

REV.
C

AS1986

FEDERAL SUPPLY CLASS
4030

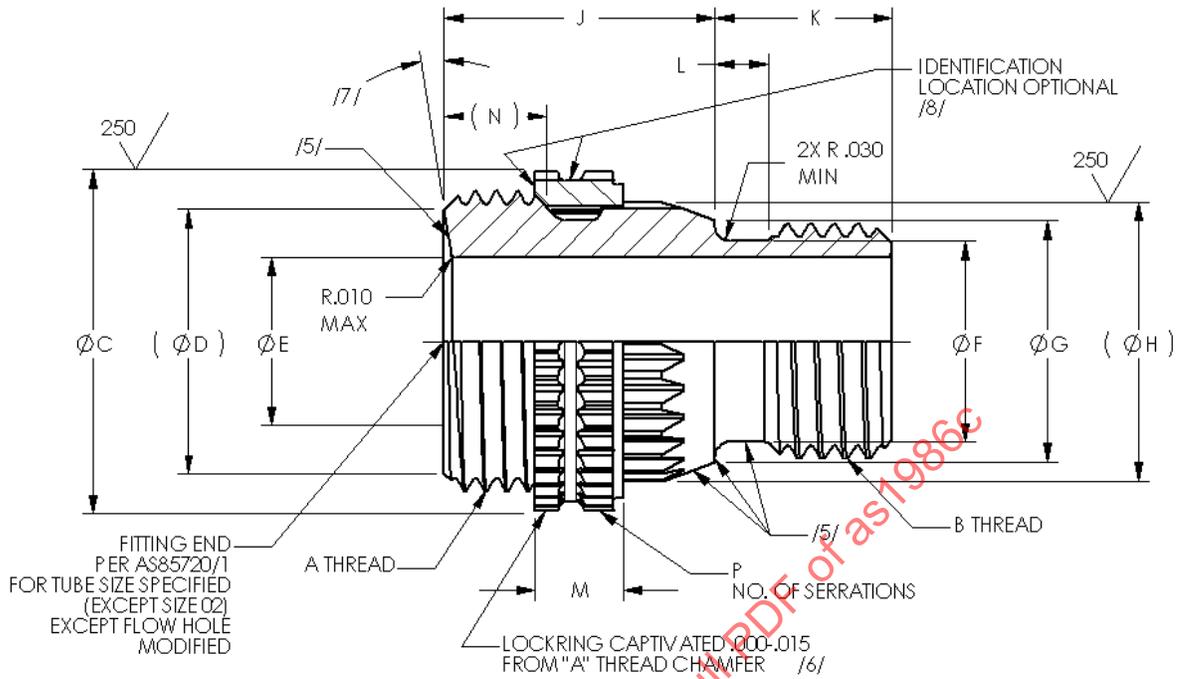
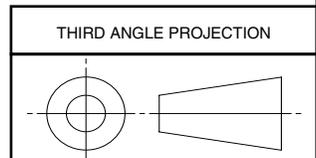


FIGURE 1 - ADAPTER ASSEMBLY

TABLE 1A - DIMENSIONS A - F

BASIC NO. AS1986 /18/ SIZE CODE	(NOMINAL TUBE SIZE)	A THREAD AS8879	B THREAD AS8879	C	D	E	F +.005/-.002
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



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS85720



AEROSPACE STANDARD
(R) FITTING ASSEMBLY, ADAPTER
RING LOCKED PORT CONNECTION TO BEAM SEAL
4000 PSI AND 5000 PSI /9/

AS1986
SHEET 1 OF 3

**REV.
C**

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ISSUED 1985-12 REAFFIRMED 2000-10 REVISED 2005-10

TABLE 1B – DIMENSIONS G – P AND WEIGHT

BASIC NO. AS1986 /18/ SIZE CODE	G MIN	H	J +.010/-.005	K 0/-.015	L +.010/-.005	M ±.007	N MIN	P	WEIGHT LB/EA MAX
02	.246	.317	.519	.300	.125	.192	.141	24	.008
03	.278	.349	.550	.355	.125	.192	.164	26	.012
04	.331	.400	.592	.355	.125	.192	.197	30	.014
05	.393	.491	.592	.381	.125	.192	.197	36	.020
06	.456	.544	.633	.395	.125	.210	.205	36	.025
08	.574	.670	.646	.430	.125	.210	.218	40	.035
10	.717	.824	.710	.465	.125	.210	.274	38	.059
12	.891	.981	.760	.527	.157	.220	.303	40	.079
14	1.022	1.118	.778	.572	.157	.220	.318	50	.101
16	1.154	1.251	.808	.564	.157	.220	.338	36	.125
20	1.379	1.466	.832	.569	.157	.240	.335	56	.179
24	1.656	1.768	.917	.608	.157	.240	.420	81	.257

NOTES:

1. MATERIAL:

- a. FITTING: 6AI-4V TITANIUM ALLOY PER AMS 4928, AMS 4965, OR AMS 4967.
- b. LOCKRING: A286 CORROSION RESISTANT STEEL PER AMS 5731, AMS 5732, AMS 5734 OR AMS 5737.

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 AMS-QQ-P-35, TYPE II.

/4/ PROCUREMENT SPECIFICATION:

- a. AS85421 (SIZES 02, 03, 05, 14, 20 AND 24): PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER AS LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST FOR PRI-QPL-AS85421 FOR THIS STANDARD. SEE <http://www.pri.sae.org/QPL/as85421.pdf> FOR CURRENT QPL ONLINE.
- b. AS85720 (SIZES 04, 06, 08, 10, 12 AND 16): USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL BY STANDARD PAGE SUPPLEMENT OR SIMILAR MEANS.

/5/ SEALING SURFACE: NO VISIBLE DEFECTS. TO BE PROTECTED FOR SHIPMENT.

/6/ LOCKRING RETAINED ON FITTING BY CONTROLLED INTERFERENCE FIT.