

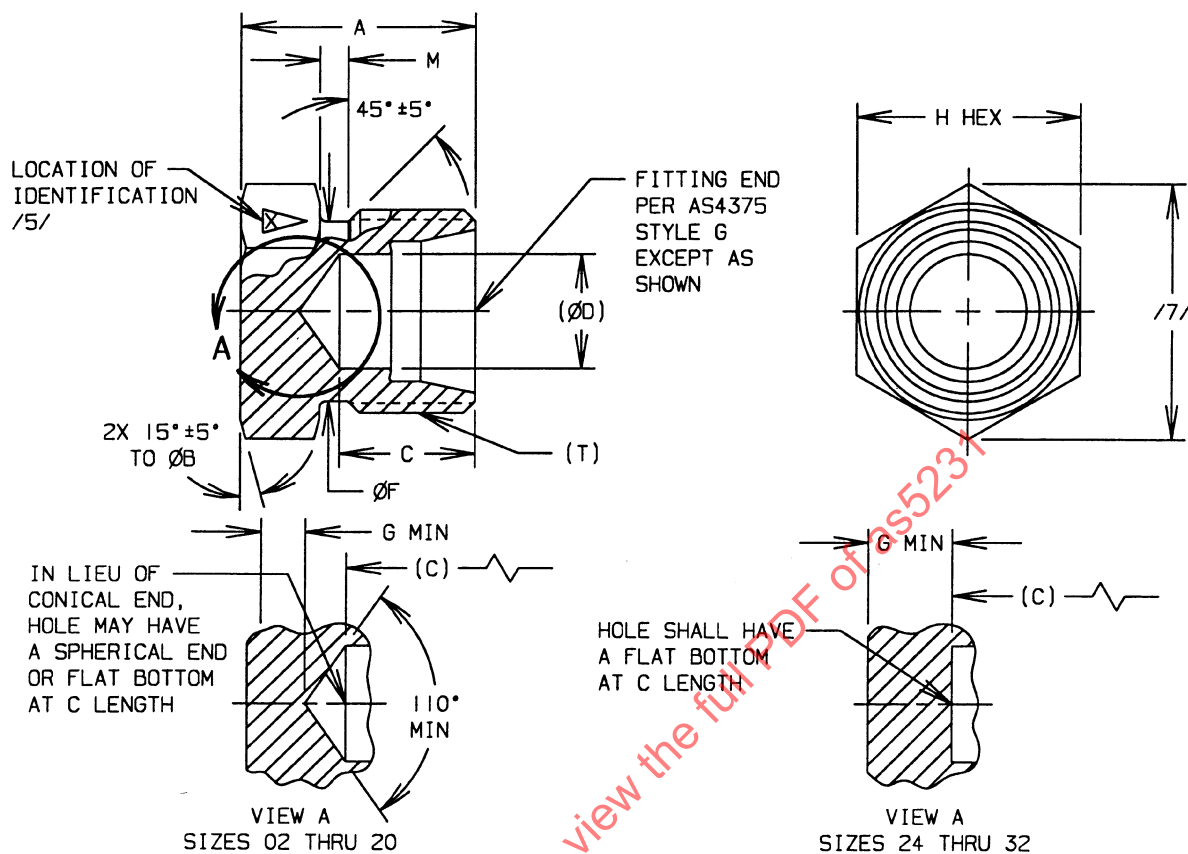
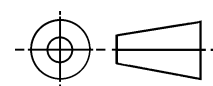


FIGURE 1 - FITTING, PLUG

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS4444

SAE Aerospace
 An SAE International Group

AEROSPACE STANDARD

FITTING, PLUG, TUBE END, FLARELESS

AS5231
 SHEET 1 OF 4

TABLE 1 - DIMENSIONS

BASIC NO. AS5231 /13/ SIZE CODE	(NOMINAL TUBE SIZE)	T THREAD PER MIL-S-8879 CLASS 3A	A	B ±.010	C	D
02	.125	.3125-24 UNJF	.562	.418	.371	.093
03	.188	.3750-24 UNJF	.609	.418	.407	.125
04	.250	.4375-20 UNJF	.641	.480	.417	.187
05	.312	.5000-20 UNJF	.672	.542	.416	.234
06	.375	.5625-18 UNJF	.719	.605	.441	.297
08	.500	.7500-16 UNJF	.844	.792	.491	.422
10	.625	.8750-14 UNJF	.984	.918	.604	.500
12	.750	1.0625-12 UNJ	1.031	1.103	.564	.656
14	.875	1.1875-12 UNJ	1.062	1.228	.557	.765
16	1.000	1.3125-12 UNJ	1.062	1.353	.519	.875
20	1.250	1.6250-12 UNJ	1.094	1.666	.428	1.093
24	1.500	1.8750-12 UNJ	1.094	1.978	.812	1.344
32	2.000	2.5000-12 UNJ	1.094	2.599	.812	1.813

