

REV.
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AS4319

FEDERAL SUPPLY CLASS
4030

RATIONALE

CORRECTING TYPOS AND UPDATING TO THE LATEST FORMAT AND SPECIFICATION CHANGES.

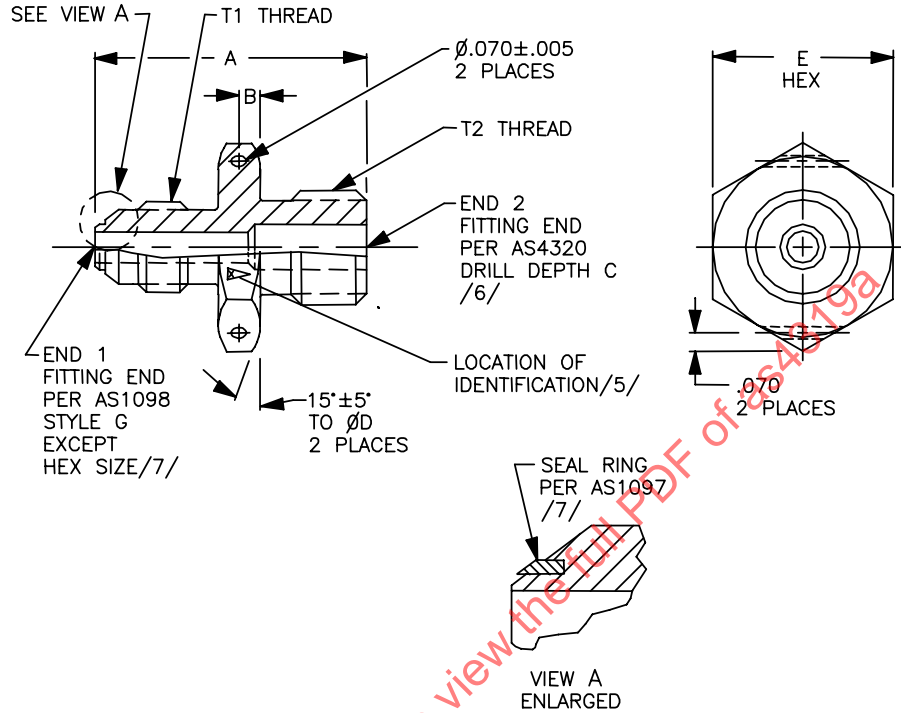
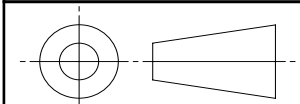


