

SAE Technical Standards Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

SAE reviews each technical report at least every five years at which time it may be revised, reaffirmed, stabilized, or cancelled. SAE invites your written comments and suggestions.

REV.
C

AS5230

FEDERAL SUPPLY CLASS
4730

RATIONALE

REVISION TO CORRECT EDITORIAL ERRORS IN PUBLISHED AS5230B (TABLE-1A MISSING VALUES FOR SIZES -16 AND LARGER; TABLE-1B MISSING TABLE; TABLE-1 DIMENSION "A" FOR SIZE 10-05 CHANGED TO 3 DIGITS).

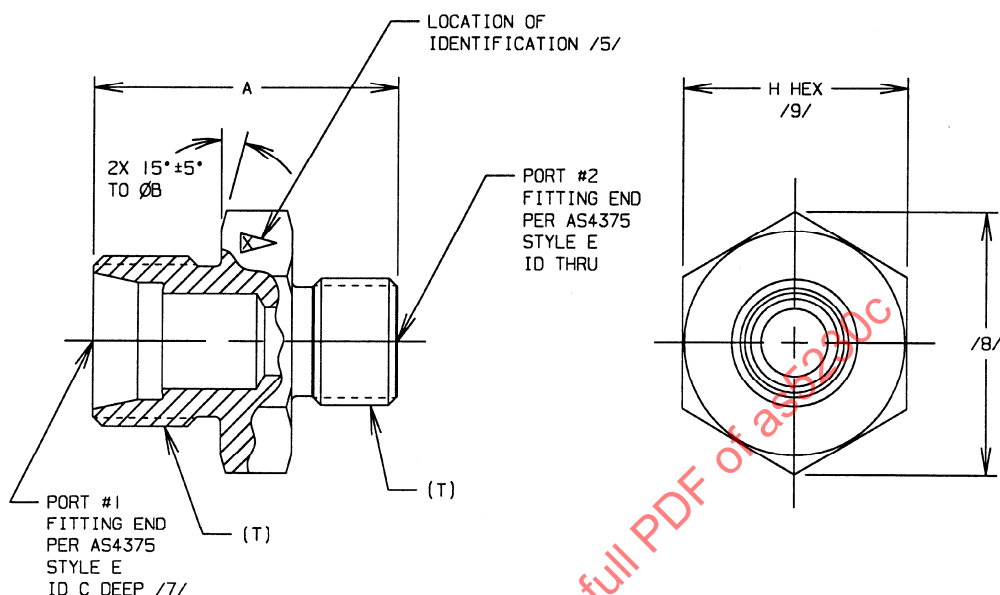


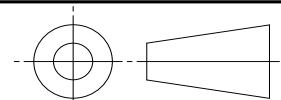
FIGURE 1 - FITTING, UNION AND REDUCER

TABLE 1 - DIMENSIONS /11/

PORT #1 /18/ SIZE CODE	PORT #2 SIZE CODE 02	PORT #2 SIZE CODE 03	PORT #2 SIZE CODE 04	PORT #2 SIZE CODE 05	PORT #2 SIZE CODE 06	PORT #2 SIZE CODE 08	PORT #2 SIZE CODE 10	PORT #2 SIZE CODE 12	PORT #2 SIZE CODE 14	PORT #2 SIZE CODE 16	PORT #2 SIZE CODE 20	PORT #2 SIZE CODE 24	PORT #2 SIZE CODE 32
02	1.063	-	-	-	-	-	-	-	-	-	-	-	-
03	1.047	1.094	-	-	-	-	-	-	-	-	-	-	-
04	1.094	1.141	1.063	-	-	-	-	-	-	-	-	-	-
05	-	-	1.156	1.063	-	-	-	-	-	-	-	-	-
06	1.156	1.203	1.219	1.219	1.188	-	-	-	-	-	-	-	-
08	1.250	1.297	1.344	1.344	1.375	-	-	-	-	-	-	-	-
10	-	-	1.438	1.438	1.625	1.531	1.563	-	-	-	-	-	-
12	-	-	1.531	1.531	1.531	1.625	1.688	1.750	-	-	-	-	-
14	-	-	1.531	1.531	1.531	1.625	1.688	1.750	1.750	-	-	-	-
16	-	-	1.531	-	-	-	1.688	1.750	-	1.750	-	-	-
20	-	-	1.531	-	-	-	-	1.813	-	1.750	1.750	-	-
24	-	-	-	-	-	-	-	-	-	1.750	1.750	1.750	-
32	-	-	-	-	-	-	-	-	-	-	-	-	1.813

