



(a) FOR HEX DIMENSIONS AND TOLERANCES SEE MS33656.

MATERIAL: STEEL - BARS, SHAPES, OR FORGINGS.
TITANIUM ALLOY - BARS, SHAPES OR FORGINGS
ALUMINUM ALLOY - BARS, SHAPES, OR FORGINGS.
CORROSION RESISTANT STEEL - BARS, SHAPES OR FORGINGS.
SEE PROCUREMENT SPECIFICATION.

FINISH: SEE PROCUREMENT SPECIFICATIONS.

NO CODE LETTER IN PART NUMBER FOR STEEL.
ADD D AFTER DASH NUMBER FOR ALUMINUM ALLOY (EXCEPT 7075-T73).
ADD J AFTER DASH NUMBER FOR CORROSION RESISTANT STEEL, TYPE 304.
ADD K AFTER DASH NUMBER FOR CORROSION RESISTANT STEEL, TYPE 316.
ADD S AFTER DASH NUMBER FOR CORROSION RESISTANT STEEL, TYPE 347.
ADD T AFTER DASH NUMBER FOR TITANIUM.
ADD W AFTER DASH NUMBER FOR 7075-T73 ALUMINUM.

EXAMPLE OF PART NUMBER:
AN815-8 - UNION, 1/2 TUBING, STEEL.
AN815-8D - UNION, 1/2 TUBING, ALUMINUM ALLOY (EXCEPT 7075-T73).
AN815-8J - UNION, 1/2 TUBING, CORROSION RESISTANT STEEL, TYPE 304.
AN815-8K - UNION, 1/2 TUBING, CORROSION RESISTANT STEEL, TYPE 316.
AN815-8S - UNION, 1/2 TUBING, CORROSION RESISTANT STEEL, TYPE 347.
AN815-8T - UNION, 1/2 TUBING, TITANIUM.
AN815-8W - UNION, 1/2 TUBING, 7075-T73.

BREAK ALL SHARP EDGE AND REMOVE ALL HANGING BURRS AND SLIVERS WHICH MIGHT BECOME DISLODGED UNDER USAGE.

DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES ON FRACTIONS $\pm 1/64$.

TITANIUM NOT TO BE USED IN OXYGEN SYSTEMS.

9 ENTIRE STANDARD REVISED

APPROVED 3 FEB 41 REVISED 8 16 APRIL 82 9 4 Aug 83

P. A. AIR FORCE - 82 Other Cost ARMY - AV NAVY - AS AIR FORCE - 99	INTERNATIONAL INTEREST	AIR FORCE-NAVY AERONAUTICAL STANDARD	AN815
		UNION - FLARED TUBE	
PROCUREMENT SPECIFICATION MIL - F - 5509	SUPERSEDES:		SHEET 1 OF 2

DD FORM 1 MAY 71 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

PROJECT 4730-0480

USER ACTIVITIES

REVIEWER ACTIVITIES DLA-CS

This military standard is approved for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

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DASH NO.	TUBING OD	THREAD T REF	E REF	M
AN815-2	1/8	5/16-24UNJF-3A	.563	1- 7/32
AN815-3	3/16	3/8 -24UNJF-3A	.625	
AN815-4	1/4	7/16-20UNJF-3A	.688	1- 1/4
AN815-5	5/16	1/2 -20UNJF-3A	.750	
AN815-6	3/8	9/16-18UNJF-3A	.813	1- 3/8
AN815-8	1/2	3/4 -16UNJF-3A	1.000	1- 9/16
AN815-10	5/8	7/8 -14UNJF-3A	1.125	1-53/64
AN815-12	3/4	1-1/16-12UNJ -3A	1.375	2- 7/64
AN815-16	1	1-5/16-12UNJ -3A	1.625	2- 3/16
AN815-20	1-1/4	1-5/8 -12UNJ -3A	1.875	2- 9/32
AN815-24	1-1/2	1-7/8 -12UNJ -3A	2.125	2-17/32
AN815-28	1-3/4	2-1/4 -12UNJ -3A	2.500	2-13/16
AN815-32	2	2-1/2 -12UNJ -3A	2.750	3- 1/16
AN815-40	2-1/2	3- 12UNJ -3A	3.250	2- 7/8
AN815-48	3	3-1/2 -12UNJ -3A	3.750	3- 1/16

APPROVED 3 FEB 41 REVISED 9 FOR CHANGES SEE PAGES 1 & 2.

<p>9 ENTIRE STANDARD REVISED</p>		<p>AIR FORCE-NAVY AERONAUTICAL STANDARD</p>	
<p>P. A. AIR FORCE-82 Other Code ARMY - AV NAVY - AS AIR FORCE-99</p>	<p>INTERNATIONAL INTEREST</p>	<p>UNION - FLARED TUBE</p>	
<p>PROCUREMENT SPECIFICATION MIL - F - 8509</p>		<p>SUPERSEDES:</p>	<p>AN815</p>
			<p>SHEET 2 OF 2</p>