

REV.
A

AS3077

FEDERAL SUPPLY CLASS
4730

RATIONALE

AS3077A HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

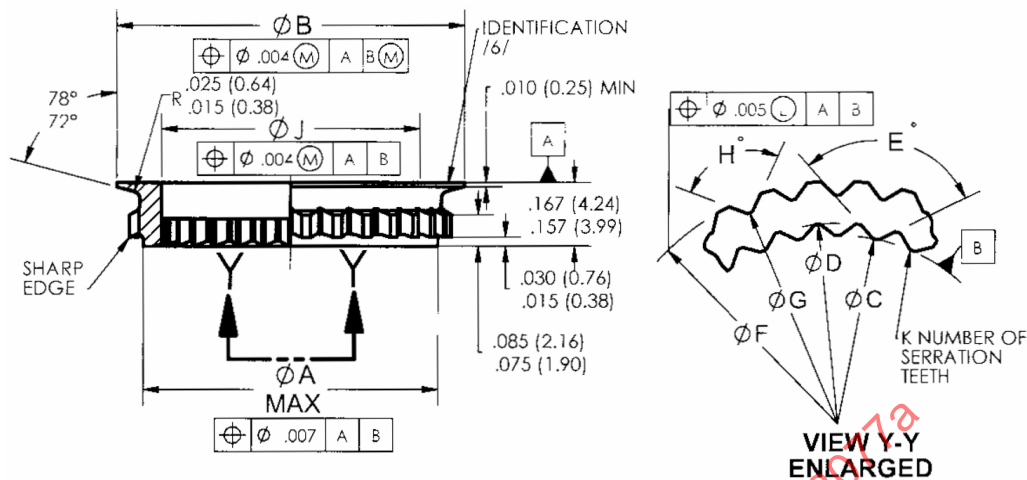
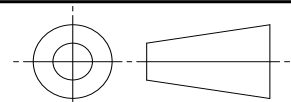


FIGURE 1- LOCKRING

1. MATERIAL: A286 CORROSION RESISTANT STEEL PER AMS5731, AMS5732, AMS5734, OR AMS 5737.
2. HEAT TREATMENT: IF THE RAW MATERIAL IS PROCURED IN THE SOLUTION TREATED CONDITION, AGE PER AMS5732, AMS5737, AMS2759/3 OR AMS-H-6875.
3. HARDNESS: 33-42 HRC.
4. FINISH: PASSIVATE PER AMS-QQ-P-35, TYPE II.
5. USERS OF THIS STANDARD SHALL PROCURE THIS PRODUCT FROM MANUFACTURER(S) ACCREDITED TO AS7112 AND AS7112/2 IN ACCORDANCE WITH AS7003. THE MANUFACTURER SHALL BE LISTED ON THE QUALIFIED MANUFACTURERS LIST (QML) FOR THIS TYPE PRODUCT.
- 16/ IDENTIFICATION:
 - a. MARK AT LOCATION SHOWN PER AS478 METHOD 2 OR 15. MANUFACTURER'S NAME, TRADEMARK OR CAGE CODE.
 - b. MARK PER AS478 CLASS 35D. MANUFACTURER'S NAME, TRADEMARK OR CAGE CODE, AND PART NUMBER.
- 17/ INTENDED USE: LOCKRING TO BE USED IN CONJUNCTION WITH AS3078 FLUID BOSS INSERT AND TO BE INSTALLED PER AS1959 INTO BOSS CAVITIES PER AS1958.
8. THE CHANGE BAR (I) LOCATED IN THE LEFT MARGIN IS FOR THE CONVENIENCE OF THE USER IN LOCATING AREAS WHERE TECHNICAL REVISIONS, EDITORIAL CHANGES, HAVE BEEN MADE TO THE PREVIOUS ISSUE OF THIS DOCUMENT. AN (R) SYMBOL TO THE LEFT OF THE DOCUMENT TITLE INDICATES A COMPLETE REVISION OF THE DOCUMENT.
9. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M, REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED NON-SERRATED SURFACES TO BE 125 MICROMETERS (3.1 MICROMETERS). SERRATED SURFACES 250 MICROMETERS (6.3 MICROMETERS).
10. BREAK SHARP EDGES .003 - .015 (0.08 - 0.38) UNLESS OTHERWISE SPECIFIED.
11. DIMENSIONING AND TOLERANCING. ASME Y14.5M-1994. INTERPRETATION OF DRAWING PER ARP4296.
12. DIMENSIONS IN INCHES (MILLIMETERS). METRIC CONVERSIONS ARE IN INTERNATIONAL SYSTEM UNITS (SI). UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS ± 0.05 (± 0.13), ANGULAR DIMENSIONS $\pm 0^{\circ}30'$.
- 13/ EXAMPLE OF PART NUMBER: **AS3077-04**
BASIC PART NUMBER ——— SIZE CODE
14. INVENTORIED PARTS CONFORMING TO PREVIOUS "LETTER CHANGE" MAY BE USED TO DEPLETION.

SAE values your input. To provide feedback
on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS3077A>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B



AEROSPACE STANDARD

(R) LOCKRING - FLUID CONNECTION BOSS
INSERT, INTERNAL STRAIGHT THREAD

AS3077
SHEET 1 OF 2

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