

REV.  
C

AS4140

RATIONALE

CORRECTED PASSIVATION TYPES FOR 304 AND 15-5PH BODIES.

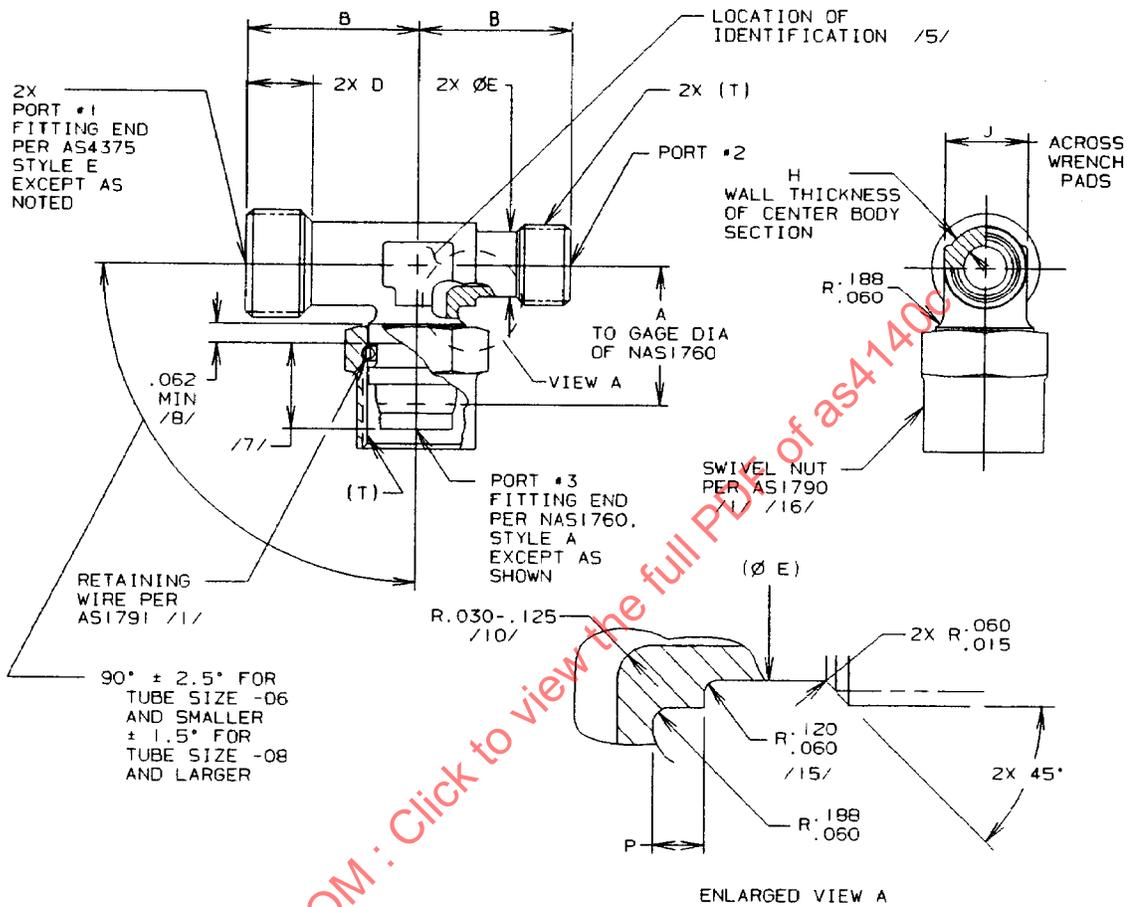
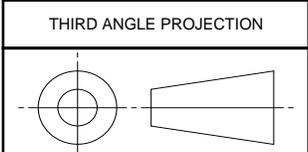


FIGURE 1 - FITTING ASSY, TEE, REDUCER, SWIVEL ON SIDE, REDUCED BODY, FLARELESS

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CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS18280



**AEROSPACE STANDARD**

FITTING ASSY, TEE, REDUCER,  
SWIVEL ON SIDE,  
REDUCED BODY, FLARELESS

**AS4140**  
SHEET 1 OF 5

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ISSUED 1992-11 REVISED 2014-07

