

REV.
D

AS1001

FEDERAL SUPPLY CLASS
4730

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 reaffirmed, revised, or cancelled. SAE invites your written comments and suggestions.

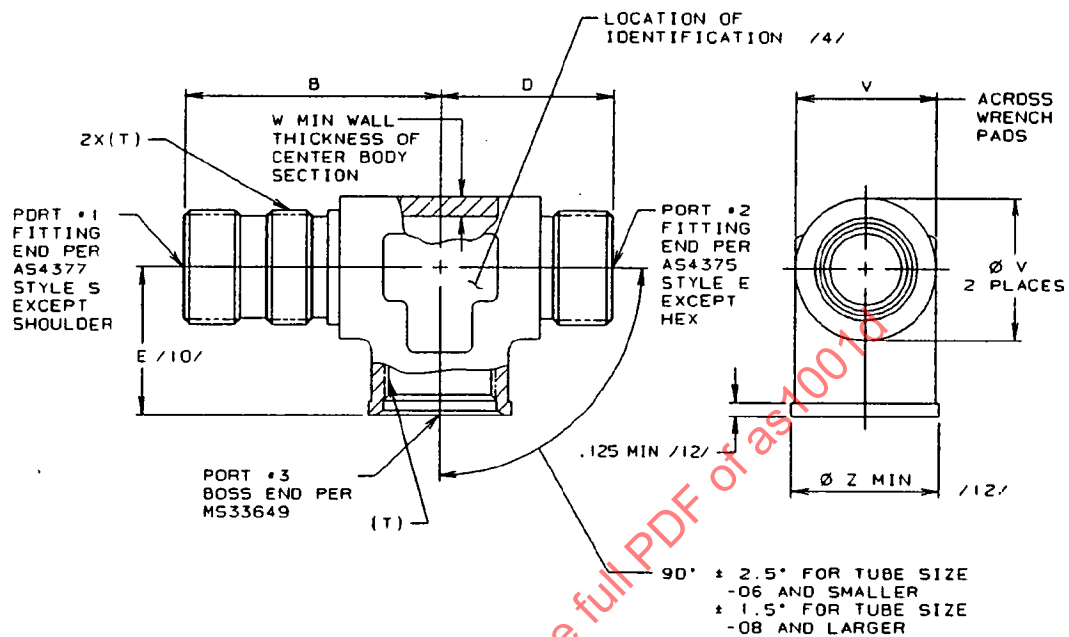


FIGURE 1 - TEE, PORT #3 SHOWN AS NONREDUCER

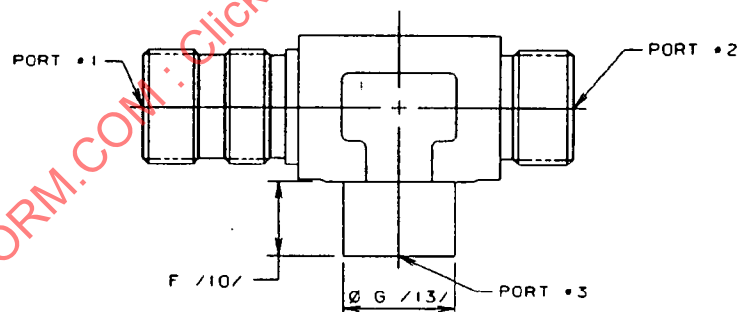
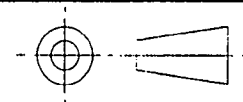


FIGURE 2 - TEE, PORT #3 SHOWN AS REDUCER

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /3/ MIL-F-18280

SAE The Engineering Society
For Advancing Mobility
Land Sea Air and Space
INTERNATIONAL

400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARDTEE, STANDARD AND REDUCER,
BULKHEAD ON RUN, INTERNAL PORT ON SIDE,
FLARELESS TUBE**AS1001**

SHEET 1 OF 5

REV.**D**

REV.
D

AS1001

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO.						LB/EA	LB/EA	LB/EA
AS1001						MAX	MAX	MAX
/11/ /19/	E	F	V	W	Z			
SIZE CODE	/10/	/10/			/12/	ALUM	CRES	T1
02	.648	---	.500	.090	.562	.018	.051	.029
03	.711	---	.562	.100	.625	.039	.104	.060
04	.773	.375	.750	.110	---	.083	.233	.134
05	.773	.375	.750	.120	.750	.099	.278	.160
06	.836	.375	.875	.120	---	.116	.326	.188
08	1.023	.469	1.062	.150	---	.197	.554	.319
10	1.180	.625	1.062	.170	1.125	.206	.579	.334
12	1.367	.688	1.312	.185	1.375	.360	1.012	.583
14	1.507	.706	1.562	.200	---	---	---	---
16	1.555	.719	1.625	.205	1.625	.455	1.340	.773
20	1.742	.781	1.875	.240	1.938	.672	1.950	1.125

