

RATIONALE

REVISE ACTIVATION DATES FOR PRI-QPL-AS1576.

REV.
F

AS1585

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.

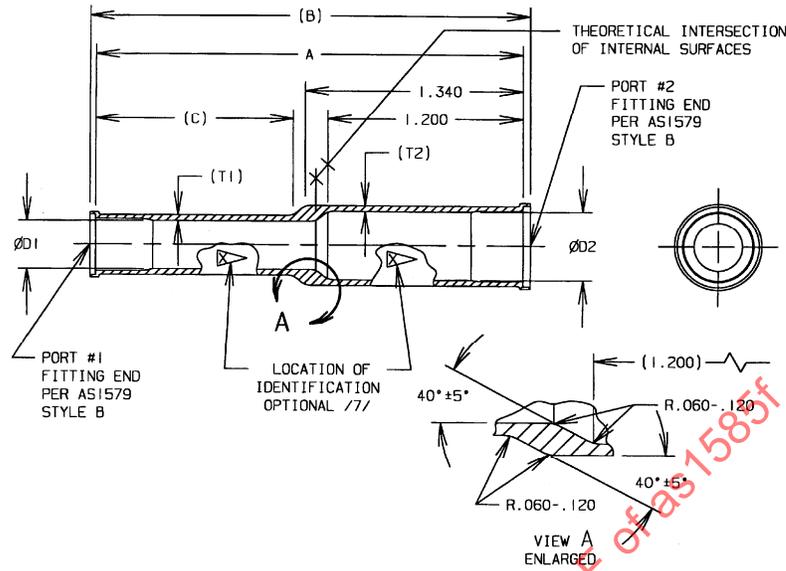


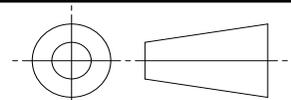
FIGURE 1 - FITTING, WELD RING

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS1585 /15/ SIZE CODE	NOMINAL TUBE SIZE PORT #1	NOMINAL TUBE SIZE PORT #2	A ±.016	B	C	D1 ±.005	D2 ±.005	T1	T2	LB/EA APPROX. REF STEEL	LB/EA APPROX. REF TI
0406	.250	.375	2.632	2.702	1.218	.200	.305	.026	.036	.0226	.0128
0408	.250	.500	2.668	2.748	1.179	.200	.430	.026	.036	.0325	.0184
0608	.375	.500	2.632	2.712	1.218	.305	.430	.036	.036	.0364	.0206
0610	.375	.625	2.668	2.748	1.179	.305	.545	.036	.041	.0501	.0283
0810	.500	.625	2.632	2.722	1.218	.430	.545	.036	.041	.0518	.0293
0812	.500	.750	2.668	2.768	1.179	.430	.650	.036	.051	.0717	.0406
1012	.625	.750	2.632	2.732	1.218	.545	.650	.041	.051	.0746	.0422
1016	.625	1.000	2.704	2.814	1.140	.545	.880	.041	.061	.119	.0674
1216	.750	1.000	2.668	2.788	1.179	.650	.880	.051	.061	.124	.0701
1220	.750	1.250	2.740	2.870	1.102	.650	1.110	.051	.071	.183	.103
1620	1.000	1.250	2.668	2.808	1.179	.880	1.110	.061	.071	.187	.106

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS1585F>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS1576 /6/



AEROSPACE STANDARD

FITTING, REDUCER, INTEGRAL
WELD RING, 3000 PSI

AS1585
SHEET 1 OF 3

REV.
F

NOTES:

/1/ MATERIAL:

- a. CODE LETTER T - TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS4928.
- b. CODE LETTER V - TYPE 15-5PH CORROSION RESISTANT STEEL BAR PER AMS5659.

2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER T - NONE.
- b. MATERIAL CODE LETTER V - HEAT TREAT TO CONDITION H 1075 PER AMS2759/3.

3. FINISH: NONE.

/4/ CLEANING:

- a. NO SUFFIX CODE LETTER IN PART NUMBER - CLEAN BY ANY SUITABLE METHOD PER PROCUREMENT SPECIFICATION.
- b. SUFFIX CODE LETTER "C" IN PART NUMBER - HOT ALKALINE CLEAN PER PROCUREMENT SPECIFICATION.
- c. SUFFIX CODE LETTER "E" IN PART NUMBER FOR TITANIUM PARTS ONLY - NITRIC-HYDROFLUORIC ACID ETCH PER PROCUREMENT SPECIFICATION.

5. PACKAGING: PER PROCUREMENT SPECIFICATION.

/6/ PROCUREMENT SPECIFICATION: AS1576 UNLESS OTHERWISE 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-AS1576 FOR THIS STANDARD. SEE www.eAuditNet.com FOR CURRENT QPL ONLINE.

THIS QPL REQUIREMENT SHALL BE IN EFFECT FOR PURCHASE ORDERS PLACED ON OR AFTER **JULY 1, 2014**. SUPPLIERS SEEKING LISTING ON THE INITIAL QPL MUST APPLY TO PRI FOR APPROVAL NO LATER THAN **JANUARY 1, 2014**. UNTIL THE QPL IS IN EFFECT, USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVALS. TRANSITION TO PRI-QPL SHALL BE COMPLETED BY JULY 1, 2014.

/7/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 METHOD 3B, 5B1, 5B2, 7A2, 7A3, 7C2, 15A3, OR 15B MANUFACTURER'S IDENTIFICATION, CAGE CODE NUMBER OR TRADEMARK, BASIC PART NUMBER FOR SIZE 08 AND LARGER, LETTERS "AS" FOR SIZE 06 AND SMALLER AND MATERIAL CODE LETTER.

8. THIS PART IS DESIGNED FOR USE IN SYSTEMS WITH MAXIMUM OPERATING PRESSURE OF 3000 PSI WHEN ORBITAL ARC WELDED TO TITANIUM ALLOY OR CORROSION RESISTANT STEEL TUBING.

9. A CHANGE BAR (I) LOCATED IN THE LEFT MARGIN IS FOR THE CONVENIENCE OF THE USER IN LOCATING AREAS WHERE TECHNICAL REVISIONS, NOT EDITORIAL CHANGES, HAVE BEEN MADE TO THE PREVIOUS ISSUE OF THIS DOCUMENT. AN (R) SYMBOL TO THE LEFT OF THE DOCUMENT TITLE INDICATES A COMPLETE REVISION OF THE DOCUMENT, INCLUDING TECHNICAL REVISIONS. CHANGE BARS AND (R) ARE NOT USED IN ORIGINAL PUBLICATIONS, NOR IN DOCUMENTS THAT CONTAIN EDITORIAL CHANGES ONLY.

11. INTERPRETATION OF DRAWING PER ARP4296.

11. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 MICROINCHES Ra.

12. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.

	AEROSPACE STANDARD	AS1585 SHEET 2 OF 3	REV. F
	FITTING, REDUCER, INTEGRAL WELD RING, 3000 PSI		