

REV.
D

SAE AS1986

RATIONALE

FEDERAL SUPPLY CLASS
4030

UPDATE QPL WEBSITE LINK LISTED IN NOTE 4 A AND ADD PRI QPL FOR SIZES RATED TO 5000 PSI.

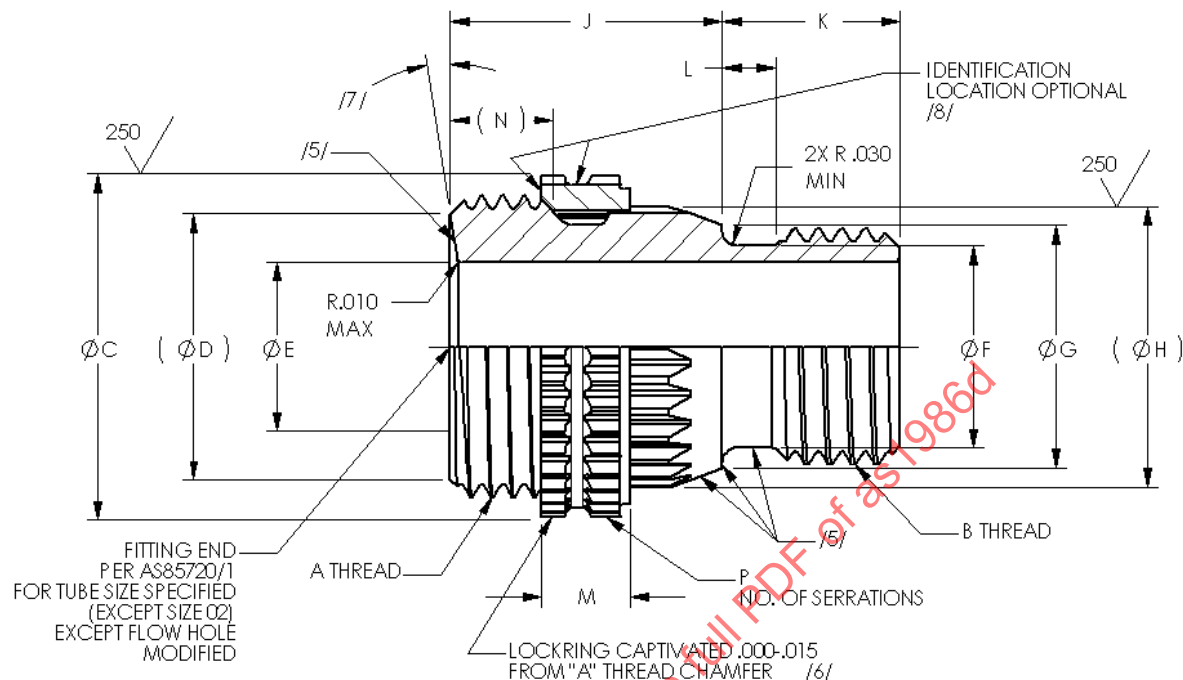


TABLE 1B – DIMENSIONS G – P AND WEIGHT

BASIC NO. AS1986 /18/ SIZE CODE	G MIN	H	J +.010/- .005	K 0/- .015	L +.010/- .005	M ±.007	N MIN	P	WEIGHT LB/EA MAX
02	.246	.317	.519	.300	.125	.192	.141	24	.008
03	.278	.349	.550	.355	.125	.192	.164	26	.012
04	.331	.400	.592	.355	.125	.192	.197	30	.014
05	.393	.491	.592	.381	.125	.192	.197	36	.020
06	.456	.544	.633	.395	.125	.210	.205	36	.025
08	.574	.670	.646	.430	.125	.210	.218	40	.035
10	.717	.824	.710	.465	.125	.210	.274	38	.059
12	.891	.981	.760	.527	.157	.220	.303	40	.079
14	1.022	1.118	.778	.572	.157	.220	.318	50	.101
16	1.154	1.251	.808	.564	.157	.220	.338	36	.125
20	1.379	1.466	.832	.569	.157	.240	.335	56	.179
24	1.656	1.768	.917	.608	.157	.240	.420	81	.257

NOTES:

1. MATERIAL:

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

2. HEAT TREATMENT:

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

3. FINISH:

- a. FITTING: ANODIC TREATMENT PER AMS2488, TYPE 2.
- b. LOCKRING: PASSIVATE PER AMS-QQ-P-35, TYPE II.

/4/ PROCUREMENT SPECIFICATION:

- a. AS85421 (SIZES 02, 03, 05, 14, 20 AND 24): PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER AS LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST FOR PRI-QPL-AS85421 FOR THIS STANDARD. SEE <http://www.eauditnet.com> FOR CURRENT QPL ONLINE.
- b. AS85720 (SIZES 04, 06, 08, 10, 12 AND 16): PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER AS LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST FOR PRI-QPL-AS85720 FOR THIS STANDARD. SEE <http://www.eauditnet.com> FOR CURRENT QPL ONLINE.

/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 DEGREES 00' TO 3 DEGREES 30'
- b. SIZES -04 AND LARGER: 8 DEGREES 30' TO 9 DEGREES 00'

 An SAE International Group	AEROSPACE STANDARD	SAE AS1986 SHEET 2 OF 3	REV. D
	FITTING ASSEMBLY, ADAPTER RING LOCKED PORT CONNECTION TO BEAM SEAL 4000 PSI AND 5000 PSI /9/		