

REV.
C

AS1036

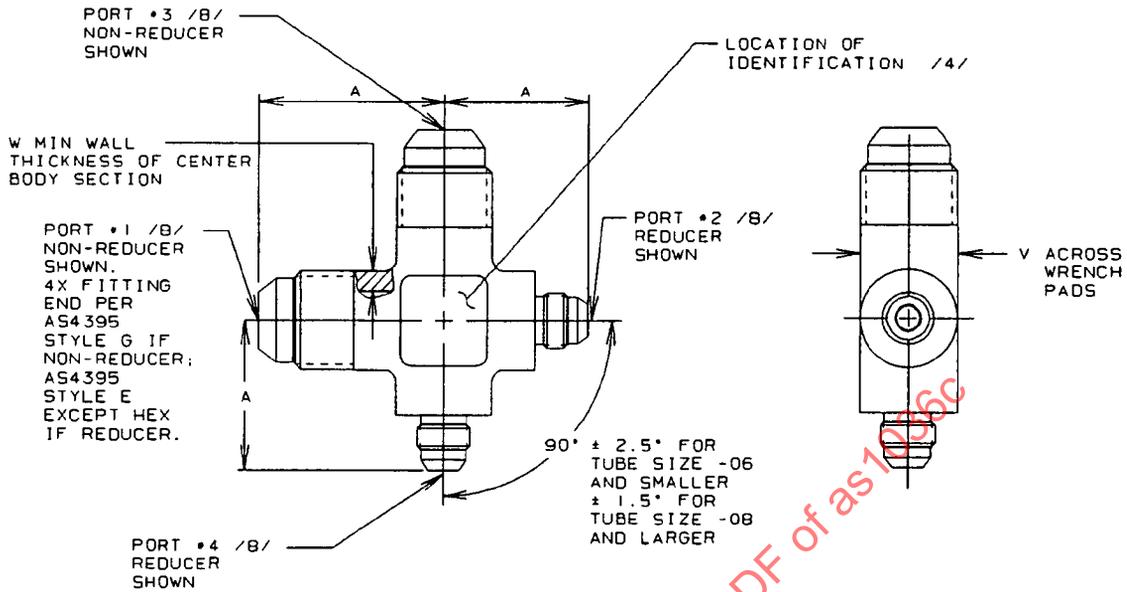
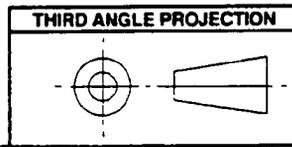


FIGURE 1 - CROSS, FLARED

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS1036 /9/ /15/ SIZE CODE	V	W	LB/EA		
			MAX ALUM	MAX CRES	MAX TI
02	.312	.090	-	-	-
03	.375	.100	-	-	-
04	.438	.110	-	-	-
05	.500	.120	-	-	-
06	.562	.120	-	-	-
08	.750	.150	-	-	-
10	.875	.170	-	-	-
12	1.062	.185	-	-	-
16	1.312	.205	-	-	-
20	1.625	.240	-	-	-
24	1.875	.250	-	-	-
32	1.562	.350	-	-	-



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /3/ MIL-F-5509

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

400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARD

CROSS, STANDARD AND
REDUCER, FLARED TUBE

AS1036

SHEET 1 OF 4

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ISSUED 1962-08-15 REVISED 1993-05-07 (C)

REV.
C

AS1036

TABLE 2 - LEG LENGTH A

SIZE OF PORTS	FORGING SIZE /9/ 02	FORGING SIZE /9/ 03	FORGING SIZE /9/ 04	FORGING SIZE /9/ 05	FORGING SIZE /9/ 06	FORGING SIZE /9/ 08	FORGING SIZE /9/ 10	FORGING SIZE /9/ 12	FORGING SIZE /9/ 16	FORGING SIZE /9/ 20	FORGING SIZE /9/ 24	FORGING SIZE /9/ 32
02	.757	.789	.789	.843	.946	1.033	1.135	1.232	1.341	1.544	1.685	2.169
03	-	.820	.811	.874	.977	1.064	1.166	1.263	1.372	1.575	1.716	2.200
04	-	-	.822	.945	1.048	1.135	1.237	1.334	1.443	1.646	1.787	2.271
05	-	-	-	.945	1.048	1.135	1.237	1.334	1.443	1.646	1.787	2.271
06	-	-	-	-	1.054	1.141	1.243	1.340	1.499	1.652	1.793	2.277
08	-	-	-	-	-	1.242	1.344	1.441	1.550	1.753	1.894	2.378
10	-	-	-	-	-	-	1.445	1.542	1.651	1.854	1.995	2.479
12	-	-	-	-	-	-	-	1.648	1.757	1.960	2.101	2.585
16	-	-	-	-	-	-	-	-	1.804	2.007	2.148	2.632
20	-	-	-	-	-	-	-	-	-	2.054	2.195	2.679
24	-	-	-	-	-	-	-	-	-	-	2.320	2.804
32	-	-	-	-	-	-	-	-	-	-	-	3.054

