

REV.  
B

AS3131

FEDERAL SUPPLY CLASS  
5315

# RATIONALE

THIS IS A LIMITED SCOPE REVISION. REVISED CLEANING REQUIREMENTS (NOTE 3) FOR CONFORMANCE TO AMS2700 OR ASTM A967/A967M.

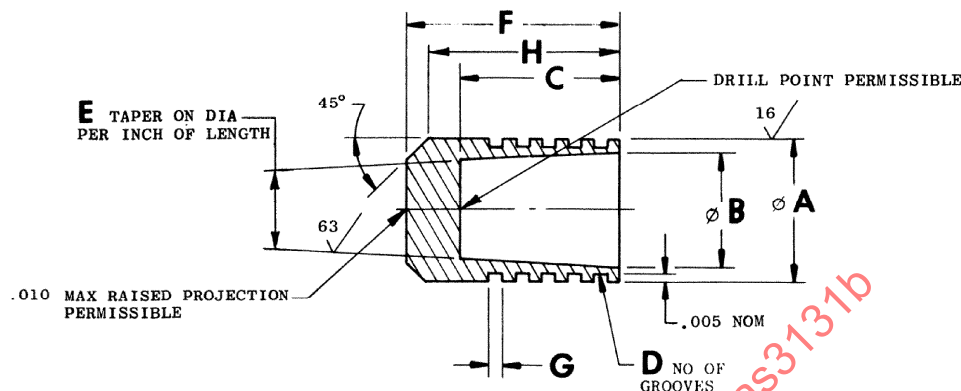


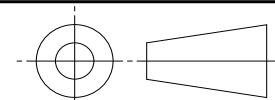
FIGURE 1

TABLE 1A – PART NUMBERS AND DIMENSIONS

| STANDARD DIAMETERS                          |                                      |             |                          |
|---------------------------------------------|--------------------------------------|-------------|--------------------------|
| AEROSPACE<br>STANDARD<br>PART NUMBER<br>/8/ | MANUFACTURER'S<br>PART NUMBER<br>/8/ | ØA          | APPROX<br>MASS<br>LB/100 |
| AS3131-01                                   | PLGA0935030A                         | .0928-.0937 | .011                     |
| AS3131-02                                   | PLGA1255030A                         | .1241-.1250 | .022                     |
| AS3131-03                                   | PLGA1565030A                         | .1553-.1562 | .040                     |
| AS3131-04                                   | PLGA1875030A                         | .1866-.1875 | .056                     |
| AS3131-05                                   | PLGA2185030A                         | .2178-.2187 | .088                     |
| AS3131-06                                   | PLGA2505030A                         | .2491-.2500 | .129                     |
| AS3131-07                                   | PLGA2815030A                         | .2803-.2812 | .178                     |
| AS3131-08                                   | PLGA3435030A                         | .3428-.3437 | .289                     |
| AS3131-09                                   | PLGA4065030A                         | .4053-.4062 | .462                     |
| AS3131-10                                   | PLGA4685030A                         | .4678-.4687 | .568                     |
| AS3131-11                                   | PLGA5315030A                         | .5303-.5312 | .986                     |
| AS3131-12                                   | PLGA6565030A                         | .6553-.6562 | 1.675                    |

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THIRD ANGLE PROJECTION



CUSTODIAN: E-25

PROCUREMENT SPECIFICATION: NONE



## AEROSPACE STANDARD

PLUG, EXPANSION - CRES, 303, SHORT;  
STD AND .010 OVERSIZE DIAMETERS,  
UNS S30300

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TABLE 1B – PART NUMBERS AND DIMENSIONS

