

REV.
C

AS894

FEDERAL SUPPLY CLASS
4730

RATIONALE

AS894C HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

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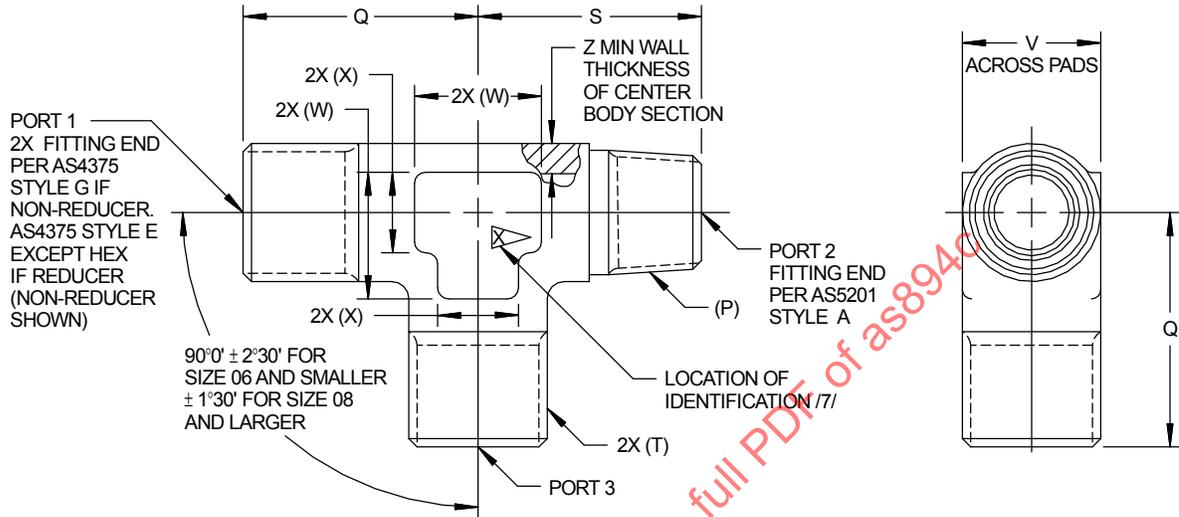
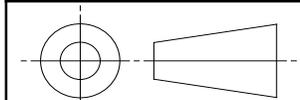


FIGURE 1 - FITTING, TEE, STANDARD AND REDUCER, FLARELESS TUBE TO PIPE ON RUN, EXTERNAL THREAD

INACTIVE IN PART /4/

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THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /6/ AS4842/2



AEROSPACE STANDARD

(R) FITTING, TEE, STANDARD AND REDUCER, FLARELESS TUBE TO PIPE ON RUN, EXTERNAL THREAD

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REAFFIRMED 2015-06

REVISED 2008-03

ISSUED 1976-01

TABLE 1 - FORGING SIZE /8/

	LARGEST SIZE OF PORT 1 OR PORT 3											
SIZE OF PORT 2	02	03	04	05	06	08	10	12	16	20	24	32
02	03	03	04	05	06	08	10	12	16	20	24	32
04	06	06	06	06	06	08	10	12	16	20	24	32
06	08	08	08	08	08	08	10	12	16	20	24	32
08	10	10	10	10	10	10	10	12	16	20	24	32
12	12	12	12	12	12	12	12	12	16	20	24	32
16	16	16	16	16	16	16	16	16	16	20	24	32
20	20	20	20	20	20	20	20	20	20	20	24	32
24	24	24	24	24	24	24	24	24	24	24	24	32
32	32	32	32	32	32	32	32	32	32	32	32	32

TABLE 2 - DIMENSIONS V - Z

BASIC NO. AS894 /8/ /15/		V	W	X	Z
SIZE CODE					
03	.360- .377	.375	.250	.090	
04	.423- .440	.375	.250	.110	
05	.485- .502	.469	.312	.120	
06	.547- .565	.500	.312	.120	
08	.735- .753	.688	.438	.150	
10	.860- .878	.781	.438	.170	
12	1.047-1 65	.906	.500	.185	
16	1.292-1 17	1.094	.625	.205	
20	1.605-1 30	1.312	.750	.240	
24	1.855-1 80	1.500	.875	.250	
32	2.542-2 72	2.031	1.188	.350	

