



AEROSPACE STANDARD

AS4842

Issued 1995-05
Reaffirmed 2015-06

Fittings and Bosses, Pipe Threaded, Fluid Connection

RATIONALE

AS4842 has been reaffirmed to comply with the SAE five-year review policy.

1. SCOPE:

1.1 Scope:

This SAE Aerospace Standard (AS) establishes the requirements for 37° flared tube or machined cone fluid connection fittings (see Section 6) for use in all types of fluid systems.

1.2 Classification:

Fittings shall be furnished in the types and styles designated by the applicable AN, AS, MS, NAS, or other engineering standard drawings. This specification is the same as MIL-F-5509 as applicable to pipe threaded fittings and bosses except for updated materials and process specifications and industry coordinated general improvements. It is intended to serve as a procurement specification for the fittings described herein and in Section 6.

2. REFERENCES:

2.1 Applicable Documents:

The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order. In the event of conflict between the text of this specification and references cited herein, the text of this specification takes precedence. Nothing in this specification, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

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on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS4842>

2.1.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AMS 4112	Aluminum Alloy Bars, Rods, and Wire, Rolled, Drawn, or Cold Finished 4.4Cu - 1.5Mg - 0.60Mn (2024-T6)
AMS 4124	Bars, Rods, and Wire, Rolled, Drawn or Cold Finished, 5.62N 2.5Mg 1.6Cu 0.23Cr
AMS 4134	Aluminum Alloy Die Forgings 4.4Cu - 0.85Si - 0.80Mn - 0.50Mg (2014-T4) Solution Heat Treated
AMS 4141	Forgings, Die, 5.6Zn - 2.6Mg - 7.6Cu - 0.23Cr, Solution and Precipitation Heat Treated
AMS 4610	Bars and Rods, Brass, Free Cutting 61.5Cu 3.1Pb 35Zn, Half Hard (H02)
AMS 5639	Bars, Wire, Forgings, Tubing and Rings, 19Cr 10Ni Solution Heat Treated
AMS 5645	Bars, Forgings, Tubing and Rings, 18Cr 10Ni 0.40Ti Solution Heat Treated
AMS 5646	Bars, Forgings, Tubing and Rings, 18Cr 11Ni 0.60 (Cr + Ta), Solution Heat Treated
AMS 5648	Bars, Forgings, Tubing and Rings, 17Cr 12Ni 2.5Mo, Solution Heat Treated
AMS 6370	Steel Bars, Forgings and Rings, 0.95Cr 0.20Mo (0.28-0.30C)
AMS 6382	Steel Bars, Forgings and Rings, 0.95Cr 0.20Mo (0.38-0.43C)
AS478	Identification Marking Methods
AS1376	Alternate Dimensions, Center Body Section, Shape Fluid Fitting, Design Standard
ARP4784	Performance and Evaluation Criteria, Surface Defects, Requirements for

2.1.2 U.S. Government Publications: Available from DODSSP, Subscription Services Desk, Building 4D,
700 Robbins Avenue, Philadelphia, PA 19111-5094.

P-C-437	Cleaning Compound, High Pressure (Steam) Cleaner
QQ-A-225/6	Aluminum Alloy Bar, Rod, and Wire; Rolled, Drawn, or Cold Finished, 2024
QQ-A-225/9	Aluminum Alloy Bar, Rod, Wire, and Special Shaped; Rolled, Drawn, or Cold Finished, 7075
QQ-A-367	Aluminum Alloy Forgings
QQ-B-728	Bronze Manganese: Rod, Shapes, Forgings, and Flat Products (Flat Wire, Strip, Sheet, Bar and Plate)
QQ-P-35	Passivation Treatments for Corrosion-Resisting Steel
QQ-P-416	Plating, Cadmium (Electro-deposited)
QQ-S-763	Steel Bars, Wire, Shapes and Forgings, Corrosion-Resisting
MIL-S-5626	Steel: Chrome Molybdenum (4140) Bars, Rods and Forging Stock (For Aircraft Applications)
MIL-H-6083	Hydraulic Fluid, Petroleum Base, For Preservation and Operation
MIL-H-6088	Heat Treatment of Aluminum Alloys
MIL-S-6758	Steel, Chrome-Molybdenum (4130) Bars and Reforging Stock (Aircraft Quality)

