

REV.
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AS1986

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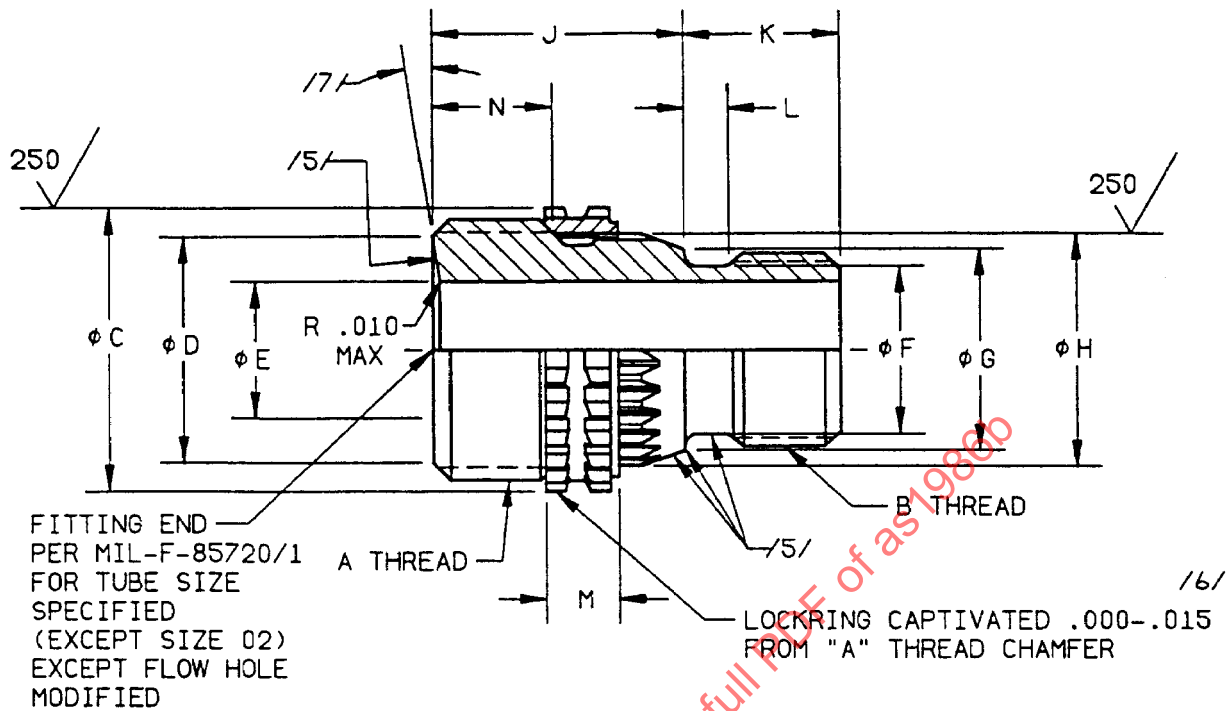


