

REV.
B

SAE AS4693

FEDERAL SUPPLY CLASS
4730

RATIONALE

PROCUREMENT NOTE /4/ HAS BEEN CHANGED TO SPECIFY PRI-QPL-AS1576, ALSO UPDATES,

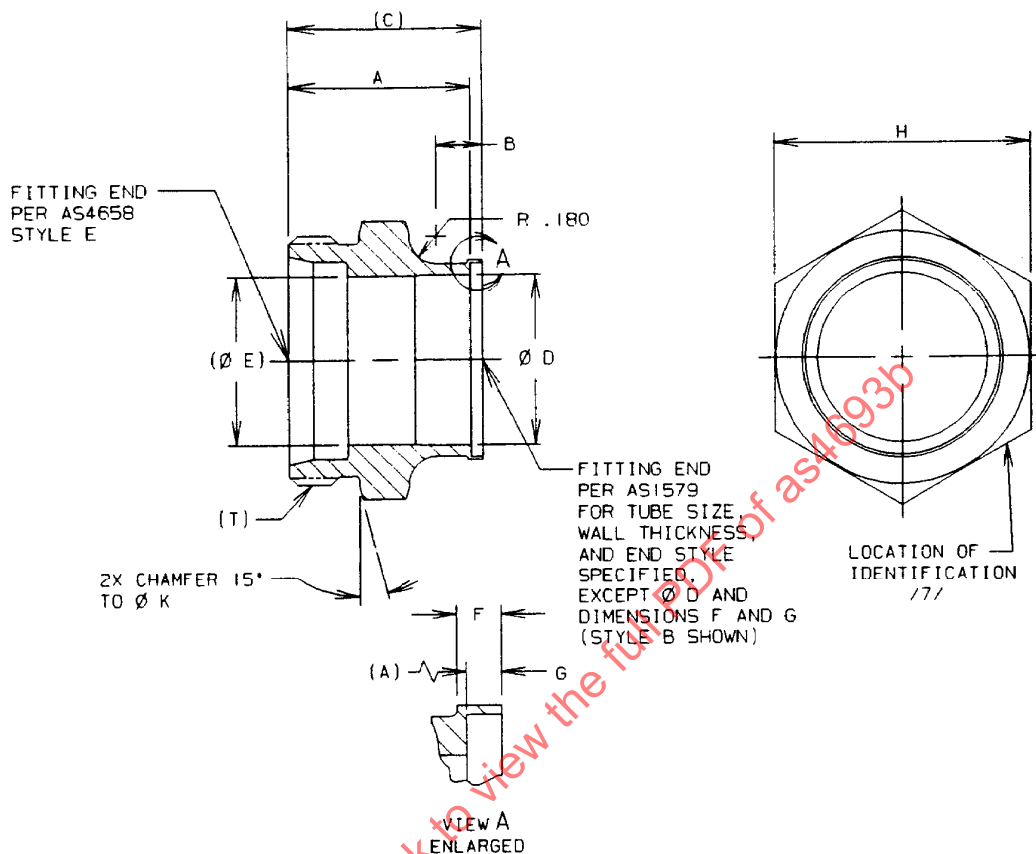


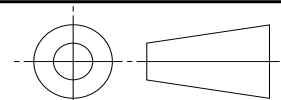
FIGURE 1 - UNION, TUBE END

TABLE 1 - DIMENSIONS AND WEIGHTS

PART NO.	(NOMINAL TUBE SIZE)	(NOMINAL TUBE WALL)	WELD END STYLE /8/	T THREAD PER AS8879	A	B ±.010	C	D ±.002	E	F	G	H +.005/- .010	K ±.010	LB/EA APPROX REF
AS4693T20-070	1.250	.070	B	1.5625-12 UNJ	1.243	.300	1.318	1.104	1.093	.135	.075	1.625	1.605	.144
AS4693V20-070	1.250	.070	B	1.5625-12 UNJ	1.243	.300	1.318	1.104	1.093	.095	.075	1.625	1.605	.252
AS4693T24-074	1.500	.074	B	1.8125-12 UNJ	1.356	.350	1.431	1.346	1.344	.135	.075	1.875	1.855	.196
AS4693Y24-040	1.500	.040	B	1.8125-12 UNJ	1.356	.350	1.431	1.414	1.344	.075	.055	1.875	1.855	.353

SAE values your input. To provide feedback
on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS4693B>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS1576

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

UNION, TUBE END,
EXTERNAL THREAD TO WELD,
SHORT FLARELESS

SAE AS4693
SHEET 1 OF 3

REV.
B

NOTES:

/1/ MATERIAL:

- a. CODE LETTER T - TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS4928
- b. CODE LETTER V - TYPE 15-5PH CORROSION RESISTANT STEEL BAR PER AMS5659
- c. CODE LETTER Y - TYPE 718 NICKEL ALLOY BAR PER AMS5662

2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER T - NONE
- b. MATERIAL CODE LETTER V - HEAT TREAT TO CONDITION H1075 PER AMS2759/3
- c. MATERIAL CODE LETTER Y - AFTER MACHINING, PRECIPITATION HEAT TREAT TO MEET THE REQUIREMENTS OF AMS5663

3. FINISH: ALL MATERIAL CODES - NONE.

/4/ PROCUREMENT SPECIFICATION: AS1576 EXCEPT AS SPECIFIED ON THIS STANDARD. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER AS LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST PRI-QPL-AS1576 FOR THIS STANDARD. SEE <http://www.eauditnet.com> FOR CURRENT QPL ONLINE.

5. CLEANING:

- a. CODE LETTER T AND V - CLEAN AND NITRIC-HYDROFLUORIC ETCH PER PROCUREMENT SPECIFICATION
- b. CODE LETTER Y - VAPOR DEGREASE OR ALKALINE CLEAN

6. PACKAGING: INDIVIDUALLY PACKAGE IN CLEAN CONTAINER WITH IDENTIFICATION PER PROCUREMENT SPECIFICATION.

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

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

- a. SIZE -20 AND -24 TITANIUM ALLOY AND CORROSION RESISTANT STEEL AND -20 NICKEL ALLOY AT 3000 psi
- b. SIZE -24 NICKEL ALLOY AT 600 psi

9. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M; REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 μ in Ra.

10. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.

11. DIMENSIONING AND TOLERANCING: ASME Y14.5M-1994

12. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS $\pm$.005, ANGULAR DIMENSIONS $\pm$ 5 DEGREES.

 An SAE International Group	AEROSPACE STANDARD	SAE AS4693 SHEET 2 OF 3	REV. B
	UNION, TUBE END, EXTERNAL THREAD TO WELD, SHORT FLARELESS		