

REV.  
C

SAE AS4693

RATIONALE

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

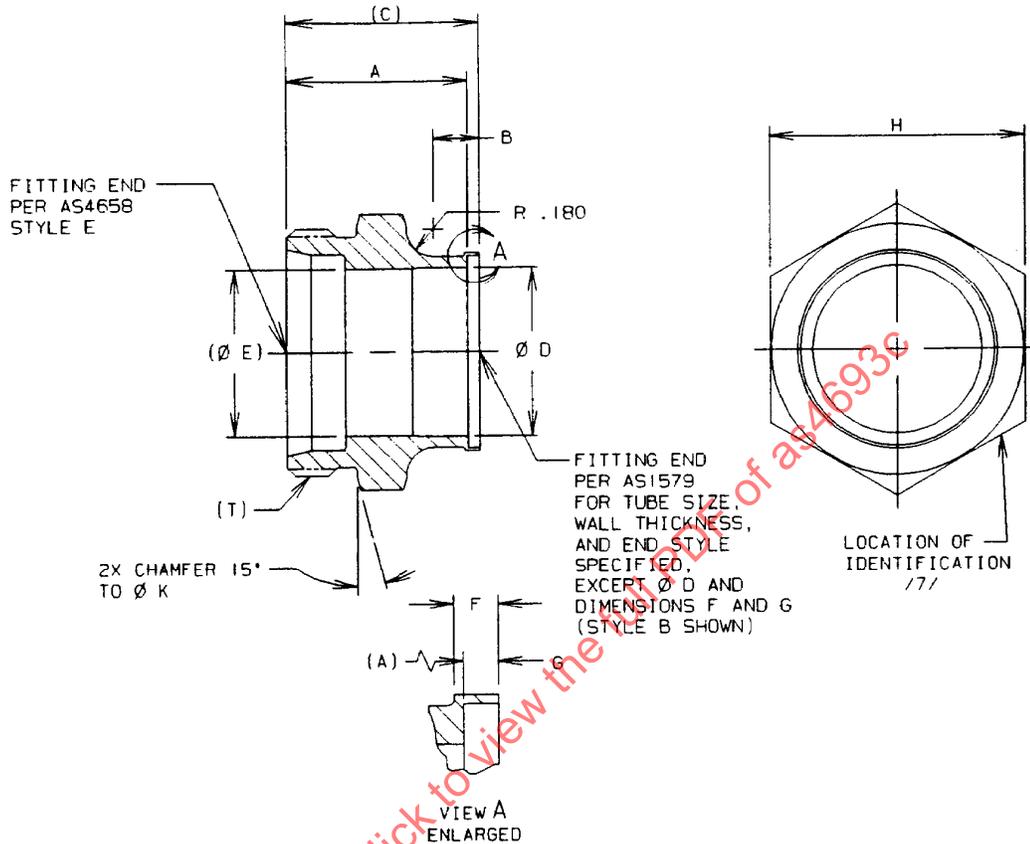


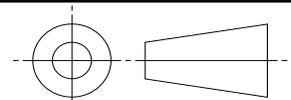
FIGURE 1 - UNION, TUBE END

TABLE 1 - DIMENSIONS AND WEIGHTS

PART NO.	(NOMINAL TUBE SIZE)	(NOMINAL TUBE WALL)	WELD END STYLE /8/	T THREAD PER AS8879 CLASS 3A	A	B ±.010	C	D ±.002	E	F	G	H +.005/-0.10	K ±.010	LB/EA APPROX REF
AS4693T20-070	1.250	.070	B	1.5625-12 UNJ	1.243	.300	1.318	1.104	1.093	.135	.075	1.625	1.605	.144
AS4693V20-070	1.250	.070	B	1.5625-12 UNJ	1.243	.300	1.318	1.104	1.093	.095	.075	1.625	1.605	.252
AS4693T24-074	1.500	.074	B	1.8125-12 UNJ	1.356	.350	1.431	1.346	1.344	.135	.075	1.875	1.855	.196
AS4693Y24-040	1.500	.040	B	1.8125-12 UNJ	1.356	.350	1.431	1.414	1.344	.075	.055	1.875	1.855	.353

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS4693C>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS1576

**SAE Aerospace**  
An SAE International Group

**AEROSPACE STANDARD**

UNION, TUBE END,  
EXTERNAL THREAD TO WELD,  
SHORT FLARELESS

**SAE AS4693**  
SHEET 1 OF 3

**REV. C**

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ISSUED 1992-05 REAFFIRMED 2004-07 REVISED 2013-01

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 BAR PER AMS4928
- b. CODE LETTER V - TYPE 15-5PH CORROSION RESISTANT STEEL BAR PER AMS5659
- c. CODE LETTER Y - TYPE 718 NICKEL ALLOY BAR PER AMS5662

2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER T - NONE
- b. MATERIAL CODE LETTER V - HEAT TREAT TO CONDITION H1075 PER AMS2759/3
- c. MATERIAL CODE LETTER Y - AFTER MACHINING, PRECIPITATION HEAT TREAT TO MEET THE REQUIREMENTS OF AMS5663

3. FINISH: ALL MATERIAL CODES - NONE.

/4/ PROCUREMENT SPECIFICATION: AS1576 EXCEPT AS SPECIFIED 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 PRI-QPL-AS1576 FOR THIS STANDARD. SEE <http://www.eAuditNet.com> FOR CURRENT QPL ONLINE.

NOTE: THIS QPL REQUIREMENT SHALL BE IN EFFECT FOR PURCHASE ORDERS PLACED ON OR AFTER JULY 1, 2013. SUPPLIERS SEEKING LISTING ON THE INITIAL QPL MUST APPLY TO PRI FOR APPROVAL NO LATER THAN JANUARY 1, 2013. UNTIL THE QPL IS IN EFFECT, USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVALS. TRANSITION TO PRI-QPL SHALL BE COMPLETED BY JULY 1, 2013.

5. CLEANING:

- a. CODE LETTER T AND V - CLEAN AND NITRIC-HYDROFLUORIC ETCH PER PROCUREMENT SPECIFICATION
- b. CODE LETTER Y - VAPOR DEGREASE OR ALKALINE CLEAN

6. PACKAGING: INDIVIDUALLY PACKAGE IN CLEAN CONTAINER WITH IDENTIFICATION PER PROCUREMENT SPECIFICATION.

/7/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B, OR TRADEMARK, BASIC PART NUMBER, AND MATERIAL CODE LETTER.

/8/ THIS PART IS DESIGNED FOR USE IN SYSTEMS WITH OPERATING PRESSURES AS FOLLOWS:

- a. SIZE -20 AND -24 TITANIUM ALLOY AND CORROSION RESISTANT STEEL AND -20 NICKEL ALLOY AT 3000 PSI
- B. SIZE -24 NICKEL ALLOY AT 600 PSI

9. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 MICRINCHES Ra.

10. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED. HEX CORNER ROUNDING OF PARTS MACHINED FROM ROUND BAR SHALL NOT EXCEED LIMITS OF ARP1942.

 An SAE International Group	<b>AEROSPACE STANDARD</b>	<b>SAE AS4693</b> SHEET 2 OF 3	<b>REV.</b> <b>C</b>
	UNION, TUBE END, EXTERNAL THREAD TO WELD, SHORT FLARELESS		