

REV.
A

SAE AS5232

FEDERAL SUPPLY CLASS
4730

RATIONALE

PROCUREMENT SPECIFICATION CHANGED FROM AS4444 TO AS18280 AND PROCUREMENT NOTE CLARIFIED. WARNING NOTICE FOR CADMIUM PLATING HAS BEEN INSERTED. UPDATES MADE TO BRING MATERIAL, HEAT TREAT, FINISH, AND PROCUREMENT REQUIREMENTS INTO COMPLIANCE WITH AS18280C. ADDED OPTION FOR OXYGEN CLEANING AND PACKAGING TO ARP1176.

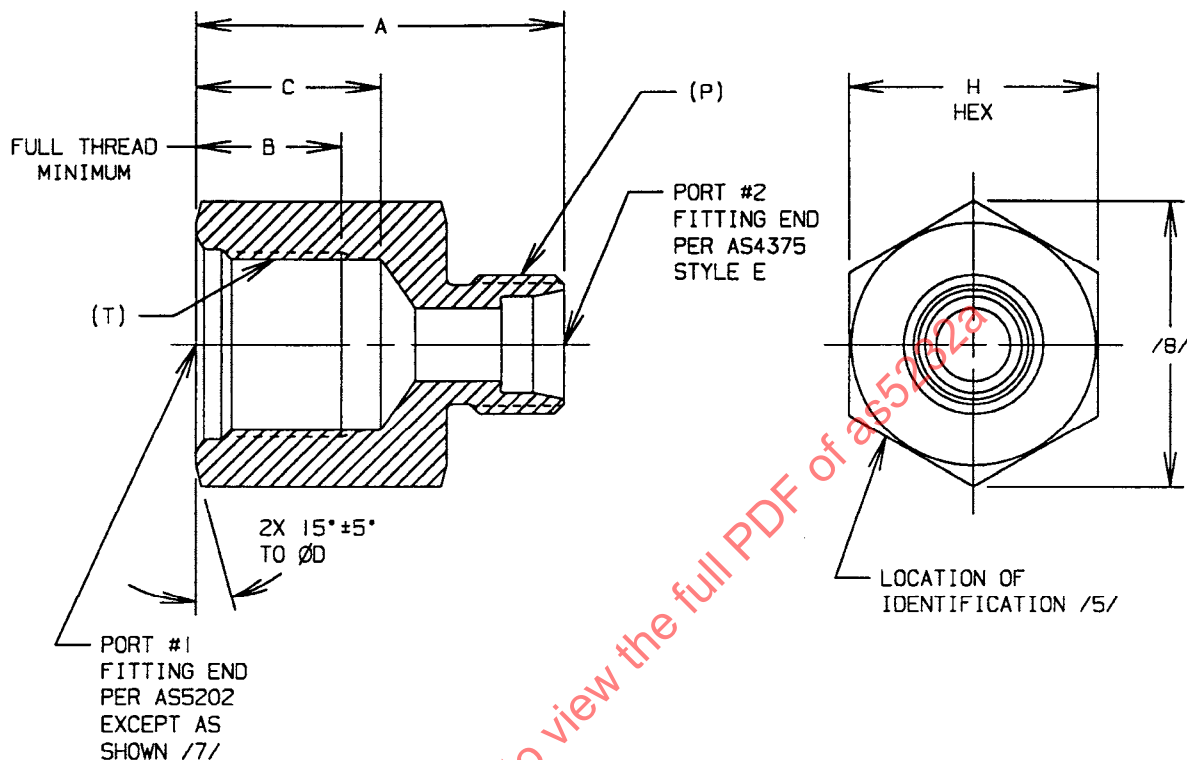
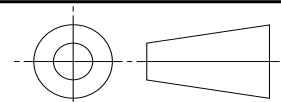


FIGURE 1 - FITTING, ADAPTER

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS5232A>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS18280

SAE Aerospace
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AEROSPACE STANDARD

FITTING, ADAPTER, REDUCER, PORT TO FLARELESS

SAE AS5232
SHEET 1 OF 5

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TABLE 1 – DIMENSIONS

BASIC NO. AS5232 /15/ SIZE CODE	(NOMINAL TUBE SIZE) PORT #1	(NOMINAL TUBE SIZE) PORT #2	T THREAD PER AS8879 CLASS 3B	P THREAD PER AS8879 CLASS 3A	A	B	C
0302	.188	.125	.3750-24 UNJF	.3125-24 UNJF	1.125	.406	.516
0402	.250	.125	.4375-20 UNJF	.3125-24 UNJF	1.234	.438	.610
0403	.250	.188	.4375-20 UNJF	.3750-24 UNJF	1.250	.438	.610
0504	.312	.250	.5000-20 UNJF	.4375-20 UNJF	1.281	.438	.610
0604	.375	.250	.5625-18 UNJF	.4375-20 UNJF	1.313	.469	.610
0605	.375	.312	.5625-18 UNJF	.5000-20 UNJF	1.281	.469	.610
0804	.500	.250	.7500-16 UNJF	.4375-20 UNJF	1.484	.562	.734
0805	.500	.312	.7500-16 UNJF	.5000-20 UNJF	1.453	.562	.734
0806	.500	.375	.7500-16 UNJF	.5625-18 UNJF	1.469	.562	.734
1004	.625	.250	.8750-14 UNJF	.4375-20 UNJF	1.578	.625	.797
1005	.625	.312	.8750-14 UNJF	.5000-20 UNJF	1.563	.625	.797
1006	.625	.375	.8750-14 UNJF	.5625-18 UNJF	1.563	.625	.797
1008	.625	.500	.8750-14 UNJF	.7500-16 UNJF	1.656	.625	.797
1206	.750	.375	1.0625-12 UNJ	.5625-18 UNJF	1.734	.688	.922
1208	.750	.500	1.0625-12 UNJ	.7500-16 UNJF	1.828	.688	.922

