

REV.
B

AS4211

RATIONALE

THIS STANDARD HAS BEEN REVISED TO CORRECT THE AS-FORGED LEG DIMENSION TO ALLOW STANDARD TOLERANCE FORGINGS TO BE USED AND STILL MEET THE SPECIFICATION.

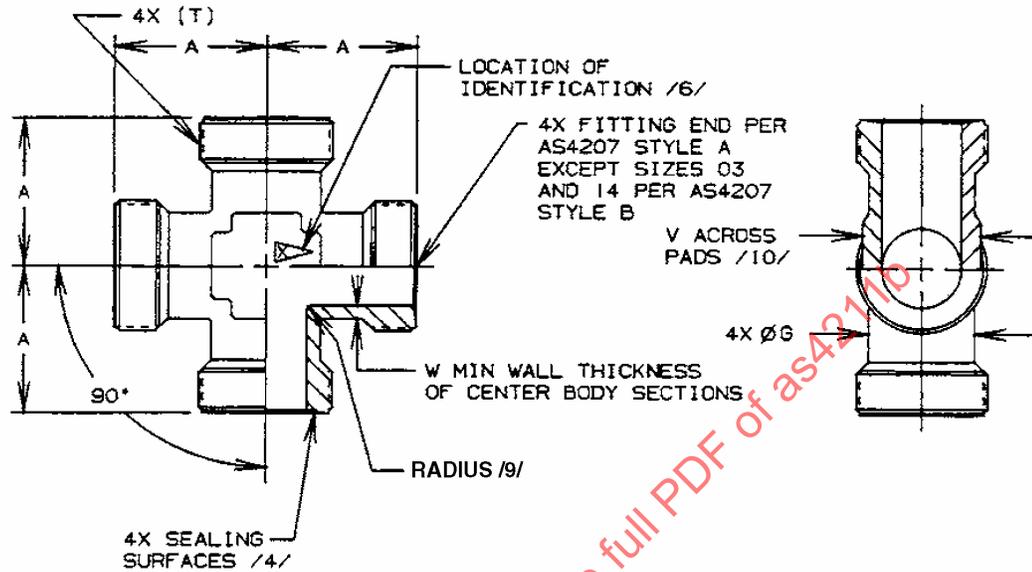
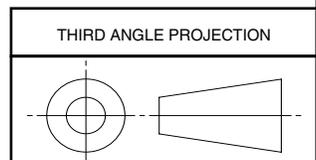


FIGURE 1 - FITTING, CROSS

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4211 /18/ SIZE CODE	(NOMINAL TUBE SIZE)	T THREAD PER AS8879 CLASS A	A	G MIN	V1 /10/	V2 /10/	W	LB/EA MAX CRES	LB/EA MAX TI
03	.188	.3750-28 UNJS	.575	.330	.360- .377	.375	.055	.0531	.0303
04	.250	.4375-24 UNJS	.617	.374	.360- .377	.375	.060	.0609	.0348
05	.312	.5000-24 UNJS	.653	.436	.423- .440	.438	.060	.0804	.0459
06	.375	.5625-20 UNJS	.704	.499	.485- .502	.500	.060	.0998	.0571
08	.500	.7188-20 UNJS	.824	.650	.547- .565	.562	.065	.142	.0814
10	.625	.8438-18 UNJS	.955	.748	.673- .691	.688	.070	.217	.124
12	.750	1.0000-16 UNJ	1.062	.955	.860- .878	.875	.095	.339	.194
14	.875	1.1250-16 UNJ	1.216	1.210	1.110-1.128	1.125	.105	.617	.353
16	1.000	1.2500-14 UNJS	1.246	1.210	1.110-1.128	1.125	.110	.589	.336
20	1.250	1.5781-14 UNJS	1.387	1.480	1.355-1.380	1.375	.110	.834	.511
24	1.500	1.8438-14 UNJS	1.688	1.740	1.605-1.630	1.625	.130	1.49	.853



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /5/ AS85421, AS85720

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

(R) FITTING, CROSS, BEAM SEAL

AS4211
SHEET 1 OF 3

**REV.
B**

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 reaffirmed, revised, or cancelled. SAE invites your written comments and suggestions.

NOTES:

/1/ MATERIAL:

- a. CODE LETTER T - TYPE 6AL-4V TITANIUM ALLOY FORGING OR BAR PER AMS 4965.
- b. CODE LETTER P - TYPE 17-4PH CORROSION RESISTANT STEEL FORGING OR BAR PER AMS 5643.
- c. CODE LETTER V - TYPE 15-5PH CORROSION RESISTANT STEEL FORGING OR BAR PER AMS 5659.

2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER T - NONE.
- b. MATERIAL CODE LETTERS P AND V - HEAT TREAT TO CONDITION H 1075 PER AMS 2759/3.

3. FINISH:

- a. MATERIAL CODE LETTER T - NONE.
- b. MATERIAL CODE LETTERS P AND V - PASSIVATE PER AMS 2700.

/4/ DRY FILM LUBRICANT: APPLY DRY FILM LUBRICANT PER AS5272, TYPE I TO SEALING SURFACE. OVERSPRAY IN BORE IS NOT PERMITTED.

/5/ PROCUREMENT SPECIFICATION: AS85421 FOR OPERATING PRESSURES TO 4000 PSI AND AS85720 FOR OPERATING PRESSURES TO 5000 PSI, EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION AS APPLICABLE IN A COMPLETE ASSEMBLY. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.

/6/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B. /7/

- a. FOR SIZES 06 (.375 OD TUBE SIZE) AND SMALLER: MANUFACTURER'S NAME OR TRADEMARK, MATERIAL CODE LETTER AND MAXIMUM PRESSURE RATING. (EXAMPLE: 5K = 5000 PSI.)
- b. FOR SIZES 08 (.500 OD TUBE SIZE) AND LARGER: MANUFACTURER'S NAME OR TRADEMARK, BASIC PART NUMBER, MATERIAL CODE LETTER AND MAXIMUM PRESSURE RATING. (EXAMPLE: 5K = 5000 PSI.)

/7/ THIS PART IS DESIGNED FOR USE IN SYSTEMS WITH MAXIMUM OPERATING PRESSURES AS FOLLOWS:

- a. SIZES 03 THROUGH 16 AT 5000 PSI
- b. SIZE 20 AT 3000 PSI
- c. SIZE 24 AT 2000 PSI

8. WHEN MACHINED FROM BAR OR OVERSIZED FORGINGS, THE CENTER BODY SECTION SHALL CONFORM TO AS1376, TABLE 4.

/9/ .030 TO .125 RADIUS UNLESS QUALIFICATION OF SPECIAL PROCESS WITH SMALLER RADIUS. APPLICABLE FOR TITANIUM ALLOY PARTS ONLY.

/10/ DIMENSIONS FOR V1 AS SHOWN ARE PREFERRED BUT PREVIOUS INDUSTRY DIMENSIONS OF V2 ± .015 MAY BE USED UNTIL FORGING DIES ARE REWORKED AND FORGING STOCKS ARE DEPLETED.