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REV.
C

AS1368™

FEDERAL SUPPLY CLASS
4730

RATIONALE

THIS TECHNICAL REPORT IS BEING STABILIZED BECAUSE IT COVERS TECHNOLOGY, PRODUCTS, OR PROCESSES WHICH ARE MATURE AND NOT LIKELY TO CHANGE IN THE FORESEEABLE FUTURE.

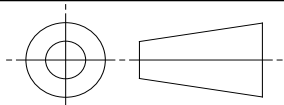
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THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: KSC-F-124 /4/



AEROSPACE STANDARD

FITTING, REDUCER-EXTERNAL
THREAD FLARED TUBE
FOR SEAL RING

AS1368™

REV.
C

ISSUED 1976-07 REAFFIRMED 2001-12 REVISED 2006-07 STABILIZED 2024-01

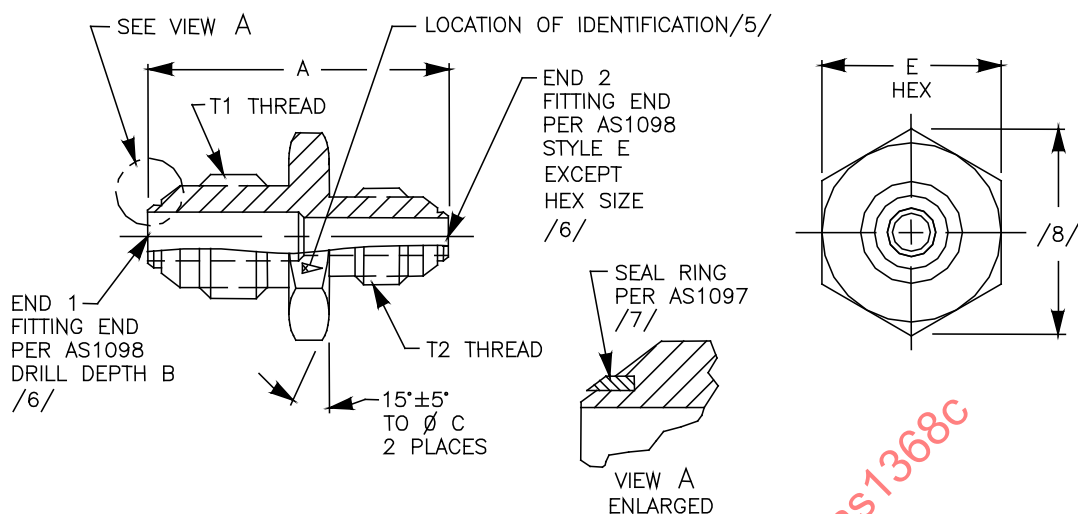


FIGURE 1 - FITTING, REDUCER - EXTERNAL THREAD FLARED TUBE

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NUMBER AS1368 /16/ SIZE CODE	(NOMINAL TUBE SIZE) END 1	T1 THREAD PER AS8879 CLASS 3A END 1	(NOMINAL TUBE SIZE) END 2	T2 THREAD PER AS8879 CLASS 3A END 2	A + .000 - .009	B MAX	C ± .010	E	LB/EA APPROX REF ALUM	LB/EA APPROX REF CRES
0604	.375	.5625-18UNJF	.250	.4375-20UNJF	1.422	.457	.792	.802-.815	.0279	.081
0804	.500	.7500-16 UNJF	.250	.4375-20UNJF	1.547	.538	.980	.990-1.003	.0462	.134
0806	.500	.7500-16 UNJF	.375	.5625-18UNJF	1.547	.538	.980	.990-1.003	.0493	.143
1004	.625	.8750-14 UNJF	.250	.4375-20UNJF	1.672	.618	1.103	1.113-1.128	.0596	.173
1006	.625	.8750-14 UNJF	.375	.5625-18UNJF	1.672	.618	1.103	1.113-1.128	.0627	.182
1008	.625	.8750-14 UNJF	.500	.7500-16 UNJF	1.766	.618	1.103	1.113-1.128	.0703	.204
1204	.750	1.0625-12UNJ	.250	.4375-20UNJF	1.813	.703	1.353	1.363-1.380	.1023	.297
1206	.750	1.0625-12UNJ	.375	.5625-18UNJF	1.813	.703	1.353	1.363-1.380	.1023	.297
1208	.750	1.0625-12UNJ	.500	.7500-16 UNJF	1.907	.703	1.353	1.363-1.380	.112	.325
1210	.750	1.0625-12UNJ	.625	.8750-14 UNJF	2.016	.703	1.353	1.363-1.380	.115	.333
1604	1.000	1.3125-12UNJ	.250	.4375-20UNJF	1.860	.741	1.603	1.613-1.630	.143	.414
1608	1.000	1.3125-12UNJ	.500	.7500-16 UNJF	2.172	.741	1.603	1.613-1.630	.150	.435
1610	1.000	1.3125-12UNJ	.625	.8750-14 UNJF	2.063	.741	1.603	1.613-1.630	.157	.456
1612	1.000	1.3125-12UNJ	.750	1.0625-12UNJ	2.172	.741	1.603	1.613-1.630	.167	.484
2004	1.250	1.6250-12UNJ	.250	.4375-20UNJF	1.907	.778	1.853	1.863-1.880	.189	.549
2012	1.250	1.6250-12UNJ	.750	1.0625-12UNJ	2.266	.778	1.853	1.863-1.880	.198	.574
2016	1.250	1.6250-12UNJ	1.000	1.3125-12UNJ	2.266	.778	1.853	1.863-1.880	.231	.670
2416	1.500	1.8750-12UNJ	1.000	1.3125-12UNJ	2.375	.878	2.099	2.109-2.135	.337	.977
2420	1.500	1.8750-12UNJ	1.250	1.6250-12UNJ	2.422	.878	2.099	2.109-2.135	.316	.916
2820	1.750	2.2500-12UNJ	1.250	1.6250-12UNJ	2.598	.978	2.474	2.484-2.510	.560	1.625
2824	1.750	2.2500-12UNJ	1.500	1.8750-12UNJ	2.723	.978	2.474	2.484-2.510	.646	1.875
3224	2.000	2.5000-12UNJ	1.500	1.8750-12UNJ	2.848	1.078	2.724	2.734-2.760	.715	2.075
3228	2.000	2.5000-12UNJ	1.750	2.2500-12UNJ	2.973	1.078	2.724	2.734-2.760	.698	2.025