TABLE 1A - DIMENSIONS AND WEIGHTS

BASIC NO. AS5232 /15/ SIZE CODE	D ±.010	H	LB/EA APPROX. REF AL	LB/EA APPROX. REF STEEL	LB/EA APPROX. REF TI
0302	.605	.615-.628	.0248	.0711	.0392
0402	.668	.678-.691	.0324	.0929	.0513
0403	.668	.678-.691	.0323	.0928	.0512
0504	.730	.740-.753	.0373	.107	.0590
0604	.792	.802-.815	.0438	.126	.0693
0605	.792	.802-.815	.0307	.0881	.0486
0804	.980	.990-1.003	.0707	.203	.112
0805	.980	.990-1.003	.0687	.197	.109
0806	.980	.990-1.003	.0701	.201	.111
1004	1.103	1.113-1.128	.0928	.266	.147
1005	1.103	1.113-1.128	.0918	.264	.145
1006	1.103	1.113-1.128	.0902	.259	.143
1008	1.103	1.113-1.128	.0958	.275	.152
1206	1.353	1.363-1.380	.153	.438	.242
1208	1.353	1.363-1.380	.158	.454	.250

TABLE 1B – DIMENSIONS

BASIC NO. AS5232 /15/ SIZE CODE	(NOMINAL TUBE SIZE) PORT #1	(NOMINAL TUBE SIZE) PORT #2	T THREAD PER AS8879 CLASS 3B	P THREAD PER AS8879 CLASS 3A	A	B	C
1210	.750	.625	1.0625-12 UNJ	.8750-14 UNJF	1.891	.688	.922
1606	1.000	.375	1.3125-12 UNJ	.5625-18 UNJF	1.844	.688	.954
1608	1.000	.500	1.3125-12 UNJ	.7500-16 UNJF	1.938	.688	.954
1610	1.000	.625	1.3125-12 UNJ	.8750-14 UNJF	1.984	.688	.954
1612	1.000	.750	1.3125-12 UNJ	1.0625-12 UNJ	2.031	.688	.954
2008	1.250	.500	1.6250-12 UNJ	.7500-16 UNJF	2.078	.688	1.000
2010	1.250	.625	1.6250-12 UNJ	.8750-14 UNJF	2.125	.688	1.000
2012	1.250	.750	1.6250-12 UNJ	1.0625-12 UNJ	2.156	.688	1.000
2016	1.250	1.000	1.6250-12 UNJ	1.3125-12 UNJ	2.078	.688	1.000

TABLE 1C - DIMENSIONS AND WEIGHTS

BASIC NO. AS5232 /15/ SIZE CODE	D ±.010	H	LB/EA APPROX. REF AL	LB/EA APPROX. REF STEEL	LB/EA APPROX. REF TI
1210	1.353	1.353-1.380	.163	.469	.259
1606	1.603	1.613-1.630	.221	.635	.350
1608	1.603	1.613-1.630	.226	.649	.358
1610	1.603	1.613-1.630	.219	.630	.347
1612	1.603	1.613-1.630	.228	.654	.361
2008	1.853	1.863-1.880	.304	.873	.481
2010	1.853	1.863-1.880	.303	.871	.480
2012	1.853	1.863-1.880	.297	.851	.470
2016	1.853	1.863-1.880	.276	.793	.438

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 CARBON STEEL BAR PER AMS6370. /2/
- 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. /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.
- 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:

- 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 AMS-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 AMS2700 PER PROCUREMENT SPECIFICATION.
- d. CODE LETTER T - ANODIZE PER AMS2488 OR FLUORIDE PHOSPHATE CONVERSION COAT PER AMS2486 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: 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 <http://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 MUST PROVIDE THEIR OWN QPL-CONTROL.

/5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR 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.

6. INTENDED USE: THIS PART IS DESIGNED FOR USE IN SYSTEMS WITH MAXIMUM OPERATING PRESSURES AS FOLLOWS:

- a. THIS STANDARD IS THE FUNCTIONAL EQUIVALENT OF MS21915 AND IS INTENDED TO BE SUITABLE AS A REPLACEMENT STANDARD.
- b. 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.

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	FITTING, ADAPTER, REDUCER, PORT TO FLARELESS		