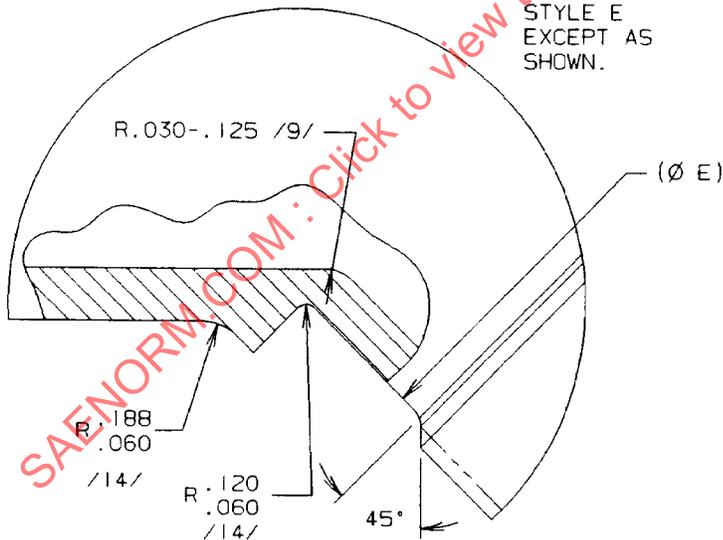
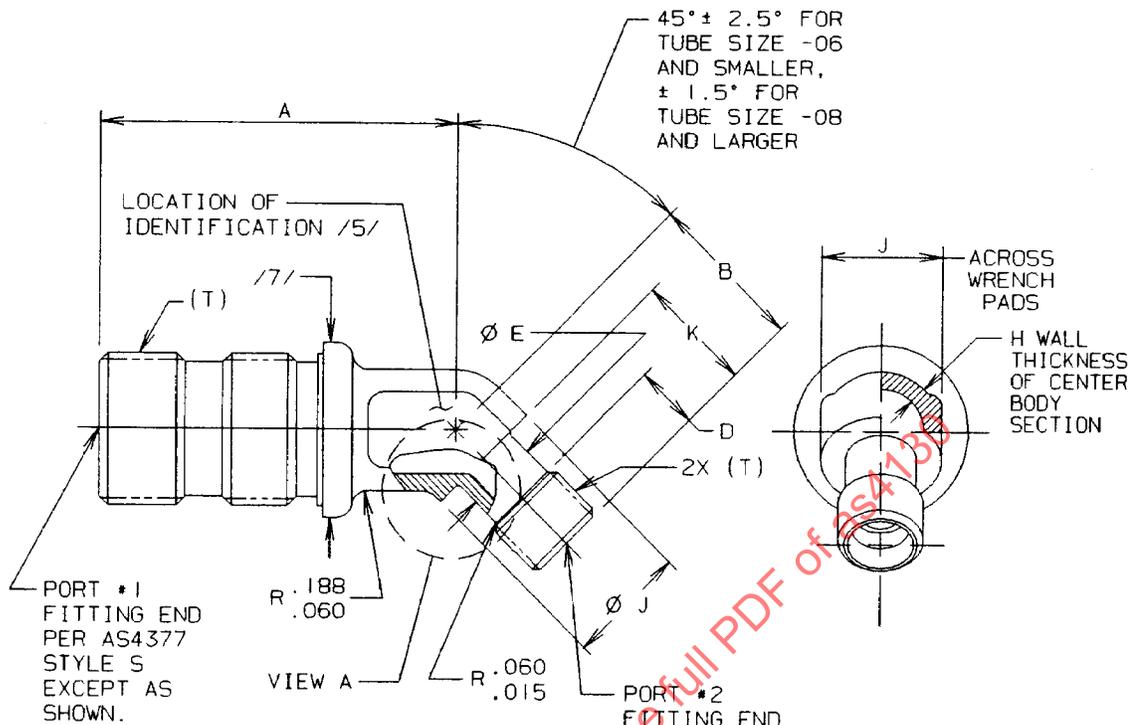


AS4130

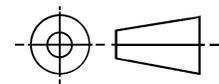
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ENLARGED VIEW A

