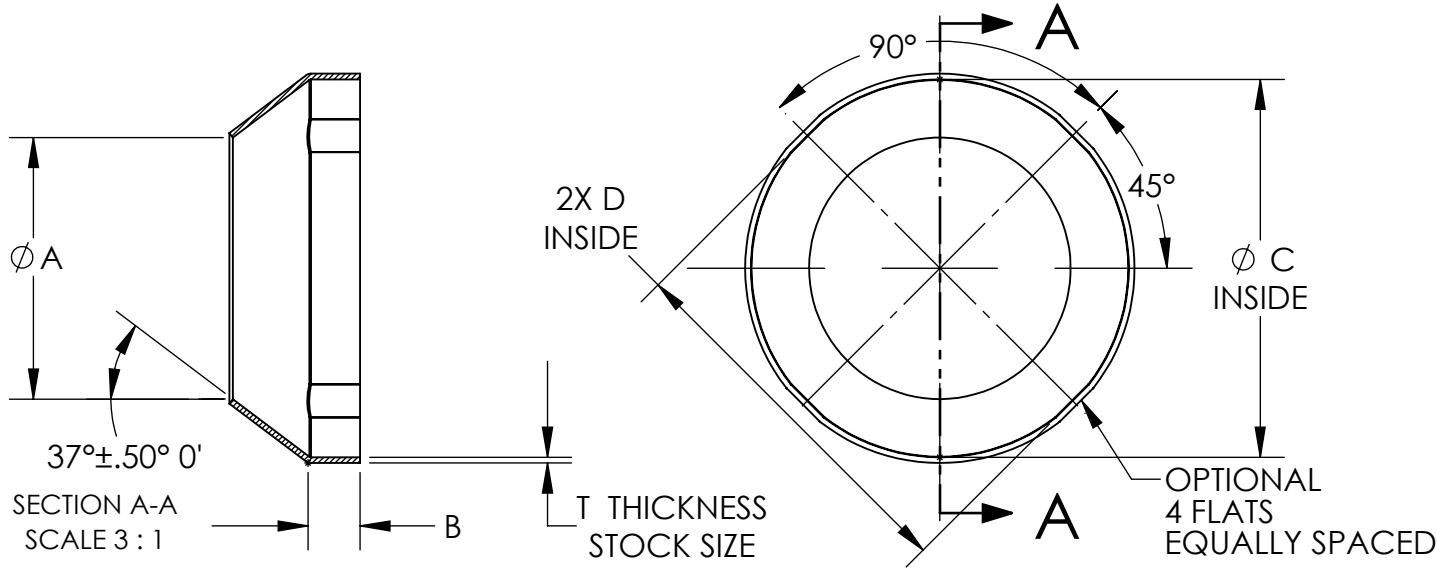


REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
—	Initial Release	11/13/2024	JS



SECO7 Dash No.	Tube Size O.D.	Nom Tube OD	Nom Tube OD mm	Ø A +0.015 -0.000	B +0.000 -0.015	Ø C +0.005 -0.000	D +0.001 -0.004	T Mat'l Thk. +0.000 -0.005				
2	1/8	.125	3.18	Ø .105	.062	Ø .244	.237	.007				
3	3/16	.188	4.78	Ø .168	.062	Ø .306	.299	.007				
4	1/4	.250	6.35	Ø .215	.077	Ø .358	.351	.007				
5	5/16	.313	7.94	Ø .277	.077	Ø .420	.413	.007				
6	3/8	.375	9.53	Ø .340	.077	Ø .477	.468	.007				
7	7/16	.438	11.11	Ø .403	.077	Ø .538	.531	.007				
8	1/2	.500	12.70	Ø .448	.097	Ø .653	.646	.012				
9	9/16	.563	14.30	Ø .531	.097	Ø .721	.714	.012				
10	5/8	.625	15.88	Ø .565	.107	Ø .766	.759	.012				
11	11/16	.688	17.46	Ø .627	.107	Ø .881	.874	.012				
12	3/4	.750	19.05	Ø .689	.107	Ø .937	.930	.012				
14	7/8	.875	22.23	Ø .828	.107	Ø 1.069	1.062	.012				
16	1	1.000	25.40	Ø .938	.127	Ø 1.187	1.180	.012				
18	1 1/8	1.125	28.58	Ø 1.048	.127	Ø 1.374	1.367	.012				
20	1 1/4	1.250	31.75	Ø 1.177	.127	Ø 1.500	1.493	.012				
22	1 3/8	1.375	34.93	Ø 1.289	.127	Ø 1.625	1.617	.012				
24	1 1/2	1.500	38.10	Ø 1.412	.127	Ø 1.750	1.742	.012				
28	1 3/4	1.750	44.45	Ø 1.682	.127	Ø 2.125	2.117	.012				
32	2	2.000	50.80	Ø 1.915	.127	Ø 2.375	2.367	.012				
40	2 1/2	2.500	63.50	Ø 2.502	.057	Ø 2.881	2.874	.017				
44	2 3/4	2.750	69.85	Ø 2.744	.057	Ø 3.131	3.124	.017				
48	3	3.000	76.20	Ø 2.992	.057	Ø 3.381	3.374	.017				

