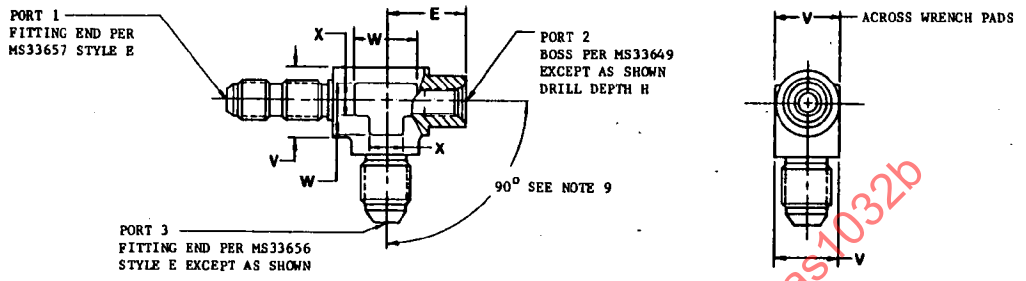
SAE The Engineering Resource For Advancing Mobility
400 COMMONWEALTH DRIVE, WARRENDALE, PA 15096

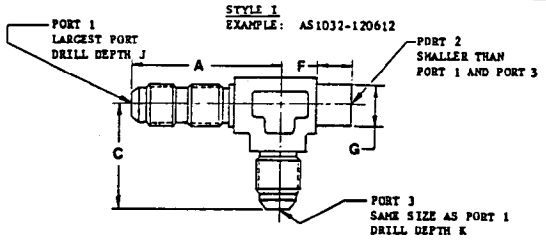
AEROSPACE STANDARD

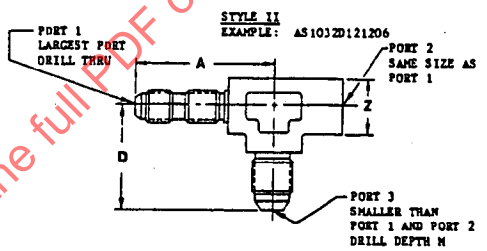
AS1032B
Issued 8-15-62
Revised 4-4-83

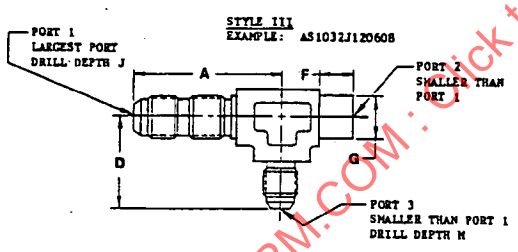
TEE, REDUCER - BULKHEAD & INTERNALLY THREADED PORT ON RUN, FLARED TUBE

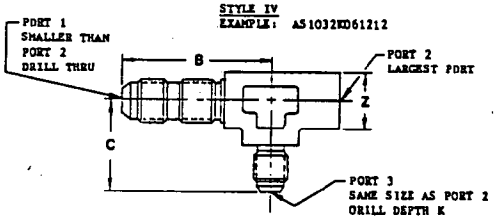


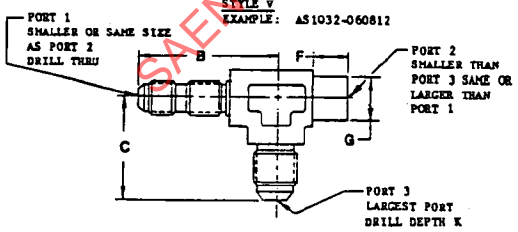
REDUCER COMBINATIONS

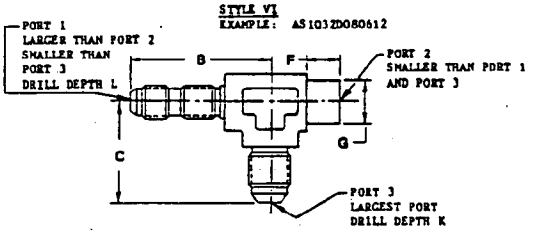


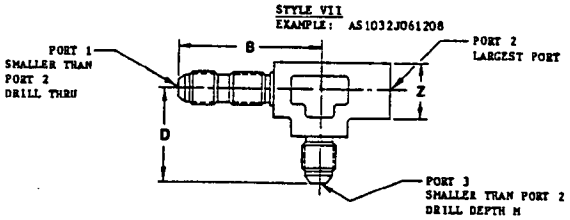












Printed in U.S.A.