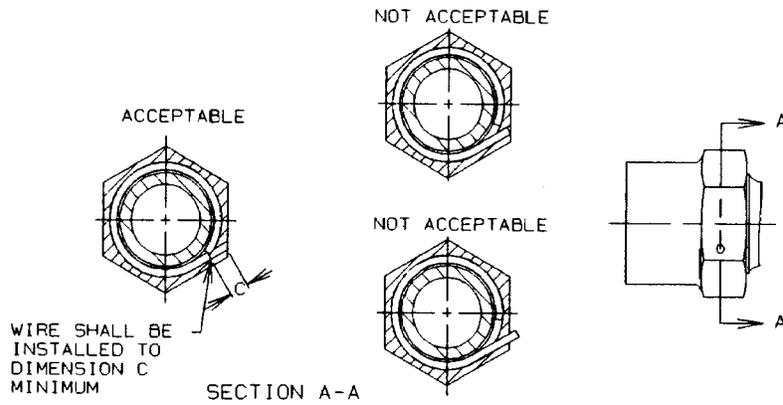


FIGURE 2 - INSTALLATION, SWIVEL NUT RETAINING WIRE

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4140 /21/ SIZE CODE	H /6/	J	P ±.030	LB/EA APPROX REF CRES	LB/EA APPROX REF TI
04	.050	.390	.030	.076	.042
05	.050	.453	.159	.098	.055
06	.050	.453	.137	.120	.067
08	.050	.577	.140	.220	.124
10	.070	.702	.157	.346	.197
12	.080	.890	.166	.529	.297
16	.090	1.140	.174	.781	.438
20	.110	1.390	.071	1.263	.709
24	.130	1.640	---	1.767	.992

TABLE 2 - FITTING END

SIZE CODE	TUBE OD	T THREAD PER AS8879	C /16/	D	E
04	.250	.4375-20UNJF	.075	.371	.350
05	.313	.5000-20UNJF	.076	.371	.412
06	.375	.5625-18UNJF	.084	.379	.453
08	.500	.7500-16UNJF	.095	.461	.577
10	.625	.8750-14UNJF	.115	.511	.702
12	.750	1.0625-12UNJF	.149	.556	.890
16	1.000	1.3125-12UNJ	.178	.556	1.140
20	1.250	1.6250-12UNJ	.221	.556	1.390
24	1.500	1.8750-12UNJ	.291	.556	1.640



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TABLE 3 - LEG LENGTH A

FORGING SIZE	04	05	06	08	10	12	16	20	24
04	.745	---	---	---	---	---	---	---	---
05	.790	.842	---	---	---	---	---	---	---
06	.847	.899	.960	---	---	---	---	---	---
08	.932	.984	1.045	1.143	---	---	---	---	---
10	1.057	1.109	1.170	1.268	1.348	---	---	---	---
12	1.119	1.171	1.232	1.330	1.410	1.398	---	---	---
16	1.244	1.296	1.357	1.454	1.533	1.522	1.590	---	---
20	1.401	1.453	1.514	1.611	1.690	1.679	1.727	1.810	---
24	1.526	1.578	1.639	1.736	1.815	1.804	1.852	1.935	2.112

TABLE 4 - LEG LENGTH B

FORGING SIZE	04	05	06	08	10	12	16	20	24
04	.883	---	---	---	---	---	---	---	---
05	.799	.914	---	---	---	---	---	---	---
06	.861	.861	1.003	---	---	---	---	---	---
08	.955	.955	.971	1.204	---	---	---	---	---
10	1.049	1.049	1.065	1.158	1.380	---	---	---	---
12	1.142	1.142	1.158	1.251	1.314	1.560	---	---	---
16	1.267	1.267	1.283	1.376	1.439	1.502	1.684	---	---
20	1.424	1.424	1.440	1.533	1.596	1.659	1.659	1.903	---
24	1.549	1.549	1.565	1.658	1.721	1.784	1.784	1.784	2.028

## 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:

## a. CODE LETTER J:

- (1) BODY: TYPE 304 CORROSION RESISTANT STEEL PER AMS5639
- (2) NUT: CODE LETTER J OF AS1790 (TYPE 304 CORROSION RESISTANT STEEL)
- (3) WIRE: PER AS1791 (CLASS 302 OR 305 CORROSION RESISTANT STEEL)

