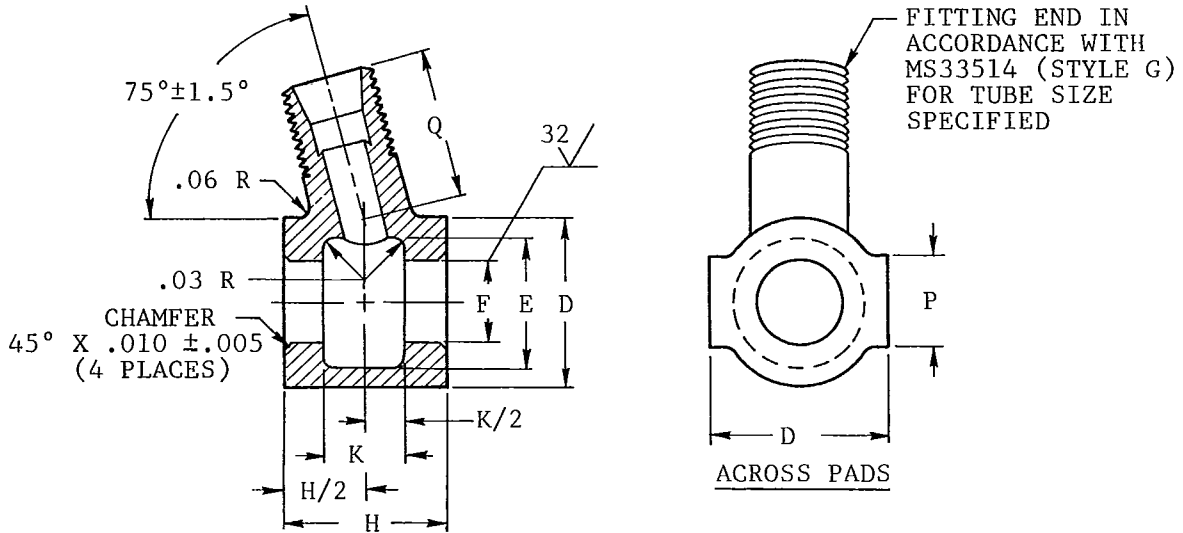


NATIONAL AEROSPACE STANDARD

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC., 1725 DE SALES STREET, N. W., WASHINGTON, D. C. 20036



BASIC PART NUMBER	TUBE O.D.	THREAD (REF)	D DIA ±.015	E DIA ±.015	F DIA +.002 -.000	H ±.005	K ±.015	P APPROX	Q ±.030
NAS1238-4	1/4	7/16-20UNF-3A	.813	.563	.437	.781	.375	.438	.716
-5	5/16	1/2-20UNF-3A	.813	.625	.500	.875	.500	.438	.716
-6	3/8	9/16-18UNF-3A	1.000	.750	.562	.968	.500	.500	.788
-8	1/2	3/4-16UNF-3A	1.188	.938	.750	1.218	.750	.500	.936
-10	5/8	7/8-14UNF-3A	1.375	1.125	.875	1.375	.813	.625	1.055
-12	3/4	1-1/16-12UN-3A	1.688	1.375	1.062	1.687	1.000	.625	1.137
NAS1238-16	1	1-5/16-12UN-3A	2.063	1.688	1.312	2.125	1.500	.813	1.277

- ① MATERIAL: SEE PROCUREMENT SPECIFICATION, EXCEPT ALUMINUM ALLOY MATERIAL LIMITED TO 2014-T6 PER SPECIFICATIONS QQ-A-200/2, QQ-A-225/4 OR QQ-A-367; OR 2024-T6 OR T851 PER SPECIFICATIONS QQ-A-200/3, QQ-A-225/6 OR QQ-A-250/4.

FINISH: SEE PROCUREMENT SPECIFICATION.

MARKING: EACH FITTING SHALL BE PERMANENTLY AND LEGIBLY MARKED WITH THE MANUFACTURERS NAME OR TRADEMARK AND NAS PART NUMBER.

SURFACE ROUGHNESS: 125 EXCEPT AS NOTED. SEE USAS B46.1.①

DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED.

TOLERANCES: ±.015, ANGLES ±2°.

ALL THREADS PER MIL-S-7742 EXCEPT AS NOTED.

①

LIST OF CURRENT SHEETS	
NO.	REV
1	1
2	NEW

① INACTIVE FOR DESIGN AFTER 8/30/69 NO SUPERSEDING STANDARD.

CUSTODIAN: NATIONAL AEROSPACE STANDARDS COMMITTEE

PROCUREMENT
SPECIFICATION

MIL-F-18280

TITLE

ELBOW - UNIVERSAL 75° - FLARELESS

CLASSIFICATION
STANDARD PART

NAS Documents

Sheet 1 of 2

NATIONAL AEROSPACE STANDARD

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC., 1725 DE SALES STREET, N. W., WASHINGTON, D. C. 20036

*CODING: NO PREFIX ON DASH NUMBER INDICATES STEEL.
 PREFIX "A" ON DASH NUMBER INDICATES ALUMINUM ALLOY.
 PREFIX "J" ON DASH NUMBER INDICATES CORROSION RESISTING STEEL TYPE 304.
 PREFIX "K" ON DASH NUMBER INDICATES CORROSION RESISTING STEEL TYPE 316.
 PREFIX "S" ON DASH NUMBER INDICATES CORROSION RESISTING STEEL TYPE 347.

EXAMPLES OF PART NUMBERS: NAS1238-4 = STEEL ELBOW FOR 1/4" TUBE O.D.
 NAS1238A4 = ALUMINUM ALLOY ELBOW FOR 1/4" TUBE O.D.
 NAS1238J4 = CORROSION RESISTING STEEL ELBOW TYPE 304 FOR 1/4" TUBE O.D.
 NAS1238K4 = CORROSION RESISTING STEEL ELBOW TYPE 316 FOR 1/4" TUBE O.D.
 NAS1238S4 = CORROSION RESISTING STEEL ELBOW TYPE 347 FOR 1/4" TUBE O.D.

DIMENSIONS APPLY AFTER PLATING.

EACH BEARING FACE SHALL BE AT 90° TO THE CENTER LINE OF THE "F" DIMENSION HOLE WITHIN A MAXIMUM INDICATOR READING VARIATION OF .006. BEARING FACES SHALL BE PARALLEL WITHIN .003.

INSTALL PER NAS550.

FOR DESCRIPTION OF STATUS NOTES SEE NAS380.

*EXISTING STOCK CODED "C" OR "CF" MAY BE USED UNTIL DEPLETED. CODE "CF" REPLACED BY "J" AND "K" CODES, EXCEPT "CF" MAY ALSO BE 302, 303 OR 321 STEEL. CODE "C" REPLACED BY "S" CODE, EXCEPT "C" MAY ALSO BE 304L STEEL.

CUSTODIAN: NATIONAL AEROSPACE STANDARDS COMMITTEE

PROCUREMENT
SPECIFICATION

MIL-F-18280

TITLE

ELBOW - UNIVERSAL 75° - FLARELESS

CLASSIFICATION
STANDARD PART

NAS 1238 Documents

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