2.1.2 (Continued):

MIL-H-6875	Heat Treatment of Steels (Aerospace Practice, Process For)
MIL-P-7105	Pipe Threads, Taper, Aeronautical National Form, Symbol Anpt, General Requirements For
MIL-A-8625	Anodic Coatings, for Aluminum and Aluminum Alloys
MIL-H-46170	Hydraulic Fluid, Rust Inhibited, Fire Resistant Synthetic Hydrocarbon Base

ANA Bulletin No. 431 Air Force-Navy Aeronautical Bulletin Fittings, Flared, Classification of Defects of

FED-STD-595 Colors Used in Government Procurement

MIL-STD-105 Sampling Procedures and Tables for Inspection by Attributes

MS33677 Fitting End, Taper Pipe Thread, Standard Dimensions for

AND10053 Bosses: Pipe - Thread, Internal - Standard Dimensions for

2.1.3 ANSI Publications: Available from ANSI, 11 West 42nd Street, New York, NY 10036-8002.

ANSI/ASME B46.1 Surface Texture (Surface Roughness, Waviness, and Lay)

2.1.4 ASTM Publications: Available from ASTM, 1916 Race Street, Philadelphia, PA 19103-1187.

ASTM A 108	Steel Bars, Carbon, Cold-finished, Standard Quality
ASTM A 370	Steel Products, Mechanical Testing of
ASTM B 16	Specification for Free-Cutting Brass Rod, Bar and Shapes for Use in Screw Machines
ASTM B 124	Copper and Copper-Alloy Forging Rod, Bar and Shapes
ASTM B 154	Copper and Copper Alloys, Mercurous Nitrate Test for

3. TECHNICAL REQUIREMENTS:

3.1 Material:

Fittings shall be fabricated of materials listed in Table 1 or as specified on the applicable part standard drawing.

TABLE 1 - Materials

Material	Type of Part	Form /1/	Specification	Alloy and Temper	Material Code
Aluminum alloy	Straight fittings, nuts	Bars, rods	QQ-A-225/6	2024-T6 or T851	D
			AMS 4112	2024-T6	D
			QQ-A-225/9	7075-T73	W
			AMS 4124	7075-T7351	W
	Shape fittings, nuts	Forgings	QQ-A-367	2014-T6	D
			AMS 4134	2014-T6	D
			QQ-A-367	7075-T73	W
			AMS 4141	7075-T73	W
	Shape fittings	Bars	QQ-A-225/6	2024-T6 or T851	D
			AMS 4112	2024-T6	D
			QQ-A-225/9	7075-T73	W
			AMS 4124	7075-T7351	W
Carbon steel /2/	Fittings, nuts, sleeves	Bars, rods	ASTM A 108	1137	None
			MIL-S-6758	4130	None
			AMS 6370	4130	None
			MIL-S-5626	4140	None
			AMS 6382	4140	None
	Shape fittings	Forgings	ASTM A 108 /3/	1137	None
			MIL-S-6758 /3/	4130	None
			AMS 6370	4130 Cold Finished	None
			MIL-S-5626 /3/	4140	None
			AMS 6382	4140 Cold Finished	None
	Straight fittings	Bars, rods	QQ-B-728	Half hard	B (None, C) /6/
			ASTM B 16	Alloy 360, half hard	B (None, C) /6/
Copper-base alloy /5/	Straight fittings	Bars, rods	AMS 4610	Alloy 360, half hard	B (None, C) /6/
			QQ-B-728	Half hard	B (None) /6/
	Shape fittings	Bars	QQ-B-728	Half hard	B (None) /6/
		Forgings	QQ-B-728	Soft or half hard	B (None) /6/
			ASTM B 124	Alloy 377	B (None) /6/
			AMS 4614	Alloy 377	B (None) /6/
Corrosion-resistant steel	Fittings	Bars	QQ-S-763	Class 304, Cond A	J
			AMS 5639	Class 304, Cond A	J
			QQ-S-763	Class 316, Cond A	K
			AMS 5648	Class 316, Cond A	K
			QQ-S-763	Class 321, Cond A	R
			AMS 5645	Class 321, Cond A	R
			QQ-S-763 /4/	Class 347, Cond A	S
			AMS 5646 /4/	Class 347, Cond A	S
	Shape fittings	Forgings	QQ-S-763	Class 304, Cond A	J
			AMS 5639	Class 304, Cond A	J
			QQ-S-763	Class 316, Cond A	K
			AMS 5648	Class 316, Cond A	K
			QQ-S-763	Class 321, Cond A	R
			AMS 5645	Class 321, Cond A	R
			QQ-S-763 /4/	Class 347, Cond A	S
			AMS 5646 /4/	Class 347, Cond A	S

