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SAE AS1008

FEDERAL SUPPLY CLASS
4730

RATIONALE

ERROR CORRECTION. ALSO, INACTIVATION FOR DESIGN IN PREVIOUS NOTE 22 WAS CHANGED TO A NOTE ON PAGE 1 INDICATING PREFERRED REPLACEMENT.

NOTE: THE NEW AS6048 FITTING IS PREFERRED REPLACEMENT BECAUSE OF IMPROVED LENGTH TOLERANCES AND IMPROVED FINISH OF THE CONICAL SEAL AREA.

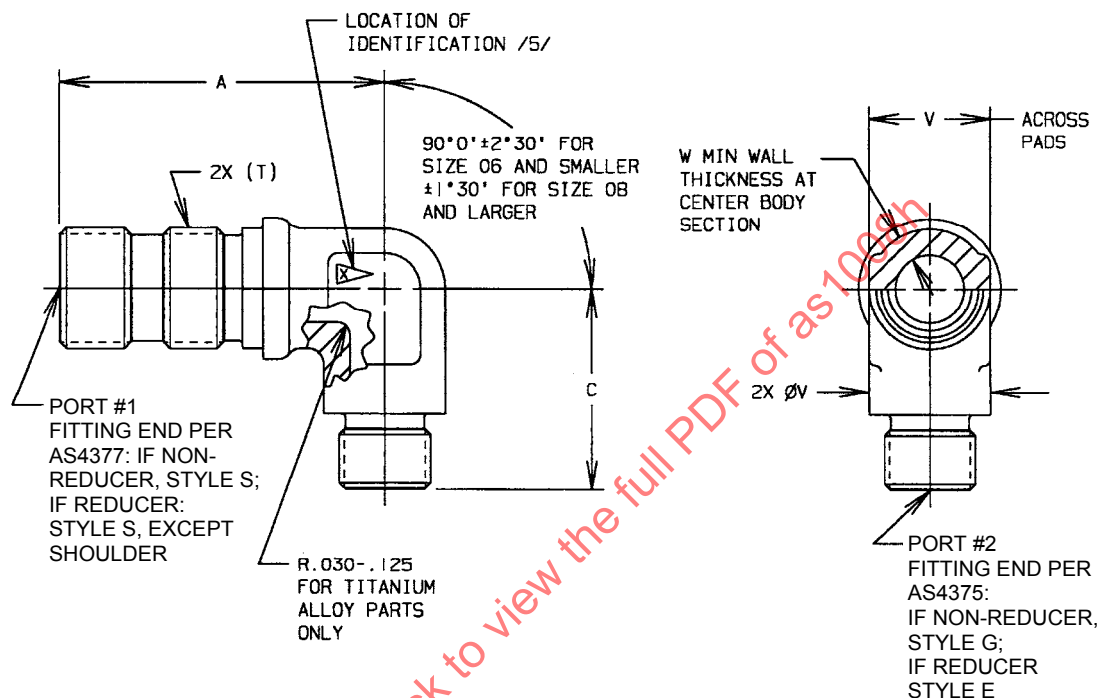
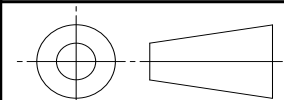


FIGURE 1 - FITTING, ELBOW, 90°, BULKHEAD END FOR OPTIONAL USE
IN PORT INSTALLATION, PORT #2 SHOWN AS REDUCER

SAE values your input. To provide feedback
on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS1008H>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS18280

SAE Aerospace
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AEROSPACE STANDARD

FITTING, ELBOW, 90 DEGREE,
STANDARD AND REDUCER,
BULKHEAD, FLARELESS

SAE AS1008
SHEET 1 OF 7

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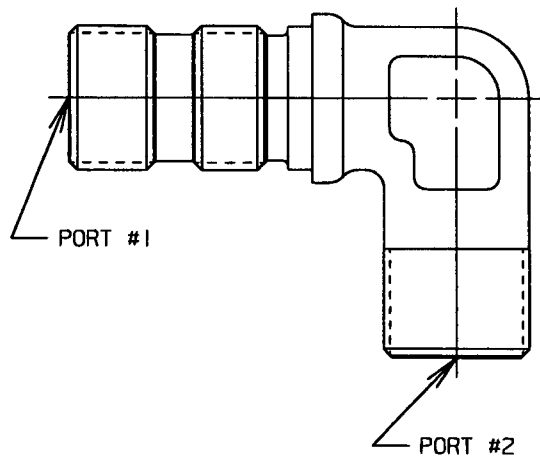


FIGURE 2 - FITTING, ELBOW, 90 DEGREE, BULKHEAD END FOR OPTIONAL USE
IN PORT INSTALLATION, SHOWN AS NON-REDUCER, SAME
AS FIGURE 1 EXCEPT AS SHOWN

