

REV. A

AS4134

FEDERAL SUPPLY CLASS
4730

NOTE

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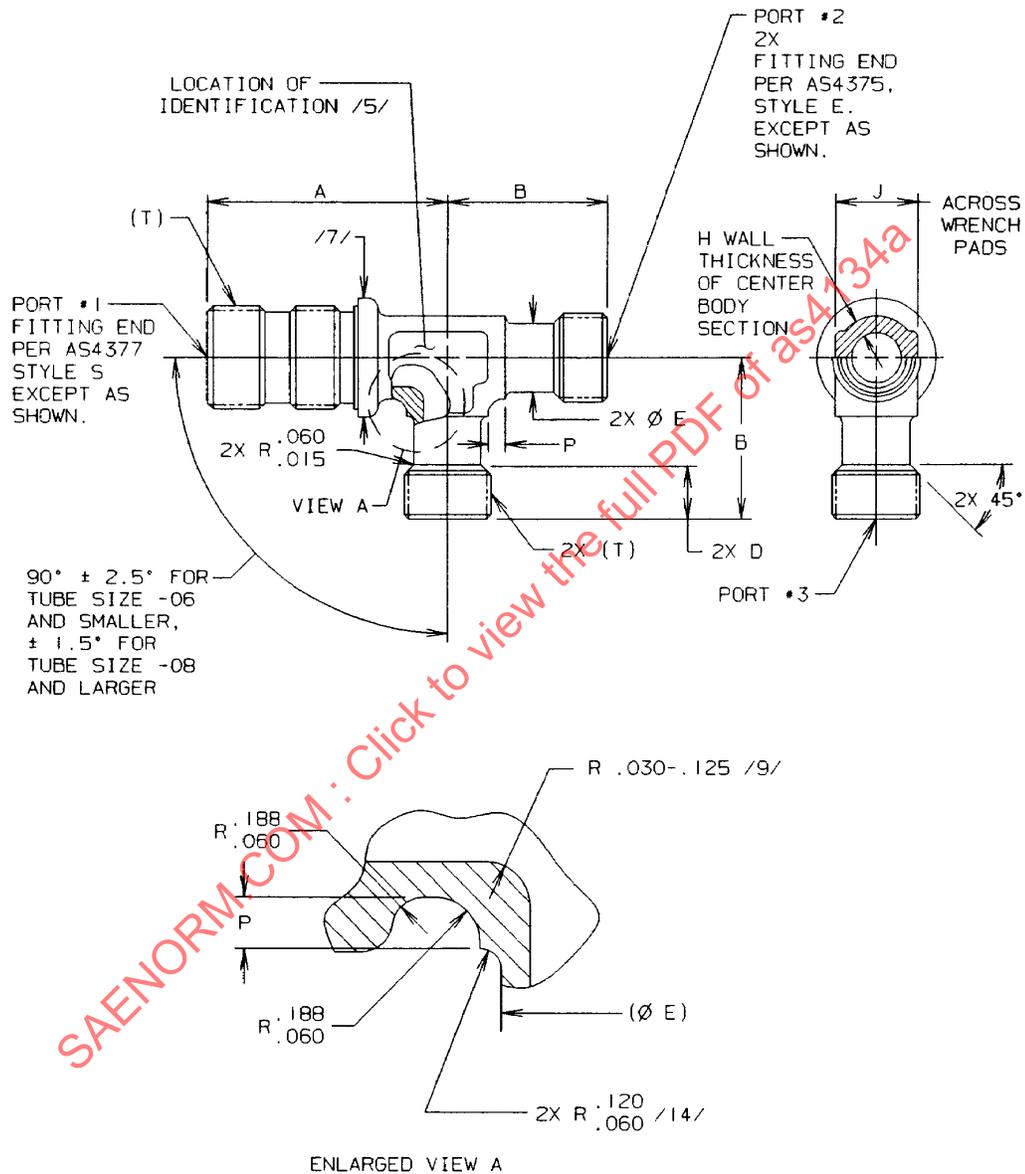
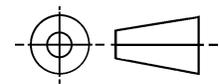


FIGURE 1 - TEE, BULKHEAD ON RUN, REDUCED BODY, FLARELESS

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS18280

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

TEE, BULKHEAD ON RUN,
REDUCED BODY, FLARELESS

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ISSUED 1992-11 REVISED 2004-01

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TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4134 /20/ SIZE CODE	H MIN	J	P ±.030	LB/EA MAX CRES	LB/EA MAX TI
04	.050	.390	.030	.082	.047
05	.050	.453	.159	.109	.061
06	.050	.453	.137	.113	.065
08	.050	.577	.140	.211	.121
10	.070	.702	.157	.364	.208
12	.080	.890	.166	.531	.305
16	.090	1.140	.174	.732	.421
20	.110	1.390	.071	1.507	.873
24	.130	1.640	---	1.959	1.133

TABLE 2 - FITTING END

SIZE CODE	TUBE OD	T THREAD PER AS8879	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	1.523	---	---	---	---	---	---	---	---
05	1.555	1.555	---	---	---	---	---	---	---
06	1.665	1.665	1.711	---	---	---	---	---	---
08	1.774	1.774	1.820	1.992	---	---	---	---	---
10	1.914	1.914	1.960	2.132	2.273	---	---	---	---
12	2.024	2.024	2.070	2.242	2.383	2.492	---	---	---
16	2.149	2.149	2.195	2.367	2.508	2.617	2.617	---	---
20	2.430	2.430	2.476	2.648	2.789	2.898	2.898	2.898	---
24	2.712	2.712	2.758	2.930	3.071	3.180	3.180	3.180	3.180

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TABLE 4 - LEG LENGTH B

FORGING SIZE	04	05	06	08	10	12	16	20	24
04	.961	---	---	---	---	---	---	---	---
05	1.055	1.055	---	---	---	---	---	---	---
06	1.070	1.070	1.086	---	---	---	---	---	---
08	1.227	1.227	1.243	1.336	---	---	---	---	---
10	1.352	1.352	1.368	1.461	1.524	---	---	---	---
12	1.414	1.414	1.430	1.523	1.586	1.649	---	---	---
16	1.507	1.507	1.523	1.616	1.679	1.742	1.742	---	---
20	1.788	1.788	1.804	1.897	1.960	2.023	2.023	2.023	---
24	1.976	1.976	1.992	2.085	2.148	2.211	2.211	2.211	2.211

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