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AS1300

FEDERAL SUPPLY CLASS
4730

RATIONALE

REVISED TO CLARIFY NOTE FOR MINIMUM BOSS DIAMETER AND TO UPDATE THE STANDARD.

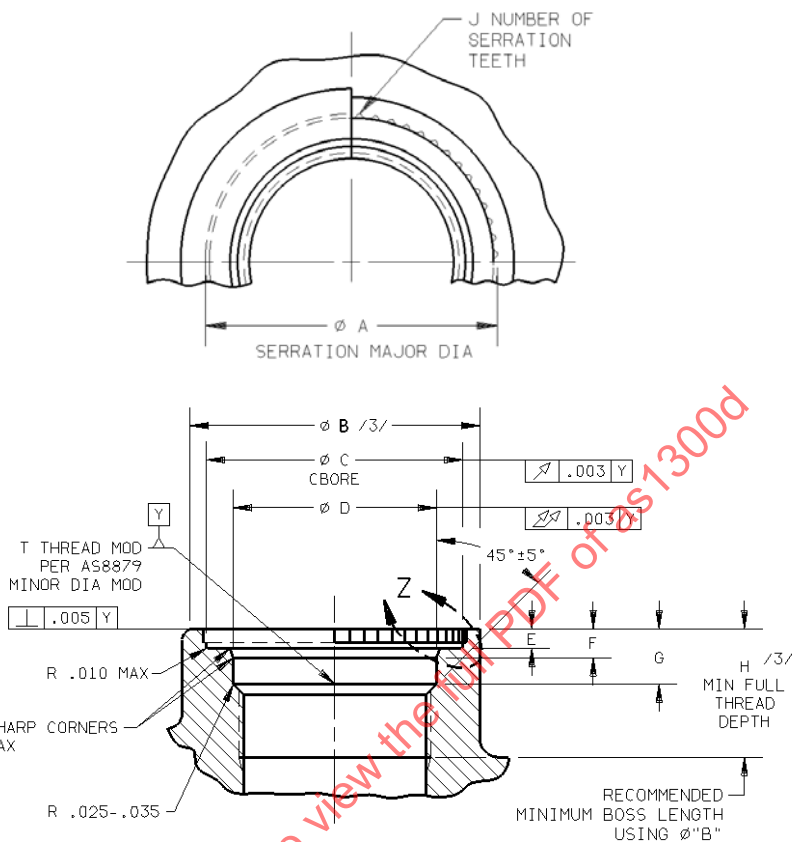
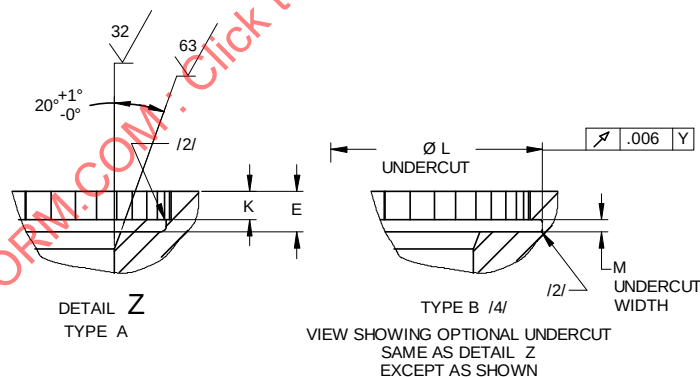
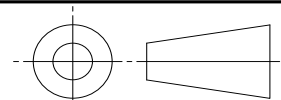


FIGURE 1 - PORT



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on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS1300D>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: NONE



AEROSPACE STANDARD

PORT - RING LOCKED FLUID
CONNECTION TYPE
STANDARD DIMENSIONS FOR

AS1300
SHEET 1 OF 3

REV.
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TABLE 1A - THREADS AND DIMENSIONS A-E