FORGING SIZE	A ±.016	C ±.016	E ±.016	F ±.016	H ±.016	V ±.016	W APPROX	X APPROX	Z ±.016
3	1.523	.992	.711	-	.750	.562	.500	.312	.625
4	1.773	1.211	.773	.375	.812	.750	.688	.438	.750
5	1.773	1.211	.773	.375	.812	.750	.688	.438	.750
6	2.023	1.273	.836	.375	.875	.875	.781	.438	.875
8	2.179	1.461	1.023	.469	1.063	1.063	.906	.500	1.063
10	2.398	1.648	1.180	.625	1.219	1.063	.906	.500	1.188
12	2.648	1.836	1.367	.688	1.406	1.312	1.094	.625	1.438
16	2.867	2.086	1.555	.719	1.594	1.625	1.312	.750	1.688
20	3.054	2.273	1.742	.781	1.781	1.875	1.500	.875	2.000

LEG LENGTH B ±.016

FORGING SIZE										
3	4	5	6	8	10	12	16	20		
1.523	1.679	1.679	1.851	1.851	1.929	2.008	2.227	2.367	2	SIZE OF PORT #1
	1.679	1.679	1.851	1.851	1.929	2.008	2.227	2.367	3	
		1.773	1.945	1.945	2.023	2.102	2.321	2.461	4	
			1.945	1.945	2.023	2.102	2.321	2.461	5	
				2.023	2.101	2.180	2.399	2.539	6	
					2.257	2.336	2.555	2.695	8	
						2.477	2.696	2.836	10	
							2.867	3.007	12	
								3.007	16	

LEG LENGTH D ±.016

FORGING SIZE										
3	4	5	6	8	10	12	16	20		
.961	1.109	1.109	1.165	1.232	1.338	1.420	1.623	1.763	2	SIZE OF PORT #2
	1.140	1.140	1.196	1.283	1.369	1.451	1.654	1.794	3	
		1.211	1.267	1.354	1.440	1.522	1.725	1.865	4	
			1.267	1.354	1.440	1.522	1.725	1.865	5	
				1.360	1.446	1.528	1.731	1.871	6	
					1.547	1.629	1.832	1.972	8	
						1.730	1.933	2.073	10	
							2.039	2.179	12	
								2.226	16	

TURNED DIA G ±.016

FORGING SIZE										
3	4	5	6	8	10	12	16	20		
-	.594	.594	.594	.594	.594	.594	.594	.594	2	SIZE OF #2 PORT
	.656	.656	.656	.656	.656	.656	.656	.656	3	
		-	.719	.719	.719	.719	.719	.719	4	
			.781	.781	.781	.781	.781	.781	5	
				.844	.844	.844	.844	.844	6	
					-	1.062	1.062	1.062	8	
						-	1.188	1.188	10	
							1.438	1.438	12	
								1.688	16	

DRILL DEPTH K ±.016

FORGING SIZE										
3	4	5	6	8	10	12	16	20		
.781	.843	.843	.906	1.094	1.250	1.438	1.625	1.812	2	SIZE OF #3 PORT
.812	.875	.875	.938	1.125	1.281	1.469	1.656	1.844	3	
	.891	.891	.953	1.141	1.297	1.484	1.672	1.859	4	
		.922	.984	1.172	1.328	1.516	1.703	1.891	5	
			1.016	1.203	1.375	1.547	1.750	1.922	6	
				1.250	1.422	1.594	1.797	1.969	8	
					1.453	1.641	1.828	2.016	10	
						1.703	1.891	2.078	12	
							2.016	2.203	16	
								2.312	20	

DRILL DEPTH J ±.016

SIZE OF #1 PORT										
3	4	5	6	8	10	12	16	20		
1.594	1.844	1.844	2.094	2.250	2.469	2.719	2.938	3.125	2	SIZE OF #3 PORT
1.625	1.875	1.875	2.125	2.281	2.500	2.750	2.968	3.156	3	
	1.891	1.891	2.141	2.297	2.516	2.766	2.984	3.172	4	
		1.922	2.172	2.328	2.547	2.797	3.016	3.203	5	
			2.203	2.359	2.578	2.828	3.047	3.234	6	
				2.406	2.625	2.875	3.094	3.281	8	
					2.672	2.922	3.141	3.328	10	
						2.984	3.203	3.391	12	
							3.328	3.516	16	
								3.625	20	

