

REV.
A

SAE AS6045

RATIONALE

CORRECTED THREAD SIZE FOR -14
CORRECTED THREAD SPECIFICATION
ADDED FINISH REQUIREMENT FOR ALUMINUM CORRECTED ANODIZE HEAT TREAT

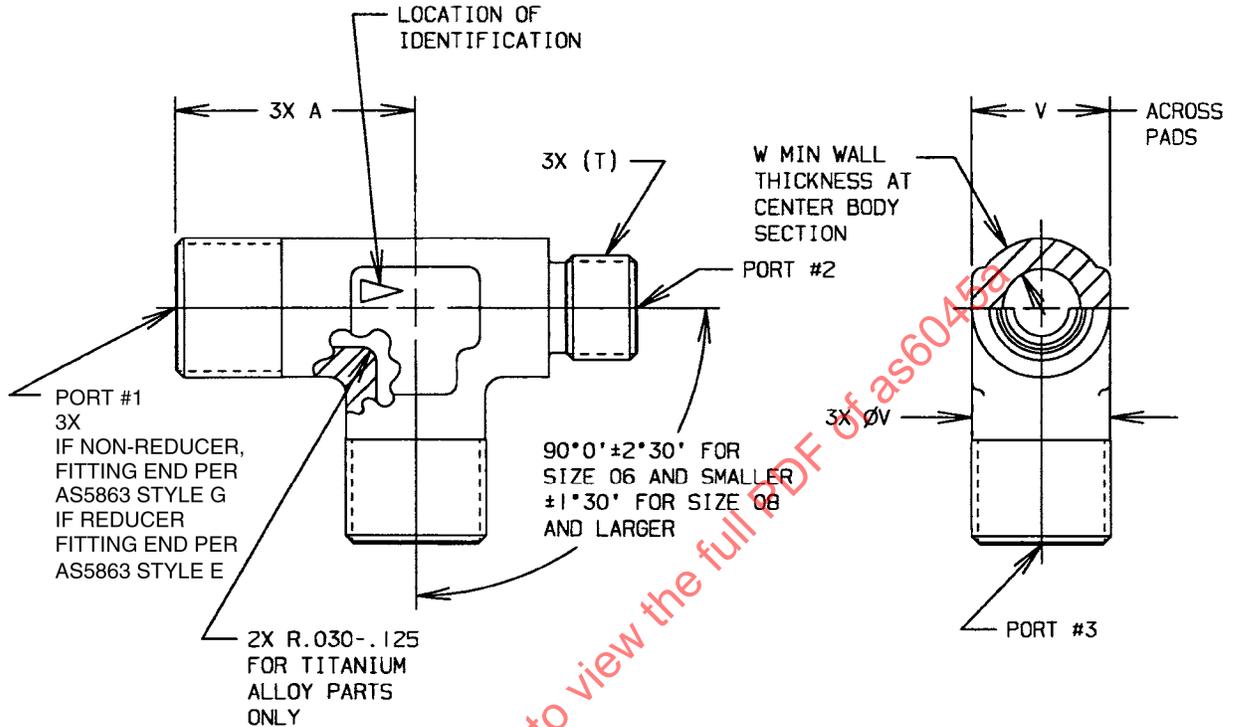
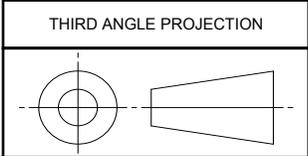


FIGURE 1 - FITTING, TEE, PORT #2 SHOWN AS REDUCER

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CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /5/ AS18280

SAE Aerospace
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AEROSPACE STANDARD

FITTING, TEE,
STANDARD AND REDUCER,
FLARELESS, PRECISION TYPE

SAE AS6045
SHEET 1 OF 4

REV.
A

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TABLE 1 - DIMENSIONS AND WEIGHTS /9/ /10/

| BASIC NO. AS1005 /19/ SIZE CODE | V | W | LB/EA APPROX REF ALUM | LB/EA APPROX REF STEEL | LB/EA APPROX REF TI |
|--|-------------|------|--------------------------------|---------------------------------|------------------------------|
| 02 | .297- .314 | .090 | .0142 | .0408 | .0225 |
| 03 | .360- .377 | .100 | .0217 | .0624 | .0344 |
| 04 | .423- .440 | .110 | .0287 | .0824 | .0455 |
| 05 | .485- .502 | .120 | .0386 | .111 | .0611 |
| 06 | .547- .565 | .120 | .0491 | .141 | .0778 |
| 08 | .735- .753 | .150 | .100 | .287 | .158 |
| 10 | .860- .878 | .170 | .126 | .361 | .199 |
| 12 | 1.047-1.065 | .185 | .222 | .638 | .352 |
| 14 | 1.173-1.191 | .200 | .278 | .799 | .441 |
| 16 | 1.292-1.317 | .205 | .333 | .956 | .528 |
| 20 | 1.605-1.630 | .240 | .549 | 1.58 | .870 |
| 24 | 1.855-1.880 | .250 | .682 | 1.96 | 1.08 |
| 32 | 2.542-2.572 | .350 | 1.55 | 4.44 | 2.45 |

