

REV.
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AS4328

FEDERAL SUPPLY CLASS
4730

RATIONALE

CORRECTED END 1 & 2 TO STYLE "E" IN FIGURE 1. UPDATED NOTE /4/ TO DELETE THE "PRI" STATEMENT AND CORRECT THE NADCAP SCOPE TO AC7112, AC7112/2.

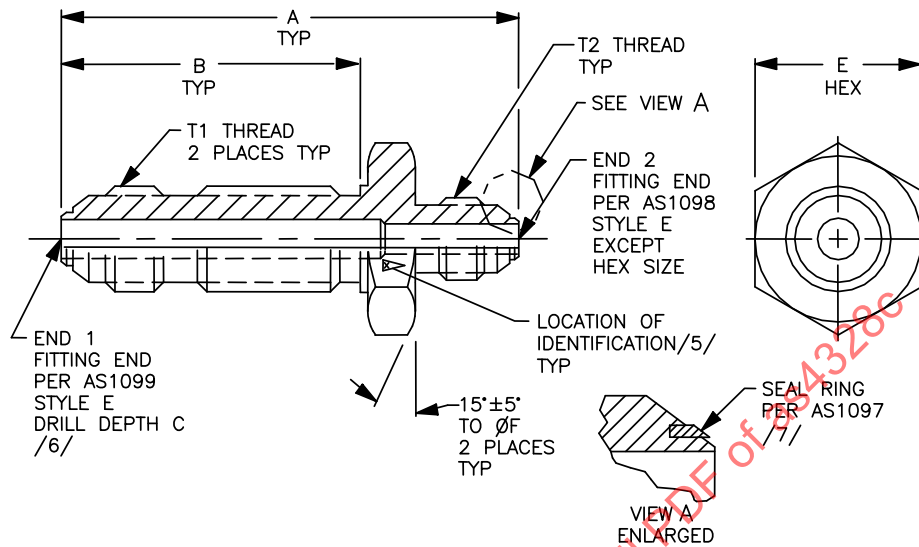


FIGURE 1 - FITTING, UNION, REDUCER, FLARED TUBE END REDUCED

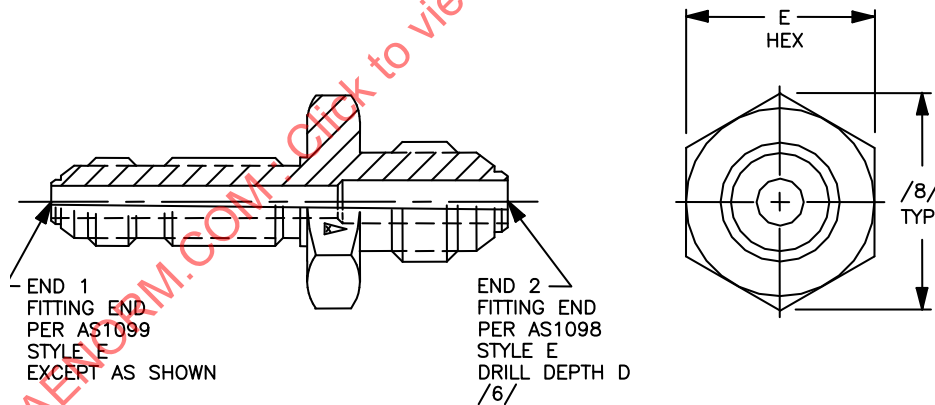
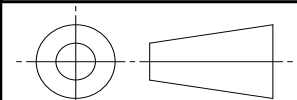


FIGURE 2 - FITTING, UNION, REDUCER, BULKHEAD END REDUCED
SAME AS FIGURE 1 EXCEPT AS SHOWN

SAE values your input. To provide feedback
on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS4328C>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ KSC-F-124



