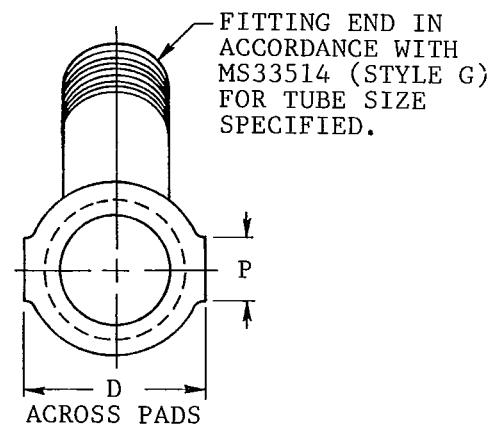
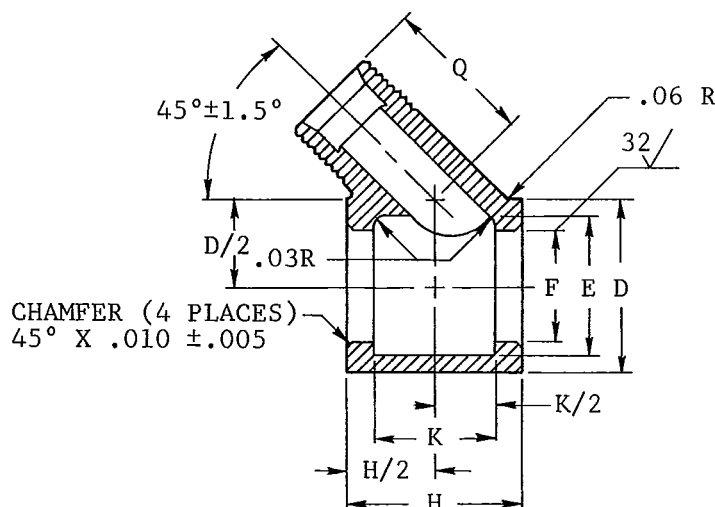


NATIONAL AEROSPACE STANDARD

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



BREAK ALL SHARP EDGES .005-.010 AND REMOVE ALL BURRS AND HANGING SLIVERS THAT MIGHT BECOME DISLODGED UNDER USAGE.
THIS ELBOW IS INTENDED FOR USE WITH A NAS551 OR NAS1236 BOLT.

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
NAS1239-4	1/4	7/16-20UNF-3A	.813	.563	.437	.781	.375	.438	.903
-5	5/16	1/2-20UNF-3A	.813	.625	.500	.875	.500	.438	.903
-6	3/8	9/16-18UNF-3A	1.000	.750	.562	.968	.500	.500	.976
-8	1/2	3/4-16UNF-3A	1.188	.938	.750	1.218	.750	.500	1.218
-10	5/8	7/8-14UNF-3A	1.375	1.125	.875	1.375	.813	.625	1.336
-12	3/4	1 1/16-12UN-3A	1.688	1.375	1.062	1.687	1.000	.625	1.449
NAS1239-16	1	1 5/16-12UN-3A	2.063	1.688	1.312	2.125	1.500	.813	1.621

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 TRADE MARK 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° EXCEPT AS NOTED.

ALL THREADS PER MIL-S-7742.

* CODING: NO PREFIX ON DASH NUMBER INDICATES STEEL.
① 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.

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

CUSTODIAN: NATIONAL AEROSPACE STANDARDS COMMITTEE

PROCUREMENT
SPECIFICATION

MIL-F-18280

TITLE

ELBOW - UNIVERSAL 45° - FLARELESS

CLASSIFICATION
STANDARD PART

NAS Documents

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NATIONAL AEROSPACE STANDARD

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

EXAMPLES OF PART NUMBERS:

- NAS1239-4 - STEEL ELBOW FOR 1/4" TUBE O.D.
- NAS1239A4 - ALUMINUM ALLOY ELBOW FOR 1/4" TUBE O.D.
- NAS1239J4 - CORROSION RESISTING STEEL ELBOW, TYPE 304, FOR 1/4" TUBE O.D.
- NAS1239K4 - CORROSION RESISTING STEEL ELBOW, TYPE 316, FOR 1/4" TUBE O.D.
- NAS1239S4 - 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.

AIA AND ITS COMMITTEES WILL NOT INVESTIGATE THE APPLICABILITY OF PATENTS TO THE SUBJECT MATTER OF NAS STANDARDS AND IN RESPECT THEREOF DO NOT ASSUME ANY LIABILITY TO PATENT OWNERS OR TO PROSPECTIVE USERS

THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST DATE OF APPROVAL SHOWN HEREON

CUSTODIAN: NATIONAL AEROSPACE STANDARDS COMMITTEE

PROCUREMENT
SPECIFICATION

MIL-F-18280

TITLE

ELBOW - UNIVERSAL 45° - FLARELESS

CLASSIFICATION
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NAS Documents

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