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TABLE 3 - LEG LENGTH Q

FORGING SIZE	SIZE OF PORT 1 OR PORT 3 02	SIZE OF PORT 1 OR PORT 3 03	SIZE OF PORT 1 OR PORT 3 04	SIZE OF PORT 1 OR PORT 3 05	SIZE OF PORT 1 OR PORT 3 06	SIZE OF PORT 1 OR PORT 3 08	SIZE OF PORT 1 OR PORT 3 10	SIZE OF PORT 1 OR PORT 3 12	SIZE OF PORT 1 OR PORT 3 16	SIZE OF PORT 1 OR PORT 3 20	SIZE OF PORT 1 OR PORT 3 24	SIZE OF PORT 1 OR PORT 3 32
	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				
16	1.429	1.476	1.507	1.507	1.523	1.616	1.679	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		
24	1.710	1.757	1.788	1.788	1.804	1.897	1.960	2.023	2.023	2.023	2.023	
32	2.148	2.159	2.226	2.226	2.242	2.335	2.398	2.461	2.461	2.461	2.461	2.461

TABLE 4 - LEG LENGTH S ±.031

FORGING SIZE	SIZE OF PORT 2 02	SIZE OF PORT 2 04	SIZE OF PORT 2 06	SIZE OF PORT 2 08	SIZE OF PORT 2 12	SIZE OF PORT 2 16	SIZE OF PORT 2 20	SIZE OF PORT 2 24	SIZE OF PORT 2 32
	03	.727							
04	.789								
05	.789								
06	.898	1.085							
08	.993	1.196	1.211						
10	1.087	1.290	1.305	1.477					
12	1.179	1.382	1.397	1.569	1.585				
16	1.368	1.571	1.586	1.758	1.774	1.961			
20	1.758	1.961	1.976	2.148	2.164	2.351	2.383		
24	1.883	2.086	2.101	2.273	2.289	2.476	2.508	2.524	
32	2.337	2.540	2.555	2.727	2.743	2.930	2.962	2.977	3.008


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TABLE 5 - TUBE SIZE AND CORRESPONDING THREAD

PORT SIZE	NOMINAL		P THREAD PER AS71051 ANPT
	TUBE SIZE	T THREAD PER AS8879	
02	.125	.3125-24 UNJF-3A	1/8 -27
03	.188	.3750-24 UNJF-3A	----
04	.250	.4375-20 UNJF-3A	1/4 -18
05	.312	.5000-20 UNJF-3A	----
06	.375	.5625-18 UNJF-3A	3/8 -18
08	.500	.7500-16 UNJF-3A	1/2 -14
10	.625	.8750-14 UNJF-3A	----
12	.750	1.0625-12 UNJ-3A	3/4 -14
16	1.000	1.3125-12 UNJ-3A	1 -11 1/2
20	1.250	1.6250-12 UNJ-3A	1 1/4 -11 1/2
24	1.500	1.8750-12 UNJ-3A	1 1/2 -11 1/2
32	2.000	2.5000-12 UNJ-3A	2 -11 1/2

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. DASH AS CODE LETTER - TYPE 4130 STEEL FORGING OR BAR PER AMS-S-6758 OR AMS6370.
- b. CODE LETTER D - TYPE 2014-T6 ALUMINUM ALLOY FORGING PER AMS4133, OR TYPE 2024-T6 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6, OR TYPE 2024-T851 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6 OR AMS4339. /4/
- c. CODE LETTER J - TYPE 304 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5639.
- d. CODE LETTER K - TYPE 316 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5648.
- e. CODE LETTER R - TYPE 321 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5645.
- f. CODE LETTER S - TYPE 347 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5646. /4/
- g. CODE LETTER W - TYPE 7075-T73 ALUMINUM ALLOY FORGING PER AMS-QQ-A-367 OR AMS4141, OR TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9, OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS4124.

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