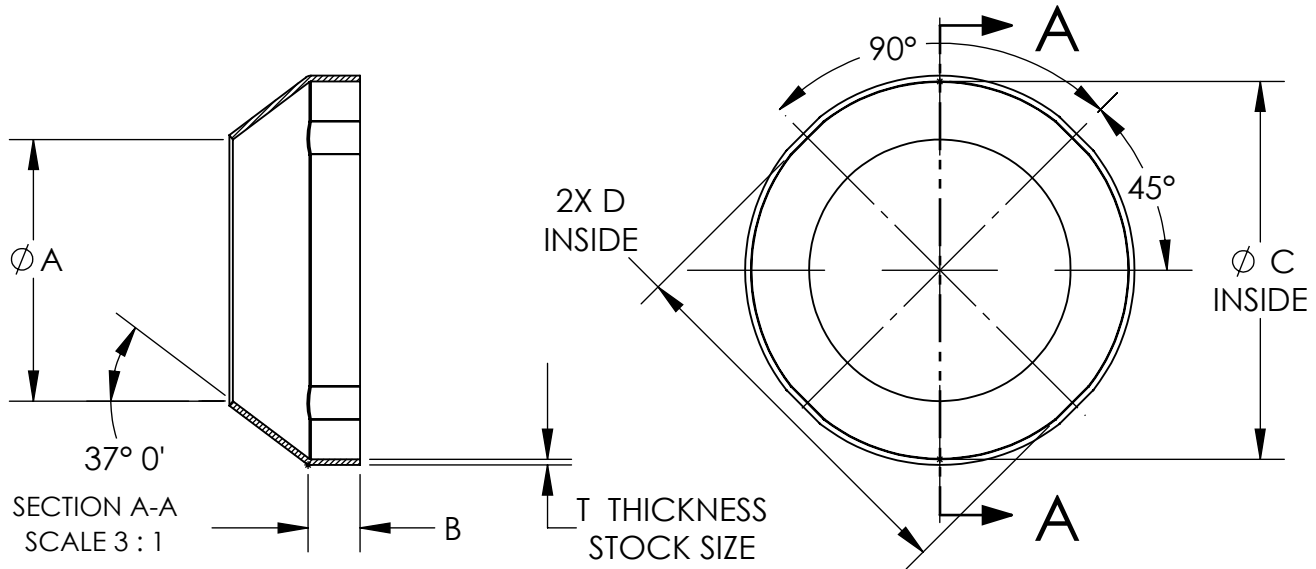


REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
H	Add Notes, Pages 2 & 3, added weights / 100 to Chart & "A" REF to Chart & Views.	11/13/2024	JS