SAE values your input. To provide feedback
on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS5230C>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS18280 /4/



AEROSPACE STANDARD

(R) FITTING, UNION AND REDUCER, FLARELESS

AS5230
SHEET 1 OF 4

REV.
C

TABLE 1A - DIMENSIONS

PORT #1 /18/ SIZE CODE	C ± .031 PORT #2 SIZE CODE 02	C ± .031 PORT #2 SIZE CODE 03	C ± .031 PORT #2 SIZE CODE 04	C ± .031 PORT #2 SIZE CODE 05	C ± .031 PORT #2 SIZE CODE 06	C ± .031 PORT #2 SIZE CODE 08	C ± .031 PORT #2 SIZE CODE 10	C ± .031 PORT #2 SIZE CODE 12	C ± .031 PORT #2 SIZE CODE 14	C ± .031 PORT #2 SIZE CODE 16	C ± .031 PORT #2 SIZE CODE 20	C ± .031 PORT #2 SIZE CODE 24	C ± .031 PORT #2 SIZE CODE 32
02	-	-	-	-	-	-	-	-	-	-	-	-	-
03	.547	-	-	-	-	-	-	-	-	-	-	-	-
04	.594	.594	-	-	-	-	-	-	-	-	-	-	-
05	-	-	.578	-	-	-	-	-	-	-	-	-	-
06	.625	.625	.625	.625	-	-	-	-	-	-	-	-	-
08	.719	.719	.719	.719	.719	-	-	-	-	-	-	-	-
10	-	-	.781	.671	.781	.781	-	-	-	-	-	-	-
12	-	-	.875	.875	.875	.875	.875	-	-	-	-	-	-
14	-	-	.875	.875	.875	.875	.875	.875	-	-	-	-	-
16	-	-	.875	-	-	-	.875	.875	-	-	-	-	-
20	-	-	.875	-	-	-	-	.875	-	.875	-	-	-
24	-	-	-	-	-	-	-	-	-	.875	.875	-	-
32	-	-	-	-	-	-	-	-	-	-	-	-	-

TABLE 1B - DIMENSIONS AND WEIGHTS /10/

PORT #1 SIZE CODE	(NOMINAL TUBE SIZE)	T THREAD PER AS8879 CLASS 3A	B ±.010	H	LB/EA APPROX REF AL	LB/EA APPROX REF STEEL	LB/EA APPROX REF TI
02	.125	.3125-24 UNJF	.542	.552-.565	.0138	.0396	.0218
03	.188	.3750-24 UNJF	.605	.615-.628	.0165	.0474	.0261
04	.250	.4375-20 UNJF	.668	.678-.691	.0164	.0470	.0259
05	.312	.5000-20 UNJF	.730	.740-.753	.0201	.0577	.0319
06	.375	.5625-18 UNJF	.792	.802-.815	.0286	.0821	.0453
08	.500	.7500-16 UNJF	.980	.990-1.003	.0508	.146	.0805
10	.625	.8750-14 UNJF	1.103	1.113-1.128	.0769	.221	.122
12	.750	1.0625-12 UNJ	1.353	1.363-1.380	.121	.348	.192
14	.875	1.1875-12 UNJ	1.478	1.488-1.505	.142	.408	.225
16	1.000	1.3125-12 UNJ	1.603	1.613-1.630	.167	.478	.264
20	1.250	1.6250-12 UNJ	1.853	1.863-1.880	.235	.676	.373
24	1.500	1.8750-12 UNJ	2.099	2.109-2.135	.279	.801	.442
32	2.000	2.5000-12 UNJ	2.724	2.734-2.760	.509	1.46	.807

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:

- DASH AS CODE LETTER - TYPE 4130 ALLOY STEEL BAR PER AMS6370. /2/
- CODE LETTER D - TYPE 2024-T6 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6 OR AMS4339 OR TYPE 2024-T851 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6. /2/
- CODE LETTER J - TYPE 304 CORROSION RESISTANT STEEL BAR PER AMS5639.
- CODE LETTER K - TYPE 316 CORROSION RESISTANT STEEL BAR PER AMS5648.
- CODE LETTER R - TYPE 321 CORROSION RESISTANT STEEL BAR PER AMS5645.
- CODE LETTER T - TYPE 6Al - 4V TITANIUM ALLOY BAR PER AMS4928.

