

REV. B

SAE AS4666

FEDERAL SUPPLY CLASS
4730

RATIONALE

CANCELED MILITARY STANDARD NUMBERS HAVE BEEN REPLACED. PRI-QPL NOTE HAS BEEN UPDATED AND CADMIUM WARNING NOTICE ADDED. OTHER UPDATES.

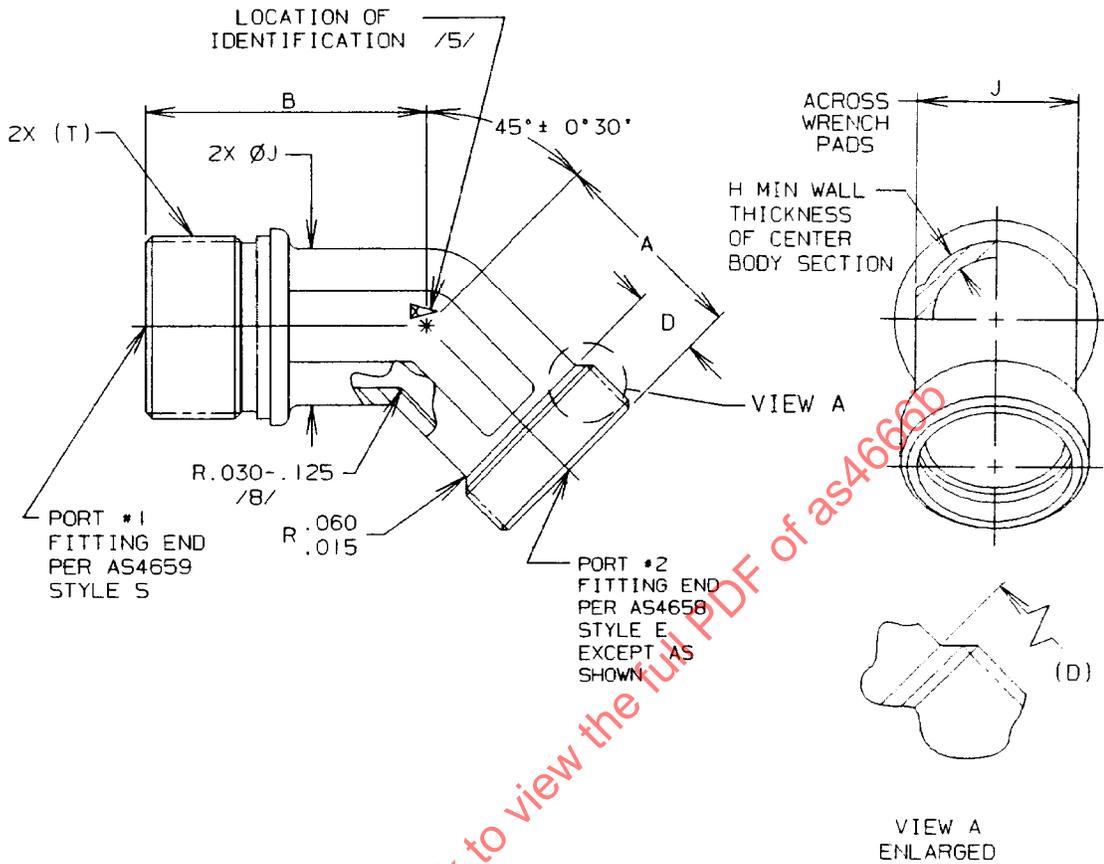


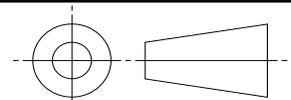
FIGURE 1 - FITTING, ELBOW, 45°

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4666	(NOMINAL TUBE SIZE)	T THREAD PER AS8879 CLASS 3A	A	B	D	H	J	LB/EA APPROX REF ALUM	LB/EA APPROX REF CRES	LB/EA APPROX REF TI
20	1.250	1.5625-12UNJ	1.236	2.217	.517	.122	1.375	.350	.971	.555
24	1.500	1.8125-12UNJ	1.330	2.233	.614	.154	1.688	.475	1.316	.752

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS4666B>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS18280

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

(R) FITTING, ELBOW, 45°, BULKHEAD, SHORT FLARELESS

SAE AS4666
SHEET 1 OF 3

REV. B

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ISSUED 1992-07 REAFFIRMED 2000-11 REVISED 2012-11

NOTES:

NOTICE

THIS DOCUMENT REFERENCES A PART WHICH CONTAINS CADMIUM AS A PLATING MATERIAL. CONSULT LOCAL OFFICIALS IF YOU HAVE QUESTIONS CONCERNING CADMIUM'S USE.

/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
- c. CODE LETTER W: TYPE 7075-T7351 ALUMINUM ALLOY FORGING PER AMS4141 OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS4124.

2. HEAT TREATMENT:

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

/3/ FINISH:

- a. MATERIAL CODE LETTER T - FLUORIDE PHOSPHATE CONVERSION COAT PER AMS2486
- b. MATERIAL CODE LETTER V:
 - (1) V CODE PARTS TO BE PASSIVATED ONLY WILL HAVE NO FINISH CODE LETTER AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE: PASSIVATE PER AMS2700 TYPE 2 OR 8.
 - (2) V CODE PARTS TO BE CADMIUM PLATED ONLY WILL HAVE THE FINISH CODE LETTER "P" AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
- c. MATERIAL CODE LETTER W: ANODIZE PER AMS2472 OR PER MIL-A-8625, TYPE II, CLASS 2 DYED BROWN SIMILAR TO COLOR 10080 OF FED-STD-595.

/4/ PROCUREMENT SPECIFICATION: AS18280 UNLESS SPECIFIED OTHERWISE 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 (QPL) PRI-QPL-AS18280 FOR THIS STANDARD. SEE <http://www.eAuditNet.com> FOR CURRENT QPL ONLINE.

/5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B. MANUFACTURER'S NAME, TRADEMARK OR GAGE CODE, BASIC PART NUMBER, AND MATERIAL CODE LETTER.

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

- a. SIZES -20 AND -24 TITANIUM ALLOY AND CORROSION RESISTANT STEEL AT 3000 psi
- b. SIZES -20 AND -24 ALUMINUM ALLOY AT 600 psi

7. WHEN MACHINED FROM BAR OR OVERSIZED FORGINGS THE CENTER BODY SECTION SHALL CONFORM TO AS1376 TABLE 10.

/8/ RADIUS APPLICABLE FOR TITANIUM PARTS ONLY.

/9/ THIS IS A NON-REDUCER FITTING. ALL PORTS OF ANY GIVEN PART WILL BE THE SAME SIZE. FOR REDUCERS USE AS4683.

 An SAE International Group	AEROSPACE STANDARD	SAE AS4666 SHEET 2 OF 3	REV. B
	(R) FITTING, ELBOW, 45°, BULKHEAD, SHORT FLARELESS		