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CORRECTED PASSIVATION TYPES FOR 304 AND 15-5PH BODIES.



PROCUREMENT SPECIFICATION: /4/ AS18280



FITTING ASSY,CROSS, REDUCER,  
SWIVEL ON SIDE,  
REDUCED BODY, FLARELESS

**AS4141**  
SHEET 1 OF 5

**REV.**  
**C**

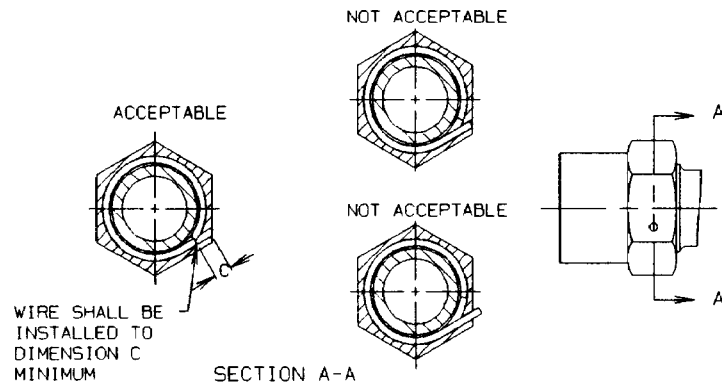


FIGURE 2 - INSTALLATION, SWIVEL NUT RETAINING WIRE

TABLE 1 - DIMENSIONS AND WEIGHTS

| BASIC NO.<br>AS4141<br>/20/<br>SIZE CODE | H<br>MIN | J     | P<br>±.030 | LB/EA<br>APPROX<br>REF<br>CRES | LB/EA<br>APPROX<br>REF<br>TI |
|------------------------------------------|----------|-------|------------|--------------------------------|------------------------------|
| 04                                       | .050     | .390  | .030       | .088                           | .049                         |
| 05                                       | .050     | .453  | .159       | .106                           | .059                         |
| 06                                       | .050     | .453  | .137       | .138                           | .078                         |
| 08                                       | .050     | .577  | .140       | .256                           | .144                         |
| 10                                       | .070     | .702  | .157       | .396                           | .222                         |
| 12                                       | .080     | .890  | .166       | .602                           | .338                         |
| 16                                       | .090     | 1.140 | .174       | .943                           | .529                         |
| 20                                       | .110     | 1.390 | .071       | 1.402                          | .787                         |
| 24                                       | .130     | 1.640 | ---        | 1.928                          | 1.082                        |

TABLE 2 - FITTING END

| SIZE<br>CODE | TUBE<br>OD | T THREAD<br>PER AS8879 | C<br>/15/ | D    | E     |
|--------------|------------|------------------------|-----------|------|-------|
| 04           | .250       | .4375-20UNJF           | .075      | .371 | .350  |
| 05           | .313       | .5000-20UNJF           | .076      | .371 | .412  |
| 06           | .375       | .5625-18UNJF           | .084      | .379 | .453  |
| 08           | .500       | .7500-16UNJF           | .095      | .461 | .577  |
| 10           | .625       | .8750-14UNJF           | .115      | .511 | .702  |
| 12           | .750       | 1.0625-12UNJ           | .149      | .556 | .890  |
| 16           | 1.000      | 1.3125-12UNJ           | .178      | .556 | 1.140 |
| 20           | 1.250      | 1.6250-12UNJ           | .221      | .556 | 1.390 |
| 24           | 1.500      | 1.8750-12UNJ           | .291      | .556 | 1.640 |