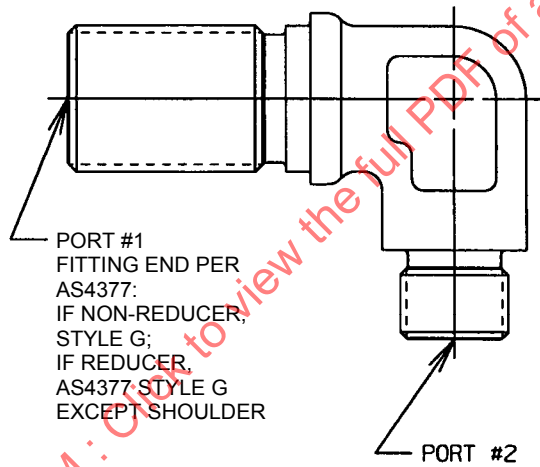


FIGURE 3 - FITTING, ELBOW, 90 DEGREE, BULKHEAD END NOT FOR USE
IN PORT INSTALLATION, PORT #2 SHOWN AS REDUCER,
SAME AS FIGURE 1 EXCEPT AS SHOWN

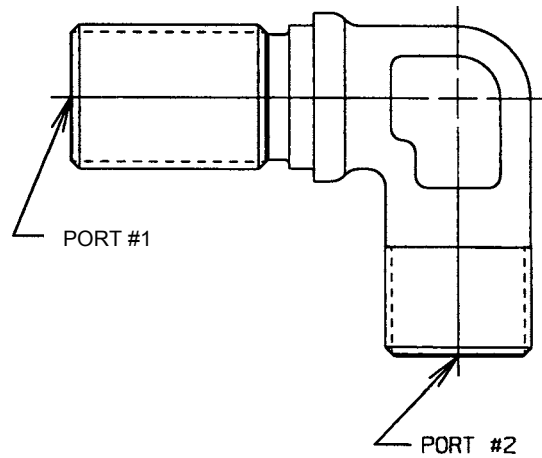


FIGURE 4 - FITTING, ELBOW, 90 DEGREE, BULKHEAD END NOT FOR USE
IN PORT INSTALLATION, SHOWN AS NON-REDUCER, SAME
AS FIGURE 2 EXCEPT AS SHOWN

TABLE 1 - DIMENSIONS AND WEIGHTS /13/

BASIC NO. AS1008 /12/ /21/ SIZE CODE	V	W	LB/EA APPROX REF ALUM	LB/EA APPROX REF STEEL	LB/EA APPROX REF TI
02	.297- .314	.090	.0153	.0432	.0243
03	.360- .377	.100	.0207	.0576	.0324
04	.423- .440	.110	.0225	.0639	.0360
05	.485- .502	.120	.0342	.0918	.0522
06	.547- .565	.120	.0486	.111	.0630
08	.735- .753	.150	.0819	.213	.122
10	.860- .878	.170	.120	.360	.207
12	1.047-1.065	.185	.171	.504	.274
14	1.173-1.191	.200	-	-	-
16	1.292-1.317	.205	.279	.828	.477
20	1.605-1.630	.240	.472	1.20	.681
24	1.855-1.880	.250	.630	1.76	1.02
32	2.542-2.572	.350	-	-	-

TABLE 2 - LEG LENGTH A /14/

FORGING SIZE /12/	TUBE SIZE OF PORT #1												
	02	03	04	05	06	08	10	12	14	16	20	24	32
02	1.336	-	-	-	-	-	-	-	-	-	-	-	-
03	1.367	1.414	-	-	-	-	-	-	-	-	-	-	-
04	1.413	1.460	1.523	-	-	-	-	-	-	-	-	-	-
05	1.445	1.492	1.555	1.555	-	-	-	-	-	-	-	-	-
06	1.555	1.602	1.665	1.665	1.711	-	-	-	-	-	-	-	-
08	1.664	1.711	1.774	1.774	1.820	1.992	-	-	-	-	-	-	-
10	1.804	1.851	1.914	1.914	1.960	2.132	2.273	-	-	-	-	-	-
12	1.914	1.961	2.024	2.024	2.070	2.242	2.383	2.492	-	-	-	-	-
14	2.024	2.071	2.134	2.134	2.180	2.352	2.493	2.617	2.543	-	-	-	-
16	2.039	2.086	2.149	2.149	2.195	2.367	2.508	2.617	2.617	2.617	-	-	-
20	2.320	2.367	2.430	2.430	2.476	2.648	2.789	2.898	2.898	2.898	2.898	-	-
24	2.602	2.649	2.712	2.712	2.758	2.930	3.071	3.180	3.180	3.180	3.180	3.180	-
32	2.992	3.039	3.102	3.102	3.148	3.320	3.461	3.570	3.570	3.570	3.570	3.570	3.773