/1/ The center body section of shape fittings machined from bar or oversized forgings shall conform to AS1376.

/2/ The hardness of finished carbon steel parts shall be 90 HRB to 31 HRC per 3.1.4. If the materials are procured with this requirement as a supplement to the specification, the purchase order shall specify that any heat treatment applied shall be per MIL-H-6875 (see 3.1.2.2).

/3/ This document is for bar from which forgings shall be made and only the chemical composition applies.

/4/ Type 347 corrosion-resistant steel shall not be used for new manufacture but type code "S" parts may be used until existing stocks are depleted.

/5/ QQ-B-728 is manganese bronze. QQ-B-626, AMS 4610, and AMS 4614 are brass.

/6/ Code letter B is preferred. Codes in parentheses are on some older standards.

3.1.2 Heat Treatment:

- 3.1.2.1 Aluminum Alloy: Aluminum alloy fittings and nuts shall be supplied in the final temper as shown in Table 1. When fitting material is purchased in other than the final temper, the process control shall be in accordance with MIL-H-6088.
- 3.1.2.2 Steel: When additional processing is required to comply with hardness requirements of 3.1.4, heat treatment shall be in accordance with MIL-H-6875.
- 3.1.3 Internal Strain of Copper-base Alloys: Fittings fabricated from copper-base alloys shall have no internal strain as revealed by the test specified in 4.4.2. After testing, the parts shall be examined; any evidence of cracks indicates internal strain and is not acceptable.
- 3.1.4 Additional Physical Properties: Unless otherwise specified on the applicable drawings, the hardness of the finished carbon steel parts with plating removed shall be 92 HRB to 31 HRC. For carbon steel fittings below a hardness of 20 HRC, hardness tests shall be made using the B scale, in which case the hardness shall be within the range of 92 to 99 HRB.

3.2 Design and Fabrication:

The design and fabrication of the fittings shall be in accordance with the applicable drawings. The fitting and tube ends shall be in accordance with AS1708, AS4395, AS4396, MS24385, MS24386, MS33583, MS33584, MS33656, or MS33657 as applicable. Dimensional requirements are applicable after heat treatment and protective finishing. The center body section of shape fittings machined from bar or oversized forgings shall conform to AS1376.

- 3.2.1 Shape and Form Restrictions: Abrupt reductions of section shall be avoided. Small external sections adjoining relatively heavy body sections shall transition into the heavier sections by means of ample fillets.
- 3.2.2 Passages:
 - 3.2.2.1 Drill Offset: On straight fittings where the fluid passage is drilled from each end, the offset between the drilled holes at the meeting point of the drills shall not exceed .015 in. It shall be possible to pass through the fluid passage a ball whose diameter is .020 less than the minimum diameter specified for the passage. This does not mean that the drilled passage may be smaller than that required by the detail drawings.
 - 3.2.2.2 Cross Section at Fluid Path Junction: On shape fittings, the cross-sectional area at the junction of fluid passages shall be such that it shall be possible to pass through the fitting from end to end, a ball whose diameter is not less than .7 times the minimum diameter specified for the smaller passage.

3.2.3 Threads: Pipe threads shall conform to MIL-P-7105 unless otherwise specified. Steel, corrosion-resistant steel, and aluminum alloy threads may be cut, ground, or rolled (see 3.2.3.1). Copper alloy threads shall be cut or ground only.

3.2.3.1 Rolled External Threads: Laps and seams, whose depths are within the limits of Table 2, are acceptable on the crest, and the nonpressure thread flank above the pitch diameter. Laps and seams are not acceptable on any part of the pressure thread flank, in the thread root, or on the nonpressure thread flank extending from above to below the pitch diameter (see Figure 1). Stress cracks are unacceptable.

