

REV.
B

AS1985

FEDERAL SUPPLY CLASS
4730

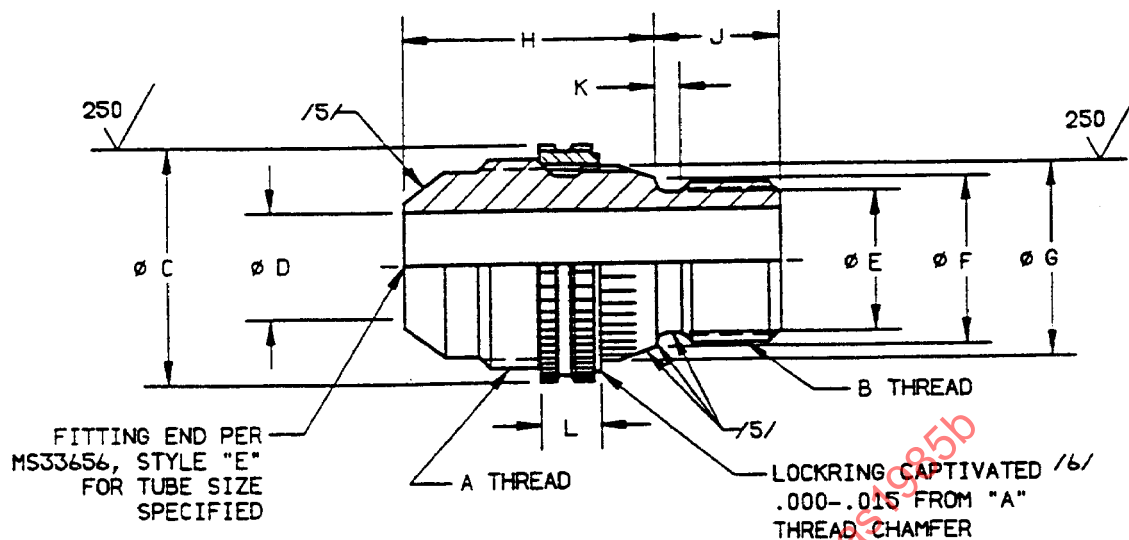


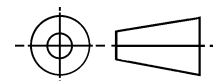
FIGURE 1 - ADAPTER, ASSEMBLY

TABLE 1A - DIMENSIONS

BASIC NO. AS1985 /15/ SIZE CODE	(NOMINAL TUBE SIZE)	A THREAD MIL-S-8879	B THREAD MIL-S-8879	C	(D)	E +.005 -.002	F MIN	(G)
02	.125	.3125-24UNJF-3A	.2160-28UNJF-3A	.400	.058-.065	.154	.246	.317
03	.188	.3750-24UNJF-3A	.2500-28UNJF-3A	.468	.121-.128	.186	.278	.349
04	.250	.4375-20UNJF-3A	.3125-24UNJF-3A	.514	.168-.175	.239	.331	.400
05	.312	.5000-20UNJF-3A	.3750-24UNJF-3A	.624	.230-.237	.301	.393	.491
06	.375	.5625-18UNJF-3A	.4375-20UNJF-3A	.700	.293-.301	.364	.456	.544
08	.500	.7500-16UNJF-3A	.5625-18UNJF-3A	.814	.387-.395	.482	.574	.670
10	.625	.8750-14UNJF-3A	.6875-24UNJEF-3A	1.040	.480-.488	.625	.717	.824
12	.750	1.0625-12UNJ-3A	.8125-20UNJEF-3A	1.170	.604-.614	.737	.891	.981
16	1.000	1.3125-12UNJ-3A	1.1250-18UNJEF-3A	1.456	.839-.851	1.000	1.154	1.251
20	1.250	1.6250-12UNJ-3A	1.3125-18UNJEF-3A	1.782	1.073-1.086	1.225	1.379	1.466
24	1.500	1.8750-12UNJ-3A	1.6250-18UNJEF-3A	2.031	1.307-1.320	1.502	1.656	1.768
32	2.000	2.5000-12UNJ-3A	2.1250-16UNJ-3A	2.548	1.776-1.791	2.040	2.194	2.311

SAE100
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THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ MIL-F-5509

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

ADAPTER, ASSEMBLY - PORT CONNECTION
RING LOCKED TO FLARED TUBE END

AS1985
SHEET 1 OF 3

**REV.
B**

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AS1985

TABLE 1B - DIMENSIONS AND WEIGHTS

BASIC NO. AS1985 /15/ SIZE CODE	H +.010 -.005	J +.000 -.015	K +.010 -.005	L ±.007	WEIGHT LB/EA MAX
02	.743	.300	.125	.192	.010
03	.774	.355	.125	.192	.014
04	.845	.355	.125	.192	.017
05	.845	.381	.125	.192	.023
06	.872	.395	.125	.210	.028
08	.973	.430	.125	.210	.047
10	1.074	.465	.125	.210	.077
12	1.190	.527	.157	.220	.110
16	1.237	.564	.157	.220	.163
20	1.311	.569	.157	.240	.245
24	1.435	.608	.157	.240	.282
32	1.726	.730	.157	.240	.612

NOTES:

1. MATERIAL:

- a. FITTING: 6Al-4V TITANIUM ALLOY PER AMS 4928, AMS 4965, OR AMS 4967
- b. LOCKRING: A286 CORROSION RESISTANT STEEL PER AMS 5731 OR AMS 5734

2. HEAT TREATMENT:

- a. FITTING: 130 ksi UTS MIN
- b. LOCKRING: 34 TO 40 HRC

3. FINISH:

- a. FITTING: ANODIC TREATMENT PER AMS 2488, TYPE 2
- b. LOCKRING: PASSIVATE PER QQ-P-35, TY II

/4/ PROCUREMENT SPECIFICATION: MIL-F-5509 EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION IN A COMPLETE ASSEMBLY. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENTS SHEET OR SIMILAR MEANS.

/5/ SEALING SURFACE: NO VISIBLE DEFECTS. TO BE PROTECTED FOR SHIPMENT.

/6/ LOCKRING RETAINED ON FITTING BY CONTROLLED INTERFERENCE FIT.

7. IDENTIFICATION PER AS478 CLASS 35D, NAME, TRADEMARK, OR CAGE CODE AND PART NUMBER.

8. WORKING PRESSURE: THIS PART IS DESIGNED FOR USE IN 4000 psi WORKING PRESSURE SYSTEMS COMPATIBLE WITH TITANIUM.

9. ADAPTERS TO BE INSTALLED PER AS1301 INTO BOSS CAVITIES PER AS1300.

10. INTERPRETATION OF DRAWING PER ARP4296.

11. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36; REQUIREMENTS PER ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 μ in Ra AND SEALING SURFACE TO BE 63 μ in Ra.

12. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.