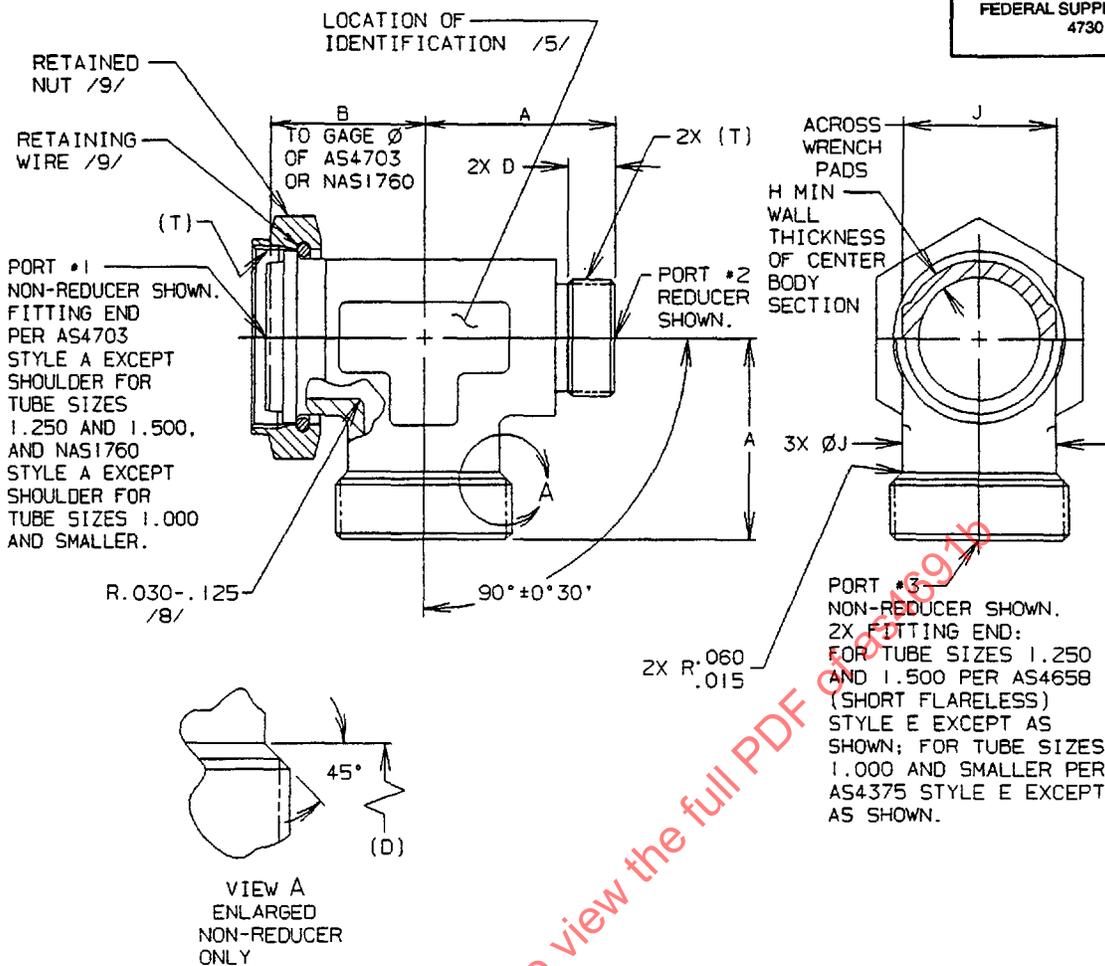


FEDERAL SUPPLY CLASS
4730

REV. B

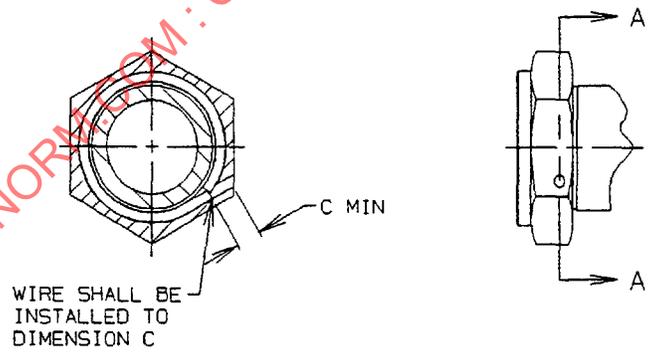
AS4691

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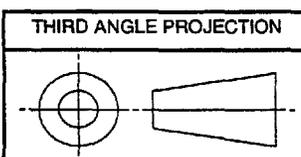


PORT #3
NON-REDUCER SHOWN.
2X FITTING END:
FOR TUBE SIZES 1.250
AND 1.500 PER AS4658
(SHORT FLARELESS)
STYLE E EXCEPT AS
SHOWN; FOR TUBE SIZES
1.000 AND SMALLER PER
AS4375 STYLE E EXCEPT
AS SHOWN.

(R) FIGURE 1 - FITTING ASSEMBLY, TEE



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. 400 Commonwealth Drive, Warrendale, PA 15096-0001</p>	AEROSPACE STANDARD		AS4691 SHEET 1 OF 4	REV. B
	FITTING ASSEMBLY, TEE, FLARELESS AND SHORT FLARELESS, REDUCER, RETAINED NUT ON RUN			

ISSUED 1992-07 REVISED 1995-05 (B)

REV.
B

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TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4691 /10/ /18/ SIZE CODE	D	H	J +0.005/-0.020	LB/EA MAX ALUM	LB/EA MAX CRES	LB/EA MAX TI
20	.517	.124	1.375	.395	1.146	.666
24	.614	.156	1.688	.570	1.651	.954

(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 & #3	FORGING SIZE /10/ 20	FORGING SIZE /10/ 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	FORGING SIZE /10/ 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	1.850
16	1.727	1.852
20	1.603	1.728
24	---	1.756

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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		.4375-20 UNJF
05	.312		.5000-20 UNJF
06	.375		.5625-18 UNJF
08	.500		.7500-16 UNJF
10	.625		.8750-14 UNJF
12	.750		1.0625-12 UNJ
16	.875		1.3125-12 UNJ
20	1.000		1.5625-12 UNJ
24	1.500		1.8125-12 UNJ

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)