TABLE 1A - DIMENSIONS AND WEIGHTS

BASIC NO. AS5231 /13/ SIZE CODE	F +.002/- .003	G	H	M +.015/- .000	LB/EA MAX AL	LB/EA MAX STEEL	LB/EA MAX TI
02	.250	.109	.428- .440	.063	.00571	.0164	.00904
03	.312	.109	.428- .440	.063	.00717	.0206	.0114
04	.364	.109	.490- .502	.075	.00938	.0269	.0148
05	.426	.125	.552- .565	.075	.0128	.0369	.0203
06	.481	.125	.615- .628	.083	.0167	.0480	.0265
08	.660	.156	.802- .815	.094	.0332	.0952	.0525
10	.773	.156	.928- .941	.107	.0532	.153	.0843
12	.945	.188	1.113-1.128	.125	.0801	.230	.127
14	1.070	.188	1.238-1.253	.125	.103	.295	.163
16	1.195	.188	1.363-1.380	.125	.128	.366	.202
20	1.507	.234	1.676-1.693	.125	.212	.610	.336
24	1.756	.234	1.988-2.005	.125	.224	.644	.355
32	2.381	.328	2.609-2.635	.125	.391	1.12	.620

NOTES:

/1/ MATERIAL:

- a. DASH AS CODE LETTER - TYPE 4130 CARBON STEEL BAR PER MIL-S-6758 OR AMS 6370. /2/
- b. CODE LETTER D - TYPE 2024-T6 ALUMINUM ALLOY BAR PER QQ-A-225/6 OR AMS 4112 OR TYPE 2024-T851 ALUMINUM ALLOY BAR PER QQ-A-225/6. /2/
- c. CODE LETTER J - TYPE 304 CORROSION RESISTANT STEEL BAR PER QQ-S-763 OR AMS 5639.
- d. CODE LETTER K - TYPE 316 CORROSION RESISTANT STEEL BAR PER QQ-S-763 OR AMS 5648.
- e. CODE LETTER R - TYPE 321 CORROSION RESISTANT STEEL BAR PER QQ-S-763 OR AMS 5645.
- f. CODE LETTER T - TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS 4928.
- g. CODE LETTER W - TYPE 7075-T73 ALUMINUM ALLOY BAR PER QQ-A-225/9 OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS 4124. /2/

/2/ HEAT TREATMENT:

- a. DASH AS CODE LETTER - SEE HARDNESS REQUIREMENT PER PROCUREMENT SPECIFICATION.
- b. CODE LETTERS D AND W - SEE ELECTRICAL CONDUCTIVITY AND HARDNESS REQUIREMENT PER PROCUREMENT SPECIFICATION.
- c. OTHER CODE LETTERS - NONE.

3. FINISH:

- a. DASH AS CODE LETTER - CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2 AND COAT WITH A LIGHT FILM OF OIL PER PROCUREMENT SPECIFICATION.
- b. CODE LETTER D - ANODIZE PER MIL-A-8625, TYPE II, CLASS 2, DYE GREEN, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.
- c. CODE LETTER J, K AND R - PASSIVATE PER QQ-P-35, TYPE VI OR VII.
- d. CODE LETTER T - ANODIZE PER AMS 2488 OR FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486 WITH COLOR PER PROCUREMENT SPECIFICATION.
- e. CODE LETTER W - ANODIZE PER MIL-A-8625, TYPE II, CLASS 2, DYE BROWN, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.

/4/ PROCUREMENT SPECIFICATION: AS4444 EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION IN A COMPLETE ASSEMBLY AS APPLICABLE. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.

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

- a. FOR SIZE 06 AND SMALLER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, LETTER "AS" AND MATERIAL CODE LETTER.
- b. FOR SIZE 08 AND LARGER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, BASIC PART NUMBER AND MATERIAL CODE LETTER.