

REV.
B

MA2027

RATIONALE

MA2027B HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

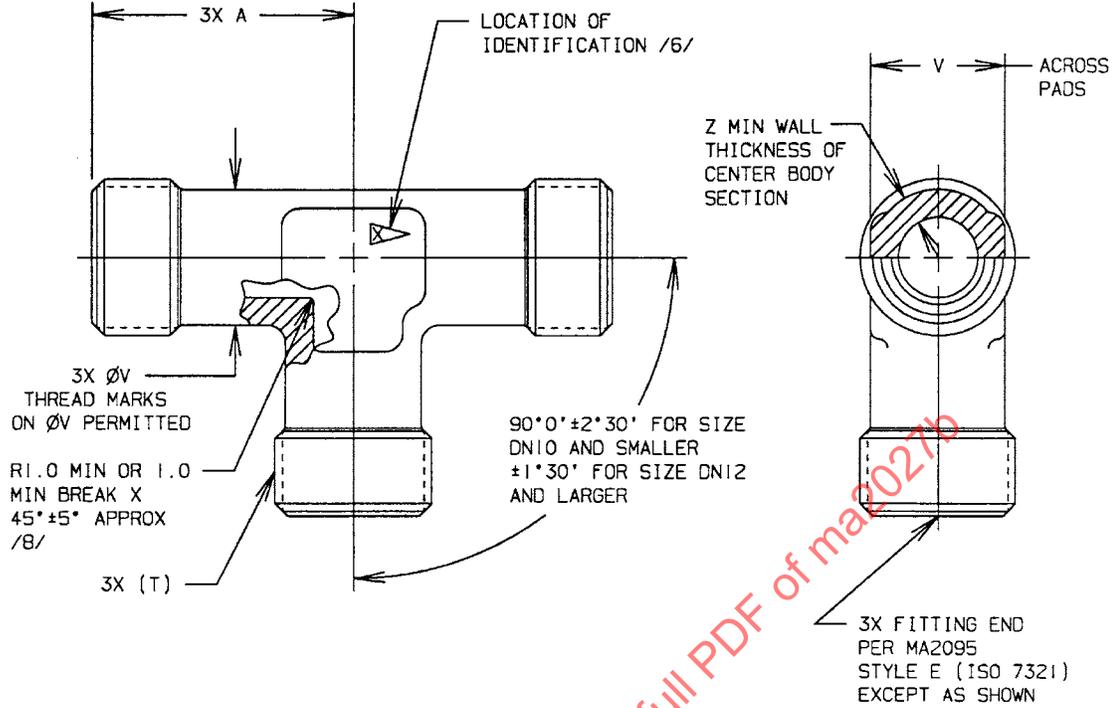


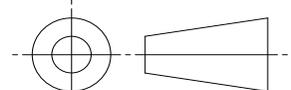
FIGURE 1 TEE, FLARELESS

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. MA2027 /17/ SIZE CODE	(NOMINAL TUBE SIZE DN) /1/	T THREAD PER MA1370 (ISO 5855-3) 4g6g	A	V	Z	Kg/100 MAX CRES	Kg/100 MAX TI
05	5	MJ 10 X 1	18	7.50- 8.06	1.3	1.94	1.07
06	6	MJ 12 X 1.25	20	9.50-10.06	1.8	3.34	1.84
08	8	MJ 14 X 1.5	23	11.40-12.06	1.8	4.59	2.53
10	10	MJ 16 X 1.5	25	13.40-14.06	2.0	6.12	3.38
12	12	MJ 18 X 1.5	26	15.4 -16.1	2.0	7.58	4.18
14	14	MJ 20 X 1.5	27	17.4 -18.1	2.0	9.24	5.10
16	16	MJ 22 X 1.5	28	19.4 -20.1	2.0	10.7	5.90
20	20	MJ 27 X 1.5	32	23.4 -24.1	2.5	16.6	9.15
25	25	MJ 33 X 1.5	36	29.4 -30.1	2.5	28.5	15.7
32	32	MJ 42 X 2	42	38.2 -39.2	3.5	52.9	29.2

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/MA2027B>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /5/ MA2005 (ISO 7169)



AEROSPACE STANDARD

(R) FITTING, TEE, THIN WALL, FLARELESS, METRIC

MA2027
SHEET 1 OF 3

REV.
B

SAE Technical Standards Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user." SAE reviews each technical report at least every five years at which time it may be revised, reaffirmed, stabilized, or cancelled. SAE invites your written comments and suggestions.