TABLE 2 -- LEG LENGTH B

SIZE OF	FORGING	FORGING	FORGING	FORGING	FORGING	FORGING	FORGING	FORGING	FORGING	FORGING	FORGING
PORT	SIZE	SIZE	SIZE	SIZE	SIZE	SIZE	SIZE	SIZE	SIZE	SIZE	SIZE
#1	/11/	/11/	/11/	/11/	/11/	/11/	/11/	/11/	/11/	/11/	/11/
	02	03	04	05	06	08	10	12	14	16	20
02	1.398	1.430	1.585	1.585	1.758	1.727	1.804	1.883	2.040	2.102	2.242
03	---	1.477	1.632	1.632	1.805	1.774	1.851	1.930	2.087	2.149	2.289
04	---	---	1.695	1.695	1.868	1.837	1.914	1.993	2.150	2.212	2.352
05	---	---	---	1.695	1.868	1.837	1.914	1.993	2.150	2.212	2.352
06	---	---	---	---	1.914	1.883	1.960	2.039	2.196	2.258	2.398
08	---	---	---	---	---	2.055	2.132	2.211	2.368	2.430	2.570
10	---	---	---	---	---	---	2.273	2.352	2.509	2.571	2.711
12	---	---	---	---	---	---	---	2.461	2.618	2.680	2.820
14	---	---	---	---	---	---	---	---	2.618	2.680	2.820
16	---	---	---	---	---	---	---	---	---	2.680	2.820
20	---	---	---	---	---	---	---	---	---	---	2.820

SAE The Engineering Society
For Advancing Mobility
Land Sea Air and Space
INTERNATIONAL

AEROSPACE STANDARD

TEE, STANDARD AND REDUCER,
BULKHEAD DN RUN, INTERNAL PORT DN SIDE,
FLARELESS TUBE

AS1001

SHEET 2 OF 5

REV.**D**

REV.
D

AS1001

TABLE 3 - LEG LENGTH D

SIZE OF PORT #2	FORGING SIZE /11/ 02	FORGING SIZE /11/ 03	FORGING SIZE /11/ 04	FORGING SIZE /11/ 05	FORGING SIZE /11/ 06	FORGING SIZE /11/ 08	FORGING SIZE /11/ 10	FORGING SIZE /11/ 12	FORGING SIZE /11/ 14	FORGING SIZE /11/ 16	FORGING SIZE /11/ 20
02	.867	.883	1.039	1.039	1.086	1.180	1.273	1.351	1.492	1.554	1.695
03	---	.930	1.086	1.086	1.133	1.227	1.320	1.398	1.593	1.601	1.742
04	---	---	1.117	1.117	1.164	1.258	1.351	1.429	1.870	1.632	1.773
05	---	---	---	1.117	1.164	1.258	1.351	1.429	1.570	1.632	1.773
06	---	---	---	---	1.180	1.274	1.364	1.445	1.586	1.648	1.789
08	---	---	---	---	---	1.367	1.460	1.538	1.679	1.741	1.882
10	---	---	---	---	---	---	1.523	1.601	1.724	1.804	1.945
12	---	---	---	---	---	---	---	1.644	1.867	1.867	2.008
14	---	---	---	---	---	---	---	---	1.867	1.867	2.008
16	---	---	---	---	---	---	---	---	---	1.867	2.008
20	---	---	---	---	---	---	---	---	---	---	2.008