TABLE 2 - LEG LENGTH A /9/ /11/

| FORGING SIZE | TUBE SIZE OF PORT #1, #2, OR #3 | | | | | | | | | | | | |
|-----------------|---------------------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| | 02 | 03 | 04 | 05 | 06 | 08 | 10 | 12 | 14 | 16 | 20 | 24 | 32 |
| 02 | .773 | - | - | - | - | - | - | - | - | - | - | - | - |
| 03 | .789 | .836 | - | - | - | - | - | - | - | - | - | - | - |
| 04 | .820 | .867 | .898 | - | - | - | - | - | - | - | - | - | - |
| 05 | .883 | .930 | .961 | .961 | - | - | - | - | - | - | - | - | - |
| 06 | .961 | 1.008 | 1.039 | 1.039 | 1.055 | - | - | - | - | - | - | - | - |
| 08 | 1.086 | 1.133 | 1.164 | 1.164 | 1.180 | 1.273 | - | - | - | - | - | - | - |
| 10 | 1.180 | 1.226 | 1.258 | 1.258 | 1.274 | 1.367 | 1.430 | - | - | - | - | - | - |
| 12 | 1.272 | 1.320 | 1.351 | 1.351 | 1.367 | 1.460 | 1.523 | 1.586 | - | - | - | - | - |
| 14 | 1.398 | 1.445 | 1.476 | 1.476 | 1.492 | 1.585 | 1.648 | 1.742 | 1.680 | - | - | - | - |
| 16 | 1.429 | 1.476 | 1.507 | 1.507 | 1.523 | 1.616 | 1.679 | 1.742 | 1.742 | 1.742 | - | - | - |
| 20 | 1.585 | 1.632 | 1.663 | 1.663 | 1.679 | 1.772 | 1.835 | 1.898 | 1.898 | 1.898 | 1.898 | - | - |
| 24 | 1.710 | 1.757 | 1.788 | 1.788 | 1.804 | 1.897 | 1.960 | 2.023 | 2.023 | 2.023 | 2.023 | 2.023 | - |
| 32 | 2.148 | 2.195 | 2.226 | 2.226 | 2.242 | 2.335 | 2.398 | 2.461 | 2.461 | 2.461 | 2.461 | 2.461 | 2.461 |

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TABLE 3 - TUBE SIZE AND CORRESPONDING THREAD

| PORT SIZE | (NOMINAL TUBE SIZE) | T THREAD PER AS8879 |
|-----------|---------------------|---------------------|
| 02 | .125 | .3125-24 UNJF |
| 03 | .188 | .3750-24 UNJF |
| 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 |
| 14 | .875 | 1.1875-12 UNJ |
| 16 | 1.000 | 1.3125-12 UNJ |
| 20 | 1.250 | 1.6250-12 UNJ |
| 24 | 1.500 | 1.8750-12 UNJ |
| 32 | 2.000 | 2.5000-12 UNJ |

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 PER PROCUREMENT SPECIFICATION
- b. CODE LETTER V – TYPE 15-5PH, CONDITION H1075 STA, CORROSION RESISTANT STEEL PER PROCUREMENT SPECIFICATION
- c. CODE LETTER W – TYPE 7075-T73 ALUMINUM ALLOY BAR OR FORGING, OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER PROCUREMENT SPECIFICATION

2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER T – ANNEALED PER PROCUREMENT SPECIFICATION
- b. MATERIAL CODE LETTER V – AGE TO CONDITION H1075 PER PROCUREMENT SPECIFICATION
- c. MATERIAL CODE LETTER W – ELECTRICAL CONDUCTIVITY AND HARDNESS PER PROCUREMENT SPECIFICATION

/3/ FINISH:

- a. MATERIAL CODE LETTER T – ANODIZE OR FLUORIDE PHOSPHATE CONVERSION COAT PER PROCUREMENT SPECIFICATION
- b. MATERIAL CODE LETTER V:
 - 1. V CODE PARTS TO BE PASSIVATED ONLY WILL HAVE NO FINISH CODE LETTER AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE: PASSIVATE PER PROCUREMENT SPECIFICATION
 - 2. V CODE PARTS TO BE CADMIUM PLATED ONLY SHALL HAVE THE FINISH CODE LETTER "P" AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE: CADMIUM PLATE PER PROCUREMENT SPECIFICATION
- c. MATERIAL CODE LETTER W – ANODIZE PER PROCUREMENT SPECIFICATION

/4/ OXYGEN SYSTEM AND COMPONENT CLEANING, SUFFIX LETTER A /19/:

- a. MATERIAL CODE LETTER P – CLEAN AND PACKAGE PER ARP1176 CATEGORY 1C
- b. MATERIAL CODE LETTER W – CLEAN AND PACKAGE PER ARP1176 CATEGORY 2

| | | | |
|---|---|-----------------------------------|------------------|
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| | FITTING, TEE, STANDARD AND REDUCER, FLARELESS, PRECISION TYPE | | |