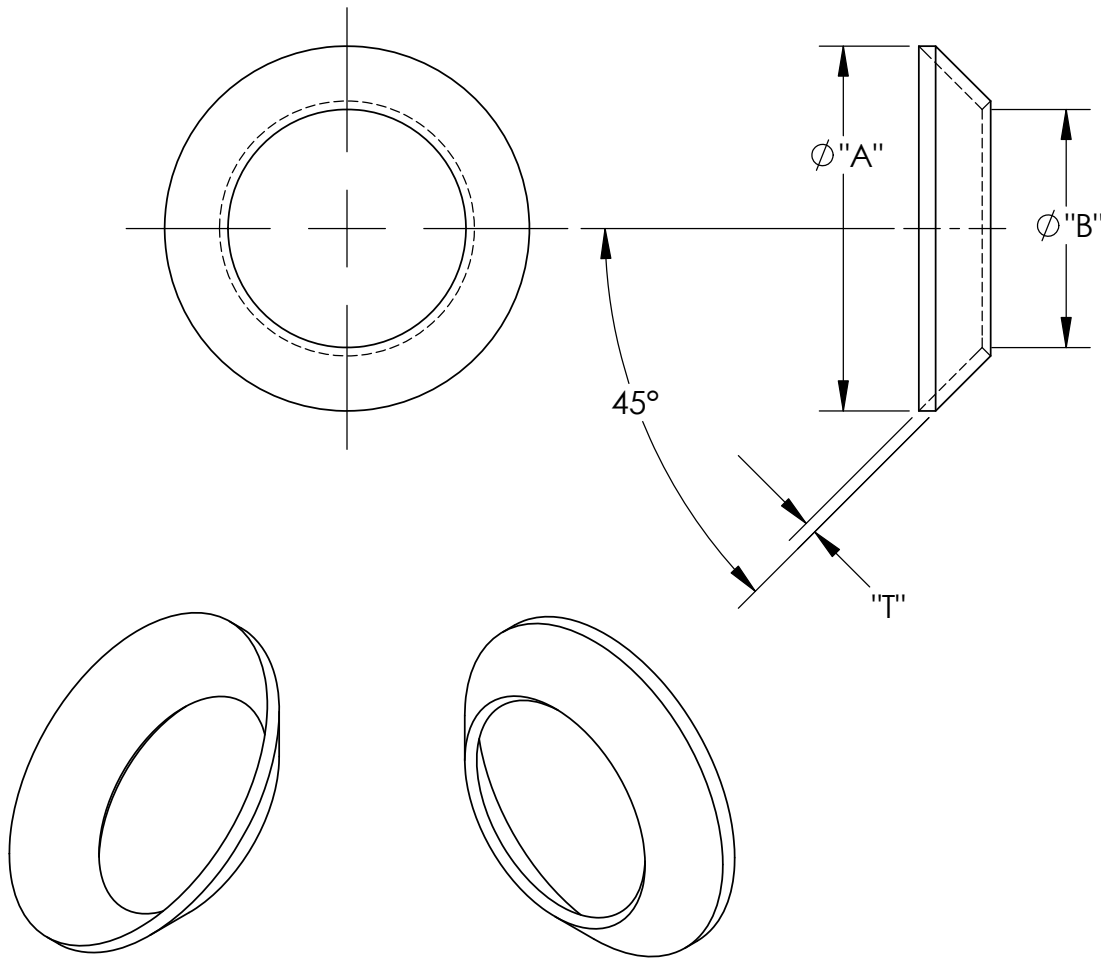


REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
01	Initial Release	5/18/2021	JL



SECO45 Dash No.	Nominal Tube OD	Nominal Tube OD mm	$\phi$ "A" $\pm 0.03$	$\phi$ "B" MAX	T $\pm .003$ Material Thickness	Lb./100 MAX Alum	Lb./100 MAX Copper	Lb./100 MAX Nickel	Lb./100 MAX Cres
3	3/16	4.76	0.31	0.12	.031	0.026	0.084	0.080	0.075
4	1/4	6.35	0.36	0.19	.031	0.029	0.094	0.089	0.084
5	5/16	7.94	0.42	0.22	.031	0.040	0.130	0.125	0.117
6	3/8	9.53	0.55	0.28	.031	0.071	0.234	0.223	0.210
8	1/2	12.70	0.66	0.41	.031	0.084	0.276	0.263	0.248
10	5/8	15.88	0.77	0.50	.031	0.108	0.355	0.339	0.319
12	3/4	19.05	0.95	0.62	.031	0.165	0.543	0.518	0.488