AEROSPACE STANDARD

FITTING, UNION, REDUCER,
BULKHEAD, FLARED TUBE,
FOR SEAL RING

AS4328
SHEET 1 OF 4

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TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NUMBER AS4328 /16/ 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 - .090	B + .000 - .045	C + .000 - .045	D + .000 - .045	E	F ± .010	LB/EA APPROX REF ALUM	LB/EA APPROX REF CRES
0406	.250	.4375-20UNJF	.375	.5625-18UNJF	2.147	1.208	--	.457	.802-.815	.792	.0442	.122
0408	.250	.4375-20UNJF	.500	.7500-16UNJF	2.225	1.208	--	.538	.990-1.003	.980	.0639	.177
0410	.250	.4375-20UNJF	.625	.8750-14UNJF	2.350	1.208	--	.618	1.113-1.128	1.103	.0958	.266
0412	.250	.4375-20UNJF	.750	1.0625-12UNJ	2.491	1.208	--	.703	1.363-1.380	1.353	.131	.362
0416	.250	.4375-20UNJF	1.000	1.3125-12UNJ	2.538	1.208	--	.741	1.613-1.630	1.603	.179	.497
0420	.250	.4375-20UNJF	1.250	1.6250-12UNJ	2.569	1.208	--	.778	1.863-1.880	1.853	.243	.674
0604	.375	.5625-18UNJF	.250	.4375-20UNJF	2.219	1.286	.883	--	.802-.815	.792	.0466	.129
0608	.375	.5625-18UNJF	.500	.7500-16UNJF	2.303	1.286	--	.538	.990-1.003	.980	.0690	.191
0610	.375	.5625-18UNJF	.625	.8750-14UNJF	2.428	1.286	--	.618	1.113-1.128	1.103	.0898	.249
0612	.375	.5625-18UNJF	.750	1.0625-12UNJ	2.569	1.286	--	.703	1.363-1.380	1.353	.136	.376
0804	.500	.7500-16UNJF	.250	.4375-20UNJF	2.352	1.442	1.008	--	.990-1.003	.980	.0771	.214
0806	.500	.7500-16UNJF	.375	.5625-18UNJF	2.358	1.442	1.008	--	.990-1.003	.980	.0796	.221
0810	.500	.7500-16UNJF	.625	.8750-14UNJF	2.584	1.442	--	.618	1.113-1.128	1.103	.110	.304
0812	.500	.7500-16UNJF	.750	1.0625-12UNJ	2.725	1.442	--	.703	1.363-1.380	1.353	.155	.430
0816	.500	.7500-16UNJF	1.000	1.3125-12UNJ	2.772	1.442	--	.741	1.613-1.630	1.603	.204	.565
1004	.625	.8750-14UNJF	.250	.4375-20UNJF	2.517	1.583	1.121	--	1.113-1.128	1.103	.103	.286
1006	.625	.8750-14UNJF	.375	.5625-18UNJF	2.523	1.583	1.121	--	1.113-1.128	1.103	.106	.293
1008	.625	.8750-14UNJF	.500	.7500-16UNJF	2.624	1.583	1.121	--	1.113-1.128	1.103	.115	.319
1012	.625	.8750-14UNJF	.750	1.0625-12UNJ	2.866	1.583	--	.703	1.363-1.380	1.353	.169	.469
1016	.625	.8750-14UNJF	1.000	1.3125-12UNJ	2.913	1.583	--	.741	1.613-1.630	1.603	.218	.604
1204	.750	1.0625-12UNJ	.250	.4375-20UNJF	2.723	1.755	1.258	--	1.363-1.380	1.353	.161	.448
1206	.750	1.0625-12UNJ	.375	.5625-18UNJF	2.729	1.755	1.258	--	1.363-1.380	1.353	.164	.455
1208	.750	1.0625-12UNJ	.500	.7500-16UNJF	2.830	1.755	1.258	--	1.363-1.380	1.353	.173	.481
1210	.750	1.0625-12UNJ	.625	.8750-14UNJF	2.931	1.755	1.258	--	1.363-1.380	1.353	.182	.505
1216	.750	1.0625-12UNJ	1.000	1.3125-12UNJ	3.084	1.755	--	.741	1.613-1.630	1.603	.247	.686
1220	.750	1.0625-12UNJ	1.250	1.6250-12UNJ	3.115	1.755	--	.778	1.863-1.880	1.853	.312	.864
1604	1.000	1.3125-12UNJ	.250	.4375-20UNJF	2.723	1.755	1.258	--	1.613-1.630	1.603	.212	.589
1608	1.000	1.3125-12UNJ	.500	.7500-16UNJF	2.830	1.755	1.258	--	1.613-1.630	1.603	.244	.676
1610	1.000	1.3125-12UNJ	.625	.8750-14UNJF	2.931	1.755	1.258	--	1.613-1.630	1.603	.233	.646
1612	1.000	1.3125-12UNJ	.750	1.0625-12UNJ	3.037	1.755	1.258	--	1.613-1.630	1.603	.250	.692
1620	1.000	1.3125-12UNJ	1.250	1.6250-12UNJ	3.115	1.755	--	.778	1.863-1.880	1.853	.333	.923
1624	1.000	1.3125-12UNJ	1.500	1.8750-12UNJ	3.256	1.755	--	.878	2.109-2.135	2.099	.415	1.150
2004	1.250	1.6250-12UNJ	.250	.4375-20UNJF	2.754	1.802	1.295	--	1.863-1.880	1.853	.299	.828
2012	1.250	1.6250-12UNJ	.750	1.0625-12UNJ	3.068	1.802	1.295	--	1.863-1.880	1.853	.336	.931
2016	1.250	1.6250-12UNJ	1.000	1.3125-12UNJ	3.015	1.802	1.295	--	1.863-1.880	1.853	.331	.917
2024	1.250	1.6250-12UNJ	1.500	1.8750-12UNJ	3.303	1.802	--	.878	2.109-2.135	2.099	.470	1.300
2416	1.500	1.8750-12UNJ	1.000	1.3125-12UNJ	3.147	1.817	1.308	--	2.109-2.135	2.099	.425	1.180
2420	1.500	1.8750-12UNJ	1.250	1.6250-12UNJ	3.194	1.817	1.308	--	2.109-2.135	2.099	.459	1.270
2820	1.750	2.2500-12UNJ	1.250	1.6250-12UNJ	3.379	1.973	1.433	--	2.484-2.510	2.474	.549	1.540
2824	1.750	2.2500-12UNJ	1.500	1.8750-12UNJ	3.504	1.973	1.433	--	2.484-2.510	2.474	.584	1.640
3224	2.000	2.5000-12UNJ	1.500	1.8750-12UNJ	3.629	2.098	1.533	--	2.734-2.760	2.724	.679	1.900
3228	2.000	2.5000-12UNJ	1.750	2.2500-12UNJ	3.754	2.098	1.533	--	2.734-2.760	2.724	.731	2.050