BASIC NO. AS1300 /12/ SIZE CODE	(TUBE OD)	T THREAD		A MIN	B MIN	C	D	E
		AS8879 CLASS-3B	MINOR DIA MOD					
02	.125	.2160-28UNJF	.1827- .1857	.408	.50	.381- .384	.254- .256	.093
03	.188	.2500-28UNJF	.2167- .2197	.478	.62	.448- .451	.286- .288	.093
04	.250	.3125-24UNJF	.2734- .2764	.524	.68	.495- .498	.339- .341	.093
05	.312	.3750-24UNJF	.3359- .3389	.635	.79	.601- .604	.401- .403	.093
06	.375	.4375-20UNJF	.3903- .3933	.710	.85	.675- .678	.464- .466	.108
08	.500	.5625-18UNJF	.5099- .5129	.826	1.04	.784- .787	.582- .584	.108
10	.625	.6875-24UNJEF	.6484- .6514	1.052	1.17	1.015-1.018	.725- .727	.108
12	.750	.8125-20UNJEF	.7653- .7683	1.182	1.42	1.139-1.142	.899- .901	.108
14	.875	.9375-20UNJEF	.8903- .8933	1.354	1.54	1.311-1.314	1.030-1.032	.108
16	1.000	1.1250-18UNJEF	1.0714-1.0744	1.471	1.67	1.427-1.430	1.162-1.164	.108
20	1.250	1.3125-18UNJEF	1.2599-1.2629	1.795	1.98	1.750-1.753	1.387-1.389	.135
24	1.500	1.6250-18UNJEF	1.5724-1.5754	2.045	2.23	2.000-2.005	1.664-1.666	.135
32	2.000	2.1250-16UNJ	2.0627-2.0657	2.561	2.86	2.516-2.521	2.202-2.204	.135

TABLE 1B - DIMENSIONS F-M AND TOOLING

BASIC NO. AS1300 /12/ SIZE CODE	F	G	H	J	K MIN	L	M REF	TOOLING /4/		
								PORTING TOOL NO.	BROACHING TOOL NO.	CHIP REMOVAL TOOL
02	.153-.158	.296-.301	.507	24	.061	.418	.032	RPT02	RFOPB5002HDB	RF02CR
03	.153-.158	.296-.301	.568	26	.061	.488	.032	RPT03	RFOPB5003HDB	RF03CR
04	.153-.158	.296-.301	.568	30	.061	.534	.032	RPT04	RFOPB5004HDB	RF04CR
05	.153-.158	.296-.301	.594	36	.061	.645	.032	RPT05	RFOPB5005HDB	RF05CR
06	.168-.173	.311-.316	.631	36	.073	.720	.035	RPT06	RFOPB5006HDB	RF06CR
08	.168-.173	.311-.316	.672	40	.073	.831	.035	RPT08	RFOPB5008HDB	RF08CR
10	.168-.173	.311-.316	.693	38	.073	1.062	.035	RPT10	RFOPB5010HDB	RF10CR
12	.168-.173	.343-.348	.763	40	.073	1.192	.035	RPT12	RFOPB5012HDB	RF12CR
14	.168-.173	.343-.348	.800	50	.073	1.364	.035	RPT14	RFOPB5014HDB	RF14CR
16	.168-.173	.343-.348	.806	36	.073	1.481	.035	RPT16	RFOPB5016HDB	RF16CR
20	.195-.200	.375-.380	.838	56	.093	1.805	.042	RPT20	RFOPB5020HDB	RF20CR
24	.195-.200	.375-.380	.877	81	.093	2.055	.042	RPT24	RFOPB5024HDB	RF24CR
32	.236-.241	.416-.421	1.050	102	.093	2.571	.042	RPT32	RFOPB5032HDB	RF32CR

NOTES:

1. THE DRILL AND PORTING TOOL METHOD OF PREPARING THE MACHINED CAVITY IS MANDATORY FOR USE WITH RING-LOCKED FITTING INSTALLED IN ACCORDANCE WITH AS1301. DRILL .015-.030 SMALLER THAN MINOR DIA MODIFIED SPECIFIED. THE PORTING TOOL WILL SIZE THE MINOR DIA AND PROVIDE BALANCE OF CAVITY CONFIGURATION READY FOR BROACHING SERRATION.
- /2/ AFTER SERRATIONS ARE BROACHED DIMENSION 'E' APPLIES, CHIP AND DEFORMED MATERIAL REMOVAL IS REQUIRED. THE CHIP REMOVAL TOOL MAY NOT BE REQUIRED FOR TYPE B UNDERCUT PORT FITTING GEOMETRY.



AEROSPACE STANDARD

PORT - RING LOCKED FLUID
CONNECTION TYPE
STANDARD DIMENSIONS FOR

AS1300
SHEET 2 OF 3

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