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AS4665

FEDERAL SUPPLY CLASS
4730

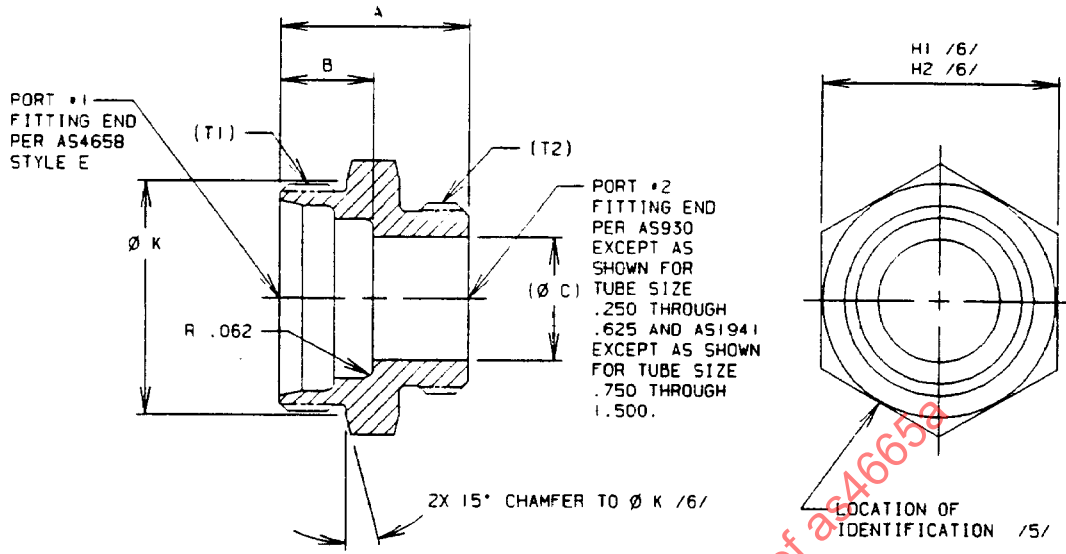
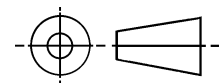


FIGURE 1 - FITTING, ADAPTER, UNION AND REDUCER

TABLE 1 - DIMENSIONS

PORT #1 SIZE /6/	A PORT #2 SIZE 04	A PORT #2 SIZE 06	A PORT #2 SIZE 08	A PORT #2 SIZE 10	A PORT #2 SIZE 12	A PORT #2 SIZE 16	A PORT #2 SIZE 20	A PORT #2 SIZE 24
20	1.238	1.238	1.278	1.278	1.451	1.520	1.520	--
24	-	-	-	-	1.514	1.583	1.583	1.614
28	-	-	-	-	-	1.583	1.583	1.614

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ MIL-F-18280

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

FITTING, ADAPTER, UNION AND REDUCER,
SHORT FLARELESS TO BOSS

AS4665
SHEET 1 OF 3

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TABLE 2 - PORT SIZES, CORRESPONDING, THREADS, HEX SIZES, AND HOLE DEPTH

PORT SIZE	(NOMINAL TUBE SIZE)	T1 THREAD PER MIL-S-8879	T2 THREAD PER MIL-S-8879	B	C	H1	H2	K1	K2
04	.250	-	.4375-20UNJF	-	.172	-	-	-	-
06	.375	-	.5625-18UNJF	-	.297	-	-	-	-
08	.500	-	.7500-16UNJF	-	.391	-	-	-	-
10	.625	-	.8750-14UNJF	-	.484	-	-	-	-
12	.750	-	1.0625-12UNJ	-	.609	-	-	-	-
16	1.000	-	1.3125-12UNJ	-	.845	-	-	-	-
20	1.250	1.5625-12UNJ	1.6250-12UNJ	.650	1.080	1.615-1.630	1.865-1.880	1.605	1.855
24	1.500	1.8125-12UNJ	1.8750-12UNJ	.682	1.314	1.865-1.880	2.115-2.135	1.855	2.105
28	1.750	2.1250-12UNJ	2.2500-12UNJ	.682	1.550	2.240-2.260	-	2.230	-

NOTES:

/1/ MATERIAL:

- CODE LETTER T: TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS 4928
- CODE LETTER V: TYPE 15-5PH CORROSION RESISTANT STEEL BAR PER AMS 5659
- CODE LETTER W: TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS 4124

2. HEAT TREATMENT:

- MATERIAL CODE LETTER T: NONE
- MATERIAL CODE LETTER V: HEAT TREAT TO CONDITION H-1075 PER AMS 2759/3
- MATERIAL CODE LETTER W: NONE

/3/ FINISH:

- MATERIAL CODE LETTER T - FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486
- MATERIAL CODE LETTER V:
 - V CODE PARTS TO BE PASSIVATED ONLY WILL HAVE NO FINISH CODE LETTER AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE: PASSIVATE PER QQ-P-35, TYPE II OR VIII.
 - V CODE PARTS TO BE CADMIUM PLATED ONLY WILL HAVE THE FINISH CODE LETTER "P" AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE: CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2.
- MATERIAL CODE LETTER W: ANODIZE PER AMS 2472 OR PER MIL-A-8625, TYPE II, CLASS 2 DYED BROWN SIMILAR TO COLOR 10080 OF FED-STD-595

/4/ PROCUREMENT SPECIFICATION: MIL-F-18280 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.

/5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B. MANUFACTURER'S NAME, TRADEMARK OR CAGE CODE, BASIC PART NUMBER, AND MATERIAL CODE LETTER.

/6/ HEX SIZES AND CHAMFERS: FOR PORT #2 SIZE 16 AND SMALLER USE H1 HEX SIZE; FOR PORT #2 SIZE 20 AND 24 USE H2 HEX SIZE. K1 CHAMFER DIAMETER CORRESPONDS TO H1 HEX; K2 CHAMFER DIAMETER CORRESPONDS TO H2 HEX.

7. LARGEST PORT #2 SIZE IS TUBE SIZE 1.500.

8. THIS PART IS DESIGNED FOR USE IN SYSTEMS WITH OPERATING PRESSURES AS FOLLOWS:

- SIZES -20 AND -24 TITANIUM ALLOY AND CORROSION RESISTANT STEEL AT 3000 psi
- SIZE -28 TITANIUM ALLOY AND CORROSION RESISTANT STEEL AND SIZES -20, -24, AND -28 ALUMINUM ALLOY AT 600 psi