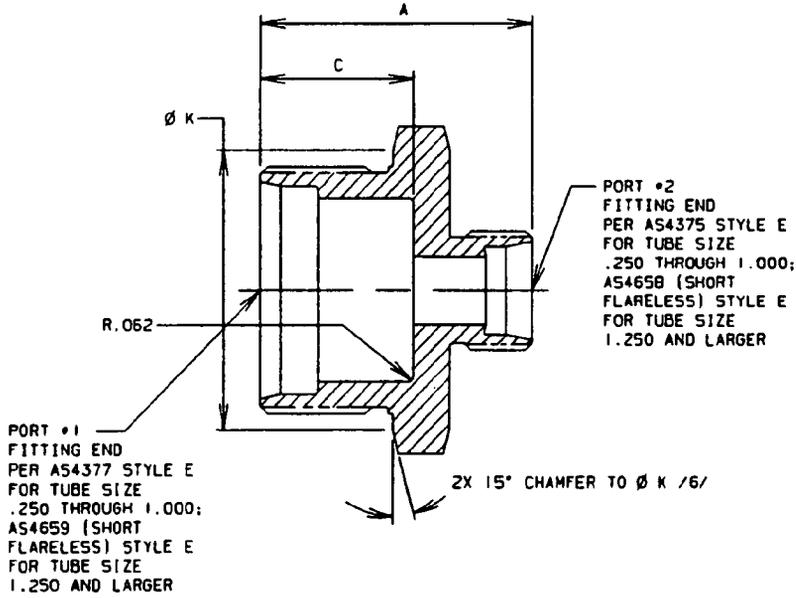


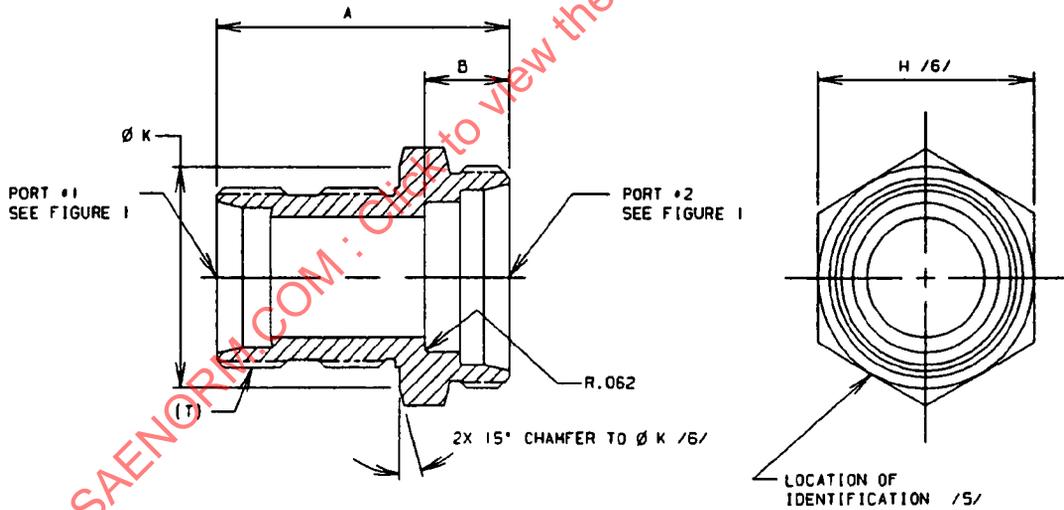
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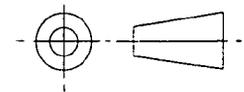


**FIGURE 1 - UNION, REDUCER, BULKHEAD, FLARELESS END SHOWN AS REDUCER**



**FIGURE 2 - UNION, EXPANDER, BULKHEAD, BULKHEAD END SHOWN AS REDUCER**

THIRD ANGLE PROJECTION



ISSUED 1992-07-15 REVISED

CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ MIL-F-18280

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**AEROSPACE STANDARD**

UNION, REDUCER, EXPANDER  
BULKHEAD, FLARELESS AND  
SHORT FLARELESS

**AS4681**

SHEET 1 OF 3

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TABLE 1 - PORT SIZES, CORRESPONDING THREADS, HEX SIZES AND DRILL DEPTH

PORT SIZE	(NOMINAL TUBE SIZE)	T THREAD PER MIL-S-8879	B	C	H1	H2	K1	K2
04	.250	.4375-20UNJF	--	--	--	--	--	--
06	.375	.5625-18UNJF	--	--	--	--	--	--
08	.500	.7500-16UNJF	--	--	--	--	--	--
10	.625	.8750-14UNJF	--	--	--	--	--	--
12	.750	1.0625-12UNJ	--	--	--	--	--	--
16	1.000	1.3125-12UNJ	--	--	--	--	--	--
20	1.250	1.5625-12UNJ	.650	1.284	1.865-1.880	1.615-1.630	1.885	1.605
24	1.500	1.8125-12UNJ	.682	1.312	2.115-2.130	1.865-1.880	2.042	1.855
28	1.750	2.1250-12UNJ	.682	1.312	2.365-2.385	2.240-2.260	2.355	2.230

TABLE 2 - DIMENSIONS

PORT #1 SIZE	A		A		A		A		A	
	PORT #2 SIZE FLARELESS /6/ 04	PORT #2 SIZE FLARELESS /6/ 06	PORT #2 SIZE FLARELESS /6/ 08	PORT #2 SIZE FLARELESS /6/ 10	PORT #2 SIZE FLARELESS /6/ 12	PORT #2 SIZE FLARELESS /6/ 16	PORT #2 SIZE FLARELESS /6/ 20	PORT #2 SIZE FLARELESS /6/ 24	PORT #2 SIZE FLARELESS /6/ 28	
04	--	--	--	--	--	--	1.914	--	--	
06	--	--	--	--	--	--	1.960	--	--	
08	--	--	--	--	--	--	2.101	--	--	
10	--	--	--	--	--	--	2.242	--	--	
12	--	--	--	--	--	--	2.351	2.414	--	
16	--	--	--	--	--	--	2.351	2.414	2.414	
20	1.952	1.968	2.061	2.125	2.187	2.187	--	2.025	2.025	
24	--	--	--	--	2.250	2.250	2.025	--	2.025	
28	--	--	--	--	--	2.250	2.025	2.025	--	