PART WEIGHT / MATERIAL USED

SECO7 Dash No.	Tube Size O.D.	Nom Tube OD	Nom Tube OD mm	ϕA +0.015 -0.000	B +0.000 -0.015	ϕC +0.005 -0.000	D +0.001 -0.004	T Material Thickness	Lb./100 MAX Alum	Lb./100 MAX Copper	Lb./100 MAX Nickel	Lb./100 MAX Cres
2	1/8	.125	3.18	ϕ .103	.060	ϕ .245	.240	.005	0.0100	0.0330	0.0328	0.0296
3	3/16	.188	4.78	ϕ .166	.060	ϕ .307	.302	.005	0.0127	0.0420	0.0417	0.0377
4	1/4	.250	6.35	ϕ .213	.075	ϕ .359	.354	.005	0.0179	0.0590	0.0586	0.0530
5	5/16	.313	7.94	ϕ .275	.075	ϕ .421	.416	.005	0.0252	0.0830	0.0825	0.0745
6	3/8	.375	9.53	ϕ .338	.075	ϕ .476	.471	.005	0.0349	0.115	0.114	0.103
7	7/16	.438	11.11	ϕ .401	.075	ϕ .539	.534	.005	0.0455	0.150	0.149	0.135
8	1/2	.500	12.70	ϕ .446	.095	ϕ .654	.649	.010	0.0558	0.184	0.183	0.165
9	9/16	.563	14.30	ϕ .529	.095	ϕ .722	.717	.010	0.0789	0.260	0.258	0.233
10	5/8	.625	15.88	ϕ .562	.105	ϕ .767	.762	.010	0.106	0.349	0.347	0.313
11	11/16	.688	17.46	ϕ .625	.105	ϕ .882	.877	.010	0.129	0.425	0.422	0.382
12	3/4	.750	19.05	ϕ .687	.105	ϕ .938	.933	.010	0.162	0.534	0.531	0.479
14	7/8	.875	22.23	ϕ .826	.105	ϕ 1.070	1.065	.010	0.186	0.612	0.608	0.479
16	1	1.000	25.40	ϕ .936	.125	ϕ 1.188	1.183	.010	0.221	0.730	0.725	0.655
18	1 1/8	1.125	28.58	ϕ 1.046	.125	ϕ 1.375	1.370	.010	0.248	0.817	0.812	0.734
20	1 1/4	1.250	31.75	ϕ 1.175	.125	ϕ 1.501	1.496	.010	0.295	0.971	0.965	0.872
22	1 3/8	1.375	34.93	ϕ 1.287	.125	ϕ 1.625	1.620	.010	0.328	1.085	1.03	1.025
24	1 1/2	1.500	38.10	ϕ 1.410	.125	ϕ 1.750	1.745	.010	0.394	1.30	1.29	1.17
28	1 3/4	1.750	44.45	ϕ 1.680	.125	ϕ 2.125	2.120	.010	0.543	1.79	1.78	1.61
32	2	2.000	50.80	ϕ 1.913	.125	ϕ 2.375	2.370	.010	0.646	2.13	2.12	1.91
40	2 1/2	2.500	63.50	ϕ 2.500	.055	ϕ 2.882	2.877	.015	0.816	2.69	2.57	2.55
44	2 3/4	2.750	69.85	ϕ 2.742	.055	ϕ 3.132	3.127	.015	0.906	2.98	2.85	2.83
48	3	3.000	76.20	ϕ 2.990	.055	ϕ 3.382	3.377	.015	0.986	3.25	3.10	3.08

Dimensions In Inches Unless Otherwise Specified		DRAWING SIZE A	 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	INCHES DIMENSIONS IN INCHES 3RD ANGLE PROJECTION 	TITLE: SECO7		REV. H	
TREATMENT: See Note Sheet 2 & Sheet 3	DESC.: Seal, Conical Flared Fitting, 37 Degree			ECCN: 9A991.d		
MAT'L SIZE: See Table	STANDARDS: SECO7		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 -

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 -

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", "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.

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.

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MAT'L: See Note Sheet 2	FSC: 4730			TITLE: SECO7	REV. H
TREATMENT: See Note Sheet 2 & Sheet 3	INCHES DIMENSIONS IN INCHES 3RD ANGLE PROJECTION 	DESC.: Seal, Conical Flared Fitting, 37 Degree	ECCN: 9A991.d		
MAT'L SIZE: See Table Sheet 1		STANDARD: SECO7	DRAWN BY Joe Littel	CAGE CODE: 33447	
		DATE DRAWN 11/13/2024	SCALE 2:1	CHECKED BY Jim Scott	SHEET 2 OF 3

8. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS +.015/-0.000, 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

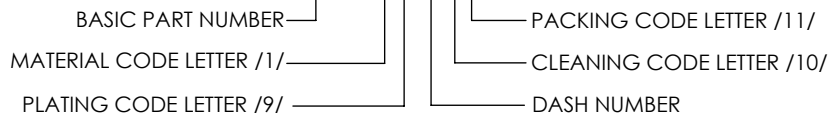
10. CLEANING:

- a. NO CODE LETTER
PARTS NOT CLEANED FOR OXYGEN SERVICE
- b. CODE LETTER L -
CLEANED PER MIL 1330 REV. D
- c. CODE LETTER SP -
SPECIALTY CLEANED PER CUSTOMER SPECIFICATION

11. 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

12. EXAMPLE OF PART NUMBER: SECO7 CT 8 LX



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MAT'L: See Note Sheet 2	FSC: 4730		TITLE: SECO7	REV. H	
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MAT'L SIZE: See Table Sheet 1		STANDARD: SECO7	DRAWN BY Joe Littel	CAGE CODE: 33447	
		DATE DRAWN 11/13/2024	SCALE 2:1	CHECKED BY Jim Scott	SHEET 3 OF 3