

REV.
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AS896™

RATIONALE

"INACTIVE" STATUS REPLACED BY "NOT RECOMMENDED." SPECIFICATION CALLOUTS UPDATED TO CURRENT ISSUE. "INTENDED USE" NOTE REVISED. QML STATEMENT REVISED.

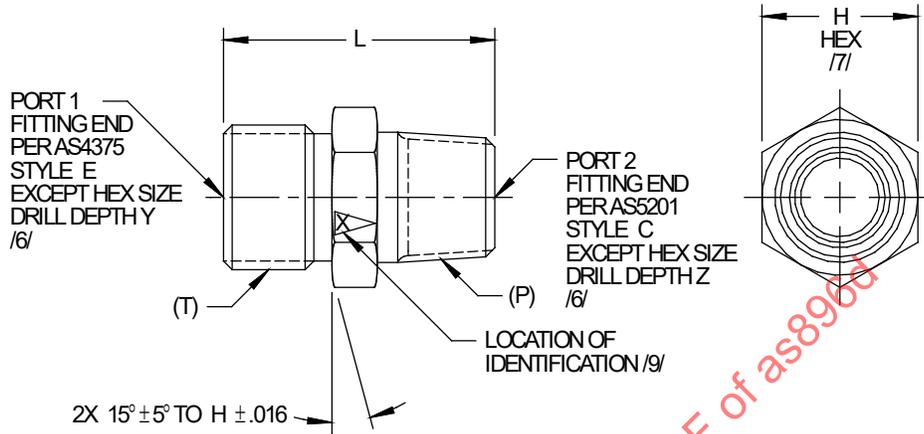


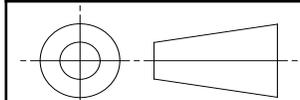
FIGURE 1 - FITTING, NIPPLE, REDUCER,
FLARELESS TUBE TO PIPE,
EXTERNAL THREAD

NOT RECOMMENDED IN PART /4/

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THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS4842/2 /8/



AEROSPACE STANDARD

FITTING, NIPPLE, REDUCER,
FLARELESS TUBE TO PIPE,
EXTERNAL THREAD

AS896™
SHEET 1 OF 6

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TABLE 1 - OVERALL LENGTH L

SIZE OF PORT 2	SIZE OF PORT 1 02	SIZE OF PORT 1 03	SIZE OF PORT 1 04	SIZE OF PORT 1 05	SIZE OF PORT 1 06	SIZE OF PORT 1 08	SIZE OF PORT 1 10	SIZE OF PORT 1 12	SIZE OF PORT 1 16	SIZE OF PORT 1 20	SIZE OF PORT 1 24	SIZE OF PORT 1 32
02	.938	.984	1.031	1.062	1.094	1.188	1.266	1.344	1.375	1.406	1.469	1.578
04	1.156	1.219	1.250	1.250	1.281	1.406	1.469	1.562	1.594	1.625	1.688	1.781
06	1.203	1.250	1.281	1.281	1.281	1.406	1.516	1.594	1.625	1.656	1.703	1.812
08	1.391	1.438	1.469	1.469	1.469	1.594	1.688	1.781	1.799	1.828	1.875	1.969
12	1.438	1.500	1.531	1.531	1.547	1.609	1.719	1.781	1.812	1.844	1.891	1.984
16	1.656	1.703	1.734	1.734	1.750	1.844	1.906	2.000	2.000	2.094	2.094	2.156
20	1.750	1.797	1.828	1.828	1.844	1.938	2.000	2.094	2.094	2.094	2.125	2.203
24	1.812	1.859	1.891	1.891	1.906	2.000	2.062	2.188	2.188	2.188	2.187	2.219
32	1.838	1.894	2.016	2.016	2.031	2.125	2.218	2.205	2.250	2.250	2.250	2.656

