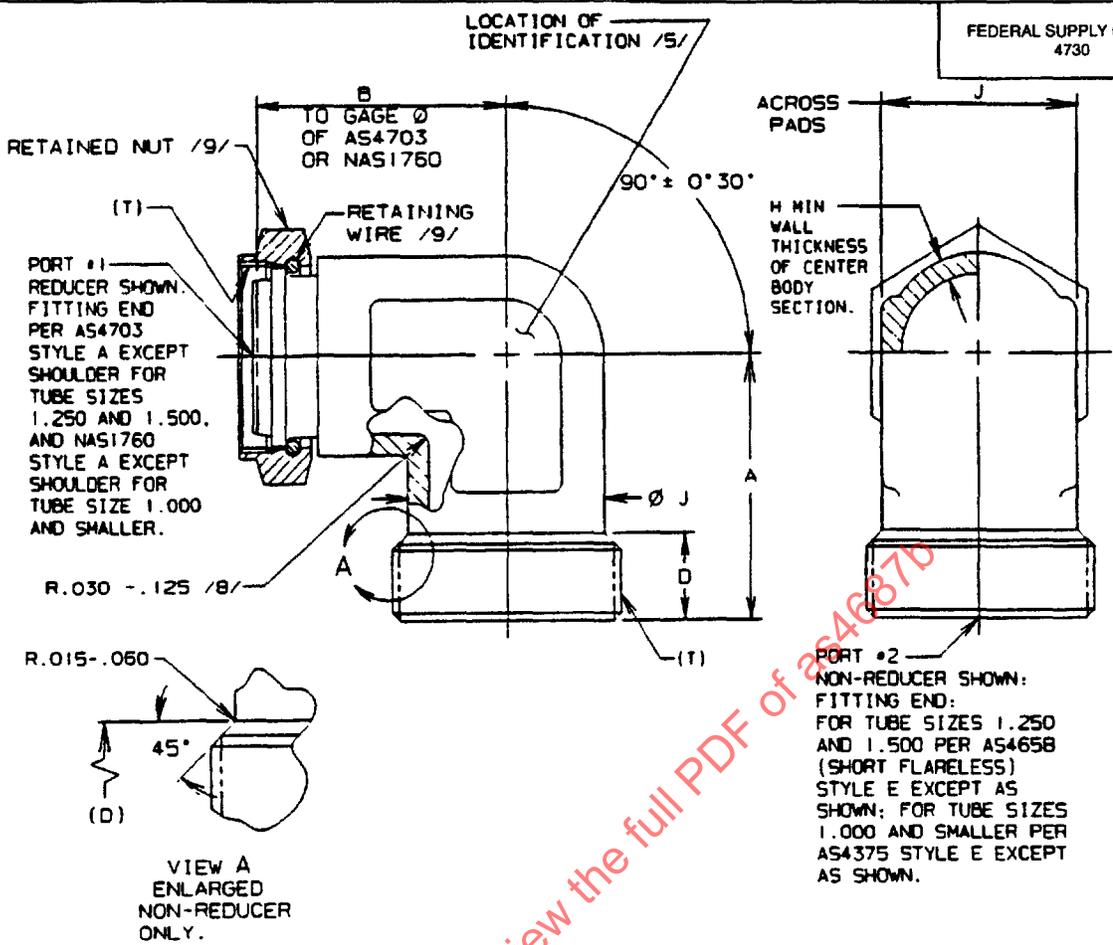
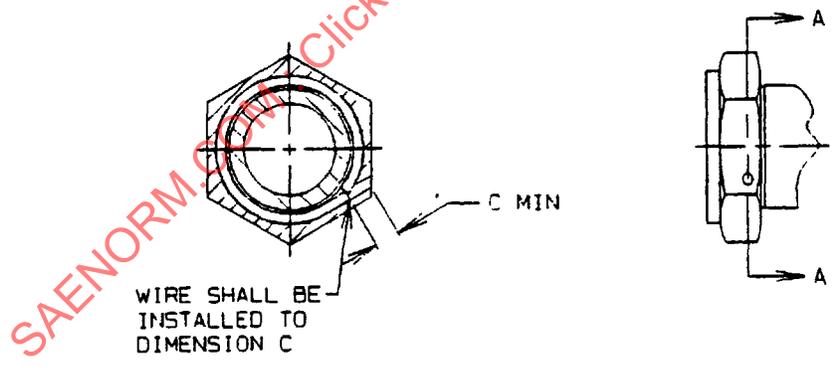


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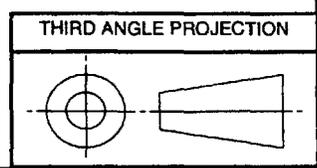
FEDERAL SUPPLY CLASS  
4730



(R) FIGURE 1 - FITTING ASSEMBLY, ELBOW, 90°



SECTION A - A  
FIGURE 2 - INSTALLATION, RETAINED NUT AND RETAINING WIRE



CUSTODIAN: SAE G-3/G-3B      PROCUREMENT SPECIFICATION: /4/ MIL-F-18280

<p>The Engineering Society For Advancing Mobility Land Sea Air and Space INTERNATIONAL 400 Commonwealth Drive, Warrendale, PA 15096-0001</p>	<b>AEROSPACE STANDARD</b>		<b>AS4687</b> SHEET 1 OF 4	<b>REV. B</b>
	FITTING ASSEMBLY, ELBOW, 90°, FLARELESS AND SHORT FLARELESS, REDUCER, RETAINED NUT			

