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SAE AS1985

RATIONALE

FEDERAL SUPPLY CLASS
4730

ADD AMS5853 OPTION FOR A286 LOCKRING MATERIAL AND OTHER GENERAL UPDATES.

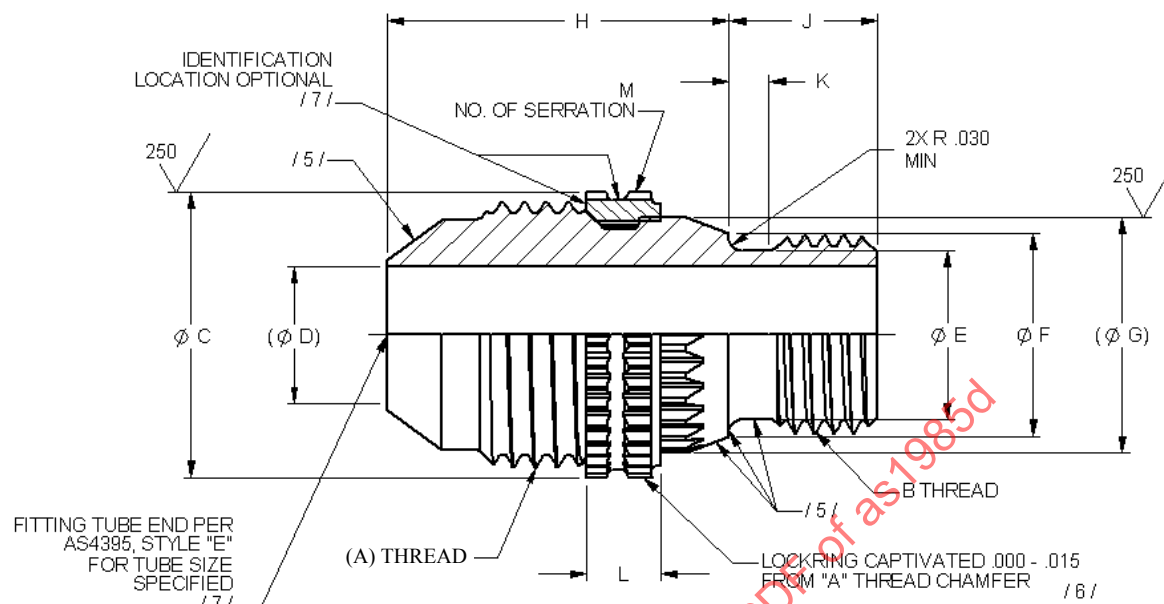


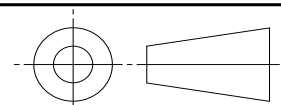
FIGURE 1 - ADAPTER, ASSEMBLY

TABLE 1A - DIMENSIONS A-G

BASIC NO. AS1985 /16/ SIZE CODE	(NOMINAL TUBE SIZE)	A THREAD AS8879	B THREAD AS8879	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

SAE values your input. To provide feedback
on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS1985D>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS4841

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

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

SAE AS1985
SHEET 1 OF 3

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TABLE 1B - DIMENSIONS H-M AND WEIGHTS

BASIC NO. AS1985 /16/ SIZE CODE	H +.010 -.005	J +.000 -.015	K +.010 -.005	L ±.007	M	WEIGHT LB/EA MAX
02	.743	.300	.125	.192	24	.010
03	.774	.355	.125	.192	26	.014
04	.845	.355	.125	.192	30	.017
05	.845	.381	.125	.192	36	.023
06	.872	.395	.125	.210	36	.028
08	.973	.430	.125	.210	40	.047
10	1.074	.465	.125	.210	38	.077
12	1.190	.527	.157	.220	40	.110
16	1.237	.564	.157	.220	36	.163
20	1.311	.569	.157	.240	56	.245
24	1.435	.608	.157	.240	81	.282
32	1.726	.730	.157	.240	102	.612

NOTES:

1. MATERIAL:

- a. FITTING: 6AL-4V TITANIUM ALLOY PER AMS4928, AMS4965, OR AMS4967.
- b. LOCKRING: A286 CORROSION RESISTANT STEEL PER AMS5731, AMS5732, AMS5734, AMS5737 OR AMS5853.

2. HEAT TREATMENT:

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

3. FINISH:

- a. FITTING: ANODIC TREATMENT PER AMS2488, TYPE 2.
- b. LOCKRING: PASSIVATE PER AMS2700, TYPE 2.

/4/ PROCUREMENT SPECIFICATION: AS4841 EXCEPT AS SPECIFIED ON THIS STANDARD. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL BY STANDARD PAGE SUPPLEMENT 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:

- a. MARK AT LOCATION(S) SHOWN PER AS478 METHOD 2 OR 15, MANUFACTURER'S NAME, TRADEMARK, OR CAGE CODE.
- b. BAG AND TAG PER AS478, METHOD 35D, MANUFACTURER'S 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.

 An SAE International Group	AEROSPACE STANDARD	SAE AS1985 SHEET 2 OF 3	REV. D
	FITTING, ASSEMBLY, ADAPTER RING LOCKED PORT CONNECTION TO FLARED TUBE END		