

FED. SUPPLY CLASS

4730

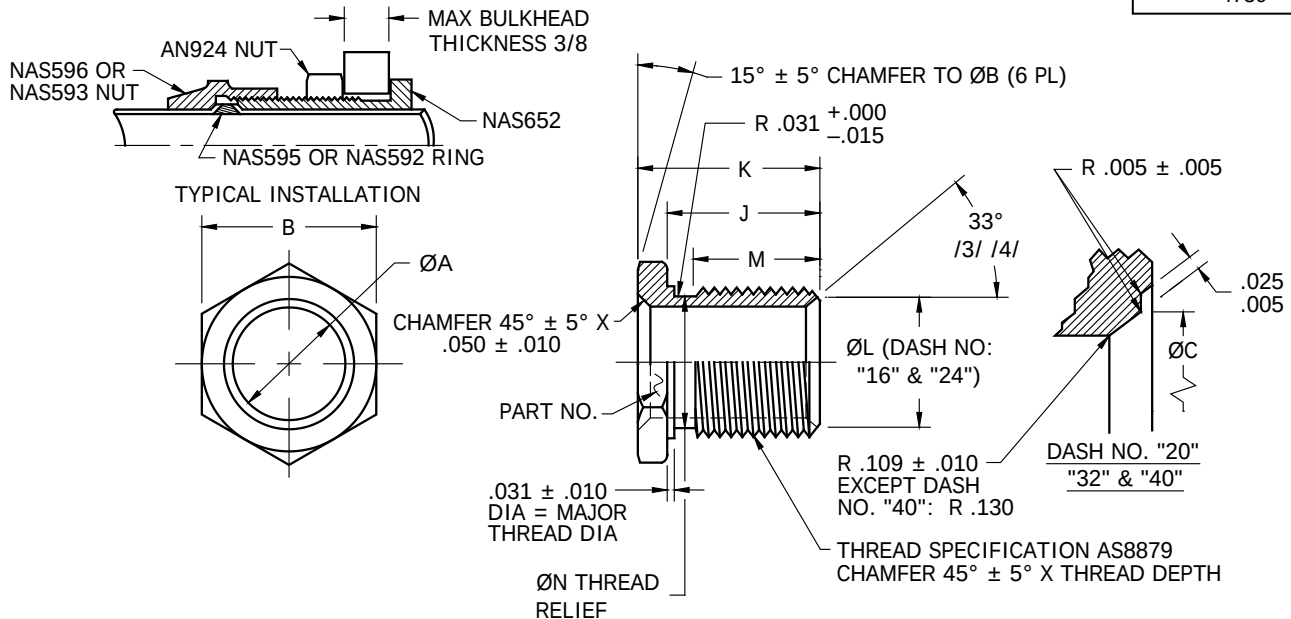


TABLE I – DIMENSIONS

| DASH NO. | TUBE SIZE<br>OD | THREAD SIZE<br>UNJ-3A | ØA BORE ID |       | B HEXAGON SIZE<br>±.030 | ØC FLARE STEP<br>±.005 | J LENGTH<br>±.010 | K LENGTH<br>±.030 | ØL FLARE<br>±.005 | M THREAD LENGTH<br>±.020 | ØN THREAD RELIEF<br>±.010 | MAX WT LBS |       |
|----------|-----------------|-----------------------|------------|-------|-------------------------|------------------------|-------------------|-------------------|-------------------|--------------------------|---------------------------|------------|-------|
|          |                 |                       |            |       |                         |                        |                   |                   |                   |                          |                           | AL ALLOY   | CRES  |
| 16       | 1               | 1.3125-12             | 1.010      | ±.005 | 1.500                   | —                      | 1.360             | 1.630             | 1.156             | 1.162                    | 1.194                     | .095       | .275  |
| 20       | 1 1/4           | 1.6250-12             | 1.260      |       | 1.750                   | 1.412                  | 1.318             | 1.560             | —                 | 1.120                    | 1.507                     | .125       | .365  |
| 24       | 1 1/2           | 1.8750-12             | 1.510      |       | 2.000                   | —                      | 1.345             | 1.630             | 1.653             | 1.147                    | 1.757                     | .155       | .455  |
| 32       | 2               | 2.5000-12             | 2.014      | +.003 | 2.750                   | 2.147                  | 1.353             | 1.720             | —                 | 1.155                    | 2.383                     | .315       | .935  |
| 40       | 2 1/2           | 3.0000-12             | 2.514      | -.000 | 3.780                   | 2.695                  | 1.353             | 1.720             | —                 | 1.155                    | 2.881                     | .655       | 1.955 |

**MATERIAL:**

ALUMINUM ALLOY: SEE PROCUREMENT SPECIFICATION.  
CRES: SEE PROCUREMENT SPECIFICATION.

**FINISH:**

SEE PROCUREMENT SPECIFICATION.

**CODE:**

PRECEDE DASH NUMBER WITH "DD" FOR ALUMINUM ALLOY OR "C" FOR CRES.

④ COMPLETELY REVISED

|                                     |                                                         |                                 |
|-------------------------------------|---------------------------------------------------------|---------------------------------|
| THIRD ANGLE PROJECTION              | CUSTODIAN<br>NATIONAL AEROSPACE STANDARDS COMMITTEE     | REVISION<br><b>4</b>            |
| PROCUREMENT SPECIFICATION<br>NAS597 | TITLE<br><b>COUPLING, RIGID TUBE BULKHEAD CONNECTOR</b> | CLASSIFICATION<br>PART STANDARD |



**NAS652**  
SHEET 1 OF 2  
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EXAMPLE OF PART NUMBER:

NAS652DD16 = RIGID TUBE BULKHEAD CONNECTOR COUPLING, ALUMINUM ALLOY, FOR 1 OD TUBE  
 NAS652C16 = RIGID TUBE BULKHEAD CONNECTOR COUPLING, CRES, FOR 1 OD TUBE

NOTES:

- (1) REMOVE ALL BURRS AND SHARP EDGES.
- (2) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- /3/ SURFACE MAKING CONTACT WITH TUBING FLARE SHALL BE FREE FROM BURRS, LONGITUDINAL FLATS, LONGITUDINAL AND SPIRAL TOOL MARKS, EXCEPT THAT ANNULAR TOOL MARKS WILL BE ALLOWED IF 90% OF CONTACT AREA IS INDICATED BY BLUEING METHOD OF INSPECTION.
- /4/ SURFACE ROUGHNESS: FOR MACHINED SURFACES, 125 MICROINCHES Ra; EXCEPT AREA IN CONTACT WITH TUBING FLARE, 63 MICROINCHES Ra PER ASME B46.1.
- (5) DO NOT USE CRES PARTS AT TEMPERATURES EXCEEDING 700 °F.
- (6) TOLERANCES UNLESS OTHERWISE SPECIFIED: ANGLES  $\pm 0^{\circ}30'$ .
- (7) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (8) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (9) 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.
- (10) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

④ COMPLETELY REVISED

REVISION

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