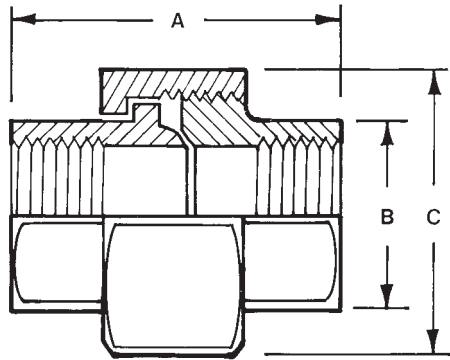


# Threaded Unions



- Unions and fittings shall be made from forgings or bar stock by machining or forging or by a combination of these operations.
- Unless otherwise specified, random samples shall be selected with lot acceptance based on sampling requirements of MIL-STD-105-D.
- Each of the samples shall be subjected to visual and dimensional inspection to determine compliance with the requirements of this drawing.
- Each fitting or component shall be capable of withstanding a hydro test pressure of  $1\frac{1}{2}$  times the rated working pressure with no leakage or deformation.
- The dimensions for manufacturing shall meet or exceed the minimum requirements of NAVSEA Dwg. 810-1385884-Rev. J., or MSS SP-83 (Ground joint unions).

## Class 3000

Nominal Pipe Size	A	B	C
$\frac{1}{4}$	$1\frac{5}{8}$	$\frac{7}{8}$	$1\frac{3}{8}$
$\frac{3}{8}$	$1\frac{13}{16}$	$1\frac{1}{32}$	$1\frac{5}{8}$
$\frac{1}{2}$	$1\frac{15}{16}$	$1\frac{1}{4}$	$1\frac{27}{32}$
$\frac{3}{4}$	$2\frac{1}{4}$	$1\frac{15}{32}$	$2\frac{3}{16}$
1	$2\frac{1}{2}$	$1\frac{5}{8}$	$2\frac{1}{2}$
$1\frac{1}{4}$	$1\frac{13}{16}$	$2\frac{1}{32}$	$3\frac{1}{16}$
$1\frac{1}{2}$	3	$2\frac{5}{16}$	$3\frac{13}{32}$
2	$3\frac{3}{8}$	$2\frac{27}{32}$	$4\frac{3}{32}$