

REV. A

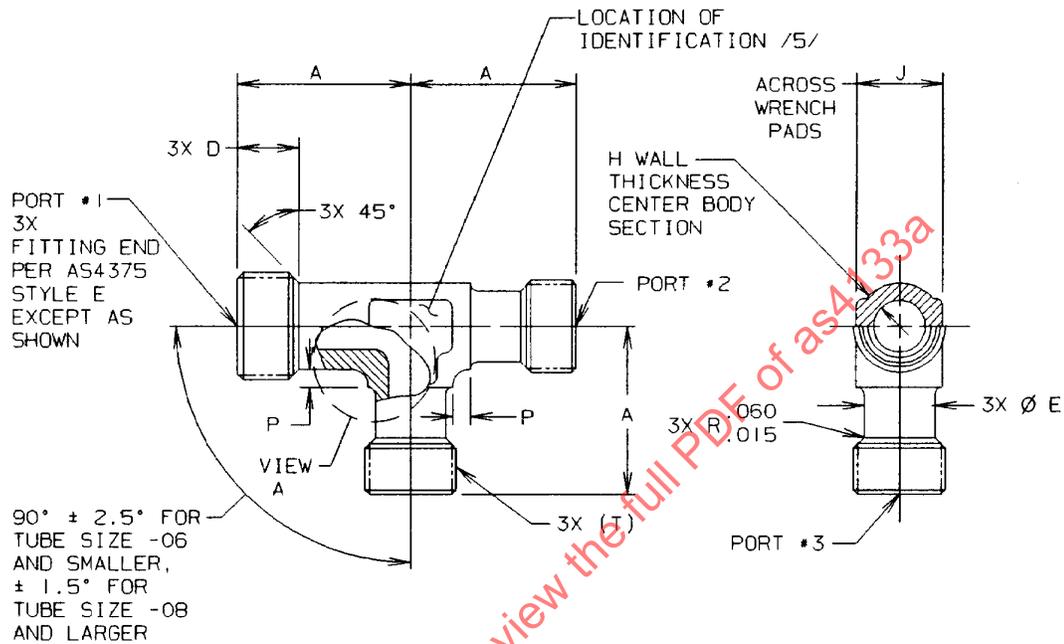
AS4133

FEDERAL SUPPLY CLASS  
4730

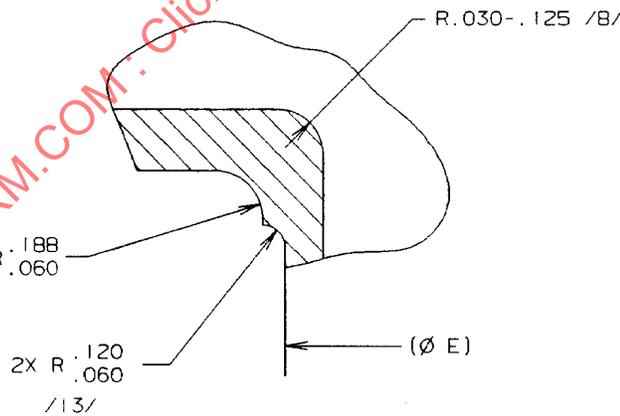
NOTE

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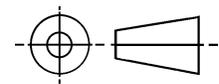
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ENLARGED VIEW A

FIGURE 1 - TEE, REDUCED BODY, FLARELESS

THIRD ANGLE PROJECTION



ISSUED 1992-11 REVISED 2004-01

CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS18280

**SAE Aerospace**  
An SAE International Group

**AEROSPACE STANDARD**

TEE, REDUCED BODY, FLARELESS

**AS4133**  
SHEET 1 OF 4

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TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4133 /19/ SIZE CODE	H MIN	J	P +.030	LB/EA MAX CRES	LB/EA MAX TI
04	.050	.390	.030	.055	.031
05	.050	.453	.159	.068	.038
06	.050	.453	.137	.080	.046
08	.050	.577	.140	.142	.081
10	.070	.702	.157	.264	.151
12	.080	.890	.166	.385	.221
16	.090	1.140	.174	.588	.338
20	.110	1.390	.071	1.141	.663
24	.130	1.640	---	1.470	.850

TABLE 2 - FITTING END

SIZE CODE	TUBE OD	T THREAD PER AS8879 CLASS 3A	D	E
04	.250	.4375-20UNJF	.371	.350
05	.313	.5000-20UNJF	.371	.412
06	.375	.5625-18UNJF	.379	.453
08	.500	.7500-16UNJF	.461	.577
10	.625	.8750-14UNJF	.511	.702
12	.750	1.0625-12UNJ	.556	.890
16	1.000	1.3125-12UNJ	.556	1.140
20	1.250	1.6250-12UNJ	.556	1.390
24	1.500	1.8750-12UNJ	.556	1.640