	AEROSPACE STANDARD	AS5230 SHEET 2 OF 4	REV. C
	(R) FITTING, UNION AND REDUCER, FLARELESS		

- g. CODE LETTER V - TYPE 15-5PH CORROSION RESISTANT STEEL BAR PER AMS5659. /2/
- h. 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/
- /2/ HEAT TREATMENT:
- DASH AS MATERIAL CODE LETTER - SEE HARDNESS REQUIREMENT PER PROCUREMENT SPECIFICATION.
 - MATERIAL CODE LETTERS D AND W - SEE ELECTRICAL CONDUCTIVITY AND HARDNESS REQUIREMENT PER PROCUREMENT SPECIFICATION.
 - MATERIAL CODE LETTER V - HEAT TREAT TO CONDITION H-1075 PER AMS2759/3.
 - OTHER MATERIAL CODE LETTERS - NONE.
3. FINISH:
- DASH AS MATERIAL CODE LETTER - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 AND COAT WITH A LIGHT FILM OF OIL PER PROCUREMENT SPECIFICATION.
 - MATERIAL CODE LETTER D - ANODIZE PER MIL-A-8625, TYPE II, CLASS 2, DYE GREEN, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.
 - MATERIAL CODE LETTER J, K, AND R - PASSIVATE PER AMS2700 PER PROCUREMENT SPECIFICATION.
 - MATERIAL CODE LETTER T - ANODIZE PER AMS2488 OR FLUORIDE PHOSPHATE CONVERSION COAT PER AMS2486 WITH COLOR PER PROCUREMENT SPECIFICATION.
 - MATERIAL CODE LETTER V:
 - PASSIVATE PER AMS2700, TYPE 2 OR 8.
 - SUFFIX FINISH CODE LETTER "P": CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
 - MATERIAL CODE LETTER W - ANODIZE PER MIL-A-8625, TYPE II, CLASS 2, DYE BROWN, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.
- /4/ PROCUREMENT SPECIFICATION: AS18280 EXCEPT AS SPECIFIED 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 PRI-QPL-AS18280 FOR THIS STANDARD. SEE www.eAuditNet.com FOR CURRENT QPL ONLINE.
- NOTE: PRI-QPL LIMITATION - WITH REVISION A OF THIS STANDARD THE PROCUREMENT SPECIFICATION HAS BEEN CHANGED FROM AS4444 FOR 5000 PSI TO AS18280 FOR 3000 PSI. USERS OF THIS FITTING FOR 5000 PSI APPLICATIONS PER AS4444 ARE ADVISED TO CONTROL SOURCE APPROVAL BY STANDARD PAGE SUPPLEMENT OR SIMILAR MEANS.
- /5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B.
- FOR SIZE 06 AND SMALLER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, LETTER "AS" AND MATERIAL CODE LETTER.
 - FOR SIZE 08 AND LARGER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, BASIC PART NUMBER AND MATERIAL CODE LETTER.
6. INTENDED USE:
- THIS STANDARD IS THE FUNCTIONAL EQUIVALENT OF MS21902 AND MS21916 AND IS INTENDED TO BE SUITABLE AS A REPLACEMENT STANDARD.
 - CLEANING OF ALUMINUM ALLOY AND CORROSION RESISTANT STEEL FITTINGS IN ACCORDANCE WITH ARP1176 (CODE LETTER "A") IS REQUIRED FOR OXYGEN SYSTEMS TO AVOID FIRE DUE TO PARTICLES OR OTHER CONTAMINANTS.
- /7/ THE INTERNAL DIAMETER SHALL END IN A CONICAL END OF 110° MINIMUM INCLUDED ANGLE.

	AEROSPACE STANDARD		AS5230 SHEET 3 OF 4	REV. C
	(R) FITTING, UNION AND REDUCER, FLARELESS			