TABLE 3 - LEG LENGTH A

| FORGING<br>SIZE | 04    | 05    | 06    | 08    | 10    | 12    | 16    | 20    | 24    |
|-----------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 04              | .745  | ---   | ---   | ---   | ---   | ---   | ---   | ---   | ---   |
| 05              | .776  | .828  | ---   | ---   | ---   | ---   | ---   | ---   | ---   |
| 06              | .838  | .890  | .951  | ---   | ---   | ---   | ---   | ---   | ---   |
| 08              | .932  | .984  | 1.045 | 1.143 | ---   | ---   | ---   | ---   | ---   |
| 10              | 1.026 | 1.075 | 1.139 | 1.237 | 1.317 | ---   | ---   | ---   | ---   |
| 12              | 1.119 | 1.171 | 1.232 | 1.330 | 1.410 | 1.398 | ---   | ---   | ---   |
| 16              | 1.244 | 1.296 | 1.357 | 1.454 | 1.533 | 1.522 | 1.590 | ---   | ---   |
| 20              | 1.401 | 1.453 | 1.514 | 1.611 | 1.690 | 1.679 | 1.727 | 1.810 | ---   |
| 24              | 1.526 | 1.578 | 1.639 | 1.736 | 1.815 | 1.804 | 1.852 | 1.935 | 2.112 |

TABLE 4 - LEG LENGTH B

| FORGING<br>SIZE | 04    | 05    | 06    | 08    | 10    | 12    | 16    | 20    | 24    |
|-----------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 04              | .883  | ---   | ---   | ---   | ---   | ---   | ---   | ---   | ---   |
| 05              | .799  | .914  | ---   | ---   | ---   | ---   | ---   | ---   | ---   |
| 06              | .861  | .861  | 1.003 | ---   | ---   | ---   | ---   | ---   | ---   |
| 08              | .955  | .955  | .971  | 1.204 | ---   | ---   | ---   | ---   | ---   |
| 10              | 1.049 | 1.049 | 1.065 | 1.158 | 1.380 | ---   | ---   | ---   | ---   |
| 12              | 1.142 | 1.142 | 1.158 | 1.251 | 1.314 | 1.560 | ---   | ---   | ---   |
| 16              | 1.267 | 1.267 | 1.283 | 1.376 | 1.439 | 1.502 | 1.684 | ---   | ---   |
| 20              | 1.424 | 1.424 | 1.440 | 1.533 | 1.596 | 1.659 | 1.659 | 1.903 | ---   |
| 24              | 1.549 | 1.549 | 1.565 | 1.658 | 1.721 | 1.784 | 1.784 | 1.784 | 2.028 |

## NOTES:

## NOTICE

THIS DOCUMENT REFERENCES A PART WHICH CONTAINS CADMIUM AS A PLATING MATERIAL. CONSULT LOCAL OFFICIALS IF YOU HAVE QUESTIONS CONCERNING CADMIUM'S USE.

## /1/ MATERIAL:

## a. CODE LETTER J:

- (1) BODY: TYPE 304 CORROSION RESISTANT STEEL PER AMS5639
- (2) NUT: CODE LETTER J OF AS1790 (TYPE 304 CORROSION RESISTANT STEEL)
- (3) WIRE: PER AS1791 (CLASS 302 OR 305 CORROSION RESISTANT STEEL)

## b. CODE LETTER T:

- (1) BODY: TYPE 6AL-4V TITANIUM ALLOY PER AMS4928
- (2) NUT: CODE LETTER T OF AS1790 (TYPE 6AL-4V TITANIUM ALLOY)
- (3) WIRE: PER AS1791 (CLASS 302 OR 305 CORROSION RESISTANT STEEL)

## c. CODE LETTER V:

- (1) BODY: TYPE 15-5PH CORROSION RESISTANT STEEL PER AMS5659
- (2) NUT: CODE LETTER V OF AS1790 (TYPE 15-5PH CORROSION RESISTANT STEEL)
- (3) WIRE: PER AS1791 (CLASS 302 OR 305 CORROSION RESISTANT STEEL)



## AEROSPACE STANDARD

FITTING ASSY, CROSS, REDUCER,  
SWIVEL ON SIDE,  
REDUCED BODY, FLARELESS

AS4141  
SHEET 3 OF 5

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C

2. HEAT TREATMENT:

a. MATERIAL CODE LETTER J:

(1) BODY, NUT AND WIRE: NONE

b. MATERIAL CODE LETTER T:

(1) BODY, NUT AND WIRE: NONE

c. MATERIAL CODE LETTER V:

(1) BODY: HEAT TREAT TO CONDITION H-1075 PER AMS2759/3

(2) NUT: MATERIAL CODE LETTER V OF AS1790 (HEAT TREAT TO CONDITION H-1075)

(3) WIRE: NONE

/3/ FINISH:

a. MATERIAL CODE LETTER J:

(1) BODY: PASSIVATE PER AMS2700 TYPE 6 OR 7 AND COAT WITH DRY FILM LUBRICANT PER AS5272 TYPE I /7/

(2) NUT: MATERIAL CODE LETTER J WITH SUFFIX CODE N OF AS1790 (PASSIVATE WITH DRY FILM LUBRICANT ON ID)

(3) WIRE: PER AS1791 (PASSIVATE AND COAT WITH DRY FILM LUBRICANT)

b. MATERIAL CODE LETTER T:

(1) BODY: FLUORIDE PHOSPHATE CONVERSION COAT PER AMS2486 AND DRY FILM LUBRICANT PER AS5272 TYPE I /7/

(2) NUT: MATERIAL CODE LETTER T WITH SUFFIX CODE N OF AS1790 (FLUORIDE PHOSPHATE CONVERSION COAT AND DRY FILM LUBRICANT ON ID)

(3) WIRE: PER AS1791 (PASSIVATE AND COAT WITH DRY FILM LUBRICANT)

c. MATERIAL CODE LETTER V:

(1) BODY:

(a) NO SUFFIX FINISH CODE LETTER: PASSIVATE PER AMS2700 TYPE 2 OR 8 AND DRY FILM LUBRICANT PER AS5272 TYPE I /7/

(b) SUFFIX FINISH CODE LETTER P: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2

(2) NUT:

(a) NO SUFFIX FINISH MATERIAL CODE LETTER WITH CODE LETTER V AND SUFFIX CODE N OF AS1790 (PASSIVATE AND COAT WITH DRY FILM LUBRICANT ON ID)

(b) SUFFIX FINISH MATERIAL CODE LETTER P WITH CODE LETTER V AND SUFFIX CODE LETTER P OF AS1790 (CADMIUM PLATE)

(3) WIRE: PER AS1791 (PASSIVATE AND COAT WITH DRY FILM LUBRICANT).

/4/ PROCUREMENT SPECIFICATION: AS18280 UNLESS SPECIFIED OTHERWISE ON THIS STANDARD. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER AS LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST (QPL) PRI-QPL-AS18280 FOR THIS STANDARD. SEE [www.eAuditNet.com](http://www.eAuditNet.com) FOR CURRENT QPL ONLINE.

/5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B.

a. FOR SIZES 06 (.375 OD TUBE SIZE) AND SMALLER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, LETTERS "AS", MATERIAL CODE LETTER AND FORGING MANUFACTURER'S IDENTIFICATION WHEN MADE FROM FORGING

b. FOR SIZES 08 (.500 OD TUBE SIZE) AND LARGER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, BASIC PART NUMBER, MATERIAL CODE LETTER AND FORGING MANUFACTURER'S IDENTIFICATION WHEN MADE FROM FORGING

|                                                                                     |                                                                             |                               |                         |
|-------------------------------------------------------------------------------------|-----------------------------------------------------------------------------|-------------------------------|-------------------------|
|  | <b>AEROSPACE STANDARD</b>                                                   | <b>AS4141</b><br>SHEET 4 OF 5 | <b>REV.</b><br><b>C</b> |
|                                                                                     | FITTING ASSY, CROSS, REDUCER,<br>SWIVEL ON SIDE,<br>REDUCED BODY, FLARELESS |                               |                         |