

REV.
A

AS4807

FEDERAL SUPPLY CLASS
4730

RATIONALE

THIS STANDARD HAS BEEN REVISED TO CORRECT THE AS-FORGED LEG DIMENSION TO ALLOW STANDARD TOLERANCE FORGINGS TO BE USED AND STILL MEET THE SPECIFICATION.

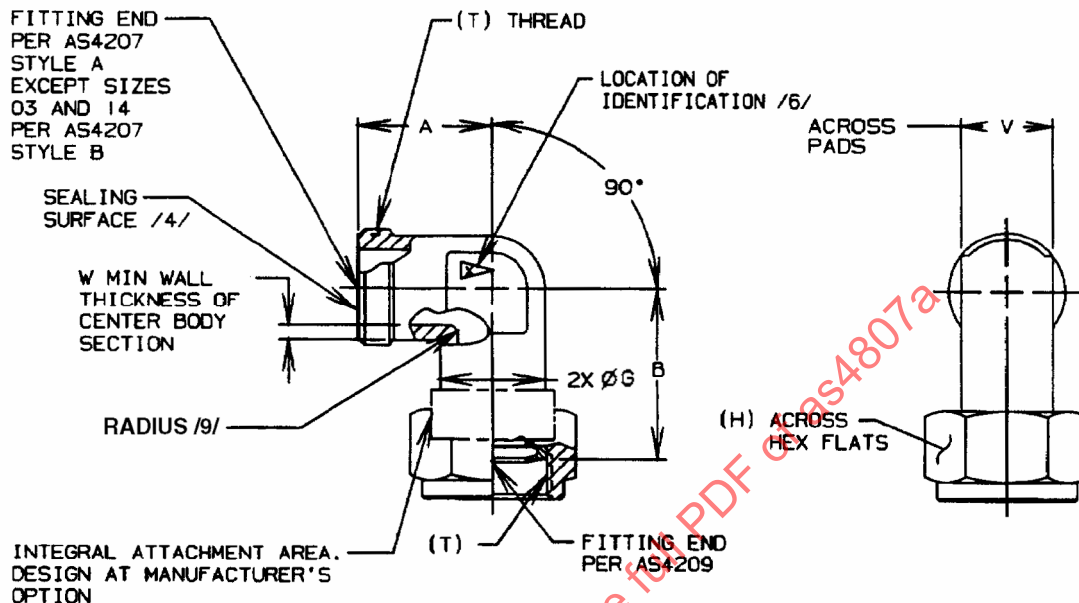
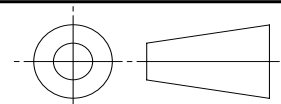


FIGURE 1 - FITTING ASSEMBLY, ELBOW, 90°

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4807 /16/ SIZE CODE	(NOMINAL TUBE SIZE)	T THREAD PER AS8879 CLASSES A AND B	A	B	G MIN	H	V	W	LB/EA MAX CRES	LB/EA MAX TI
03	.188	.3750-28 UNJS	.575	.781	.330	.500	.360-.377	.055	.0480	.0274
04	.250	.4375-24 UNJS	.617	.808	.374	.562	.360-.377	.060	.0554	.0317
05	.312	.5000-24 UNJS	.653	.850	.436	.625	.423-.440	.060	.0716	.0409
06	.375	.5625-20 UNJS	.704	.945	.499	.688	.485-.502	.060	.0894	.0511
08	.500	.7188-20 UNJS	.824	1.045	.650	.875	.547-.565	.065	.129	.0738
10	.625	.8438-18 UNJS	.955	1.178	.748	1.000	.673-.681	.070	.183	.105
12	.750	1.0000-16 UNJ	1.062	1.316	.955	1.125	.860-.878	.095	.271	.155
14	.875	1.1250-16 UNJ	1.216	1.514	1.210	1.375	1.110-1.128	.105	.541	.309
16	1.000	1.2500-14 UNJS	1.246	1.529	1.210	1.500	1.110-1.128	.115	.509	.291
20	1.250	1.5781-14 UNJS	1.387	1.847	1.480	1.875	1.355-1.380	.110	.788	.450
24	1.500	1.8438-14 UNJS	1.688	2.171	1.740	2.125	1.605-1.630	.130	1.20	.683

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /5/ AS85421, AS85720

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

(R) FITTING ASSEMBLY, ELBOW, 90°,
BEAM SEAL, RETAINED NUT

AS4807
SHEET 1 OF 3

**REV.
A**

NOTES:

/1/ MATERIAL:

a. CODE LETTER T

(1) BODY: TYPE 6AL-4V TITANIUM ALLOY FORGING OR BAR PER AMS 4965.

(2) NUT: TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS 4965.

b. CODE LETTER P

(1) BODY: TYPE 17-4PH CORROSION RESISTANT STEEL FORGING OR BAR PER AMS 5643.

(2) NUT: TYPE 17-4PH CORROSION RESISTANT STEEL BAR PER AMS 5643.

c. CODE LETTER V

(1) BODY: TYPE 15-5PH CORROSION RESISTANT STEEL FORGING OR BAR PER AMS 5659.

(2) NUT: TYPE 15-5PH CORROSION RESISTANT STEEL BAR PER AMS 5659.

2. HEAT TREAT:

a. MATERIAL CODE LETTER T

(1) BODY AND NUT: NONE.

b. MATERIAL CODE LETTERS P AND V

(1) BODY AND NUT: HEAT TREAT TO CONDITION H 1075 PER AMS 2759/3.

3. FINISH:

a. MATERIAL CODE LETTER T

(1) BODY: NONE.

(2) NUT: NONE.

b. MATERIAL CODE LETTERS P AND V

(1) BODY: PASSIVATE PER AMS 2700.

(2) NUT: PASSIVATE PER AMS 2700.

/4/ DRY FILM LUBRICANT: APPLY DRY FILM LUBRICANT PER AS5272, TYPE I TO THE SEALING SURFACE. OVERSPRAY IN BORE IS NOT PERMITTED. APPLY DRY FILM LUBRICANT PER AS5272, TYPE I TO THE INSIDE OF THE NUT. MINOR OVERSPRAY IS PERMITTED ON THE NUT.

/5/ PROCUREMENT SPECIFICATION: AS85421 FOR OPERATING PRESSURES TO 4000 PSI AND AS85720 FOR OPERATING PRESSURES TO 5000 PSI, EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION AS APPLICABLE IN A COMPLETE ASSEMBLY. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.