FIGURE 1 - ADAPTER ASSEMBLY

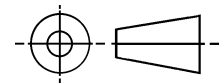
TABLE 1 - DIMENSIONS

TABLE 1A - A THROUGH F

BASIC NO. AS1986 /17/ SIZE CODE	(NOMINAL TUBE SIZE)	A THREAD MIL-S-8879	B THREAD MIL-S-8879	C	(D)	E	F +.005/- .002
02	.125	.3125-32UNJEF-3A	.2160-28UNJF-3A	.400	.265-.271	.090-.096	.154
03	.188	.3750-28UNJS-3A	.2500-28UNJF-3A	.468	.323-.329	.122-.128	.186
04	.250	.4375-24UNJS-3A	.3125-24UNJF-3A	.514	.377-.383	.169-.175	.239
05	.312	.5000-24UNJS-3A	.3750-24UNJF-3A	.624	.440-.446	.231-.237	.301
06	.375	.5625-20UNJS-3A	.4375-20UNJF-3A	.700	.490-.497	.294-.300	.364
08	.500	.7188-20UNJS-3A	.5625-18UNJF-3A	.814	.646-.654	.398-.408	.482
10	.625	.8438-18UNJS-3A	.6875-24UNJEF-3A	1.040	.763-.772	.493-.503	.625
12	.750	1.0000-16UNJ-3A	.8125-20UNJEF-3A	1.170	.910-.919	.604-.614	.737
14	.875	1.1250-16UNJ-3A	.9375-20UNJEF-3A	1.341	1.034-1.044	.729-.739	.868
16	1.000	1.2500-14UNJS-3A	1.1250-18UNJEF-3A	1.456	1.148-1.158	.839-.851	1.000
20	1.250	1.5781-14UNJS-3A	1.3125-18UNJEF-3A	1.782	1.476-1.486	1.073-1.086	1.225
24	1.500	1.8438-14UNJS-3A	1.6250-18UNJEF-3A	2.031	1.741-1.751	1.307-1.320	1.502



THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ MIL-F-85720

SAE Aerospace
An SAE International Group**AEROSPACE STANDARD**FITTING ASSEMBLY, ADAPTER RING LOCKED PORT
CONNECTION TO BEAM SEAL 4000 psi AND 5000 psi /9/**AS1986**
SHEET 1 OF 3**REV.
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TABLE 1B - G THROUGH N

BASIC NO. AS1986								
/17/ SIZE CODE	G MIN	(H)	J +.010/- .005	K 0/- .015	L +.010/- .005	M +.007	(N) MIN	LB/EA MAX
02	.246	.317	.519	.300	.125	.192	.141	.008
03	.278	.349	.550	.355	.125	.192	.164	.012
04	.331	.400	.592	.355	.125	.192	.197	.014
05	.393	.491	.592	.381	.125	.192	.197	.020
06	.456	.544	.633	.395	.125	.210	.205	.025
08	.574	.670	.646	.430	.125	.210	.218	.035
10	.717	.824	.710	.465	.125	.210	.274	.059
12	.891	.981	.760	.527	.157	.220	.303	.079
14	1.022	1.118	.778	.572	.157	.220	.318	.101
16	1.154	1.251	.808	.564	.157	.220	.338	.125
20	1.379	1.466	.832	.569	.157	.240	.335	.179
24	1.656	1.768	.917	.608	.157	.240	.420	.257

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: 34-40 HRC
3. FINISH:
 - a. FITTING: ANODIC TREATMENT PER AMS 2488, TYPE 2
 - b. LOCKRING: PASSIVATE PER QQ-P-35, TYPE II
- /4/ PROCUREMENT SPECIFICATION: MIL-F-85720 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 SUPPLEMENT 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/ SEALING ANGLES:
 - a. SIZES -02 AND -03: 3°00' TO 3°30'
 - b. SIZES -04 AND LARGER: 8°30' TO 9°00'
8. IDENTIFICATION PER AS478 CLASS 35D. NAME, TRADEMARK OR CAGE CODE, AND PART NUMBER.
- /9/ WORKING PRESSURE: THIS PART IS DESIGNED FOR USE IN HYDRAULIC SYSTEMS COMPATIBLE WITH TITANIUM.
 - a. SIZE -04, -06, -08, -10, -12, AND -16: 5000 psi (20 000 psi BURST PRESSURE) SYSTEMS.
 - b. ALL OTHER SIZES: 4000 psi (16 000 psi BURST PRESSURE) SYSTEMS.
10. ADAPTERS TO BE INSTALLED PER AS1301 INTO BOSS CAVITIES PER AS1300.
11. INVENTORIED PARTS CONFORMING TO THE PREVIOUS "LETTER CHANGE" MAY BE USED TO DEPLETION.
12. INTERPRETATION OF DRAWING PER ARP4296.
13. 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.