

REV.  
F

AS1986

FEDERAL SUPPLY CLASS  
4030

RATIONALE

UPDATE OF MAXIMUM WEIGHT VALUES VERIFIED THROUGH CAD MODELING, AND UPDATE OF DRAWING INTERPRETATION SPECIFICATION.

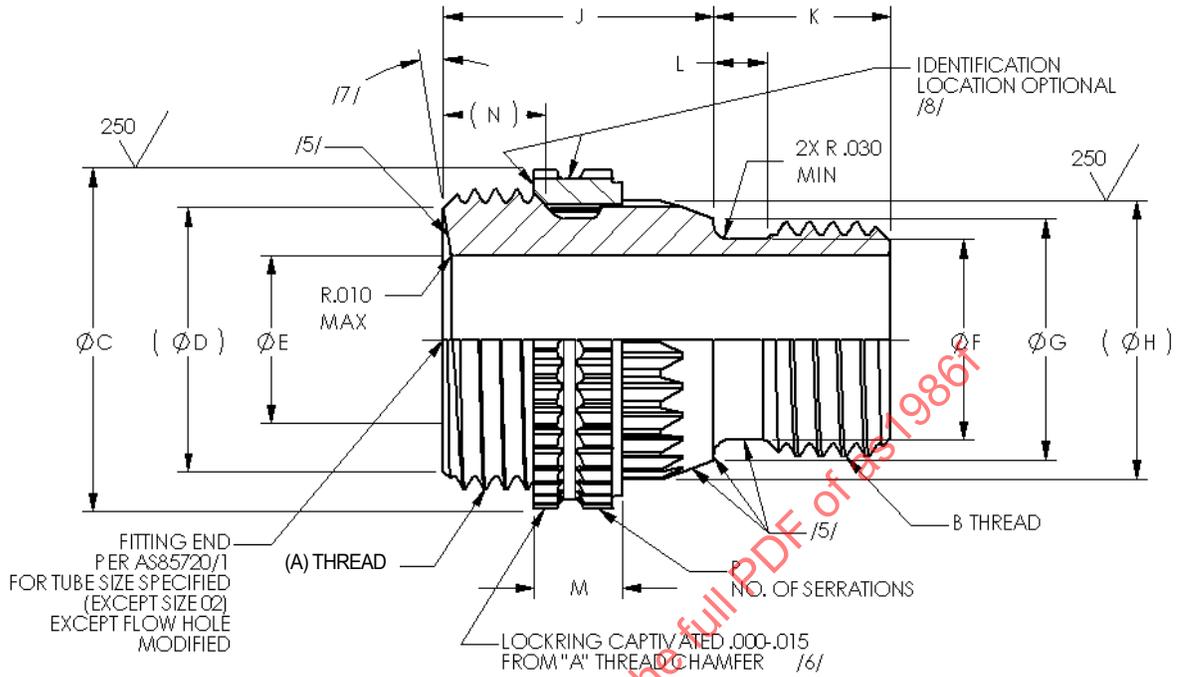
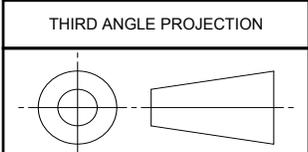


FIGURE 1 - ADAPTER, ASSEMBLY

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

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS1986F>



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS85720



AEROSPACE STANDARD

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

AS1986  
SHEET 1 OF 3

REV.  
F

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.

ISSUED 1985-12 REAFFIRMED 2000-10 REVISED 2015-02

**TABLE 1B - DIMENSIONS G – P AND WEIGHT**

BASIC NO. AS1986 /18/ SIZE CODE	G MIN	H	J +.010 -.005	K +.000 -.015	L +.010 -.005	M ±.007	N MIN	P	WEIGHT LB/EA MAX
02	.246	.317	.519	.300	.125	.192	.141	24	.009
03	.278	.349	.550	.355	.125	.192	.164	26	.012
04	.331	.400	.592	.355	.125	.192	.197	30	.016
05	.393	.491	.592	.381	.125	.192	.197	36	.021
06	.456	.544	.633	.395	.125	.210	.205	36	.027
08	.574	.670	.646	.430	.125	.210	.218	40	.038
10	.717	.824	.710	.465	.125	.210	.274	38	.066
12	.891	.981	.760	.527	.157	.220	.303	40	.088
14	1.022	1.118	.778	.572	.157	.220	.318	50	.111
16	1.154	1.251	.808	.564	.157	.220	.338	36	.137
20	1.379	1.466	.832	.569	.157	.240	.335	56	.198
24	1.656	1.768	.917	.608	.157	.240	.420	81	.299

NOTES:

1. MATERIAL:

- a. FITTING: 6Al-4V TITANIUM ALLOY PER AMS4928, AMS4965, OR AMS4967.
- b. LOCKRING: A286 CORROSION RESISTANT STEEL PER AMS5731, AMS5732, AMS5734, AMS5737, OR AMS5853.

2. HEAT TREATMENT:

- a. FITTING: 130 KSI UTS MIN.
- b. LOCKRING: 34-40 HRC.

3. FINISH:

- a. FITTING: ANODIC TREATMENT PER AMS2488, TYPE 2.
- b. LOCKRING: PASSIVATE PER AMS2700, TYPE 2.

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.eAuditNet.com> FOR CURRENT QPL ONLINE.
- b. AS85720 (SIZES 04, 06, 08, 10, 12, AND 16): 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-AS85720 FOR THIS STANDARD. SEE <http://www.eAuditNet.com> FOR CURRENT QPL ONLINE.

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

6/ LOCKRING RETAINED ON FITTING BY CONTROLLED INTERFERENCE FIT.

	<b>AEROSPACE STANDARD</b>	<b>AS1986</b> SHEET 2 OF 3	<b>REV.</b> <b>F</b>
	FITTING ASSEMBLY, ADAPTER RING LOCKED PORT CONNECTION TO BEAM SEAL 4000 PSI AND 5000 PSI /9/		