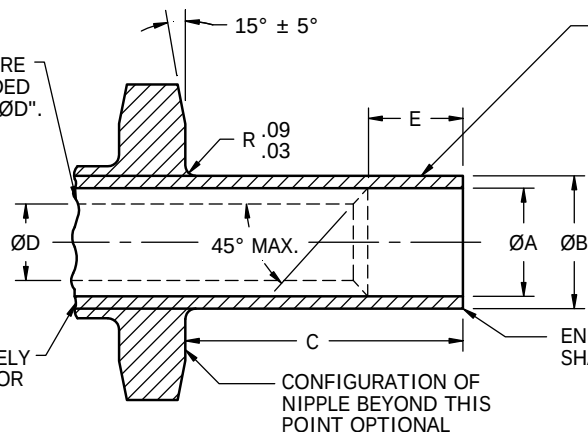


FED. SUPPLY CLASS

4730

REDUCTION OF THE NIPPLE BORE PERMITTED AS SHOWN PROVIDED THE BORE IS NOT LESS THAN "ØD".

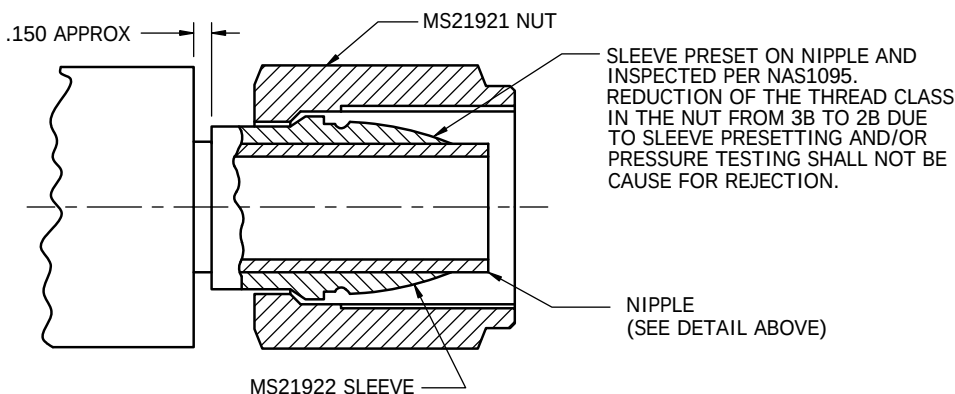


THIS SURFACE SHALL BE FREE FROM BURRS, LONGITUDINAL AND SPIRAL TOOL MARKS, AND SHALL BE SMOOTH, EXCEPT THAT ANNULAR TOOL MARKS WILL BE ALLOWED TO 100 MICROINCHES MAX.

END SHALL BE SQUARE AND THE CORNERS SHALL BE BROKEN

THE NIPPLE MAY BE COMPLETELY MACHINED FROM BAR STOCK OR BUILT UP FROM TUBING AND BAR STOCK.

CONFIGURATION OF NIPPLE BEYOND THIS POINT OPTIONAL



SLEEVE PRESET ON NIPPLE AND INSPECTED PER NAS1095. REDUCTION OF THE THREAD CLASS IN THE NUT FROM 3B TO 2B DUE TO SLEEVE PRESETTING AND/OR PRESSURE TESTING SHALL NOT BE CAUSE FOR REJECTION.

NIPPLE
(SEE DETAIL ABOVE)

MS21922 SLEEVE

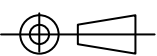
TYPICAL HOSE FITTING
ASSEMBLY

TABLE I – DIMENSIONS

PART NO.	TUBE OD (REF)	ØA MAX /1/	NIPPLE OD		C ±.015	ØD MIN	E ±.010	NUT MS21921 DASH NO. /2/	SLEEVE MS21922 DASH NO.
			ØB	TOL					
NAS1077-2	1/8	.093	.125	±.004	.700	.062	.320	2	2
NAS1077-3	3/16	.156	.188		.750	.123	.330	3	3
NAS1077-4	1/4	.209	.250		.800	.146	.380	4	4
NAS1077-5	5/16	.263	.312		.900	.177	.380	5	5
NAS1077-6	3/8	.310	.375		1.000	.271	.380	6	6
NAS1077-8	1/2	.421	.500	±.005	1.100	.365	.440	8	8
NAS1077-10	5/8	.531	.625		1.150	.455	.440	10	10
NAS1077-12	3/4	.642	.750		1.150	.568	.440	12	12
NAS1077-16	1	.860	1.000		1.200	.781	.440	16	16
NAS1077-20	1 1/4	1.110	1.250		1.200	1.031	.500	20	20

① COMPLETELY REVISED

THIRD
ANGLE
PROJECTION



CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION
1

PROCUREMENT
SPECIFICATION

NONE

TITLE

**FITTING END, HOSE, STANDARD DIMENSIONS
FOR FLARELESS TUBE**

CLASSIFICATION
DESIGN STANDARD

NAS1077
SHEET 1 OF 2



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THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME
PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST
REVISION DATE.

FORM 09-01

REVISION DATE: FEBRUARY 29, 2012

ISSUE DATE: JANUARY 1961

NOTES:

- /1/ MINIMUM BORE TO BE SPECIFIED ON PART DRAWING.
- /2/ NUT MATERIAL TO BE SPECIFIED ON PART DRAWING.
- (3) CONCENTRICITY: "ØA" AND "ØB" SHALL BE CONCENTRIC WITHIN .005 FIM.
- (4) SURFACE ROUGHNESS SHALL NOT EXCEED 125 MICROINCHES Ra PER ASME B46.1.
- (5) DIMENSIONS IN INCHES.
- (6) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (7) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (8) 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.
- (9) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

① COMPLETELY REVISED

REVISION

1



NAS1077
SHEET 2

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