TABLE 3 - LEG LENGTH A

FORGING SIZE	04	05	06	08	10	12	16	20	24
04	.898	---	---	---	---	---	---	---	---
05	.961	.961	---	---	---	---	---	---	---
06	1.039	1.039	1.055	---	---	---	---	---	---
08	1.164	1.164	1.180	1.273	---	---	---	---	---
10	1.258	1.258	1.274	1.367	1.430	---	---	---	---
12	1.351	1.351	1.367	1.460	1.523	1.586	---	---	---
16	1.507	1.507	1.523	1.616	1.679	1.742	1.742	---	---
20	1.663	1.663	1.679	1.772	1.835	1.896	1.896	1.898	---
24	1.788	1.788	1.804	1.897	1.960	2.023	2.023	2.023	2.023

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AEROSPACE STANDARD

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NOTES:

/1/ MATERIAL:

- a. CODE LETTER J: TYPE 304 CORROSION RESISTANT STEEL PER AMS 5639
- b. CODE LETTER T: TYPE 6AL-4V TITANIUM ALLOY PER AMS 4928
- c. CODE LETTER V: TYPE 15-5PH CORROSION RESISTANT STEEL PER AMS 5659

2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER J: NONE
- b. MATERIAL CODE LETTER T: NONE
- c. MATERIAL CODE LETTER V: HEAT TREAT TO CONDITION H-1075 PER AMS 2759/3

/3/ FINISH:

- a. MATERIAL CODE LETTER J: PASSIVATE PER AMS-QQ-P-35 TYPE VI OR TYPE VII
- b. MATERIAL CODE LETTER T: FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486
- c. MATERIAL CODE LETTER V:

- (1) NO SUFFIX FINISH CODE LETTER: PASSIVATE PER AMS-QQ-P-35, TYPE II OR VIII
- (2) SUFFIX FINISH CODE LETTER "P": CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2

/4/ USERS OF THIS STANDARD SHALL PROCURE THE PRODUCT FROM ACCREDITED MANUFACTURERS OR ACCREDITED DISTRIBUTORS AS LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST PRI-QPL-AS18280 FOR THIS STANDARD. SEE <http://www.pri.sae.org/QPL/as18280.pdf> FOR CURRENT QPL ONLINE. NOTE THAT MANUFACTURERS ARE ACCREDITED BY PART NUMBER, SIZE AND MATERIALS ON PRI-QPL-AS18280.

/5/ 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 CODE OR TRADEMARK, LETTERS "AS", MATERIAL CODE LETTER AND FORGING MANUFACTURER'S IDENTIFICATION WHEN MADE FROM FORGING
- b. FOR SIZES 08 (.500 OD TUBE SIZE) AND LARGER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, BASIC PART NUMBER, MATERIAL CODE LETTER AND FORGING MANUFACTURER'S IDENTIFICATION WHEN MADE FROM FORGING

6. THIS PART IS INTENDED FOR USE IN SYSTEMS WITH OPERATING PRESSURES AS FOLLOWS:

- a. SIZES -04 THRU -16 AT 4000 psi
- b. SIZES -20 AND -24 AT 2000 psi

7. WHEN MACHINED FROM BAR OR OVERSIZED FORGING, THE CENTER BODY SECTION SHALL CONFORM TO AS1376, TABLE 2.

/8/ RADIUS APPLICABLE TO TITANIUM PARTS ONLY.

9. INSPECTION: CLASSIFICATION OF DEFECTS AS SPECIFIED FOR EQUIVALENT PARTS IN MIL-HDBK-1655. IN ADDITION, 1.5% AQL FOR THE .030 TO .125 RADIUS AT BORE INTERSECTION.

10. THIS PART IS A REDUCED BODY VERSION OF MS21905 IF NONREDUCER, OR AS1005 IF REDUCER.

/11/ SPECIFY END SIZES IN THIS ORDER: LARGEST PORT ON RUN FIRST, OPPOSITE PORT ON RUN SECOND, SIDE PORT THIRD.

12. LARGEST END DETERMINES FORGING SIZE.

/13/ APPLICABLE ONLY TO REDUCERS AND SIZE 04 AND 05 NONREDUCERS.

14. INTERPRETATION OF DRAWING PER ARP4296.

15. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M; REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125  $\mu$ m Ra.