

REV.
A

AS4330

FEDERAL SUPPLY CLASS
4730

RATIONALE

1. CLARIFIED THE INCLUDED ANGLE TOLERANCES IN FIGURE 1.
2. FIGURE 1 AND VIEW "A" REDRAWN TO SHOW TUBE END VIEW AFTER FORMING.
3. CHANGED TITLE IN ACCORDANCE WITH ARP1987.
4. REVISED NOTES TO AGREE WITH KC154.

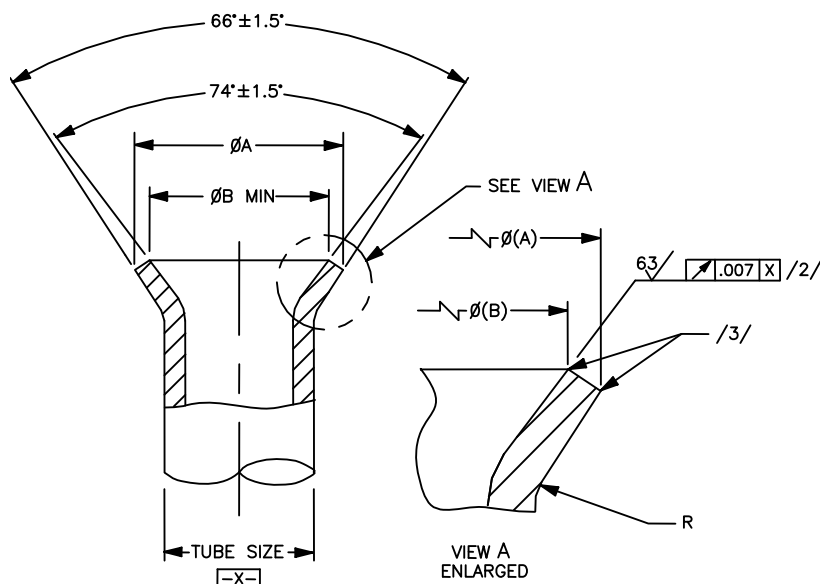


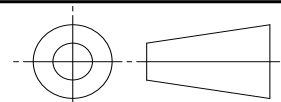
FIGURE 1 - TUBING END, FLARED

TABLE 1 - DIMENSIONS

BASIC NUMBER AS4330 /9/ SIZE CODE	(NOMINAL TUBE SIZE)	A	B	R
02	.125	.190 - .210	.140	.017 - .047
03	.188	.292 - .312	.245	.017 - .047
04	.250	.349 - .369	.300	.017 - .047
05	.312	.411 - .431	.320	.017 - .047
06	.375	.474 - .494	.440	.031 - .061
08	.500	.646 - .666	.555	.047 - .077
10	.625	.771 - .791	.665	.047 - .077
12	.750	.927 - .947	.800	.063 - .093
16	1.000	1.172 - 1.202	1.080	.083 - .113
20	1.250	1.485 - 1.515	1.400	.083 - .113
24	1.500	1.706 - 1.736	1.600	.099 - .129
28	1.750	2.091 - 2.121	1.850	.099 - .129
32	2.000	2.341 - 2.371	2.100	.099 - .129

SAE values your input. To provide feedback
on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS4330A>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: NONE /1/



AEROSPACE STANDARD

TUBING, FLARED, STANDARD
DIMENSIONS FOR, DESIGN STANDARD

AS4330
SHEET 1 OF 2

REV.
A



Documents

Copyright 2014 SAE International

All rights reserved. No part of this publication may be reproduced, stored in a retrieval system or transmitted, in any form or by any means, electronic, mechanical, photocopying, recording, or otherwise, without the prior written permission of SAE.

TO PLACE A DOCUMENT ORDER: Tel: 877-606-7323 (inside USA and Canada)
Fax: 724-776-0790

Tel: +1 724-776-4970 (outside USA)
Email: CustomerService@sae.org

SAE WEB ADDRESS: <http://www.sae.org>

NOTES:

- /1/ THIS DESIGN STANDARD ESTABLISHES DIMENSIONS GOVERNING THE FORMING OF TUBE FLARES THAT ARE TO BE USED WITH AS4395, AS4396 TYPE STANDARD FLARED FITTINGS PER AS4841 AND AS1098, AS1099 TYPE RING SEAL FLARED FITTINGS PER KSC-F-124.
- /2/ THE FLARED SEALING SURFACE SHALL NOT EXHIBIT CONCAVE AREAS EXCEEDING .001 OR CONVEX AREAS EXCEEDING .002.
- /3/ DEBURR EDGES OF TUBING BEFORE FLARING: RADIUS OR CHAMFER THE EDGE OF THE ID .010 MAX AND THE EDGE OF THE OD 20% TO 50% OF THE TUBING WALL THICKNESS. EDGES TO BE FREE OF CHATTER MARKS.
4. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1 UNLESS OTHERWISE SPECIFIED, SURFACES ARE TO BE 125 MICROINCHES Ra.
5. INTERPETATION OF DRAWING PER ARP4296.
6. DIMENSIONING AND TOLERANCING: ASME Y14.5M-1994.
7. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS $\pm .016$, ANGULAR DIMENSIONS $\pm 0^{\circ}30'$.
8. A CHANGE BAR (I) LOCATED IN THE LEFT MARGIN IS FOR THE CONVENIENCE OF THE USER IN LOCATING AREAS WHERE TECHNICAL REVISIONS, NOT EDITORIAL CHANGES, HAVE BEEN MADE TO THE PREVIOUS ISSUE OF THIS DOCUMENT. AN (R) SYMBOL TO THE LEFT OF THE DOCUMENT TITLE INDICATES A COMPLETE REVISION OF THE DOCUMENT, INCLUDING TECHNICAL REVISIONS. CHANGE BARS AND (R) ARE NOT USED IN ORIGINAL PUBLICATIONS, NOR IN DOCUMENTS THAT CONTAIN EDITORIAL CHANGES ONLY.
- /9/ EXAMPLE OF DRAWING CALLOUT:
 - a. TABULATED PART NUMBER: FLARE PER AS4330
 - b. INDIVIDUAL PART DRAWING: AS4330 - 08

BASIC PART NUMBER

NOMINAL TUBE SIZE IN
.062 INCREMENTS

	AEROSPACE STANDARD		AS4330 SHEET 2 OF 2	REV. A
	TUBING, FLARED, STANDARD DIMENSIONS FOR, DESIGN STANDARD			