| .010 OVERSIZE DIAMETERS                     |                                      |             |                          |
|---------------------------------------------|--------------------------------------|-------------|--------------------------|
| AEROSPACE<br>STANDARD<br>PART NUMBER<br>/8/ | MANUFACTURER'S<br>PART NUMBER<br>/8/ | ØA          | APPROX<br>MASS<br>LB/100 |
| AS3131-51                                   | PLGA1035030A                         | .1028-.1037 | .013                     |
| AS3131-52                                   | PLGA1355030A                         | .1341-.1350 | .029                     |
| AS3131-53                                   | PLGA1665030A                         | .1653-.1662 | .047                     |
| AS3131-54                                   | PLGA1975030A                         | .1966-.1975 | .068                     |
| AS3131-55                                   | PLGA2285030A                         | .2278-.2287 | .108                     |
| AS3131-56                                   | PLGA2605030A                         | .2591-.2600 | .150                     |
| AS3131-57                                   | PLGA2915030A                         | .2903-.2912 | .203                     |
| AS3131-58                                   | PLGA3535030A                         | .3528-.3537 | .329                     |
| AS3131-59                                   | PLGA4165030A                         | .4153-.4162 | .527                     |
| AS3131-60                                   | PLGA4785030 A                        | .4778-.4787 | .645                     |
| AS3131-61                                   | PLGA5415030 A                        | .5403-.5412 | 1.080                    |
| AS3131-62                                   | PLGA6665030 A                        | .6653-.6662 | 1.863                    |

TABLE 1C – PART NUMBERS AND DIMENSIONS

| AEROSPACE<br>STANDARD<br>PART NUMBER<br>/8/ | ØB<br>NOM | C<br>NOM | D  | ØE<br>NOM | F         | G<br>NOM | H         |
|---------------------------------------------|-----------|----------|----|-----------|-----------|----------|-----------|
| AS3131-01 & 51                              | .062      | .069     | 3  | .0417     | .093-.102 | .010     | .070-.085 |
| AS3131-02 & 52                              | .088      | .104     | 4  | .0417     | .123-.132 | .010     | .100-.115 |
| AS3131-03 & 53                              | .110      | .090     | 4  | .0417     | .118-.132 | .010     | .100-.120 |
| AS3131-04 & 54                              | .146      | .128     | 4  | .0417     | .154-.166 | .010     | .128-.142 |
| AS3131-05 & 55                              | .173      | .157     | 5  | .0417     | .180-.194 | .010     | .157-.177 |
| AS3131-06 & 56                              | .204      | .183     | 4  | .0417     | .218-.232 | .015     | .184-.202 |
| AS3131-07 & 57                              | .240      | .205     | 5  | .0313     | .248-.262 | .010     | .220-.240 |
| AS3131-08 & 58                              | .300      | .242     | 5  | .0208     | .300-.314 | .020     | .262-.282 |
| AS3131-09 & 59                              | .358      | .279     | 12 | .0208     | .358-.372 | .010     | .295-.315 |
| AS3131-10 & 60                              | .428      | .305     | 6  | .0208     | .383-.397 | .020     | .320-.340 |
| AS3131-11 & 61                              | .486      | .410     | 8  | .0156     | .513-.527 | .020     | .445-.475 |
| AS3131-12 & 62                              | .592      | .425     | 9  | .0182     | .543-.557 | .020     | .460-.480 |

## NOTES:

- MATERIAL: 303 CRES BAR PER AMS5640, TYPE 1, UNS S30300.
- HEAT TREAT: PER AMS5640.
- CLEANING: FINISHED PARTS SHALL BE DEGREASED AND PASSIVATED PER ASTM A967/A967M OR AMS2700. A SOLUTION CONTAINING SODIUM DICHROMATE AND NOT LESS THAN 20% BY VOLUME OF NITRIC ACID MUST BE USED. A CITRIC ACID METHOD MAY BE USED AS AN ALTERNATIVE IF REQUESTED BY THE PROCURING ACTIVITY AND THE SUPPLIER AGREES.
- GROOVE BURRS PERMITTED ON OD OF PLUG TO .001 OVER MAX Ø A.
- SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 250 MICROINCHES Ra.

|                                                                                     |                                                                                       |                               |                         |
|-------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|-------------------------------|-------------------------|
|  | <b>AEROSPACE STANDARD</b>                                                             | <b>AS3131</b><br>SHEET 2 OF 3 | <b>REV.</b><br><b>B</b> |
|                                                                                     | PLUG, EXPANSION - CRES, 303, SHORT;<br>STD AND .010 OVERSIZE DIAMETERS,<br>UNS S30300 |                               |                         |