INCH-POUND

AN785 Rev 7
4 August 2011
SUPERSEDING
AN785 Rev 6
14 August 1956

DETAIL SPECIFICATION SHEET

COUPLING, UNION, BRAZING

Inactive for new design after 24 July 1998.

This specification is approved for use by all Departments and Agencies of the Department of Defense.

The requirements for acquiring the product described herein shall consist of this specification sheet and MIL-DTL-6001.

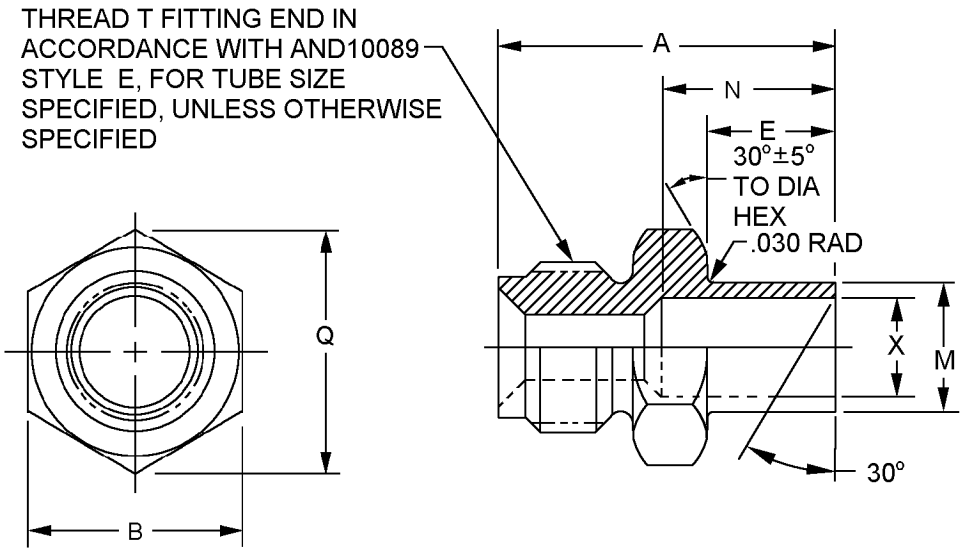

FIGURE 1. Coupling, union, brazing.

TABLE I. Dash numbers and size. 1/ 2/

Dash number		Tubing outside diameter	Thread T AND10089	A ±.015	B		E ±.015 Diameter	K +.005 -.002 Diameter	H Diameter	N ±.010	Q Reference	Weight Max	
Brass	Corrosion resistant steel											Brass	Corrosion resistant steel
2	C2	.125	.3125-32 UNEF-3A	.750	.438	±.003	.312	.125	.219	.375	.51		
3	C3	.188	.3750-24 UNF-3A	.938			.375	.191	.281	.438	.51		
4	C4	.250	.4375-20 UNF-3A	1.000	.500		.375	.257	.344	.500	.65		
5	C5	.312	.5000-20 UNF-3A	1.188	.625	±.004	.500	.323	.406	.562	.72		
6	C6	.375	.6250-18 UNF-3A	1.250	.750		.500	.386	.469	.625	.87		
8	C8	.500	.7500-16 UNF-3A	1.625	.875		.750	.516	.609	.875	1.01		
10	C10	.625	.9375-14 NS-3	1.688	1.000		.750	.641	.719	.875	1.09		

TABLE I. Dash numbers and size – Continued. 1/ 2/

Dash number		Tubing outside diameter	Thread T AND10089	A ±..381	B		E ±.381 Diameter	K +.127 -.051 Diameter	H Diameter	N ±.254	Q Reference	Weight Max	
Brass	Corrosion resistant steel											Brass	Corrosion resistant steel
2	C2	3.175	.3125-32 UNEF-3A	20.625	11.125	±..0762	7.925	3.175	5.563	9.525	12.954		
3	C3	4.267	.3750-24 UNF-3A	23.825			9.525	4.851	7.137	11.125	12.954		
4	C4	6.350	.4375-20 UNF-3A	25.400	14.275	±.1016	9.525	6.528	8.738	12.7	16.510		
5	C5	7.925	.5000-20 UNF-3A	26.975	15.875		12.70	8.204	10.312	14.275	18.288		
6	C6	9.525	.6250-18 UNF-3A	33.325	19.050		12.70	9.804	11.913	15.875	22.098		
8	C8	12.700	.7500-16 UNF-3A	38.100	22.225		19.05	13.106	15.469	22.225	25.654		
10	C10	15.875	.9375-14 NS-3	44.450	23.825		19.05	16.281	18.263	22.225	27.686		

1/ Dimensions are in inches
2/ Metric equivalents are given for information only.

REQUIREMENTS

Dimensions. See table I. Unless otherwise specified tolerances on decimals are ±.010, angles ±0.5°.

Configuration. See figure 1.

Inactive for new design. Dash numbers 12 and 16 are inactive for new design.
Dash numbers 2, 3 and 4 are inactive for new design except for use in oxygen systems and engine primer lines.
Dash numbers 5, 6, 8 and 10 are not to be used on engine primer lines.

Materials: Brass; bars, shapes or forgings.
Corrosion – resistant steel; bars, shapes or forgings.
See procurement specification.

Finish: See procurement specification.

Identification of product. Add P before the dash number for cadmium – plated brass nipple.

AN785 X X
- X: Size
- X: Material, finish
- AN785: Drawing number

Example of Part or Identifying Number (PIN): AN785-4 coupling – union, brass, for .250 tubing OD.
AN785P4 coupling – union, brass, cadmium plated, for .250 tubing OD.
AN785C4 coupling – union, corrosion resistant steel, for .250 tubing OD.

Workmanship. Break all sharp edges and remove all hanging burrs and slivers which might become dislodged under usage.

Changes from previous issue. Marginal notations are not used in this revision to identify changes with respect to the previous issue due to the extent of the changes.

Referenced documents. In addition to MIL-DTL-6001, this document references the following:

AND10089

CONCLUDING MATERIAL

Custodians:
Army – AR
Navy – SH
Air Force - 99
DLA - CC

Preparing activity:
DLA - CC

(Project 4730-2010-181)

Review activities:
Army – AT, AV, CR4
Navy – AS, CG, MC, SA, YD
Air Force - 71

NOTE: The activities listed above were interested in this document as of the date of this document. Since organizations and responsibilities can change, you should verify the currency of the information above using the ASSIST Online database at https://assist.daps.dla.mil.