

RATIONALE

PROCUREMENT NOTE /6/ HAS BEEN CHANGED TO SPECIFY PRI-QPL-AS1576, ALSO UPDATES

REV.  
C

SAE AS1584

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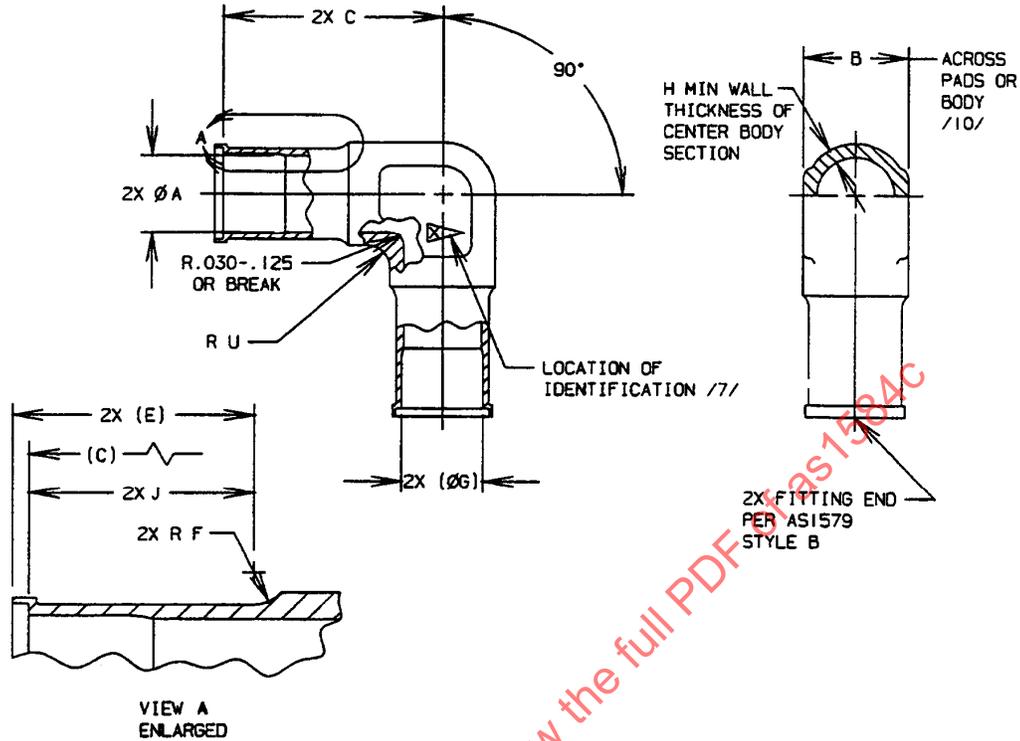


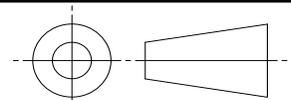
FIGURE 1 - FITTING, ELBOW, 90°

TABLE 1 - DIMENSIONS

BASIC NO. AS1584 /17/ SIZE CODE	(NOMINAL TUBE SIZE)	(NOMINAL TUBE WALL)	A	B	C ±.010	E	F
04	.250	.016	.187	.376-.393	.840	.650	.090
05	.312	.020	.234	.438-.455	.895	.650	.090
06	.375	.020	.297	.438-.455	.982	.650	.090
08	.500	.026	.422	.563-.581	1.188	.650	.090
10	.625	.033	.515	.688-.706	1.250	.830	.125
12	.750	.039	.656	.876-.894	1.400	.870	.125
16	1.000	.052	.875	1.121-1.146	1.625	1.000	.125
20	1.250	.065	1.093	1.370-1.395	1.750	1.125	.125

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THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /6/ AS1576

**SAE Aerospace**  
An SAE International Group

**AEROSPACE STANDARD**

FITTING, ELBOW, 90°,  
INTEGRAL WELD RING, 3000 PSI

**SAE AS1584**  
SHEET 1 OF 3

REV.  
C

TABLE 1A - DIMENSIONS AND WEIGHTS

BASIC NO. AS1584 /17/ SIZE CODE	G	H	J	U ±.030	LBS APPROX REF CRES	LBS APPROX REF TI
04	.212	.050	.615	.090	.0241	.0133
05	.266	.050	.615	.090	.0322	.0177
06	.329	.050	.615	.120	.0367	.0203
08	.442	.050	.605	.120	.0624	.0344
10	.553	.070	.785	.190	.110	.0609
12	.666	.080	.815	.190	.185	.102
16	.890	.090	.935	.190	.326	.180
20	1.114	.110	1.050	.190	.517	.285

## NOTES:

## /1/ MATERIAL:

- a. CODE LETTER T - TYPE 6AL-4V TITANIUM ALLOY FORGING OR BAR PER AMS4928.
- b. CODE LETTER V - TYPE 15-5PH CORROSION RESISTANT STEEL FORGING OR BAR PER AMS5659.

## 2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER T - NONE
- b. MATERIAL CODE LETTER V - HEAT TREAT TO CONDITION H 1075 PER AMS2759/3.

## 3. FINISH: NONE.

## /4/ CLEANING:

- a. NO SUFFIX CODE LETTER IN PART NUMBER - CLEAN BY ANY SUITABLE METHOD PER PROCUREMENT SPECIFICATION.
- b. SUFFIX CODE LETTER "C" IN PART NUMBER - HOT ALKALINE CLEAN PER PROCUREMENT SPECIFICATION.
- c. SUFFIX CODE LETTER "E" IN PART NUMBER FOR TITANIUM ALLOY PARTS ONLY - NITRIC-HYDROFLUORIC ACID ETCH PER PROCUREMENT SPECIFICATION.

## 5. PACKAGING: PER PROCUREMENT SPECIFICATION.

/6/ PROCUREMENT SPECIFICATION: AS1576 UNLESS OTHERWISE SPECIFIED ON THIS STANDARD PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER AS LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST PRI-QPL-AS1576 FOR THIS STANDARD. SEE <http://www.eauditnet.com> FOR CURRENT QPL ONLINE.

/7/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B MANUFACTURER'S IDENTIFICATION, CAGE CODE NUMBER OR TRADEMARK, BASIC PART NUMBER FOR SIZE 08 AND LARGER, LETTERS "AS" FOR SIZE 06 AND SMALLER AND MATERIAL CODE LETTER.

8. THIS PART IS DESIGNED FOR USE IN SYSTEMS WITH MAXIMUM OPERATING PRESSURE OF 3000 psi WHEN ORBITAL ARC WELDED TO TITANIUM ALLOY OR CORROSION RESISTANT STEEL TUBING.

9. DIMENSION "J" HAS BEEN ADDED TO THIS REVISION TO REPLACE DIMENSION "E" TO RELATE THE TURN LENGTH TO THE TUBE STOP. THE NOMINAL DIMENSION OF "E" HAS NOT CHANGED AND IS SHOWN AS A REFERENCE; IT MAY BE DELETED AT THE NEXT REVISION.

 An SAE International Group	<b>AEROSPACE STANDARD</b>	<b>SAE AS1584</b> SHEET 2 OF 3	<b>REV.</b> <b>C</b>
	FITTING, ELBOW, 90°, INTEGRAL WELD RING, 3000 PSI		