AEROSPACE STANDARD

FITTING, UNION, REDUCER,
BULKHEAD, FLARED TUBE,
FOR SEAL RING

AS4328
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NOTES:

/1/ MATERIAL:

- a. CODE LETTER D: TYPE 2024-T6 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6 OR AMS4112; 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 AMS5639.
- c. CODE LETTER K: 316 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS5648.
- d. CODE LETTER R: 321 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS5645.
- e. CODE LETTER S: 347 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS5646.
- f. CODE LETTER W: TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9 OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS4124.

2. HEAT TREAT:

- a. ALL CODE LETTERS: NONE

3. FINISH:

- a. MATERIAL CODE LETTER D: ANODIZE PER AMS2472 OR MIL-A-8625 TYPE II, CLASS 2, DYE BLUE AND DUPLEX SEAL PER PROCUREMENT SPECIFICATION.
- b. MATERIAL CODE LETTERS J, K, R, AND S; PASSIVATE PER AMS2700, TYPE 6 OR TYPE 7.
- c. MATERIAL CODE LETTER W: ANODIZE PER AMS2472 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 THE NATIONAL AEROSPACE AND DEFENSE CONTRACTORS ACCREDITATION PROGRAM (NADCAP) QUALIFIED MANUFACTURERS LIST (QML) AC7112, AC7112/2 FOR SIMILAR FLARED FITTINGS. THE QML IS AVAILABLE AT www.eAuditNet.com.

/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.
- c. MATERIAL CODE LETTER W: ANODIZE PER AMS2472 OR MIL-A-8625, TYPE II, CLASS 2, DYE BROWN, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.

/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/ HEX CORNERS MAY BE ROUNDED PER ARP1942.

9. INTERPRETATION OF DRAWING PER AS4296.

	AEROSPACE STANDARD	AS4328 SHEET 3 OF 4	REV. C
	FITTING, UNION, REDUCER, BULKHEAD, FLARED TUBE, FOR SEAL RING		