TABLE 2 - Depth of Laps, Seams, Surface Irregularities, and Discontinuities in Rolled Threads

Nominal Pipe Size, Inches	Depth, Inch, Max
.125	.006
.250	.007
.375	.008
.500	.009
.750 through 2.000	.010

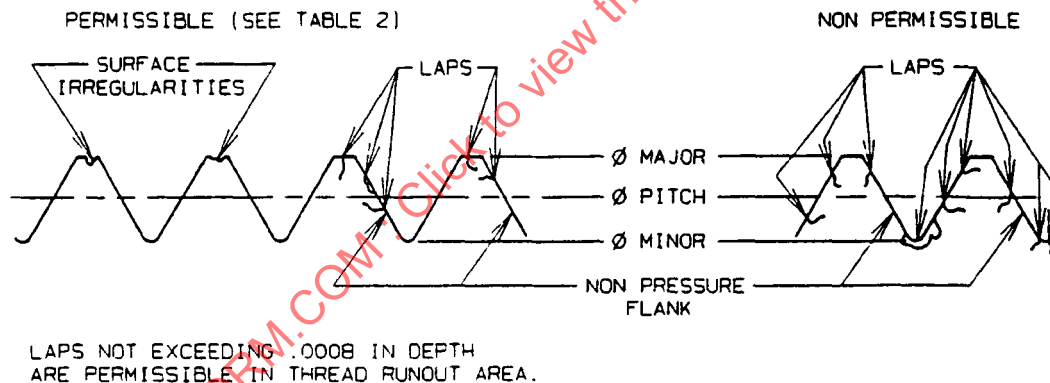


FIGURE 1 - Laps and Surface Irregularities in Threads

3.3 Finish:

3.3.1 Aluminum Alloy Fittings: Aluminum alloy fittings, sleeves, and nuts shall be anodized in accordance with MIL-A-8625, Type II, Class 2, dyed blue or brown as applicable (see 3.4.4) and shall be duplex sealed.

- 3.3.2 Carbon Steel Fittings: Carbon steel fittings, sleeves, and nuts shall be cadmium plated in accordance with QQ-P-416, Type II, Class 2, dyed black (see 3.4.4). All such carbon steel fittings, sleeves, and nuts shall be dipped in oil conforming to MIL-H-6083 or MIL-H-46170. Fluid passage holes, other openings, and internal threads shall not be subject to a plating thickness requirement and may exhibit bare areas provided that they are protected with a light film of oil.
- 3.3.3 Corrosion-Resistant Steel Fittings: Corrosion-resistant steel fittings, nuts, and sleeves shall be passivated per QQ-P-35, Type VI or VII.
- 3.3.4 Copper-base Alloy Fittings: Plating of copper-base alloy fittings in accordance with QQ-P-416, Type II, Class 3 is optional.

3.4 Identification of Product:

All fittings, nuts, and sleeves shall be marked in accordance with the following instructions. The marking shall be applied per AS478 as specified on the applicable drawing in a location not detrimental to the performance of the fitting and not detrimental to the corrosion protection of the fitting. When items cannot be physically marked because of lack of space or because marking would have a deleterious effect, the package shall provide the identification per 5.4.

- 3.4.1 Manufacturer's Identification: Unless otherwise specified, all fittings and nuts shall be marked with the manufacturer's name, CAGE code or trademark and with the letters AN, MS, AS, or NAS as applicable.
- 3.4.2 Material Identification: Fittings, nuts, and sleeves shall be marked with the material code letter as shown in Table 1.
- 3.4.3 Marking for Part Number and Size: A numerical equivalent to the nominal tube size is optional. All fittings larger than .375 in nominal pipe size shall be marked with the part number, exclusive of size. Fittings previously manufactured to AN, AS, MS, or NAS standards that meet all other requirements of this document and the applicable part standards may retain their identification in addition to the previous requirements.
- 3.4.4 Color Identification: In addition to the markings specified, the fittings, nuts, and sleeves shall be identified by the following colors:
- Aluminum alloys 2014 and 2024: Blue (see 3.3.1)
 - Aluminum alloy 7075: Brown (see 3.3.1)
 - Steel: Black (see 3.3.2)
 - Copper-base alloys: Natural cadmium plate, if applicable (see 3.3.4)
 - Corrosion-resistant steel: None