TABLE 2 - HEX SIZE H / I

LARGEST PORT SIZE	SIZE OF PORT 1 TUBE	SIZE OF PORT 2 PIPE
02	.428- .440	.428- .440
03	.428- .440	---
04	.490- .502	.552- .565
05	.552- .565	---
06	.615- .628	.740- .753
08	.802- .815	.865- .878
10	.928- .941	---
12	1.113-1.128	1.113-1.128
16	1.363-1.380	1.363-1.380
20	1.676-1.693	1.676-1.693
24	1.988-2.005	1.988-2.005
32	2.609-2.635	2.609-2.635

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TABLE 3 - DRILL DEPTH Y

SIZE OF PORT 2	SIZE OF PORT 1 02	SIZE OF PORT 1 03	SIZE OF PORT 1 04	SIZE OF PORT 1 05	SIZE OF PORT 1 06	SIZE OF PORT 1 08	SIZE OF PORT 1 10	SIZE OF PORT 1 12	SIZE OF PORT 1 16	SIZE OF PORT 1 20	SIZE OF PORT 1 24	SIZE OF PORT 1 32
02	THRU	THRU	THRU	.516	.531	.578	.656	.622	.641	.609	.594	.562
04	THRU	THRU	THRU	THRU	.516	.609	.641	.688	.656	.625	.625	.578
06	THRU	THRU	THRU	THRU	THRU	.625	.703	.766	.703	.672	.656	.625
08	THRU	.766	.734	.688	.672	.625						
12	THRU	.766	.734	.703	.672							
16	THRU	.844	.766	.688								
20	THRU	.844	.781									
24	THRU	.859										
32	THRU											

TABLE 4 - LEG LENGTH Z

SIZE OF PORT 2	SIZE OF PORT 1 02	SIZE OF PORT 1 03	SIZE OF PORT 1 04	SIZE OF PORT 1 05	SIZE OF PORT 1 06	SIZE OF PORT 1 08	SIZE OF PORT 1 10	SIZE OF PORT 1 12	SIZE OF PORT 1 16	SIZE OF PORT 1 20	SIZE OF PORT 1 24	SIZE OF PORT 1 32
02	.422	.406	THRU									
04	.609	.625	.641	.656	THRU							
06	.625	.625	.641	.641	.656	THRU						
08	.766	.766	.797	.797	.797	.844	.875	THRU	THRU	THRU	THRU	THRU
12	.766	.781	.797	.797	.812	.797	.859	.891	THRU	THRU	THRU	THRU
16	.922	.906	.938	.938	.969	.969	.984	1.047	1.094	THRU	THRU	THRU
20	.922	.922	.938	.953	.969	.984	.984	1.047	1.094	1.109	THRU	THRU
24	.906	.906	.938	.938	.953	.969	.969	1.078	1.125	1.141	1.203	THRU
32	.906	.906	.922	.938	.953	.969	1.031	1.000	1.062	1.078	1.141	1.609

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TABLE 5 - TUBE SIZE AND CORRESPONDING THREAD

PORT SIZE	NOMINAL TUBE SIZE	T THREAD PER AS8879	P THREAD PER AS71051 ANPT
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 1137 STEEL FORGING OR BAR PER ASTM-A-108. /4/
- b. CODE LETTER D - 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 F - TYPE 4130 STEEL BAR PER AMS-S-6758 OR AMS6370.
- d. CODE LETTER J - TYPE 304 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS5639.
- e. CODE LETTER K - TYPE 316 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS5648.
- f. CODE LETTER R - TYPE 321 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS5645.
- g. CODE LETTER S - TYPE 347 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS5646. /4/
- h. CODE LETTER W - TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9, OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS4124.

2. FINISH:

- a. DASH AS CODE LETTER - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
- b. MATERIAL CODE LETTER D - ANODIZE PER AMS2472 OR MIL-A-8625, TYPE II, CLASS 2 DYED GREEN SIMILAR TO COLOR 14187 OF AMS-STD-595.
- c. MATERIAL CODE LETTER F - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
- d. MATERIAL CODE LETTER J - PASSIVATE PER AMS2700, TYPE 6 OR 7.

	AEROSPACE STANDARD	AS896™ SHEET 4 OF 6	REV. D
	FITTING, NIPPLE, REDUCER, FLARELESS TUBE TO PIPE, EXTERNAL THREAD		