Dimensions In Inches Unless Otherwise Specified		DRAWING SIZE <b>A</b>		SECO SEALS, INC sales@secoseals.com www.secoseals.com		1370 LOGAN AVE STE K COSTA MESA, CA. 92626 (714) 546-3478	
MAT'L: See Note Sheet 2	FSC: 4730			TITLE: SECO5007		REV. —	
TREATMENT: See Note Sheet 2 & Sheet 3	INCHES DIMENSIONS IN INCHES 3RD ANGLE PROJECTION 	DESC.: SECO5007 Xylan 1424 .001" Coating			ECCN: 9A991.d		
MAT'L SIZE: See Table		STANDARDS: SECO7 - AS4824	DRAWN BY Joe Littel		CAGE CODE: 33447		
		DATE DRAWN 11/13/2024	SCALE 2:1	CHECKED BY Jim Scott	SHEET 1 of 3		

**NOTES:**

1. MATERIAL CODE LETTER:

a. CODE LETTER A - ALUMINUM (BLUE)

TYPE 1100-0, ANNEALED ALUMINUM GRADE B FOIL PER QQ-A-1876, FOR .005 THICK.  
TYPE 1100-0, ANNEALED ALUMINUM SHEET PER AMS 4001, FOR .010 THICK.

b. CODE LETTER C - COPPER (GREEN)

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 - NICKEL (ORANGE)

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

d. CODE LETTER S - STAINLESS STEEL (BLACK)

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", "B", AND "C" 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. THESE PARTS ARE INTENDED FOR USE WITH STANDARD 37 DEGREE FLARE FITTING ENDS PER AS4395 (MS23485) OR AS4396 (MS23486) OF APPROPRIATE SIZE. THESE PARTS ARE INTENDED FOR ONE TIME USE ONLY.

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.

	<b>SECO SEALS, INC.</b> sales@secoseals.com www.secoseals.com		<b>1370 LOGAN AVE. UNIT K</b> <b>COSTA MESA, CA. 92626</b> <b>(714) 546-3478</b>	
	FILE NAME: SECO5007			REV. _____
DATE DRAWN 11/13/2024	SCALE N/A	DRAWN BY Joe Littel	SHEET 2 OF 3	

6. COATING CODE:

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

b. CODE LETTER X24 -  
Xylan 1424 as per ASTM B117, ASTM D406 & MIL-PRF-46147.

NOTE: SECO5007 XYLAN 1424 COATING APPLIED PER SECO 5500

7. CLEANING:

a. NO CODE LETTER  
PARTS NOT CLEANED FOR OXYGEN SERVICE

b. CODE LETTER L -  
CLEANED PER MIL 1330 REV. D

c. CODE LETTER SP -  
SPECIALTY CLEANED PER CUSTOMER SPECIFICATION

8. PACKAGING

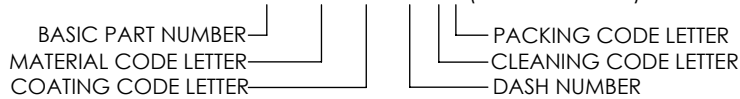
a. NO CODE LETTER  
PARTS PACKAGED IN PLASTIC TUBES OF 50 DASH 2 THROUGH DASH 6  
PARTS PACKAGED IN PLASTIC TUBES OF 25 DASH 7 THROUGH DASH 24  
PARTS PACKAGED IN PLASTIC BOXES OF 10 DASH 28 THROUGH DASH 48

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

c. CODE LETTER V -  
PARTS PACKAGED IN PLASTIC TUBES OF 15 DASH 2 THROUGH DASH 16

9. EXAMPLE OF PART NUMBER:

- a. SECO5007 A 1424 -08 L X (ALUMINUM)
- b. SECO5007 C 1424 -08 L X (COPPER)
- c. SECO5007 N 1424 -08 L X (NICKEL)
- d. SECO5007 S 1424 -08 L X (STAINLESS STEEL)



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	FILE NAME: SECO5007			REV. _____
DATE DRAWN 11/13/2024	SCALE N/A	DRAWN BY Joe Littell	SHEET 3 OF 3	