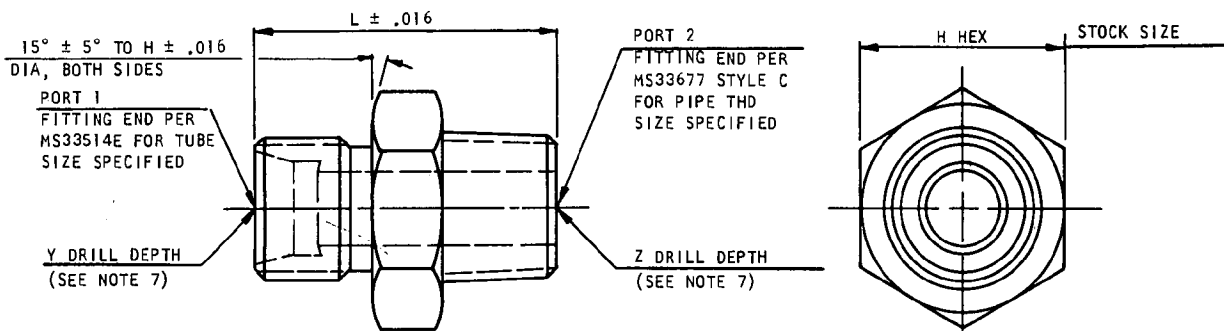


NIPPLE, FLARELESS TUBE TO MALE PIPE

Issued 1-15-76
Revised



.438	.438	.500	.562	.625	.812	.938	1.125	1.375	1.688	2.000	2.625	H HEX		
1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2	2	#1 PORT TUBE SIZE		
2	3	4	5	6	8	10	12	16	20	24	32	#1 PORT DASH NO.		
DIMENSION L OVERALL LENGTH												#2 PORT DASH NO.	#2 PORT PIPE SIZE	H HEX
.938	.984	1.031	1.062	1.094	1.188	1.266	1.344	1.375	1.406	1.469	1.578	2	1/8	.438
1.156	1.219	1.250	1.250	1.281	1.406	1.469	1.562	1.594	1.625	1.688	1.781	4	1/4	.562
1.203	1.250	1.281	1.281	1.281	1.406	1.516	1.594	1.625	1.656	1.703	1.812	6	3/8	.750
1.391	1.438	1.469	1.469	1.469	1.594	1.688	1.781	1.799	1.828	1.875	1.969	8	1/2	.875
1.438	1.500	1.531	1.531	1.547	1.609	1.719	1.781	1.812	1.844	1.891	1.984	12	3/4	1.125
1.656	1.703	1.734	1.734	1.750	1.844	1.906	2.000	2.000	2.094	2.094	2.156	16	1	1.375
1.750	1.797	1.828	1.828	1.844	1.938	2.000	2.094	2.094	2.094	2.125	2.203	20	1 1/4	1.688
1.812	1.859	1.891	1.891	1.906	2.000	2.062	2.188	2.188	2.188	2.187	2.219	24	1 1/2	2.000
1.938	1.984	2.016	2.016	2.031	2.125	2.218	2.250	2.250	2.250	2.250	2.256	32	2	2.625

DRILL DEPTH Y ± .016													#1 PORT DASH NUMBER
2	3	4	5	6	8	10	12	16	20	24	32		
THRU	THRU	THRU	.516	.531	.578	.656	.672	.641	.609	.594	.562	2	
THRU	THRU	THRU	THRU	.516	.609	.641	.688	.656	.625	.625	.578	4	#2
THRU	THRU	THRU	THRU	THRU	.625	.703	.766	.703	.672	.656	.625	6	PORT
THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	.766	.734	.688	.672	8	
THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	.766	.734	.703	.672	12	
THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	.844	.766	.688	16	DASH
THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	.844	.781	20	
THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	.859	24	NO.
THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	32	

DRILL DEPTH Z ± .016													#1 PORT DASH NUMBER
2	3	4	5	6	8	10	12	16	20	24	32		
.422	.406	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	2	
.609	.625	.641	.656	THRU	THRU	THRU	THRU	THRU	THRU	THRU	THRU	4	#2
.625	.625	.641	.641	.656	THRU	THRU	THRU	THRU	THRU	THRU	THRU	6	PORT
.766	.766	.797	.797	.797	.844	.875	THRU	THRU	THRU	THRU	THRU	8	
.766	.781	.797	.797	.812	.797	.859	.891	THRU	THRU	THRU	THRU	12	
.922	.906	.938	.938	.969	.969	.984	1.047	1.094	THRU	THRU	THRU	16	DASH
.922	.922	.938	.953	.969	.984	.984	1.047	1.094	1.109	THRU	THRU	20	
.906	.906	.938	.938	.953	.969	.969	1.078	1.125	1.141	1.203	THRU	24	NO.
.906	.906	.922	.938	.953	.969	1.031	1.000	1.062	1.078	1.141	1.609	32	

NOTES:

- MATERIAL, FINISH, AND MANUFACTURE SHALL BE IN ACCORDANCE WITH MIL-F-18280B, MARCH 7, 1963 OR LATER ISSUE AUTHORIZED BY PURCHASER.
 - MATERIAL CODE: IN PLACE OF FIRST DASH, ADD CODE LETTERS AS FOLLOWS:
NO LETTER INDICATES STEEL (USE DASH "-")
LETTER "D" INDICATES ALUMINUM ALLOY
LETTER "C" INDICATES CORROSION RESISTANT STEEL, CLASS 304
LETTER "3" INDICATES CORROSION RESISTANT STEEL, CLASS 347
LETTER "K" INDICATES CORROSION RESISTANT STEEL, CLASS 316
 - SPECIFY END SIZES IN THIS ORDER: FLARELESS TUBE END FIRST, PIPE THREAD END SECOND.
 - LARGEST END SHALL DETERMINE THE HEX SIZE WHEN BOTH PORTS ARE EQUAL, USE LARGEST HEX SPECIFIED FOR APPLICABLE DASH NUMBERS.
EXAMPLE OF PART NUMBER AS896D1012 (OVER ALL LENGTH PER DIMENSION L, 1.719, HEX SIZE PER DIMENSION H, (1.125))
- BASIC PART NUMBER
- ALUMINUM ALLOY
- FLARELESS TUBE END PER MS33514E10
- DRILL DEPTH PER DIMENSION Y, THRU
- PIPE END PER MS33677-12 STYLE C
- DRILL DEPTH PER DIMENSION Z, .859
- (OR SMALLER DIAMETER MAY BE DRILLED THRU, SEE NOTE 7)
6. REMOVE ALL BURRS AND BREAK ALL SHARP EDGES
7. AT THE OPTION OF THE MANUFACTURER, THE SMALLER DIA MAY BE DRILLED THRU THE FITTING FROM END TO END
8. ALL MACHINED SURFACES SHALL BE SMOOTH TO 125 MICROINCHES AA MAX PER ANSI B46.1.
9. FOR USE ON OXYGEN SYSTEMS AND GROUND SERVICE EQUIPMENT ONLY.

PREPARED BY
SAE COMMITTEE G-3B, AEROSPACE FITTINGS