TABLE 3 - LEG LENGTH C /14/

FORGING SIZE /12/	TUBE SIZE OF PORT #2												
	02	03	04	05	06	08	10	12	14	16	20	24	32
02	.804	-	-	-	-	-	-	-	-	-	-	-	-
03	.883	.930	-	-	-	-	-	-	-	-	-	-	-
04	.883	.930	.961	-	-	-	-	-	-	-	-	-	-
05	.977	1.024	1.055	1.055	-	-	-	-	-	-	-	-	-
06	.992	1.039	1.070	1.070	1.086	-	-	-	-	-	-	-	-
08	1.149	1.196	1.227	1.227	1.243	1.336	-	-	-	-	-	-	-
10	1.274	1.320	1.352	1.352	1.368	1.461	1.524	-	-	-	-	-	-
12	1.335	1.383	1.414	1.414	1.430	1.523	1.586	1.649	-	-	-	-	-
14	1.398	1.445	1.476	1.476	1.492	1.585	1.648	1.742	1.693	-	-	-	-
16	1.429	1.476	1.507	1.507	1.523	1.616	1.679	1.742	1.742	1.742	-	-	-
20	1.710	1.757	1.788	1.788	1.804	1.897	1.960	2.023	2.023	2.023	2.023	-	-
24	1.898	1.945	1.976	1.976	1.992	2.085	2.148	2.211	2.211	2.211	2.211	2.211	-
32	2.085	2.132	2.163	2.163	2.179	2.272	2.335	2.398	2.398	2.398	2.398	2.398	2.398

TABLE 4 - TUBE SIZE AND CORRESPONDING THREAD

PORT SIZE	(NOMINAL TUBE SIZE)	T THREAD PER AS8879 CLASS 3A
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 DASH (-) - TYPE 4130 LOW ALLOY STEEL FORGING OR BAR PER AMS6370 OR AMS-S-6758 EXCEPT HEAT TREATMENT PER PROCUREMENT SPECIFICATION. /2/
- b. CODE LETTER D - TYPE 2024-T6 OR -T851 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6 OR TYPE 2014-T6 ALUMINUM ALLOY FORGING PER AMS4133. /2/
- c. CODE LETTER F - TYPE 4130 LOW ALLOY STEEL FORGING OR BAR PER AMS6370 OR AMS-S-6758 EXCEPT HEAT TREATMENT PER PROCUREMENT SPECIFICATION. /2/
- d. CODE LETTER J - TYPE 304 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS5639 OR AMS-QQ-S- 763 EXCEPT HARDNESS PER PROCUREMENT SPECIFICATION. /2/
- e. CODE LETTER K - TYPE 316 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS5648 OR AMS-QQ- S-763 EXCEPT HARDNESS PER PROCUREMENT SPECIFICATION. /2/
- f. CODE LETTER R - TYPE 321 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS5645 OR AMS-QQ- S-763 EXCEPT HARDNESS PER PROCUREMENT SPECIFICATION. /2/
- g. CODE LETTER S - TYPE 347 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS5646 OR AMS-QQ- S-763 EXCEPT HARDNESS PER PROCUREMENT SPECIFICATION. /2/
- h. CODE LETTER T - TYPE 6AL-4V TITANIUM ALLOY FORGING OR BAR PER AMS4928.
- i. CODE LETTER W - TYPE 7075-T73 ALUMINUM ALLOY FORGING PER AMS4141 OR AMS-QQ-A-367; OR 7075- T7351 ALUMINUM ALLOY BAR PER AMS4124; OR 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9. /2/

/2/ HEAT TREATMENT:

- a. MATERIAL CODE LETTER (-) AND F - HARDNESS SHALL BE 92 HRB TO 40 HRC PER PROCUREMENT SPECIFICATION.
- b. MATERIAL CODE LETTERS D AND W - ELECTRICAL CONDUCTIVITY AND HARDNESS PER PROCUREMENT SPECIFICATION.
- c. MATERIAL CODE LETTERS J, K, R AND S - HARDNESS SHALL BE 80 HRB MINIMUM PER PROCUREMENT SPECIFICATION.
- d. OTHER MATERIAL CODES - NONE

3. FINISH:

- a. MATERIAL CODE LETTER (-) AND F - 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, DYE GREEN SIMILAR TO COLOR 14187 OF FED-STD-595.
- c. MATERIAL CODE LETTERS J, K, R AND S - PASSIVATE PER AMS2700 TYPE 6 OR 7.
- d. MATERIAL CODE LETTER T - FLUORIDE PHOSPHATE CONVERSION COAT PER AMS2486 OR ANODIZE PER AMS2488, TYPE 2.
- e. MATERIAL CODE LETTER W - ANODIZE PER AMS2472 OR MIL-A-8625, TYPE II, CLASS 2, DYE BROWN SIMILAR TO COLOR 10080 OF FED-STD-595.

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	FITTING, ELBOW, 90 DEGREE, STANDARD AND REDUCER, BULKHEAD, FLARELESS		