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AS1032™

FEDERAL SUPPLY CLASS
4730

RATIONALE

OPTIONAL MATERIAL SPECIFICATIONS ADDED. NOTE 2 AND 3 REVISED. QML STATEMENT REVISED. INTENDED USE NOTE REVISED, TABLE 6 DELETED. GENERAL UPDATES INCORPORATED.

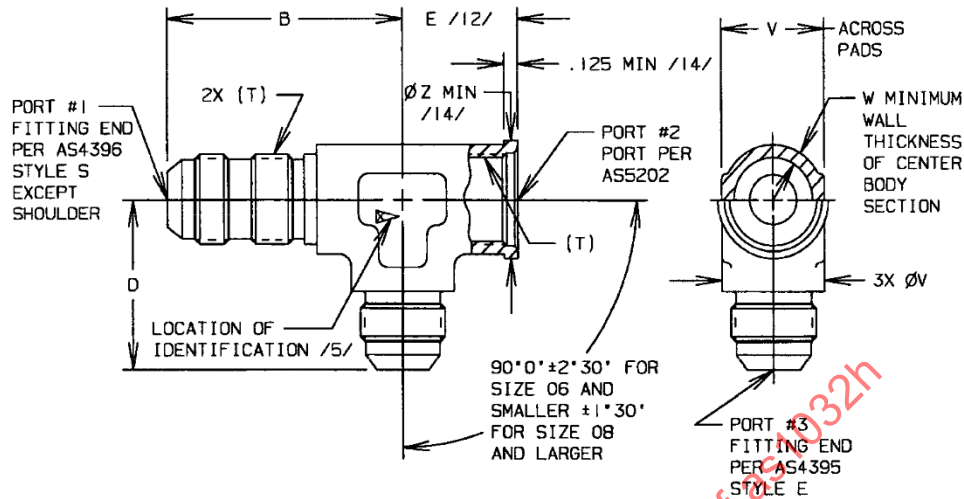


FIGURE 1 - FITTING, TEE, BULKHEAD END FOR OPTIONAL USE IN PORT
PORT #2 SHOWN AS NON-REDUCER

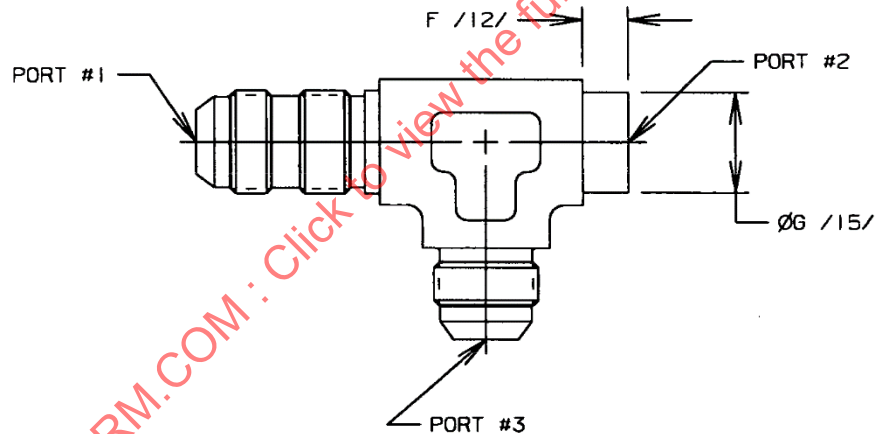
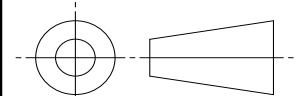


FIGURE 2 - FITTING, TEE, BULKHEAD END FOR OPTIONAL USE IN PORT
PORT #2 SHOWN AS REDUCER
SAME AS FIGURE 1 EXCEPT AS SHOWN

NOT RECOMMENDED IN PART /23/

For more information on this standard, visit
<https://www.sae.org/standards/content/AS1032H/>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS4875/1 /4/

