

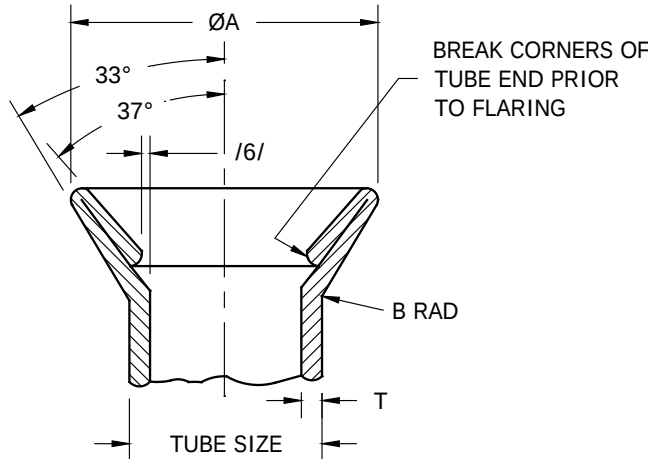


TABLE I – DIMENSIONS

TUBE SIZE NOM OD	ØA +.000 -.010	B RAD ±.010	T WALL THKNS	MIN ID	TUBE SIZE NOM OD	ØA +.000 -.010	B RAD ±.010	T WALL THKNS	MIN ID	TUBE SIZE NOM OD	ØA +.000 -.010	B RAD ±.010	T WALL THKNS	MIN ID
.125	.200	—	—	—										
.187	.302	.032	.016	.135	.500	.656	.062	.016	.448	1.250	1.500	.093	.016	1.198
			.020	.127				.020	.440				.020	1.190
			.025	.117				.025	.430				.025	1.180
			.028	.111				.028	.424				.028	1.174
			.028	.111				.035	.410				.035	1.160
			.035	.097				.049	.382				.049	1.132
			.049	.069				.058	.372				.058	1.122
			.058	.059				.065	.350				.065	1.100
.250	.359	.032	.065	.037	.625	.781	.062	.016	.573	1.500	1.721	.109	.016	1.448
			.016	.198				.020	.565				.020	1.440
			.020	.190				.025	.555				.025	1.430
			.025	.180				.028	.549				.028	1.424
			.028	.174				.035	.535				.035	1.410
			.035	.160				.049	.507				.049	1.382
			.049	.132				.058	.497				.058	1.372
			.058	.122				.065	.475				.065	1.350
.312	.421	.032	.065	.100	.750	.937	.078	.016	.698	1.750	2.106	.109	.016	1.698
			.016	.260				.020	.690				.020	1.690
			.020	.252				.025	.680				.025	1.680
			.025	.242				.028	.674				.028	1.674
			.028	.236				.035	.660				.035	1.660
			.035	.222				.049	.632				.049	1.632
			.049	.194				.058	.622				.058	1.622
			.058	.184				.065	.600				.065	1.600
.375	.484	.046	.065	.162	1.000	1.187	.093	.016	.948	2.000	2.356	.109	.016	1.948
			.016	.323				.020	.940				.020	1.940
			.020	.315				.025	.930				.025	1.930
			.025	.305				.028	.924				.028	1.924
			.028	.299				.035	.910				.035	1.910
			.035	.285				.049	.882				.049	1.882
			.049	.257				.058	.872				.058	1.872
			.058	.247				.065	.850				.065	1.850
			.065	.225										

② COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE		REVISION 2
PROCUREMENT SPECIFICATION NONE	TITLE TUBE END, STANDARD DIMENSIONS FOR INSIDE DOUBLE FLARE		CLASSIFICATION STANDARD PRACTICE
	②		NAS1000 SHEET 1 OF 2

TABLE I – DIMENSIONS (CONTINUED)

TUBE SIZE NOM OD	ØA +.000 -.010	B RAD ±.010	T WALL THKNS	MIN ID	TUBE SIZE NOM OD	ØA +.000 -.010	B RAD ±.010	T WALL THKNS	MIN ID
2.500	2.856	.109	.016	2.448	3.500	3.856	.109	.016	3.448
			.020	2.440				.020	3.440
			.025	2.430				.025	3.430
			.028	2.424				.028	3.424
			.035	2.410				.035	3.410
			.049	2.382				.049	3.382
			.058	2.372				.058	3.372
			.065	2.350				.065	3.350
3.000	3.356	.109	.016	2.948	4.000	4.356	.109	.016	3.948
			.020	2.940				.020	3.940
			.025	2.930				.025	3.930
			.028	2.924				.028	3.924
			.035	2.910				.035	3.910
			.049	2.882				.049	3.882
			.058	2.872				.058	3.872
			.065	2.850				.065	3.850

NOTES:

- (1) FOR USE WITH MS, AN AND NAS STANDARD TUBE FITTINGS.
- (2) FLARE SHALL BE SQUARE WITH CENTERLINE OF TUBE.
- (3) FLARE SHALL BE FREE FROM CRACKS AND PIT MARKS.
- (4) FLARE SHALL BE CONCENTRIC WITH OD OF TUBE WITHIN .005 FULL INDICATOR MOVEMENT.
- (5) DIMENSIONS IN INCHES.
- (6) THE RETURN LIP OF THE FLARE MAY BE AS LARGE IN DIAMETER AS TO COINCIDE WITH THE INSIDE DIAMETER OF THE PERMISSIBLE MINIMUM WALL OF THE MAX OD TUBE PLUS .040, AND MAY BE AS SMALL AS THE MINIMUM INSIDE DIAMETERS OF THE TABLE.
- (7) TOLERANCES UNLESS OTHERWISE SPECIFIED: ANGLES $\pm 1/2^\circ$.
- (8) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (9) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (10) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- (11) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

② COMPLETELY REVISED

REVISION
2
NAS1000
SHEET 2



Documents

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