Dimensions In Inches Unless Otherwise Specified		DRAWING SIZE <b>A</b>		 <b>SECO SEALS, INC</b> sales@secoseals.com www.secoseals.com		1370 LOGAN AVE STE K COSTA MESA, CA. 92626 (714) 546-3478	
MAT'L: See Notes, Sheet 2	FSCM: 4730	INCHES DIMENSIONS IN INCHES 3RD ANGLE PROJECTION 		DESC.: Gasket, Flared Tube Fitting, 45 Degree		ECCN: 9A991.d	
TREATMENT: See Notes, Sheet 2 & Sheet 3				STANDARD: SECO45		DRAWN BY Joe Littel	
MAT'L SIZE: See Table, Sheet 1		DATE DRAWN 5/18/2021		SCALE 2:1		CHECKED BY Jim Scott	
US PATENT PENDING: 17/588239						SHEET 1 of 3	
TITLE: SECO45				REV. 01			

**NOTES:**

## 1. MATERIAL CODE LETTER:

## a. CODE LETTER A -

TYPE 1100-0, ANNEALED ALUMINUM SHEET PER AMS 4001.

## b. CODE LETTER C -

TYPE C10100, C10200 OR C11000, COLD-ROLLED ANNEALED COPPER FOIL OR STRIP, CHEMICAL COMPOSITION PER ASTM B 152 AND MECHANICAL PROPERTIES PER ASTM B 152M

## c. CODE LETTER N -

TYPE N02201 COLD-ROLLED ANNEALED NICKEL SHEET OR STRIP PER ASTM B 162 OR AMS 5553.

## d. CODE LETTER S -

TYPE S30500 ANNEALED CORROSION RESISTANT STEEL SHEET OR STRIP PER ASTM A 240.

## 2. HEAT TREATMENT:

## a. ALUMINUM - FULL ANNEAL AFTER FORMING PER AMS 2770.

b. COPPER - BRIGHT ANNEAL TO FULL SOFT CONDITION AFTER FORMING AT 1200 °F ± 25 °F FOR 45 TO 60 min IN A VACUUM FURNACE. PYROMETRY SHALL BE IN ACCORDANCE WITH AMS 2750.

c. NICKEL - BRIGHT ANNEAL TO FULL SOFT CONDITION AFTER FORMING AT 1500 °F ± 25 °F FOR 30 TO 60 min IN A VACUUM FURNACE, AND GASEOUS NITROGEN OR ARGON QUENCH. PYROMETRY SHALL BE IN ACCORDANCE WITH AMS 2750.

d. CORROSION RESISTANT STEEL - BRIGHT ANNEAL AFTER FORMING AT 1950 °F ± 25 °F FOR 15 TO 20 min IN A VACUUM FURNACE, AND GASEOUS NITROGEN OR ARGON QUENCH. PYROMETRY SHALL BE IN ACCORDANCE WITH AMS 2750.


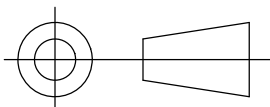
3. CLEANING, PACKAGING, AND IDENTIFICATION: SURFACES OF PART SHALL BE FREE OF OIL, GREASE, DIRT, AND OTHER FOREIGN MATERIALS. CAUTION: THESE PARTS ARE SOFT AND CAN BE EASILY DEFORMED OR DAMAGED. PACKAGE TO PREVENT DAMAGE IN HANDLING OR SHIPMENT. IDENTIFY PACKAGE WITH MANUFACTURER'S NAME, TRADEMARK OR CAGE CODE, BASIC PART NUMBER, AND QUANTITY OF PARTS.

4. THESE PARTS ARE SOFT AND EASILY DEFORMED, THEREFORE, DIMENSIONS "A" AND "B" SHALL NOT BE CONFIRMED IN THE FREE STATE CONDITION. FUNCTIONALITY AND FIT MAY BE VERIFIED BY INSTALLING THE GASKET ON A STANDARD FITTING END OF THE APPROPRIATE SIZE. AN OUT-OF-ROUND CONDITION, WHICH DOES NOT PREVENT INSTALLATION OF THE SEAL, SHALL NOT BE CAUSE FOR REJECTION.