TABLE 4 - TURNED DIA G

SIZE OF PORT #3	FORGING SIZE /11/ 03	FORGING SIZE /11/ 04	FORGING SIZE /11/ 05	FORGING SIZE /11/ 06	FORGING SIZE /11/ 08	FORGING SIZE /11/ 10	FORGING SIZE /11/ 12	FORGING SIZE /11/ 14	FORGING SIZE /11/ 16	FORGING SIZE /11/ 20
02	---	.594	.594	.594	.594	.594	.594	.594	.594	.594
03	---	.656	.656	.656	.656	.656	.656	.656	.656	.656
04	---	---	---	.719	.719	.719	.719	.719	.719	.719
05	---	---	---	.781	.781	.781	.781	.781	.781	.781
06	---	---	---	---	.844	.844	.844	.844	.844	.844
08	---	---	---	---	---	---	1.062	1.062	1.062	1.062
10	---	---	---	---	---	---	---	1.188	1.188	1.188
12	---	---	---	---	---	---	---	1.438	1.438	1.438
14	---	---	---	---	---	---	---	---	1.562	1.562
16	---	---	---	---	---	---	---	---	---	1.688

SAE The Engineering Society
For Advancing Mobility
Land Sea Air and Space
INTERNATIONAL

AEROSPACE STANDARD

TEE, STANDARD AND REDUCER,
BULKHEAD ON RUN, INTERNAL PORT ON SIDE,
FLARELESS TUBE

AS1001

SHEET 3 OF 5

REV.**D**

TABLE 5 - TUBE SIZE AND CORRESPONDING THREAD

PORT SIZE	(NOMINAL TUBE SIZE)		T THREAD PER MIL-S-8879
02	.125		.3125-24UNJF
03	.188		.3750-24UNJF
04	.250		.4375-20UNJF
05	.312		.5000-20UNJF
06	.375		.5625-18UNJF
08	.500		.7500-16UNJF
10	.625		.8750-14UNJF
12	.750		1.0625-12UNJ
14	.875		1.1875-12UNJ
16	1.000		1.3125-12UNJ
20	1.250		1.6250-12UNJ

NOTES:

/1/ MATERIAL:

- a. CODE LETTER D: 2014T6 ALUMINUM ALLOY FORGING PER AMS 4133 OR QQ-A-367; OR 2024T6 ALUMINUM ALLOY BAR PER AMS 4112 OR QQ-A-225/6; OR 2024T851 ALUMINUM ALLOY BAR PER QQ-A-225/6.
- b. CODE LETTER F: 4130 STEEL FORGING OR BAR PER AMS 6370 OR MIL-S-6758.
- c. CODE LETTER J: 30304 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS 5639 OR 304 CORROSION RESISTANT STEEL PER QQ-S-763.
- d. CODE LETTER K: 30316 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS 5648 OR 316 CORROSION RESISTANT STEEL PER QQ-S-763.
- e. CODE LETTER R: 30321 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS 5645 OR 321 CORROSION RESISTANT STEEL PER QQ-S-763. /7/
- f. CODE LETTER S: 30347 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS 5646 OR 347 CORROSION RESISTANT STEEL PER QQ-S-763. /8/
- g. CODE LETTER T: 6AL4V TITANIUM ALLOY FORGING OR BAR PER AMS 4928.
- h. CODE LETTER W: 7075T73 ALUMINUM ALLOY FORGING PER AMS 4141 OR QQ-A-367; OR 7075T7351 ALUMINUM ALLOY BAR PER AMS 4124; OR 7075T73 ALUMINUM ALLOY BAR PER QQ-A-225/9.

2. FINISH:

- a. MATERIAL CODE LETTER D: ANODIZE PER AMS 2472 OR MIL-A-8625, TYPE II, CLASS 2. DYE GREEN, SIMILAR TO COLOR 14187 OF FED-STD-595.
- b. MATERIAL CODE LETTER F: CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2.
- c. MATERIAL CODE LETTER J: PASSIVATE PER QQ-P-35, TYPE VI OR VII.
- d. MATERIAL CODE LETTER K: PASSIVATE PER QQ-P-35, TYPE VI OR VII.
- e. MATERIAL CODE LETTER R: PASSIVATE PER QQ-P-35, TYPE VI OR VII.
- f. MATERIAL CODE LETTER S: PASSIVATE PER QQ-P-35, TYPE VI OR VII.
- g. MATERIAL CODE LETTER T: FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486.
- h. MATERIAL CODE LETTER W: ANODIZE PER AMS 2472 OR MIL-A-8625, TYPE II, CLASS 2. DYE BROWN, SIMILAR TO COLOR 10D80 OF FED-STD-595.

- /3/ PROCUREMENT SPECIFICATION: MIL-F-1828D EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION IN A COMPLETE ASSEMBLY. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.