

REV.
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AS4684™

RATIONALE

ADDED CONDUCTIVE HIGH PURITY ALUMINUM COATING FOR ALUMINUM ALLOY FITTINGS.

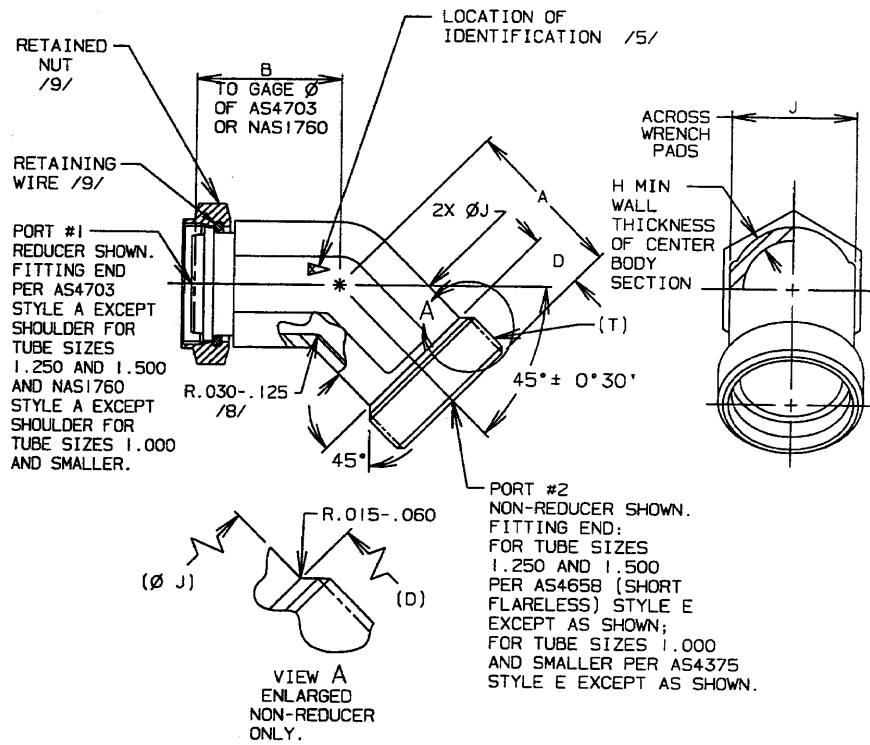


FIGURE 1 - ELBOW ASSEMBLY, 45°

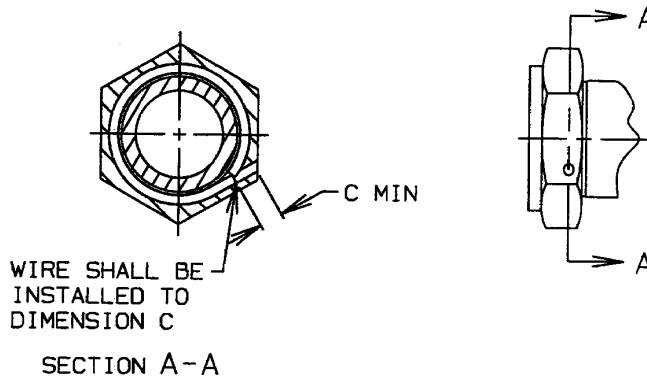
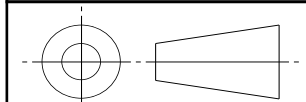


FIGURE 2 - INSTALLATION, RETAINED NUT AND RETAINING WIRE

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THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS18280 /4/



AEROSPACE STANDARD

FITTING ASSEMBLY, ELBOW, 45°, FLARELESS AND SHORT FLARELESS, REDUCER, RETAINED NUT

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SHEET 1 OF 6

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TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4684 /10/ /19/ SIZE CODE	D	H	J +.005/- .020	LB/EA APPROX REF ALUM	LB/EA APPROX REF CRES	LB/EA APPROX REF TI
20	.517	.124	1.375	.268	.779	.451
24	.614	.156	1.688	.381	1.098	.636

TABLE 2 - WIRE INSERTION DEPTH

PORT SIZE	(NOMINAL TUBE SIZE)	C
04	.250	.076
05	.312	.076
06	.375	.084
08	.500	.095
10	.625	.114
12	.750	.150
16	1.000	.176
20	1.250	.247
24	1.500	.287

TABLE 3 - LEG LENGTH A

SIZE OF PORT #2	FORGING SIZE /10/ 20	FORGING SIZE /10/ 24
04	.876	.928
05	.876	.928
06	.892	.944
08	.985	1.037
10	1.048	1.100
12	1.111	1.163
16	1.111	1.163
20	1.053	.956
24	---	1.105

TABLE 4 - LEG LENGTH B

SIZE OF PORT #1	FORGING SIZE /10/ 20	FORGING SIZE /10/ 24
04	.853	.950
05	.905	.957
06	.966	1.018
08	1.063	1.115
10	1.142	1.194
12	1.131	1.183
16	1.179	1.231
20	1.055	1.107
24	---	1.135

**AEROSPACE STANDARD**FITTING ASSEMBLY, ELBOW, 45°, FLARELESS AND
SHORT FLARELESS, REDUCER, RETAINED NUT**AS4684™**
SHEET 2 OF 6**REV.**
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