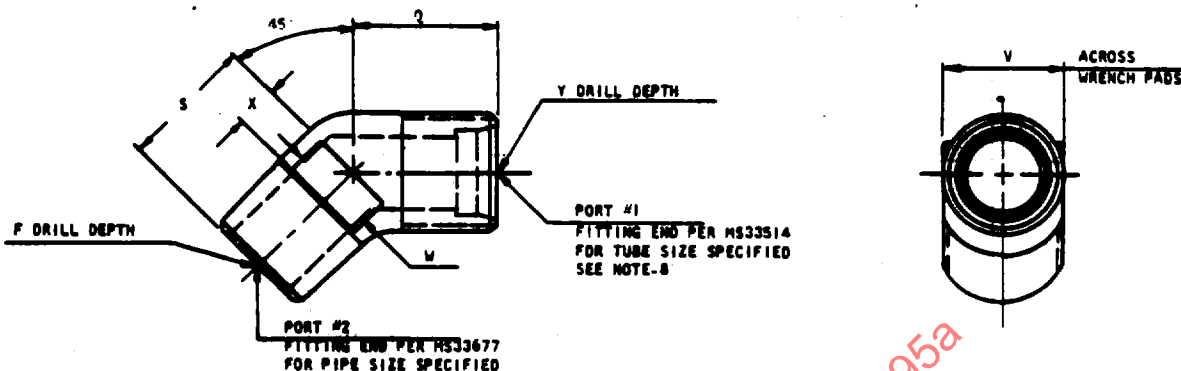




NOTES:

- Δ1. PARTS SHALL CONFORM WITH APPLICABLE REQUIREMENTS OF MIL-F-18280, LATEST REVISION UNLESS OTHERWISE SPECIFIED BY PROCURING ACTIVITY.
- Δ2. MATERIAL CODE: IN PLACE OF DASH IN PART NUMBER, ADD MATERIAL CODE AS FOLLOWS:

NO LETTER INDICATES STEEL (USE DASH "-")
 LETTER "D" INDICATES TYPE 2014-T6 ALUMINUM ALLOY
 LETTER "J" INDICATES CORROSION RESISTANT STEEL, CLASS 304
 LETTER "K" INDICATES CORROSION RESISTANT STEEL, CLASS 316
 LETTER "S" INDICATES CORROSION RESISTANT STEEL, CLASS 347
 LETTER "W" INDICATES TYPE 7075-T73 ALUMINUM ALLOY

3. SPECIFY END SIZES IN THIS ORDER: FLARELESS TUBE END FIRST (PORT #1), PIPE END SECOND (PORT #2).
4. USE FORGING SIZE AS DETERMINED FROM TABLE 1.
5. EXAMPLE OF PART NUMBER:

AS895K0402
 BASIC PART NUMBER
 CLASS 316 CRES
 FLARELESS TUBE END (PORT #1) PER MS33514G4
 LEG LENGTH PER DIMENSION Q, .711
 DRILL DEPTH PER DIMENSION Y, .703
 PIPE END (PORT #2) PER MS33677, 1/8" PIPE SIZE
 LEG LENGTH PER DIMENSION S, .625
 DRILL DEPTH PER DIMENSION F, .625

6. TOLERANCE ON 45° ANGLE: $\pm 1/2^\circ$ FOR DASH 6 AND SMALLER, $\pm 1/3^\circ$ FOR DASH 8 AND LARGER.
7. REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
8. FITTING END PER MS33514 SHALL CONFORM TO STYLE G WHEN NORMAL THREAD SIZE EQUALS NORMAL FORGING SIZE. USE STYLE E WHEN THREAD SIZE IS SMALLER THAN FORGING SIZE, EXCEPT OMT HEX.
9. AT OPTION OF MANUFACTURER, THE FLUID PASSAGE MAY CONFORM TO THE SMALLER DIAMETER HOLE ON BOTH ENDS.
- Δ10. ALL MACHINED SURFACES SHALL BE SMOOTH TO 125 MICROINCHES R_a MAX PER ANSI B46.1.
- Δ11. PARTS FOR OXYGEN SERVICE SHALL BE FURNISHED CLEANED, PACKAGED, AND LABELED PER AIR 1176 (OR OTHER CUSTOMER SPECIFIED DOCUMENT) WHEN SPECIFIED BY PROCURING ACTIVITY.
- Δ12. IDENTIFY PER MIL-F-18280 EXCEPT SUBSTITUTE AS OR AS895 MARKING IN PLACE OF MS OR MSXXXX AS APPLICABLE.
- Δ13. FOR DESIGN FEATURE PURPOSES THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.

1983 CHANGE DESIGNATED BY Δ

SAE Technical 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.

RECEIVED
APR 12 1983

ISSUED 1-15-76 REVISED 12-1-83

PREPARED BY SAE SUBCOMMITTEE Q-38, AEROSPACE FITTINGS, OF SAE COMMITTEE G-3, AEROSPACE FITTINGS, HOSE, & TUBING ASSEMBLIES

SAE The Society of Automotive Engineers
 400 Commonwealth Drive
 Warrendale, PA 15090

AEROSPACE STANDARD

ELBOW, 45°, FLARELESS TUBE
 TO MALE PIPE

AS 895
 SHEET 1 OF 2

Rev. A