NOTES:

/1/ MATERIAL:

- a. CODE LETTER D: TYPE 2024-T6 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6 OR AMS 4112; OR, TYPE 2024-T851 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6.
- b. CODE LETTER J: 304 CORROSION RESISTANT STEEL BAR PER AMS-QQ-763 OR AMS 5639.
- c. CODE LETTER K: 316 CORROSION RESISTANT STEEL BAR PER AMS-QQ-763 OR AMS 5648.
- d. CODE LETTER R: 321 CORROSION RESISTANT STEEL BAR PER AMS-QQ-763 OR AMS 5645.
- e. CODE LETTER S: 347 CORROSION RESISTANT STEEL BAR PER AMS-QQ-763 OR AMS 5646.
- f. CODE LETTER W: TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9 OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS 4124.

2. HEAT TREAT:

- a. ALL CODE LETTERS: NONE

3. FINISH:

- a. MATERIAL CODE LETTER D: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2, DYE BLUE AND DUPLEX SEAL PER PROCUREMENT SPECIFICATION.
- b. MATERIAL CODE LETTER J, K, R AND S; PASSIVATE PER AMS 2700, TYPE 6 OR TYPE 7.
- c. MATERIAL CODE LETTER W: ANODIZE PER AMS 2472 OR MIL-A-8625, TYPE II, CLASS 2, DYE BROWN, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.

/4/ PROCUREMENT SPECIFICATION: KSC-F-124 JOHN F KENNEDY SPACE CENTER, NASA, SPECIFICATION FOR FITTINGS (PRESSURE CONNECTIONS), FLARED TUBE. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER LISTED IN "PERFORMANCE REVIEW INSTITUTE" (PRI) "QUALIFIED MANUFACTURER LIST" (QML) FOR THIS TYPE PRODUCT. THE QML IS AVAILABLE AT www.eauditnet.com. NADCAP QML AS7112, 7112/2.

/5/ IDENTIFICATION: MARK PER AS478 CLASS C OR CLASS D; METHOD 7A3, 15A3 OR 15B.

- a. FOR SIZES 06 (.375 OD TUBE SIZE) AND SMALLER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, LETTERS "AS" AND MATERIAL CODE LETTER.
- b. FOR SIZES 08 (.500 OD TUBE SIZE) AND LARGER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, BASIC PART NUMBER AND MATERIAL CODE LETTER.

/6/ AT THE OPTION OF THE MANUFACTURER, THE SMALLER DIAMETER MAY BE DRILLED THRU.

/7/ THE SEAL RING IS ORDERED SEPARATELY AS AN AS1097.

/8/ HEX CORNERS MAY BE ROUNDED PER ARP1942.

9. INTERPRETATION OF DRAWING PER ARP4296.

/10/ SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M; REQUIREMENTS PER ASME B46.1 UNLESS OTHERWISE SPECIFIED; MACHINED SURFACES ARE TO BE 125 μ in Ra.

	AEROSPACE STANDARD	AS1368™ SHEET 2 OF 3	REV. C
	FITTING, REDUCER-EXTERNAL THREAD FLARED TUBE FOR SEAL RING		