

REV. B

AS1986

FEDERAL SUPPLY CLASS
4730

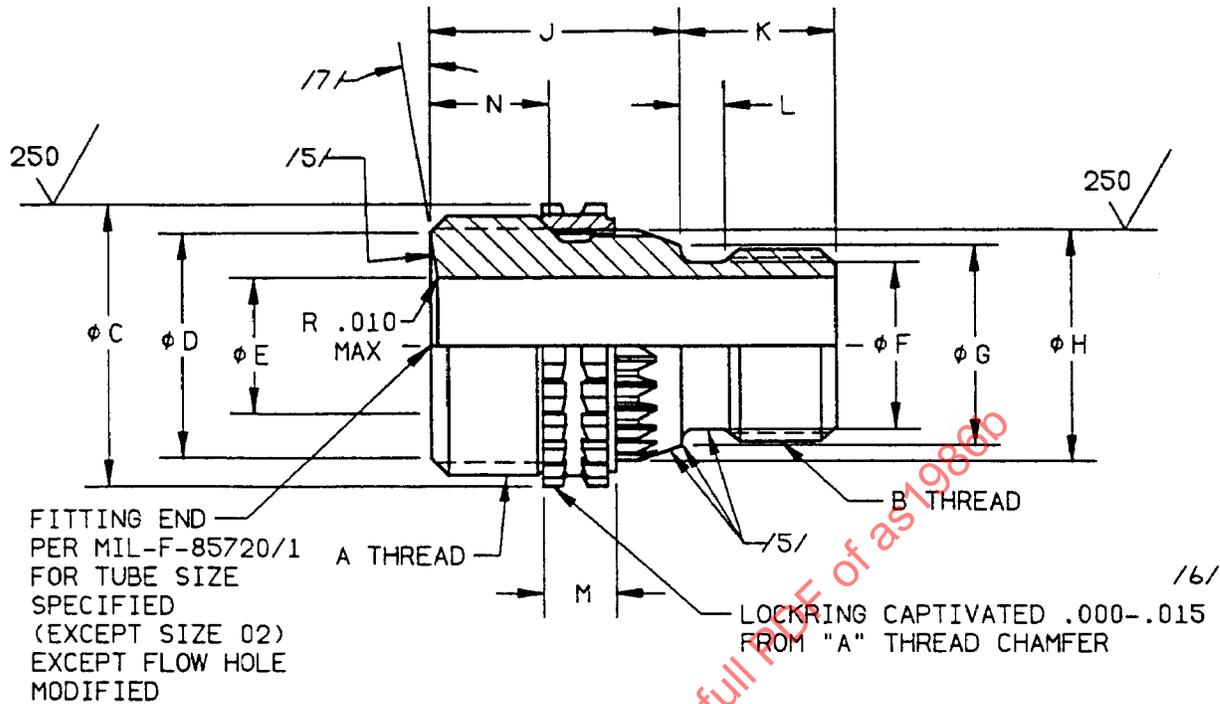


FIGURE 1 - ADAPTER ASSEMBLY

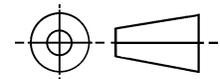
TABLE 1 - DIMENSIONS

TABLE 1A - A THROUGH F

BASIC NO. AS1986 /17/ SIZE CODE	(NOMINAL TUBE SIZE)	A		B		C	(D)		E	F +.005/- .002	
		MIL-S-8879	THREAD	MIL-S-8879	THREAD						
02	.125	.3125	32UNJEF-3A	.2160	28UNJF-3A	.400	.265	.271	.090	.096	.154
03	.188	.3750	28UNJS-3A	.2500	28UNJF-3A	.468	.323	.329	.122	.128	.186
04	.250	.4375	24UNJS-3A	.3125	24UNJF-3A	.514	.377	.383	.169	.175	.239
05	.312	.5000	24UNJS-3A	.3750	24UNJF-3A	.624	.440	.446	.231	.237	.301
06	.375	.5625	20UNJS-3A	.4375	20UNJF-3A	.700	.490	.497	.294	.300	.364
08	.500	.7188	20UNJS-3A	.5625	18UNJF-3A	.814	.646	.654	.398	.408	.482
10	.625	.8438	18UNJS-3A	.6875	24UNJEF-3A	1.040	.763	.772	.493	.503	.625
12	.750	1.0000	16UNJ-3A	.8125	20UNJEF-3A	1.170	.910	.919	.604	.614	.737
14	.875	1.1250	16UNJ-3A	.9375	20UNJEF-3A	1.341	1.034	1.044	.729	.739	.868
16	1.000	1.2500	14UNJS-3A	1.1250	18UNJEF-3A	1.456	1.148	1.158	.839	.851	1.000
20	1.250	1.5781	14UNJS-3A	1.3125	18UNJEF-3A	1.782	1.476	1.486	1.073	1.086	1.225
24	1.500	1.8438	14UNJS-3A	1.6250	18UNJEF-3A	2.031	1.741	1.751	1.307	1.320	1.502



THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ MIL-F-85720



AEROSPACE STANDARD

FITTING ASSEMBLY, ADAPTER RING LOCKED PORT
CONNECTION TO BEAM SEAL 4000 psi AND 5000 psi /9/

AS1986
SHEET 1 OF 3

REV. B

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ISSUED 1985-12 REVISED 1994-07 REAFFIRMED 2005-06

REV.
B

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TABLE 1B - G THROUGH N

BASIC NO. AS1986 /17/ SIZE CODE	G MIN	(H)	J +.010/- .005	K 0/- .015	L +.010/- .005	M +.007	(N) MIN	LB/EA MAX
02	.246	.317	.519	.300	.125	.192	.141	.008
03	.278	.349	.550	.355	.125	.192	.164	.012
04	.331	.400	.592	.355	.125	.192	.197	.014
05	.393	.491	.592	.381	.125	.192	.197	.020
06	.456	.544	.633	.395	.125	.210	.205	.025
08	.574	.670	.646	.430	.125	.210	.218	.035
10	.717	.824	.710	.465	.125	.210	.274	.059
12	.891	.981	.760	.527	.157	.220	.303	.079
14	1.022	1.118	.778	.572	.157	.220	.318	.101
16	1.154	1.251	.808	.564	.157	.220	.338	.125
20	1.379	1.466	.832	.569	.157	.240	.335	.179
24	1.656	1.768	.917	.608	.157	.240	.420	.257

NOTES:

1. MATERIAL:
 - a. FITTING: 6Al-4V TITANIUM ALLOY PER AMS 4928, AMS 4965, OR AMS 4967
 - b. LOCKRING: A286 CORROSION RESISTANT STEEL PER AMS 5731 OR AMS 5734
2. HEAT TREATMENT:
 - a. FITTING: 130 ksi UTS MIN
 - b. LOCKRING: 34-40 HRC
3. FINISH:
 - a. FITTING: ANODIC TREATMENT PER AMS 2488, TYPE 2
 - b. LOCKRING: PASSIVATE PER QQ-P-35, TYPE II
- /4/ PROCUREMENT SPECIFICATION: MIL-F-85720 EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION IN A COMPLETE ASSEMBLY. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.
- /5/ SEALING SURFACE: NO VISIBLE DEFECTS. TO BE PROTECTED FOR SHIPMENT.
- /6/ LOCKRING RETAINED ON FITTING BY CONTROLLED INTERFERENCE FIT.
- /7/ SEALING ANGLES:
 - a. SIZES -02 AND -03: 3°00' TO 3°30'
 - b. SIZES -04 AND LARGER: 8°30' TO 9°00'
8. IDENTIFICATION PER AS478 CLASS 35D. NAME, TRADEMARK OR CAGE CODE, AND PART NUMBER.
- /9/ WORKING PRESSURE: THIS PART IS DESIGNED FOR USE IN HYDRAULIC SYSTEMS COMPATIBLE WITH TITANIUM.
 - a. SIZE -04, -06, -08, -10, -12, AND -16: 5000 psi (20 000 psi BURST PRESSURE) SYSTEMS.
 - b. ALL OTHER SIZES: 4000 psi (16 000 psi BURST PRESSURE) SYSTEMS.
10. ADAPTERS TO BE INSTALLED PER AS1301 INTO BOSS CAVITIES PER AS1300.
11. INVENTORIED PARTS CONFORMING TO THE PREVIOUS "LETTER CHANGE" MAY BE USED TO DEPLETION.
12. INTERPRETATION OF DRAWING PER ARP4296.
13. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36; REQUIREMENTS PER ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 µin Ra AND SEALING SURFACE TO BE 63 µin Ra.