5. ASSEMBLY TORQUE TECHNIQUE: IN ORDER TO COMPENSATE FOR YIELDING OF THE GASKET, RE-TORQUE THE NUT TO THE ORIGINAL TORQUE VALUE WITHIN 10 TO 15 s AFTER APPLICATION OF THE INITIAL TORQUE.

6. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M; REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, FORMED SURFACES TO BE 125 µm Ra.

7. DIMENSIONING AND TOLERANCING: ASME Y14.5M-1994.

Dimensions In Inches Unless Otherwise Specified		DRAWING SIZE		SECO SEALS, INC sales@secoseals.com www.secoseals.com		1370 LOGAN AVE STE K COSTA MESA, CA. 92626 (714) 546-3478	
MAT'L: See Notes Sheet 2	FSCM: 4730	<b>A</b>		TITLE: SECO45		REV. 01	
TREATMENT: See Notes, Sheet 2 & Sheet 3	INCHES DIMENSIONS IN INCHES 3RD ANGLE PROJECTION			DESC.: Gasket, Flared Tube Fitting, 45 Degree		ECCN: 9A991.d	
MAT'L SIZE: See Table, Sheet 1			STANDARD: SECO45		DRAWN BY: Joe Littel		CAGE CODE: 33447
US PATENT PENDING: 17/588239			DATE DRAWN: 5/18/2021	SCALE: 2:1	CHECKED BY: Jim Scott		SHEET 2 OF 3

8. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS +.015/-.000, ANGULAR DIMENSIONS ±0°30'.

9. PLATING CODE LETTER:

a. CODE LETTER T -  
TIN PLATE PER MIL-T-10727, TYPE 1 OR AMS2408-2

b. CODE LETTER S -  
SILVER MATTE (FLASH) PER AMS 2410 "K"

c. CODE LETTER G -  
GOLD 24K .00050 THICK PER MIL-G-45204 "C" AM#3, TY III, CL 5, GR A

10. CLEANING:

a. NO CODE LETTER  
PARTS NOT CLEANED FOR OXYGEN SERVICE

b. CODE LETTER L -  
CLEANED PER MIL 1330d LEVEL 100

c. CODE LETTER SP -  
SPECIALTY CLEANED PER CUSTOMER SPECIFICATION

11. PACKAGING

a. NO CODE LETTER  
PARTS PACKAGED IN PLASTIC TUBES OF 50 DASH 3 THROUGH DASH 12


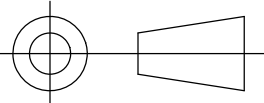
b. CODE LETTER X -  
INDIVIDUALLY PACKAGED ONE EACH IN A PLASTIC BOX

c. CODE LETTER V -  
PARTS PACKAGED IN PLASTIC TUBES OF 15 DASH 3 THROUGH DASH 12

12. EXAMPLE OF PART NUMBER: SECO45 C T 8 L X



13. SECO45 IS INTENDED FOR USE ON 45° FLARE TUBE FITTING ENDS PER SAE J512 AND J513

Dimensions In Inches Unless Otherwise Specified		DRAWING SIZE <b>A</b>	 <b>SECO SEALS, INC</b> sales@secoseals.com www.secoseals.com		<b>1370 LOGAN AVE STE K</b> <b>COSTA MESA, CA. 92626</b> <b>(714) 546-3478</b>	
MAT'L: See Notes Sheet 2	FSCM: 4730	<b>INCHES</b> DIMENSIONS IN INCHES 3RD ANGLE PROJECTION 	TITLE: SECO45		REV. 01	
TREATMENT: See Notes, Sheet 2 & Sheet 3	DESC.: Gasket, Flared Tube Fitting, 45 Degree		ECCN: 9A991.d			
MAT'L SIZE: See Table, Sheet 1	STANDARD: SECO45		DRAWN BY: Joe Littel		CAGE CODE: 33447	
US PATENT PENDING: 17/588239	DATE DRAWN: 5/18/2021		SCALE: 2:1		CHECKED BY: Jim Scott	SHEET 3 OF 3