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TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4687 /10/ /18/ SIZE CODE	D	H	J +.005/- .020	LB/EA MAX ALUM	LB/EA MAX CRES	LB/EA MAX TI
20	.517	.124	1.375	.332	.964	.560
24	.614	.156	1.688	.502	1.430	.828

(R) TABLE 2 - WIRE INSERTION DEPTH

PORT SIZE	(NOMINAL TUBE SIZE)	
		C
04	.250	.076
05	.312	.076
06	.375	.084
08	.500	.095
10	.625	.114
12	.750	.150
16	.875	.176
20	1.000	.247
24	1.500	.287

TABLE 3 - LEG LENGTH A

SIZE OF PORT #2	FORGING SIZE /10/	
	20	24
04	1.424	1.549
05	1.424	1.549
06	1.440	1.565
08	1.533	1.658
10	1.596	1.721
12	1.659	1.784
16	1.659	1.784
20	1.678	1.577
24	--	1.803

TABLE 4 - LEG LENGTH B

SIZE OF PORT #1	FORGING SIZE /10/	
	20	24
04	1.401	1.526
05	1.453	1.578
06	1.514	1.639
08	1.611	1.736
10	1.690	1.815
12	1.679	1.804
16	1.727	1.852
20	1.603	1.728
24	--	1.756

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B

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(R) TABLE 5 - TUBE SIZE AND CORRESPONDING THREADS

PORT SIZE	(NOMINAL TUBE SIZE)	T THREAD PER MIL-S-8879
04	.250	.4375-20UNJF
05	.312	.5000-20UNJF
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
24	1.500	1.8125-12UNJ

## NOTES:

- /1/ MATERIAL:
- a. CODE LETTER T:
    - (1) BODY: TYPE 6AL-4V TITANIUM ALLOY PER AMS 4928
    - (2) NUT: CODE LETTER T OF AS4702 OR AS1790 REFERENCE (TYPE 6AL-4V TITANIUM ALLOY)
    - (3) WIRE: PER AS4701 OR AS1791 REFERENCE (CLASS 302 OR 305 CORROSION RESISTANT STEEL)
  - b. CODE LETTER V:
    - (1) BODY: TYPE 15-5PH CORROSION RESISTANT STEEL PER AMS 5659
    - (2) NUT: CODE LETTER V OF AS4702 OR AS1790 REFERENCE (TYPE 15-5PH CORROSION RESISTANT STEEL)
    - (3) WIRE: PER AS4701 OR AS1791 REFERENCE (CLASS 302 OR 305 CORROSION RESISTANT STEEL)
  - c. CODE LETTER W:
    - (1) BODY: TYPE 7075-T73 ALUMINUM ALLOY FORGING PER AMS 4141 OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS 4124
    - (2) NUT: CODE LETTER W OF AS4702 OR AS1790 REFERENCE (TYPE 7075-T73 ALUMINUM ALLOY)
    - (3) WIRE: PER AS4701 OR AS1791 REFERENCE (CLASS 302 OR 305 CORROSION RESISTANT STEEL)
2. HEAT TREAT:
- a. MATERIAL CODE LETTER T:
    - (1) BODY, NUT, AND WIRE: NONE
  - b. MATERIAL CODE LETTER V:
    - (1) BODY: HEAT TREAT TO CONDITION H-1075 PER AMS 2759/3
    - (2) NUT: MATERIAL CODE LETTER V OF AS4702 OR AS1790 REFERENCE (HEAT TREAT TO CONDITION H-1075)
    - (3) WIRE: NONE
  - c. MATERIAL CODE LETTER W:
    - (1) BODY, NUT, AND WIRE: NONE
- /3/ FINISH:
- a. MATERIAL CODE LETTER T:
    - (1) BODY: FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486
    - (2) NUT: CODE LETTER T OF AS4702 OR AS1790 WITH SUFFIX N REFERENCE (FLUORIDE PHOSPHATE CONVERSION COAT AND COAT WITH DRY LUBRICANT ON ID)
    - (3) WIRE: PER AS4701 OR AS1791 REFERENCE (PASSIVATE AND COAT WITH DRY LUBRICANT)
  - b. MATERIAL CODE LETTER V:
    - (1) BODY:
      - (a) V CODE PARTS TO BE PASSIVATED ONLY WILL HAVE NO FINISH CODE LETTER AFTER THE PART NUMBER. THE FINISH WILL BE: PASSIVATE PER QQ-P-35, TYPE II OR VIII.
      - (b) 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 QQ-P-416, TYPE II, CLASS 2.
    - (2) NUT: CODE LETTER V OF AS4702 OR AS1790 REFERENCE
      - (a) NO FINISH CODE LETTER AT END OF PART NUMBER: PASSIVATE AND COAT WITH DRY FILM LUBRICANT ON ID
      - (b) FINISH CODE LETTER P AT END OF PART NUMBER: CADMIUM PLATE
    - (3) WIRE: PER AS4701 OR AS1791 REFERENCE (PASSIVATE AND COAT WITH DRY LUBRICANT)