TABLE 3 - TUBE SIZE AND CORRESPONDING THREAD

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

REV.
C

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NOTES:

- /1/ MATERIAL:
- a. NO CODE LETTER - 1137 STEEL FORGING OR BAR PER AMS 5024 OR ASTM A 108, OR 4130 STEEL FORGING OR BAR PER AMS 6370 OR MIL-S-6758.
 - b. CODE LETTER O - 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.
 - 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 S - 30347 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS 5646 OR 347 CORROSION RESISTANT STEEL PER QQ-S-763.
 - f. CODE LETTER T - 6AL4V TITANIUM ALLOY FORGING OR BAR PER AMS 492B.
 - g. 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. NO MATERIAL CODE LETTER - CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2, DYE BLACK.
 - b. MATERIAL CODE LETTER D - ANODIZE PER AMS 2472 OR MIL-A-8625, TYPE II, CLASS 2, DYE BLUE, DUPLEX SEAL.
 - c. MATERIAL CODE LETTER J - PASSIVATE PER QQ-P-35, TYPE VI OR VII.
 - d. MATERIAL CODE LETTER K - PASSIVATE PER QQ-O-35, TYPE VI OR VII.
 - e. MATERIAL CODE LETTER S - PASSIVATE PER QQ-P-35, TYPE VI OR VII.
 - f. MATERIAL CODE LETTER T - FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486.
 - g. MATERIAL CODE LETTER W - ANODIZE PER AMS 2472 OR MIL-A-8625, TYPE II, CLASS 2, DYE BROWN, DUPLEX SEAL.
- /3/ PROCUREMENT SPECIFICATION: MIL-F-5509 EXCEPT AS SPECIFIED ON THIS STANDARD. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.
- /4/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B.
- a. FOR SIZES 06 (.375 OD TUBE SIZE) AND SMALLER MANUFACTURER'S NAME, CAGE NUMBER OR TRADEMARK, LETTERS "AS", AND MATERIAL CODE LETTER FOR CORROSION RESISTANT STEEL, TITANIUM AND 7075 ALUMINUM. NO MATERIAL CODE LETTER FOR CARBON STEEL EXCEPT LETTER "F" MAY APPEAR ON PARTS MADE FROM 4130 STEEL. LETTER "O" IS OPTIONAL ON PARTS MADE FROM 2014 AND 2024 ALUMINUM.
 - b. FOR SIZES 08 (.500 OD TUBE SIZE) AND LARGER, MANUFACTURER'S NAME, CAGE NUMBER OR TRADEMARK, BASIC PART NUMBER, AND MATERIAL CODE LETTER FOR CORROSION RESISTANT STEEL, TITANIUM AND 7075 ALUMINUM. NO MATERIAL CODE LETTER FOR CARBON STEEL EXCEPT LETTER "F" MAY APPEAR ON PARTS MADE FROM 4130 STEEL. LETTER "O" IS OPTIONAL ON PARTS MADE FROM 2014 AND 2024 ALUMINUM.
- THE PRESENCE OF SYMBOL "Δ" OR LETTERS "AN", "MS" OR "AN827", "MS24403" OR COMPLETE PART NUMBER FOR NONREDUCER FITTINGS SHALL NOT BE CAUSE FOR REJECTION.
5. THIS PART IS DESIGNED FOR USE AS SPECIFIED IN THE PROCUREMENT SPECIFICATION. FOR REDUCER CONFIGURATION, PRESSURE RATING IS DETERMINED BY LARGEST PORT.
 6. THE NONREDUCER CONFIGURATION IS FUNCTIONALLY EQUIVALENT TO AN827 AND MS24403 FOR THE CORRESPONDING FORGING SIZE.
- /7/ WHEN MACHINING FROM BAR STOCK OR OVERSIZED FORGING, THE CENTER BODY DIMENSIONS SHALL CONFORM TO AS1376, TABLE 1.
- /8/ PORT #1 IS THE LARGEST PORT, LARGER OR EQUAL TO PORT #2 AND #3; PORT #2 IS LARGER OR EQUAL TO PORT #4.
- /9/ FORGING SIZE IS DETERMINED BY LARGEST PORT (PORT #1).
10. INTERPRETATION OF DRAWING PER ARP4296.