FIGURE 1 - FITTING, EXPANDER, ADAPTER, FLARED
TUBE TO BOSS, FOR SEAL RING

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ KSC-F-124

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

(R) FITTING, EXPANDER, ADAPTER,
FLARED TUBE TO BOSS
FOR SEAL RING

AS4319
SHEET 1 OF 4

**REV.
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ISSUED 1993-08 REAFFIRMED 2001-12 REVISED 2006-03

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TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NUMBER AS4319 /15/ SIZE CODE	(NOMINAL TUBE SIZE) END 1	T1 THREAD PER AS8879 CLASS 3A END 1	(NOMINAL TUBE SIZE) END 2	T2 THREAD PER AS8879 CLASS 3A END 2	A + .000 - .060	B ± .030	C MAX	D ± .010	E	LB/EA APPROX REF ALUM	LB/EA APPROX REF CRES
0204	.125	.3125-24UNJF	.250	.4375-20UNJF	1.084	.123	.311	.668	.678-.691	.0137	.0383
0304	.188	.3750-24UNJF	.250	.4375-20UNJF	1.115	.123	.311	.668	.678-.691	.0156	.0438
0206	.125	.3125-24UNJF	.375	.5625-18UNJF	1.163	.147	.336	.792	.802-.815	.0211	.0592
0306	.188	.3750-24UNJF	.375	.5625-18UNJF	1.194	.147	.336	.792	.802-.815	.0233	.0653
0406	.250	.4375-20UNJF	.375	.5625-18UNJF	1.265	.140	.336	.792	.802-.815	.0303	.0840
0506	.312	.5000-20UNJF	.375	.5625-18UNJF	1.265	.147	.336	.792	.802-.815	.0304	.0850
0208	.125	.3125-24UNJF	.500	.7500-16UNJF	1.258	.158	.417	.980	.990-1.003	.0368	.103
0308	.188	.3750-24UNJF	.500	.7500-16UNJF	1.315	.157	.417	.980	.990-1.003	.0397	.111
0408	.250	.4375-20UNJF	.500	.7500-16UNJF	1.390	.152	.417	.980	.990-1.003	.0509	.141
0508	.312	.5000-20UNJF	.500	.7500-16UNJF	1.390	.159	.417	.980	.990-1.003	.0512	.142
0608	.375	.5625-18UNJF	.500	.7500-16UNJF	1.392	.150	.417	.980	.990-1.003	.0514	.143
0410	.250	.4375-20UNJF	.625	.8750-14UNJF	1.460	.164	.454	1.103	1.113-1.128	.0680	.189
0610	.375	.5625-18UNJF	.625	.8750-14UNJF	1.460	.161	.454	1.103	1.113-1.128	.0681	.189
0810	.500	.7500-16UNJF	.625	.8750-14UNJF	1.560	.160	.454	1.103	1.113-1.128	.0755	.209
0412	.250	.4375-20UNJF	.750	1.0625-12UNJ	1.560	.179	.509	1.353	1.363-1.380	.107	.297
0512	.312	.5000-20UNJF	.750	1.0625-12UNJ	1.560	.187	.509	1.353	1.363-1.380	.108	.298
0612	.375	.5625-18UNJF	.750	1.0625-12UNJ	1.567	.180	.509	1.353	1.363-1.380	.108	.299
0812	.500	.7500-16UNJF	.750	1.0625-12UNJ	1.668	.180	.509	1.353	1.363-1.380	.115	.319
1012	.625	.8750-14UNJF	.750	1.0625-12UNJ	1.769	.180	.509	1.353	1.363-1.380	.121	.337
0416	.250	.4375-20UNJF	1.000	1.3125-12UNJ	1.597	.180	.538	1.603	1.613-1.630	.149	.414
0616	.375	.5625-18UNJF	1.000	1.3125-12UNJ	1.603	.180	.538	1.603	1.613-1.630	.150	.415
0816	.500	.7500-16UNJF	1.000	1.3125-12UNJ	1.704	.180	.538	1.603	1.613-1.630	.157	.436
1016	.625	.8750-14UNJF	1.000	1.3125-12UNJ	1.805	.180	.538	1.603	1.613-1.630	.163	.453
1216	.750	1.0625-12UNJ	1.000	1.3125-12UNJ	1.911	.180	.538	1.603	1.613-1.630	.175	.486
0420	.250	.4375-20UNJF	1.250	1.6250-12UNJ	1.693	.228	.610	1.853	1.863-1.880	.238	.659
1220	.750	1.0625-12UNJ	1.250	1.6250-12UNJ	2.007	.228	.610	1.853	1.863-1.880	.261	.724
1620	1.000	1.3125-12UNJ	1.250	1.6250-12UNJ	2.054	.228	.610	1.853	1.863-1.880	.265	.735
1624	1.000	1.3125-12UNJ	1.500	1.8750-12UNJ	2.095	.224	.635	2.099	2.109-2.135	.331	.918
2024	1.250	1.6250-12UNJ	1.500	1.8750-12UNJ	2.142	.224	.635	2.099	2.109-2.135	.347	.962
2028	1.250	1.6250-12UNJ	1.750	2.2500-12UNJ	2.297	.276	.759	2.474	2.484-2.510	.358	1.490
2428	1.500	1.8750-12UNJ	1.750	2.2500-12UNJ	2.422	.276	.759	2.474	2.484-2.510	.548	1.520
2432	1.500	1.8750-12UNJ	2.000	2.5000-12UNJ	2.516	.265	.782	2.724	2.734-2.760	.661	1.930
2832	1.750	2.2500-12UNJ	2.000	2.5000-12UNJ	2.641	.265	.782	2.724	2.734-2.760	.714	2.020

NOTES:

/1/ MATERIAL:

- a. CODE LETTER D: TYPE 2024-T6 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6 OR AMS 4112; OR, TYPE 2024-T851 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6.
- b. CODE LETTER J: 304 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS 5639.
- c. CODE LETTER K: 316 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS 5648.
- d. CODE LETTER R: 321 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS 5645.
- e. CODE LETTER S: 347 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS 5646.
- f. CODE LETTER W: TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9 OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS 4124.

2. HEAT TREAT:

- a. ALL CODE LETTERS: NONE

3. FINISH:

- a. MATERIAL CODE LETTER D: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2, DYE BLUE AND DUPLEX SEAL PER PROCURMENT SPECIFICATION.
- b. MATERIAL CODE LETTERS J, K, R AND S; PASSIVATE PER AMS 2700, TYPE 6 OR TYPE 7.
- c. MATERIAL CODE LETTER W: ANODIZE PER AMS 2472 OR MIL-A-8625, TYPE II, CLASS 2, DYE BROWN, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.

/4/ PROCUREMENT SPECIFICATION: KSC-F-124 JOHN F KENNEDY SPACE CENTER, NASA, SPECIFICATION FOR FITTINGS (PRESSURE CONNECTIONS), FLARED TUBE. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER LISTED IN "PERFORMANCE REVIEW INSTITUTE" (PRI) "QUALIFIED MANUFACTURER LIST" (QML) FOR THIS TYPE PRODUCT. THE QML IS AVAILABLE AT www.eauditnet.com. NADCAP QML AS7112, 7112/2

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

- a. FOR SIZES .06 (.375 OD TUBE SIZE) AND SMALLER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, LETTERS "AS" AND MATERIAL CODE LETTER.
- b. FOR SIZES .08 (.500 OD TUBE SIZE) AND LARGER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, BASIC PART NUMBER AND MATERIAL CODE LETTER.

/6/ AT THE OPTION OF THE MANUFACTURER, THE SMALLER DIAMETER MAY BE DRILLED THRU.

/7/ THE SEAL RING IS ORDERED SEPARATELY AS AN AS1097.

8. INTERPRETATION OF DRAWING PER ARP4296.

9. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M: REQUIREMENTS PER ASME B46.1 UNLESS OTHERWISE SPECIFIED; MACHINED SURFACES ARE TO BE 125 μ in Ra.

10. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.