DRILL DEPTH L ±.016

SIZE OF #1 PORT									
16	12	10	8	6	5	4	3		
3.578	3.578	3.406	3.266	3.109	3.031	3.031	2.938	20	SIZE OF #3 PORT
	3.328	3.156	3.016	2.859	2.781	2.781	2.688	16	
		2.828	2.672	2.516	2.438	2.438	2.344	12	
			2.531	2.375	2.297	2.297	2.203	10	
				2.250	2.172	2.172	2.078	8	
					2.125	2.125	2.031	6	
						1.922	1.828	5	
							1.797	4	

DRILL DEPTH M ±.016

FORGING SIZE										
3	4	5	6	8	10	12	16	20		
1.000	1.141	1.141	1.203	1.266	1.375	1.453	1.656	1.797	2	SIZE OF #3 PORT
	1.172	1.172	1.234	1.328	1.406	1.484	1.688	1.828	3	
		1.250	1.312	1.391	1.484	1.562	1.766	1.906	4	
			1.312	1.391	1.484	1.562	1.766	1.906	5	
				1.391	1.484	1.562	1.766	1.906	6	
					1.578	1.672	1.875	2.016	8	
						1.766	1.969	2.109	10	
							2.078	2.219	12	
								2.266	16	

1. SPECIFY END SIZES IN THE FOLLOWING ORDER: (1) BULKHEAD END; (2) INTERNALLY THREADED END ON RUN; (3) SIDE END.
2. LARGEST TUBE SIZE DETERMINES FORGING SIZES.
3. MATERIAL CODING:
   - \- STEEL 1137 OR 1141 PER QQ-S-637 (OPTIONAL: 4130/MIL-S-6758). FINISH CADMIUM PLATE PER QQ-P-416. TYPE II, CLASS 2. COLOR BLACK.
   - S CRES TYPE 347. CRES PER QQ-S-763 SURFACE TREAT PER MIL-S-5002.
   - J CRES TYPE 304. CRES PER QQ-S-763 SURFACE TREAT PER MIL-S-5002.
   - K CRES TYPE 316. CRES PER QQ-S-763 SURFACE TREAT PER MIL-S-5002.
   - D ALUMINUM ALLOY 2014-T6 PER QQ-A-367 (OR 2024-T851). ANODIZE PER MIL-A-8625 TYPE II, CLASS 2. DYE BLUE.
   - W ALUMINUM ALLOY 7075-T73 PER QQ-A-225/9 (OPTIONAL: QQ-A-367). ANODIZE PER MIL-A-8625, TYPE II, CLASS 2. DYE BROWN.
   - T TITANIUM ALLOY (6AL-4V) PER AMS 4928. FLUORIDE PHOSPHATE COAT PER AMS 2486.
4. PART NUMBER EXAMPLE:

AS 1032 D 16 10 08 — ALUMINUM ALLOY 1.625 WRENCH FLATS
MS33649-10
MS33657-16
MS33656-8

A	B	C	D	E	F	G	DRILL DEPTH
			1.832				1.875
				1.555	.719	1.188	THRU
2.867							3.094

5. PROC. SPEC. MIL-F-5509, LATEST REVISION, UNLESS OTHERWISE SPECIFIED ON PURCHASE ORDER BY PURCHASER.
6. REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
7. THIS STANDARD TAKES PRECEDENCE OVER REFERENCED DOCUMENTS HEREIN.
8. MANUFACTURER'S TRADEMARK AND BASIC PART NUMBER (EXCLUSIVE OF SIZE) TO APPEAR PERMANENTLY ON FINISHED PARTS. BASIC PART NUMBER MAY BE REDUCED TO "AS" ON FORGINGS SIZE 6 AND SMALLER. PARTS PREVIOUSLY IMPRESSION STAMPED WITH AN, MS OR PROPRIETARY IDENTIFICATION SHALL BE ACCEPTABLE PROVIDED SUCH IDENTIFICATION IS OBLITERATED BY IMPRESSION STAMPING WITHOUT DAMAGING THE PART.
9. TOLERANCE ON 90° ANGLE: ±2-1/2° FOR TUBE SIZE 6 AND SMALLER, ±1-1/2° FOR TUBE SIZE 8 AND LARGER.
10. WHEN FITTING IS MADE FROM BAR, THE CONTOUR OF THE BODY SECTION SHALL BE PER AS 1376 FOR FORGING SIZES DASH 3 THROUGH DASH 8, AND AS 1376 CODE M FOR SIZES DASH 10 AND LARGER.

PREPARED BY SUBCOMMITTEE G-3B, AEROSPACE FITTINGS OF
SAE COMMITTEE G-3, AEROSPACE FITTINGS & HOSE ASSEMBLIES