3.5 Workmanship:

Machined surfaces of fittings, sleeves, and nuts shall be as specified on the applicable drawings. Unmachined surfaces, such as forged surfaces and bar stock flats, shall be free from blisters, fins, folds, seams, laps, cracks, segregations, spongy areas, or other defects as specified in ARP4784. Surface defects may be explored by suitable etching and if they can be removed so that they do not appear on re-etching and the required section thickness can be maintained, they shall not be cause for rejection. The surface texture of unmachined surfaces, except forging parting lines, shall be 250 μ in Ra per ANSI/ASME B46.1. The surface texture of forging parting planes shall be 500 μ in Ra per ANSI/ASME B46.1.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection and test requirements as specified herein. Except as otherwise specified, the supplier may utilize their own facilities or any commercial laboratory acceptable to the purchaser for the performance of the inspection and test requirement. The purchaser reserves the right to perform any of the inspections and tests set forth in this document whenever such inspections and tests are deemed necessary to assure that supplies and services conform to prescribed requirements.

4.2 Inspection Lot:

A lot shall consist of all the fittings of a given part number, made from the same batch of material and processed at the same time.

4.2.1 Material Certification: Records of the chemical composition analysis and mechanical property tests showing conformance to the material requirements of this document shall be available to the procuring activity upon request for each lot of fittings except that for aluminum alloys a certificate of conformance to the chemical analysis requirement may be furnished in lieu of an actual chemical analysis test report.

4.3 Quality Conformance Inspection:

4.3.1 Sampling:

4.3.1.1 Sampling for Nondestructive Tests: Samples for heat treatment, threads, finish, dimensions, marking, surface defects, durability of finish, and workmanship shall be taken at random in accordance with MIL-STD-105, Inspection Level S-3 with an AQL of 4.0%, unless otherwise specified in ANA Bulletin No. 431. ANA Bulletin No. 431 will not be used for government purposes. Government acceptance will be based upon a sampling plan which accepts on zero defects.

- 4.3.1.2 Sampling for Destructive Tests: Sampling for hardness (4.4.1) and internal strain of copper-base alloys (4.4.2), shall be performed in accordance with MIL-STD-105, Inspection Level S-3, with an AQL of 4.0%. Government acceptance will be based upon a sampling plan which accepts on zero defects.
- 4.3.2 Examination and Inspection Methods: Each lot of fittings shall be examined and inspected as specified in Table 3.

TABLE 3 - Quality Conformance Inspection

Examination or Inspection	Requirement Paragraph	Examination or Inspection Paragraph
Material requirements	3.1	4.2.1
Internal strain of copper-base alloys	3.1.3	4.4.2
Hardness of carbon steel fittings	3.1.4	4.4.1
Design and dimensions	3.2	4.3.2.1
Finish	3.3	4.3.2.1, 4.4.4
Identification of product	3.4	4.3.2.1
Workmanship	3.5	4.3.2.1

- 4.3.2.1 Examination of Product: Each lot of fittings will be examined to determine conformance with this document and the applicable standard with respect to material, dimensions, passages, threads, wall thickness, surface defects, finish, marking, and workmanship.
- 4.4 Tests:
- 4.4.1 Hardness of Steel Fittings: The hardness of steel fittings shall be determined by hardness tests of the fittings. Rockwell hardness readings shall be taken on a smooth flat surface of any unthreaded portion of the fitting from which the plating has been removed. Hardness tensile strength relationships are specified in ASTM A 370. For this document, the hardness scale to scale conversions and hardness to tensile strength conversions of Tables 2A, 2B, 2C, and 2D of ASTM A 370 may be considered as equivalent.
- 4.4.2 Internal Strain of Copper-base Alloys: Fittings fabricated from copper-base alloys, as specified herein, shall be tested per ASTM B 154.
- 4.4.3 Durability of Finish: Dyed fittings shall withstand immersion in a cleaning solution containing 5 to 6 oz of a cleaner conforming to P-C-437 per gallon of solution at a temperature of 160 to 170 °F for 5 min. The color shall not rub off when wiped lightly with a clean cloth.