

NOTICE

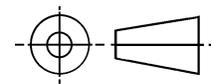
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THIRD ANGLE PROJECTION



ISSUED 1999-07 REAFFIRMED 2004-04

AS24652

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PREPARED BY SAE COMMITTEE G-3

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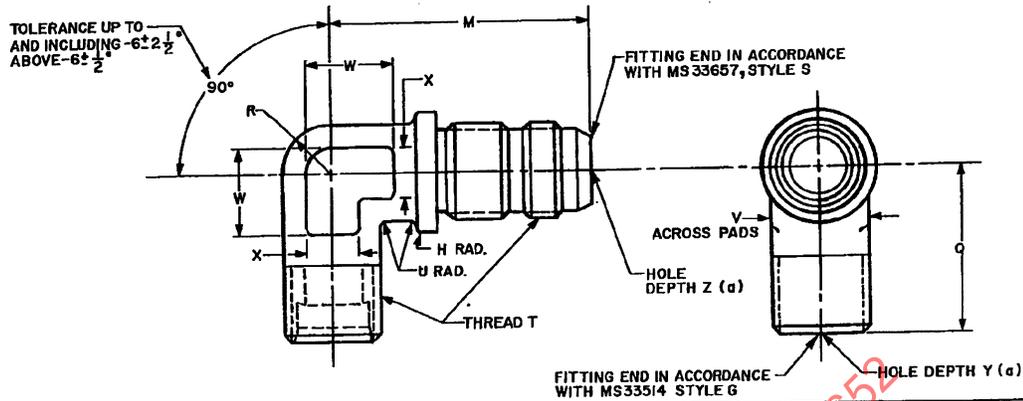
AEROSPACE STANDARD

ELBOW, TUBE - 90°, BULKHEAD, FLARED TUBE,
UNIVERSAL TO FLARELESS TUBE

AS24652
SHEET 1 OF 3

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THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODISS SPECIFIED IN THE SOLICITATION: MIL-F-18280.



DASH NO.	TUBE OD	THREAD T MIL-T-8879	H RAD	M +.047 -0	Q ±.047 -0	R RAD	U RAD	V	W APPROX	X APPROX
-3	3/16	.3750-24 UNJF-3A	.063	1.438	.906	.188	.063	.375	.313	.250
-4	1/4	.4375-20 UNJF-3A		1.578	.938	.219		.438	.375	
-5	5/16	.5000-20 UNJF-3A		1.609	1.031	.250		.500	.500	.313
-6	3/8	.5625-18 UNJF-3A	.094	1.797	1.063	.281	.094	.563	.500	.438
-8	1/2	.7500-16 UNJF-3A		2.094	1.313	.375		.750	.625	
-10	5/8	.8750-14 UNJF-3A		2.375	1.500	.438		.875	.750	.500
-12	3/4	1.0625-12 UNJ-3A	.125	2.656	1.625	.531	.125	1.063	.875	.625
-16	1	1.3125-12 UNJ-3A		2.781	1.719	.656		1.313	1.063	.625
-20	1-1/4	1.6250-12 UNJ-3A		3.109	2.000	.813		1.625	1.250	.750
-24	1-1/2	1.8750-12 UNJ-3A	.188	3.203	2.188	.938	.188	1.875	1.438	.875
-32	2	2.5000-12 UNJ-3A		4.094	2.375	1.250		2.563	1.938	1.188

(a) DEPTHS Y AND Z SHOULD BE MACHINED SUCH THAT THE CROSS-SECTIONAL AREA AT THE JUNCTION OF THE PASSAGES IS NOT SMALLER THAN THE CROSS-SECTIONAL AREA OF THE SMALLER HOLE. Y AND Z AT THEIR DEEPEST POINTS SHALL NOT EXTEND BEYOND THE WALL ESTABLISHED BY THE RESPECTIVE INTERSECTING HOLE.

REQUIREMENTS:

- MATERIAL: CARBON STEEL - CORROSION RESISTANT STEEL } SEE PROCUREMENT SPECIFICATION.
ALUMINUM ALLOY -
TITANIUM ALLOY -
- PARTS MADE FROM 1137 OR 1141 FORGINGS QUALIFIED TO MIL-F-18280C SHALL NOT BE SUPPLIED AFTER 30 JUNE 1984.
- FINISH: SEE PROCUREMENT SPECIFICATION.