## b. CODE LETTER T:

- (1) BODY: TYPE 6AL-4V TITANIUM ALLOY PER AMS4928
- (2) NUT: CODE LETTER T OF AS1790 (TYPE 6AL-4V TITANIUM ALLOY)
- (3) WIRE: PER AS1791 (CLASS 302 OR 305 CORROSION RESISTANT STEEL)

## c. CODE LETTER V:

- (1) BODY: TYPE 15-5PH CORROSION RESISTANT STEEL PER AMS5659
- (2) NUT: CODE LETTER V OF AS1790 (TYPE 15-5PH CORROSION RESISTANT STEEL)
- (3) WIRE: PER AS1791 (CLASS 302 OR 305 CORROSION RESISTANT STEEL)



## AEROSPACE STANDARD

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2. HEAT TREATMENT:

a. MATERIAL CODE LETTER J:

(1) BODY, NUT AND WIRE: NONE

b. MATERIAL CODE LETTER T:

(1) BODY, NUT AND WIRE: NONE

c. MATERIAL CODE LETTER V:

(1) BODY: HEAT TREAT TO CONDITION H-1075 PER AMS2759/3

(2) NUT: MATERIAL CODE LETTER V OF AS1790 (HEAT TREAT TO CONDITION H-1075)

(3) WIRE: NONE

/3/ FINISH:

a. MATERIAL CODE LETTER J:

(1) BODY: PASSIVATE PER AMS2700 TYPE 6 OR 7 AND COAT WITH DRY FILM LUBRICANT PER AS5272 TYPE I /7/

(2) NUT: CODE LETTER J SUFFIX CODE N OF AS1790 (PASSIVATE WITH DRY FILM LUBRICANT ON ID)

(3) WIRE: PER AS1791 (PASSIVATE AND COAT WITH DRY FILM LUBRICANT)

b. MATERIAL CODE LETTER T:

(1) BODY: FLUORIDE PHOSPHATE CONVERSION COAT PER AMS2486 AND DRY FILM LUBRICANT PER AS5272 TYPE I /7/

(2) NUT: CODE LETTER T WITH SUFFIX CODE N OF AS1790 (FLUORIDE PHOSPHATE CONVERSION COAT AND DRY FILM LUBRICANT ON ID)

(3) WIRE: PER AS1791 (PASSIVATE AND COAT WITH DRY FILM LUBRICANT)

c. MATERIAL CODE LETTER V:

(1) BODY:

(a) NO SUFFIX FINISH MATERIAL CODE LETTER WITH PASSIVATE PER AMS2700 TYPE 2 OR 8 AND DRY FILM LUBRICANT PER PER AS5272 TYPE I /7/

(b) SUFFIX FINISH CODE LETTER P; CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2

(2) NUT:

(a) NO SUFFIX FINISH CODE LETTER; MATERIAL CODE LETTER V AND SUFFIX CODE LETTER N OF AS1790 (PASSIVATE AND COAT WITH DRY FILM LUBRICANT ON ID)

(c) SUFFIX FINISH CODE LETTER P; MATERIAL CODE LETTER V AND SUFFIX CODE LETTER P OF AS1790 (CADIUM PLATE)

(3) WIRE: PER AS1791 (PASSIVATE AND COAT WITH DRY FILM LUBRICANT).

/4/ PROCUREMENT SPECIFICATION: AS18280 UNLESS SPECIFIED OTHERWISE 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 (QPL) PRI-QPL-AS18280 FOR THIS STANDARD. SEE [www.eAuditNet.com](http://www.eAuditNet.com) FOR CURRENT QPL ONLINE.

/5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B.

a. FOR SIZES 06 (.375 OD TUBE SIZE) AND SMALLER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, LETTERS "AS", MATERIAL CODE LETTER AND FORGING MANUFACTURER'S IDENTIFICATION WHEN MADE FROM FORGING

b. FOR SIZES 08 (.500 OD TUBE SIZE) AND LARGER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, BASIC PART NUMBER, MATERIAL CODE LETTER AND FORGING MANUFACTURER'S IDENTIFICATION WHEN MADE FROM FORGING

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