

REV.  
B

SAE AS4677

RATIONALE

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

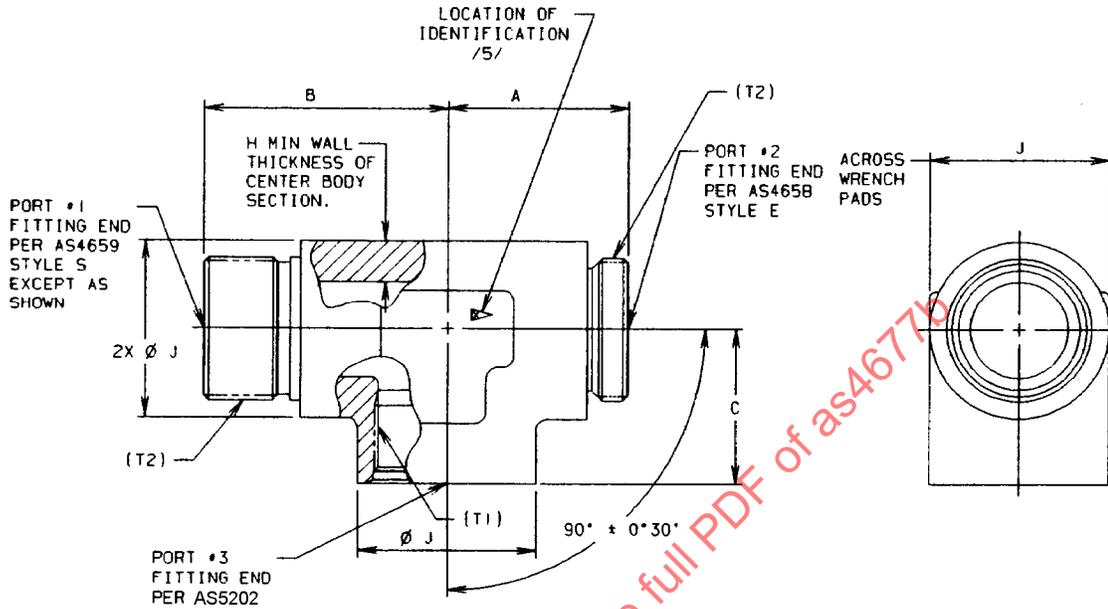
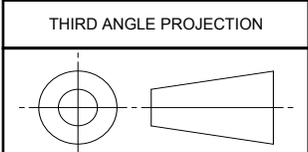


FIGURE 1 - FITTING, TEE

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CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS18280

**SAE Aerospace**  
An SAE International Group

**AEROSPACE STANDARD**

(R) FITTING, TEE, BULKHEAD ON RUN, BOSS ON SIDE,  
SHORT FLARELESS

**SAE AS4677**  
SHEET 1 OF 3

**REV. B**

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TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4677 /15/ SIZE CODE	(NOMINAL TUBE SIZE)	T1	T2	J						LB/EA	LB/EA	LB/EA
		THREAD PER AS8879 CLASS 3B	THREAD PER AS8879 CLASS 3A	A	B	C	H	+0.005/-0.020	REF ALUM	REF CRES	REF TI	
20	1.250	1.6250-12UNJ	1.5625-12UNJ	1.783	2.608	1.742	.122	2.000	1.153	3.197	1.827	
24	1.500	1.8750-12UNJ	1.8125-12UNJ	1.970	2.795	1.930	.154	2.250	1.501	4.163	2.379	

## 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-T73 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 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 CAGE CODE, BASIC PART NUMBER, AND MATERIAL CODE LETTER.

## 6. THIS PART IS DESIGNED 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

NOTE: THIS IS A NON-REDUCER FITTING.

 An SAE International Group	<b>AEROSPACE STANDARD</b>	<b>SAE AS4677</b> SHEET 2 OF 3	<b>REV.</b> <b>B</b>
	(R) FITTING, TEE, BULKHEAD ON RUN, BOSS ON SIDE, SHORT FLARELESS		