FEDERAL SUPPLY CLASS
4730

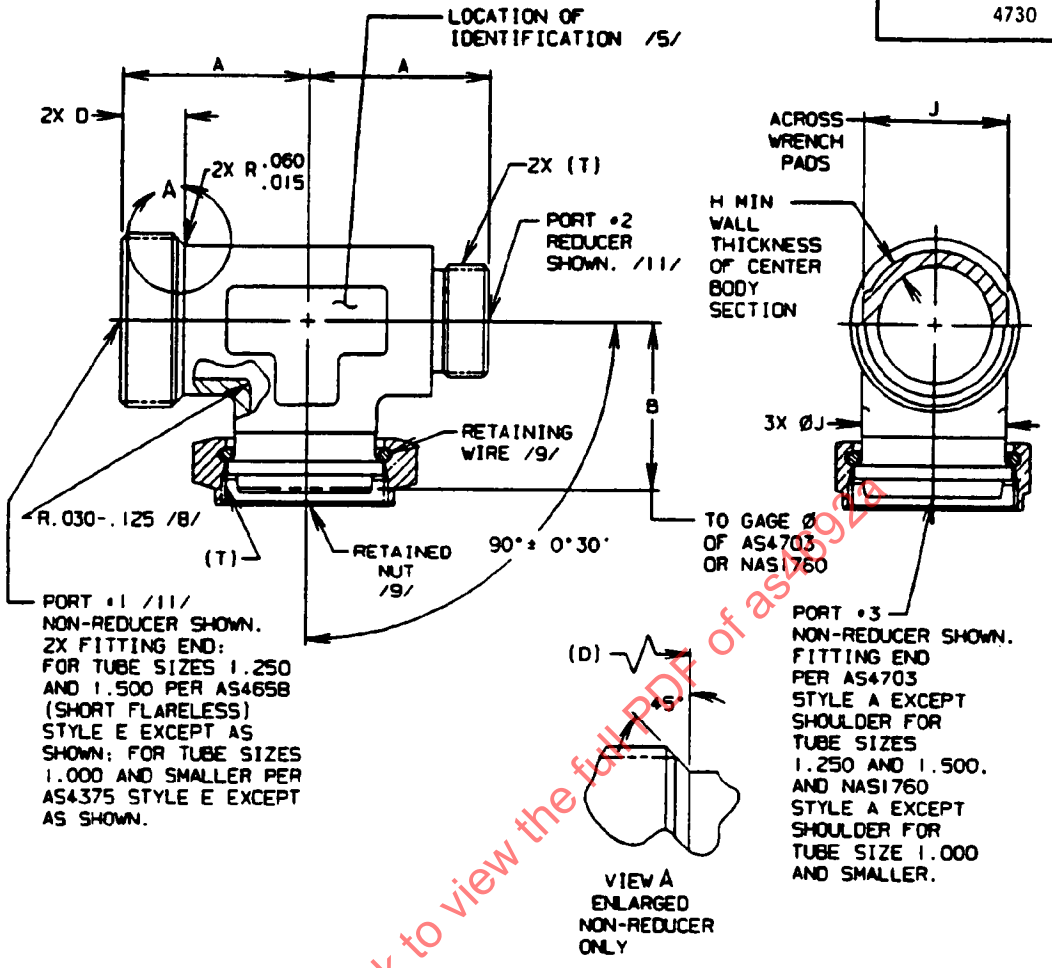
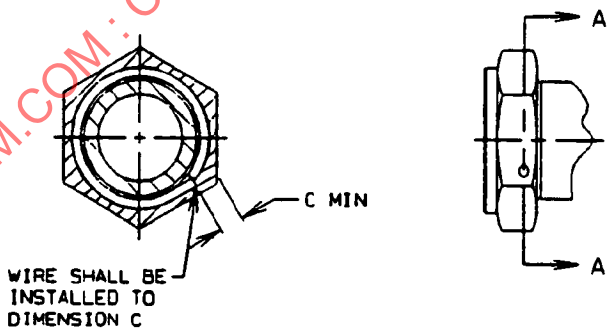


FIGURE 1 - TEE ASSEMBLY



SECTION A-A

FIGURE 2 - INSTALLATION, RETAINED NUT AND RETAINING WIRE

THIRD ANGLE PROJECTION

ISSUED 1992-07-15 REVISED 1994-01-12 (A)

CUSTODIAN: SAE G-3/G-38

PROCUREMENT SPECIFICATION: /4/ MIL-F-18280

SAE INTERNATIONAL
The Engineering Society For Advancing Mobility Land Sea Air and Space
400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARD

TEE ASSEMBLY, REDUCER, RETAINED NUT ON SIDE, FLARELESS AND SHORT FLARELESS

AS4692 REV. A

SHEET 1 OF 5

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4692 /10/ /18/ SIZE CODE	C	D	H	J +.005/-.020	LB/EA MAX ALUM	LB/EA MAX CRES	LB/EA MAX TI
20	.155	.517	.124	1.375	.395	1.146	.666
24	.180	.614	.156	1.688	.570	1.651	.954

TABLE 2 - LEG LENGTH A

SIZE OF PORT #1 & #2	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 3 - LEG LENGTH B

SIZE OF PORT #3	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

TABLE 4 - 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)

NOTES (CONTINUED):

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)

c. MATERIAL CODE LETTER W:
   (1) BODY: ANODIZE PER AMS 2472 DYED BROWN, SIMILAR TO COLOR 10080 OF FED-STD-595
   (2) NUT: CODE LETTER W OF AS4702 OR AS1790 WITH SUFFIX N REFERENCE (ANODIZE DYED BROWN AND COAT WITH DRY LUBRICANT)
   (3) WIRE: PER AS4701 OR AS1791 REFERENCE, FINISH CODE LETTER P AT END OF PART NUMBER (CADMIUM PLATE)

/4/ PROCUREMENT SPECIFICATION: MIL-F-18280 EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION AS APPLICABLE IN A COMPLETE ASSEMBLY. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT OR SIMILAR MEANS.

/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
   LARGEST PORT DETERMINES PRESSURE RATING.

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/ RETAINED NUT AND RETAINING WIRE:
   a. TUBE SIZES 1.250 AND 1.500: AS4702 RETAINED NUT AND AS4701 RETAINING WIRE
   b. TUBE SIZES 1.000 AND SMALLER: AS1790 RETAINED NUT AND AS1791 RETAINING WIRE
   ASSEMBLE RETAINED NUT TO FITTING BODY WITH RETAINING WIRE AS SHOWN IN FIGURE 2. THE NUT SHALL BE FREE TO ROTATE AFTER ASSEMBLY.

/10/ LARGEST PORT DETERMINES FORGING SIZE REGARDLESS OF THE LOCATION. MINIMUM FORGING SIZE IS -20. THIS STANDARD IS FOR REDUCERS ONLY; FOR ALL PORTS THE SAME SIZE USE AS4675.

/11/ PORT #1 IS LARGER OR EQUAL TO PORT #2.

12. INVENTORIED PARTS CONFORMING TO THE PREVIOUS "LETTER CHANGE" MAY BE USED TO DEPLETION.

13. INTERPRETATION OF DRAWING PER ARP4296.

14. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36; REQUIREMENTS PER ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 μin Ra.

15. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.

16. DIMENSIONING AND TOLERANCING: ANSI Y14.5M

17. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS $\pm$.010, ANGULAR DIMENSIONS $\pm$5°.