILL DEPTH L ±.016

FORGING SIZE											SIZE OF #3 PORT
4	5	6	8	10	12	16	20	24	32		
.938	1.031	1.172	1.297	1.453	1.609	1.828	2.156	2.406	3.125	3	
	1.094	1.234	1.375	1.516	1.672	1.906	2.219	2.484	3.203	4	
		1.234	1.375	1.516	1.672	1.906	2.219	2.484	3.203	5	
			1.375	1.516	1.688	1.906	2.234	2.484	3.203	6	
				1.625	1.781	2.016	2.328	2.594	3.312	8	
					1.891	2.109	2.438	2.688	3.406	10	
						2.219	2.531	2.797	3.516	12	
							2.578	2.844	3.562	16	
								2.891	3.609	20	
									3.734	24	

- SPECIFY END SIZES IN THE FOLLOWING ORDER: (1) LARGEST END; (2) OPPOSITE END ON RUN; (3) LARGEST REMAINING END; (4) OPPOSITE END (IF THERE ARE TWO LARGEST ENDS AT 90°, THE ONE WITH THE LARGEST OPPOSITE END SHALL BE FIRST).
- LARGEST TUBE SIZE DETERMINES FORGING SIZE.
- MATERIAL CODING:
 - STEEL 1137 OR 1141 PER QQ-S-637 (OPTIONAL: 4130/MIL-S-6758). FINISH CADMIUM PLATE PER QQ-P-416. TYPE II, CLASS 2. COLOR BLACK.
 - S CRES TYPE 347. CRES PER QQ-S-763 SURFACE TREAT PER MIL-S-5002.
 - J CRES TYPE 304. CRES PER QQ-S-763 SURFACE TREAT PER MIL-S-5002.
 - K CRES TYPE 316. CRES PER QQ-S-763 SURFACE TREAT PER MIL-S-5002.
 - D ALUMINUM ALLOY 2014-T6 PER QQ-A-367 (OR 2024-T851). ANODIZE PER MIL-A-8625, TYPE II, CLASS 2. DYE BLUE.
 - W ALUMINUM ALLOY 7075-T73 PER QQ-A-225/9 (OPTIONAL: QQ-A-367). ANODIZE PER MIL-A-8625. TYPE II, CLASS 2. DYE BROWN.
 - T TITANIUM ALLOY (6AL-4V) PER AMS 4928. FLUORIDE PHOSPHATE COAT PER AMS 2486.
- PART NUMBER EXAMPLE:



- PROC. SPEC. MIL-F-5509, LATEST REVISION, UNLESS OTHERWISE SPECIFIED ON PURCHASE ORDER BY PURCHASER.
- REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
- THIS STANDARD TAKES PRECEDENCE OVER REFERENCED DOCUMENTS HEREIN.
- MANUFACTURER'S TRADEMARK AND BASIC PART NUMBER (EXCLUSIVE OF SIZE) TO APPEAR PERMANENTLY ON FINISHED PARTS. BASIC PART NUMBER MAY BE REDUCED TO "AS" ON FORGINGS SIZE 6 AND SMALLER. PARTS PREVIOUSLY IMPRESSION STAMPED WITH AN, MS OR PROPRIETARY IDENTIFICATION SHALL BE ACCEPTABLE PROVIDED SUCH IDENTIFICATION IS OBLITERATED BY IMPRESSION STAMPING WITHOUT DAMAGING THE PART.
- TOLERANCE ON 90° ANGLE: ±2-1/2° FOR TUBE SIZE 6 AND SMALLER, ±1-1/2° FOR TUBE SIZE 8 AND LARGER.
- WHEN FITTING IS MADE FROM BAR, THE CONTOUR OF THE BODY SECTION SHALL BE PER AS 1376 FOR FORGING SIZES DASH 3 THROUGH DASH 8, AND AS 1376 CODE M FOR SIZES DASH 10 AND LARGER.