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REV.
D

AS21902™

FEDERAL SUPPLY CLASS
4730

RATIONALE

ADDED REVISION BLOCK, INTRODUCTORY NOTICE, TABLE 1 COLUMN E MIN MAX, AND MARKING AND DIMENSIONING NOTES, REACTIVATED MATERIAL CODE "D" AND CLARIFIED OTHER MATERIALS STATUS.

NOTICE

THE INITIAL SAE PUBLICATION OF THIS DOCUMENT WAS TAKEN DIRECTLY FROM U.S. MILITARY STANDARD MS21902 AND RETAINS THE SAME PART NUMBERS ESTABLISHED BY THE ORIGINAL MILITARY DOCUMENT. PROCUREMENT OF MS21902 PART NUMBERS TO THIS "AS" STANDARD MAY RESULT IN LOSS OF CONFIGURATION CONTROL WHERE DIFFERENCES IN THE CANCELLED MIL-F-18280 AND THE SUPERSEDING AS18280 PROCUREMENT SPECIFICATIONS EXIST. AS5230 IS A RECOMMENDED REPLACEMENT STANDARD THAT ELIMINATES THIS PROBLEM.

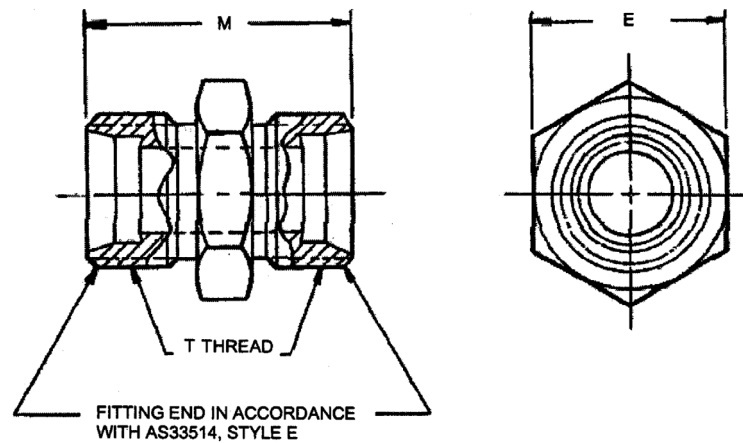


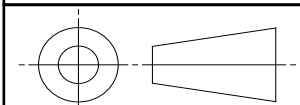
FIGURE 1 - UNION, FLARELESS TUBE

TABLE 1 - DIMENSIONS

DASH NO. /5/	NOMINAL TUBE SIZE REF	(T) THREAD AS8879	E		M	WEIGHT, LB/EA, APPROX, REF.		
			MIN	MAX		STEEL	AL ALLOY	TI ALLOY
-2	.125	.3125-24 UNJF-3A	.553	.566	1.063	.029	.013	.016
-3	.188	.3750-24 UNJF-3A	.615	.628	1.094	.031	.014	.017
-4	.250	.4375-20 UNJF-3A	.678	.691	1.063	.035	.015	.020
-5	.313	.5000-20 UNJF-3A	.740	.753	1.063	.045	.016	.025
-6	.375	.5625-18 UNJF-3A	.803	.816	1.188	.066	.023	.038
-8	.500	.7500-16 UNJF-3A	.990	1.003	1.375	.111	.040	.064
-10	.625	.8750-14 UNJF-3A	1.113	1.128	1.563	.165	.056	.095
-12	.750	1.0625-12 UNJ-3A	1.363	1.380	1.750	.281	.097	.162
-16	1.000	1.3125-12 UNJ-3A	1.613	1.630	1.750	.355	.126	.204
-20	1.250	1.6250-12 UNJ-3A	1.863	1.880	1.750	.514	.183	.296
-24	1.500	1.8750-12 UNJ-3A	2.109	2.135	1.750	.754	.277	.435
-32	2.000	2.5000-12 UNJ-3A	2.734	2.760	1.813	1.094	.402	.631

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on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS21902D>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /11/ AS18280



AEROSPACE STANDARD

(R) UNION, FLARELESS TUBE

AS21902™
SHEET 1 OF 3

REV.
D

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NOTES:

NOTICE

THIS DOCUMENT REFERENCES PARTS THAT CONTAIN CADMIUM AS A PLATING MATERIAL. CONSULT LOCAL OFFICIALS IF YOU HAVE QUESTIONS CONCERNING CADMIUM'S USE.