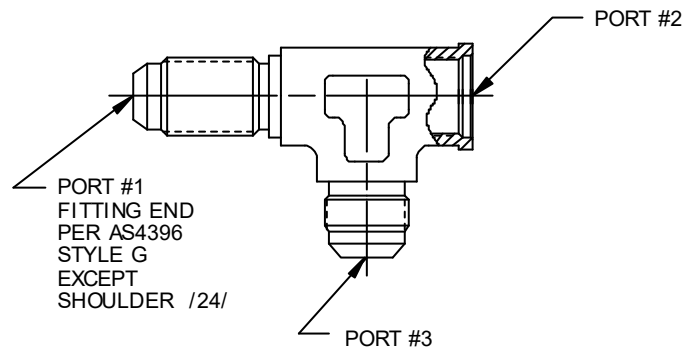


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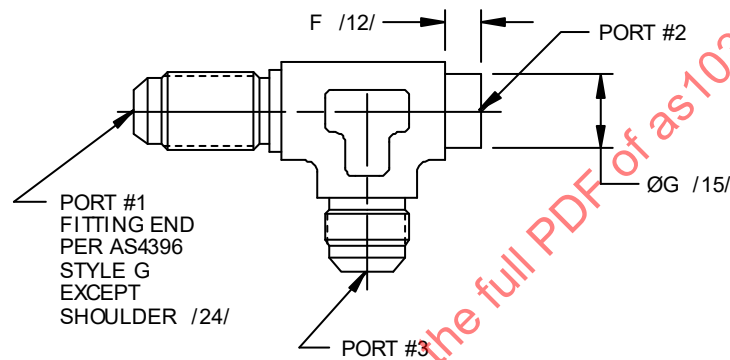
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BULKHEAD ON RUN, INTERNAL PORT ON RUN,
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**FIGURE 3 - FITTING, TEE, BULKHEAD END NOT FOR USE IN PORT
PORT #2 SHOWN AS NON-REDUCER
SAME AS FIGURE 1 EXCEPT AS SHOWN /22/**



**FIGURE 4 - FITTING, TEE, BULKHEAD END NOT FOR USE IN PORT
PORT #2 SHOWN AS REDUCER
SAME AS FIGURE 1 EXCEPT AS SHOWN /22/**

TABLE 1 - DIMENSIONS E - Z AND WEIGHTS /16/

BASIC NO. AS1032 /13/ /22/ SIZE CODE	E /12/	F /12/	V	W	Z /14/	LB/EA APPROX REF ALUM	LB/EA APPROX REF STEEL	LB/EA APPROX REF TI
02	.648	-	.485- .502	.090	.562	.0313	.0898	.0496
03	.711	-	.547- .565	.100	.625	.0410	.1179	.06498
04	.773	.375	.735- .753	.110	-	.0837	.2403	.1323
05	.773	.375	.735- .753	.120	-	.0806	.2313	.1278
06	.836	.375	.860- .878	.120	-	.1206	.3474	.1917
08	1.023	.469	1.047-1.065	.150	-	.2160	.5553	.306
10	1.180	.625	1.047-1.065	.170	1.125	.1989	.5724	.316
12	1.367	.688	1.292-1.317	.185	1.375	.3285	.945	.521
16	1.555	.719	1.605-1.630	.205	1.625	.4743	1.359	.752
20	1.742	.781	1.855-1.880	.240	1.938	.6831	1.962	1.08

TABLE 2 - LEG LENGTH B

FORGING SIZE /13/	TUBE SIZE OF PORT #1 02	TUBE SIZE OF PORT #1 03	TUBE SIZE OF PORT #1 04	TUBE SIZE OF PORT #1 05	TUBE SIZE OF PORT #1 06	TUBE SIZE OF PORT #1 08	TUBE SIZE OF PORT #1 10	TUBE SIZE OF PORT #1 12	TUBE SIZE OF PORT #1 16	TUBE SIZE OF PORT #1 20
02	1.491	-	-	-	-	-	-	-	-	-
03	1.523	1.523	-	-	-	-	-	-	-	-
04	1.679	1.679	1.773	-	-	-	-	-	-	-
05	1.679	1.679	1.773	1.773	-	-	-	-	-	-
06	1.851	1.851	1.945	1.945	2.023	-	-	-	-	-
08	1.851	1.851	1.945	1.945	2.023	2.179	-	-	-	-
10	1.929	1.929	2.023	2.023	2.101	2.257	2.398	-	-	-
12	2.008	2.008	2.102	2.102	2.180	2.336	2.477	2.648	-	-
16	2.227	2.227	2.321	2.321	2.399	2.555	2.696	2.867	2.867	-
20	2.367	2.367	2.461	2.461	2.539	2.695	2.836	3.007	3.007	3.054

TABLE 3 - LEG LENGTH D

FORGING SIZE /13/	TUBE SIZE OF PORT #3 02	TUBE SIZE OF PORT #3 03	TUBE SIZE OF PORT #3 04	TUBE SIZE OF PORT #3 05	TUBE SIZE OF PORT #3 06	TUBE SIZE OF PORT #3 08	TUBE SIZE OF PORT #3 10	TUBE SIZE OF PORT #3 12	TUBE SIZE OF PORT #3 16	TUBE SIZE OF PORT #3 20
02	.929	-	-	-	-	-	-	-	-	-
03	.961	.992	-	-	-	-	-	-	-	-
04	1.109	1.140	1.211	-	-	-	-	-	-	-
05	1.109	1.140	1.211	1.211	-	-	-	-	-	-
06	1.165	1.196	1.267	1.267	1.273	-	-	-	-	-
08	1.232	1.283	1.354	1.354	1.360	1.461	-	-	-	-
10	1.338	1.369	1.440	1.440	1.446	1.547	1.648	-	-	-
12	1.420	1.451	1.522	1.522	1.528	1.629	1.730	1.836	-	-
16	1.623	1.654	1.725	1.725	1.731	1.832	1.933	2.039	2.086	-
20	1.763	1.794	1.865	1.865	1.871	1.972	2.073	2.179	2.226	2.273

