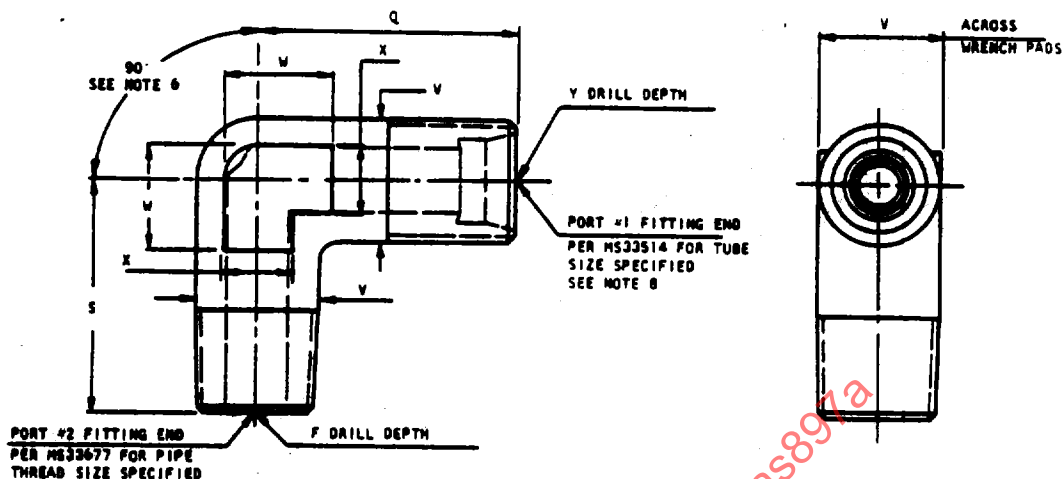




NOTES:

- 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:

589708806
 BASIC PART NUMBER
 ALUMINUM ALLOY
 FLARELESS TUBE END (PORT #1) PER MS33514G8
 LEG LENGTH PER DIMENSION Q, 1.273
 DRILL DEPTH PER DIMENSION Y, 1.32"
 PIPE END (PORT #2) PER MS33677, 3/8" PIPE SIZE
 LEG LENGTH PER DIMENSION S, 1.211
 DRILL DEPTH PER DIMENSION F, 1.264

6. TOLERANCE ON 90° ANGLE: $\pm 2 \frac{1}{2}^\circ$ FOR DASH 6 AND SMALLER, $\pm 1 \frac{1}{2}^\circ$ 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 OMIT 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 AMSI 846.1.
- Δ11. PARTS FOR OXYGEN SERVICE SHALL BE FURNISHED CLEANED, PACKAGED, AND LABELED PER ATR 1176 (OR OTHER CUSTOMER SPECIFIED DOCUMENT) WHEN SPECIFIED BY PROCURING ACTIVITY.
- Δ12. IDENTIFY PER MIL-F-18280 EXCEPT SUBSTITUTE AS OR AS897 MARKING IN PLACE OF MS OR MEXXXXX AS APPLICABLE.
- Δ13. FOR DESIGN FEATURE PURPOSES THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.

1983 CHANGE DESIGNATED BY Δ

REAFFIRMED
APR 14 1993

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

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

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AEROSPACE STANDARD

**ELBOW, 90°, FLARELESS TUBE
TO MALE PIPE**

AS 897

SHEET 1 OF 2

**Rev.
A**