NOTES:

- /1/ DN = NOMINAL TUBE OUTSIDE DIAMETER.
- /2/ MATERIAL:
- a. CODE LETTER J - TYPE 304 CORROSION RESISTANT STEEL PER AMS 5639 OR QQ-S-763.
 - b. CODE LETTER K - TYPE 316 CORROSION RESISTANT STEEL PER AMS 5648 OR QQ-S-763.
 - c. CODE LETTER R - TYPE 321 CORROSION RESISTANT STEEL PER AMS 5645 OR QQ-S-763.
 - d. CODE LETTER T - TYPE 6AL-4V TITANIUM ALLOY PER AMS 4928.
3. HEAT TREATMENT: NONE.
4. FINISH
- a. MATERIAL CODE LETTERS J, K, AND R - PASSIVATE PER QQ-P-35, TYPE VI OR VII.
 - b. MATERIAL CODE LETTER T - ANODIZE PER AMS 2488 OR FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486.
- /5/ PROCUREMENT SPECIFICATION: MA2005 (ISO 7169) 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 SHEET OR SIMILAR MEANS.
- /6/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR METHOD 7A3, 15A3, OR 15B.
- a. FOR SIZES DN10 AND SMALLER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, MATERIAL CODE LETTER AND PRESSURE RATING (EXAMPLE: 28K = 28,000 kPa).
 - b. FOR SIZES DN12 AND LARGER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, BASIC PART NUMBER, MATERIAL CODE LETTER AND PRESSURE RATING (EXAMPLE: 28K = 28,000 kPa).
7. THIS PART IS DESIGNED FOR USE IN SYSTEMS AT TYPE II TEMPERATURE (-55 TO 135 °C) WITH OPERATING PRESSURE AS FOLLOWS:
- a. SIZES DN05 THROUGH DN25 AT 28,000 kPa.
 - b. SIZE DN32 AT 14,000 kPa.
- /8/ RADIUS OR BREAK APPLICABLE FOR TITANIUM PARTS ONLY.
9. WHEN MACHINED FROM BAR OR OVERSIZED FORGING, THE CENTER BODY SECTION SHALL CONFORM TO MA2023, TABLE 2.
10. THE CHANGE BAR (I) LOCATED IN THE LEFT MARGIN IS FOR THE CONVENIENCE OF THE USER IN LOCATING AREAS WHERE TECHNICAL REVISIONS, NOT EDITORIAL CHANGES, HAVE BEEN MADE TO THE PREVIOUS ISSUE OF THIS DOCUMENT. AN (R) SYMBOL TO THE LEFT OF THE DOCUMENT TITLE INDICATES A COMPLETE REVISION OF THE DOCUMENT.
11. INVENTORIED PARTS CONFORMING TO THE PREVIOUS "LETTER CHANGE" MAY BE USED TO DEPLETION.
12. INTERPRETATION OF DRAWING PER MAP4296.
13. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M; REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 3.2 µm Ra. FORGED SURFACES MAY BE 6.3 µm Ra.
14. BREAK EDGES 0.1 TO 0.4 UNLESS OTHERWISE SPECIFIED.
15. DIMENSIONING AND TOLERANCING: ASME Y14.5M-1994.

	AEROSPACE STANDARD	MA2027 SHEET 2 OF 3	REV. B
	(R) FITTING, TEE, THIN WALL, FLARELESS, METRIC		