TABLE 4 - ØG /15/

FORGING SIZE /13/	TUBE SIZE OF PORT #2 02	TUBE SIZE OF PORT #2 03	TUBE SIZE OF PORT #2 04	TUBE SIZE OF PORT #2 05	TUBE SIZE OF PORT #2 06	TUBE SIZE OF PORT #2 08	TUBE SIZE OF PORT #2 10	TUBE SIZE OF PORT #2 12	TUBE SIZE OF PORT #2 16
03	-	-	-	-	-	-	-	-	-
04	.594	.656	-	-	-	-	-	-	-
05	.594	.656	-	-	-	-	-	-	-
06	.594	.656	.719	.781	-	-	-	-	-
08	.594	.656	.719	.781	.844	-	-	-	-
10	.594	.656	.719	.781	.844	-	-	-	-
12	.594	.656	.719	.781	.844	1.062	-	-	-
16	.594	.656	.719	.781	.844	1.062	1.188	1.438	-
20	.594	.656	.719	.781	.844	1.062	1.188	1.438	1.688



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TABLE 5 - TUBE SIZE AND CORRESPONDING THREAD

PORT SIZE	(NOMINAL TUBE SIZE)	T THREAD PER AS8879 CLASS 3A
02	.125	.3125-24 UNJF
03	.188	.3750-24 UNJF
04	.250	.4375-20 UNJF
05	.312	.5000-20 UNJF
06	.375	.5625-18 UNJF
08	.500	.7500-16 UNJF
10	.625	.8750-14 UNJF
12	.750	1.0625-12 UNJ
16	1.000	1.3125-12 UNJ
20	1.250	1.6250-12 UNJ

NOTES:

NOTICE

THIS DOCUMENT REFERENCES A PART WHICH CONTAINS CADMIUM AS A PLATING MATERIAL. CONSULT LOCAL OFFICIALS IF YOU HAVE QUESTIONS REGARDING CADMIUM'S USE.

/1/ MATERIAL:

- a. DASH AS CODE LETTER: TYPE 4130 STEEL FORGING OR BAR PER AMS6370 OR AMS-S-6758; OR TYPE 4140 STEEL BAR PER AMS6349 OR AMS6382.
- b. CODE LETTER D: TYPE 2014-T6 ALUMINUM ALLOY FORGING PER AMS4133 OR AMS-QQ-A-367; OR 2024-T6 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6; OR 2024-T851 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6 OR AMS4339. /23/
- c. CODE LETTER J: TYPE 304 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5639.
- d. CODE LETTER K: TYPE 316 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5648.
- e. CODE LETTER R: TYPE 321 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5645.
- f. CODE LETTER S: TYPE 347 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5646. /23/
- g. CODE LETTER T: 6AL-4V TITANIUM ALLOY FORGING OR BAR PER AMS4928.
- h. CODE LETTER W: 7075-T73 ALUMINUM ALLOY FORGING PER AMS4141 OR AMS-QQ-A-367 OR 7075-T7351 ALUMINUM ALLOY BAR PER AMS4124 OR 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9.

2. HEAT TREATMENT:

- a. DASH AS MATERIAL CODE LETTER: REFER TO HARDNESS REQUIREMENT PER PROCUREMENT SPECIFICATION.
- b. MATERIAL CODE LETTERS D AND W: REFER TO ELECTRICAL CONDUCTIVITY AND HARDNESS REQUIREMENT PER PROCUREMENT SPECIFICATION.
- c. OTHER MATERIAL CODE LETTERS: NONE.

3. FINISH:

- a. DASH AS MATERIAL CODE LETTER: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2, DYE BLACK AND COAT WITH A LIGHT FILM OF OIL PER PROCUREMENT SPECIFICATION.
- b. MATERIAL CODE LETTER D:
 1. ANODIZE PER AMS2472 OR MIL-A-8625, TYPE II, CLASS 2, DYE BLUE, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.
 2. D CODE PARTS TO BE COATED WITH HIGH PURITY ALUMINUM ONLY WILL HAVE THE FINISH CODE LETTER "V" PLACED AFTER THE SIZE CODE IN THE PART NUMBER. HIGH PURITY ALUMINUM COAT PER PROCUREMENT SPECIFICATION. /22/

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