FIGURE 1 - ELBOW, 45°, BULKHEAD, REDUCED BODY, FLARELESS

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ MIL-F-18280

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AEROSPACE STANDARD

ELBOW, 45°, BULKHEAD,
REDUCED BODY, FLARELESS

AS4130
SHEET 1 OF 4

ISSUED 1992-11 REAFFIRMED 2000-10

AS4130

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4130 /20/ SIZE CODE	H MIN	J	LB/EA MAX CRES	LB/EA MAX TI
04	.050	.390	.060	.034
05	.050	.453	.072	.040
06	.050	.453	.090	.051
08	.050	.577	.169	.097
10	.070	.702	.301	.172
12	.080	.890	.432	.248
16	.090	1.140	.565	.325
20	.110	1.390	1.123	.651
24	.130	1.640	1.412	.817

TABLE 2 - LEG LENGTH A

FORGING SIZE	04	05	06	08	10	12	16	20	24
04	1.477	---	---	---	---	---	---	---	---
05	1.477	1.477	---	---	---	---	---	---	---
06	1.540	1.540	1.586	---	---	---	---	---	---
08	1.618	1.618	1.664	1.836	---	---	---	---	---
10	1.711	1.711	1.757	1.929	2.070	---	---	---	---
12	1.805	1.805	1.851	2.023	2.164	2.273	---	---	---
16	1.930	1.930	1.976	2.148	2.289	2.398	2.398	---	---
20	1.962	1.962	2.008	2.180	2.321	2.430	2.430	2.430	---
24	1.977	1.977	2.023	2.195	2.336	2.445	2.445	2.445	2.445

TABLE 3 - LEG LENGTH B

FORGING SIZE	04	05	06	08	10	12	16	20	24
04	.711	---	---	---	---	---	---	---	---
05	.742	.742	---	---	---	---	---	---	---
06	.820	.820	.836	---	---	---	---	---	---
08	.883	.883	.899	.992	---	---	---	---	---
10	.914	.914	.930	1.023	1.086	---	---	---	---
12	1.038	1.038	1.054	1.147	1.210	1.273	---	---	---
16	1.132	1.132	1.148	1.241	1.304	1.367	1.367	---	---
20	1.226	1.226	1.242	1.355	1.398	1.461	1.461	1.461	---
24	1.320	1.320	1.336	1.429	1.492	1.555	1.555	1.555	1.555

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TABLE 4 - TURN LENGTH K

FORGING SIZE	04	05	06	08	10	12	16	20
04	.540	---	---	---	---	---	---	---
05	.560	---	---	---	---	---	---	---
06	.635	.635	---	---	---	---	---	---
08	.635	.635	.635	---	---	---	---	---
10	.635	.685	.685	.735	---	---	---	---
12	.635	.635	.685	.785	.835	---	---	---
16	.735	.735	.735	.835	.885	.985	---	---
20	.775	.775	.785	.885	.930	1.000	1.000	---
24	.820	.820	.825	.915	.970	1.040	1.040	1.040

TABLE 5 - FITTING END

SIZE CODE	TUBE OD	T THREAD	D	E
		PER MIL-S-8879 CLASS 3A		
04	.250	.4375-20UNJF	.371	.350
05	.313	.5000-20UNJF	.371	.412
06	.375	.5625-18UNJF	.379	.453
08	.500	.7500-16UNJF	.461	.577
10	.625	.8750-14UNJF	.511	.702
12	.750	1.0625-12UNJ	.556	.890
16	1.000	1.3125-12UNJ	.556	1.140
20	1.250	1.6250-12UNJ	.556	1.390
24	1.500	1.8750-12UNJ	.556	1.640

NOTES:

/1/ MATERIAL:

- a. CODE LETTER J: TYPE 304 CORROSION RESISTANT STEEL PER AMS 5639
- b. CODE LETTER T: TYPE 6AL-4V TITANIUM ALLOY PER AMS 4928
- c. CODE LETTER V: TYPE 15-5PH CORROSION RESISTANT STEEL PER AMS 5659

2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER J: NONE
- b. MATERIAL CODE LETTER T: NONE
- c. MATERIAL CODE LETTER V: HEAT TREAT TO CONDITION H-1075 PER AMS 2759/3

/3/ FINISH:

- a. MATERIAL CODE LETTER J: PASSIVATE PER QQ-P-35 TYPE VI OR TYPE VII
- b. MATERIAL CODE LETTER T: FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486
- c. MATERIAL CODE LETTER V:

- (1) NO SUFFIX FINISH CODE LETTER: PASSIVATE PER QQ-P-35, TYPE II OR VIII
- (2) SUFFIX FINISH CODE LETTER "P": CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2