1. MATERIAL: SEE PROCUREMENT SPECIFICATION.

ALLOY STEEL
ALUMINUM ALLOY
CORROSION RESISTANT STEEL
TITANIUM ALLOY

2. FINISH: SEE PROCUREMENT SPECIFICATION.

3. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.

4. DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS ± 0.016 , ANGLES $\pm 0^{\circ}30'$.

/5/ PART NUMBERS:

MATERIAL CODE DASH "-" IN PART NUMBER FOR 4130 ALLOY STEEL.
ADD MATERIAL CODE "V(SIZE)P" IN PLACE OF DASH FOR CORROSION RESISTANT STEEL (15-5PH), CADMIUM PLATED.
ADD MATERIAL CODE "V" IN PLACE OF DASH FOR CORROSION RESISTANT STEEL (15-5PH), NOT CADMIUM PLATED.
ADD MATERIAL CODE "D" IN PLACE OF DASH FOR ALUMINUM ALLOY (2024).
ADD MATERIAL CODE "W" IN PLACE OF DASH FOR ALUMINUM ALLOY (7075).
ADD MATERIAL CODE "J" IN PLACE OF DASH FOR CORROSION RESISTANT STEEL (TYPE 304).
ADD MATERIAL CODE "K" IN PLACE OF DASH FOR CORROSION RESISTANT STEEL (TYPE 316).
ADD MATERIAL CODE "R" AFTER DASH NUMBER FOR CORROSION RESISTANT STEEL (TYPE 321).
ADD MATERIAL CODE "S" AFTER DASH NUMBER FOR CORROSION RESISTANT STEEL (TYPE 347). (INACTIVE)
ADD MATERIAL CODE "T" AFTER DASH NUMBER FOR TITANIUM ALLOY (6AL-4V).

EXAMPLES OF PART NUMBERS:

MS21902-4	UNION, .250 TUBING, 4130 ALLOY STEEL.
MS21902V4P	UNION, .250 TUBING, CORROSION RESISTANT STEEL (15-5PH), CADMIUM PLATED. SEE TABLE 2 /A/
MS21902V4	UNION, .250 TUBING, CORROSION RESISTANT STEEL (15-5PH), NOT CADMIUM PLATED.
MS21902D4	UNION, .250 TUBING, ALUMINUM ALLOY (2024). SEE TABLE 2 /C/
MS21902W4	UNION, .250 TUBING, ALUMINUM ALLOY (7075).
MS21902J4	UNION, .250 TUBING, CORROSION RESISTANT STEEL (TYPE 304).
MS21902K4	UNION, .250 TUBING, CORROSION RESISTANT STEEL (TYPE 316).
MS21902-4R	UNION, .250 TUBING, CORROSION RESISTANT STEEL (TYPE 321).
MS21902-4S	UNION, .250 TUBING, CORROSION RESISTANT STEEL (TYPE 347). (REPLACED) SEE TABLE 2 /D/
MS21902-4T	UNION, .250 TUBING, TITANIUM ALLOY (6AL-4V).

6. PART MARKING: SEE PROCUREMENT SPECIFICATION.

7. DIMENSIONING AND TOLERANCING: ASME Y14.5M-1994.

8. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.

9. IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS STANDARD AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE.

10. INTERPRETATION OF DRAWING PER AS4296.

	AEROSPACE STANDARD	AS21902™ SHEET 2 OF 3	REV. D 
	(R) UNION, FLARELESS TUBE		