

REV.
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AS4230

FEDERAL SUPPLY CLASS
4730

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.

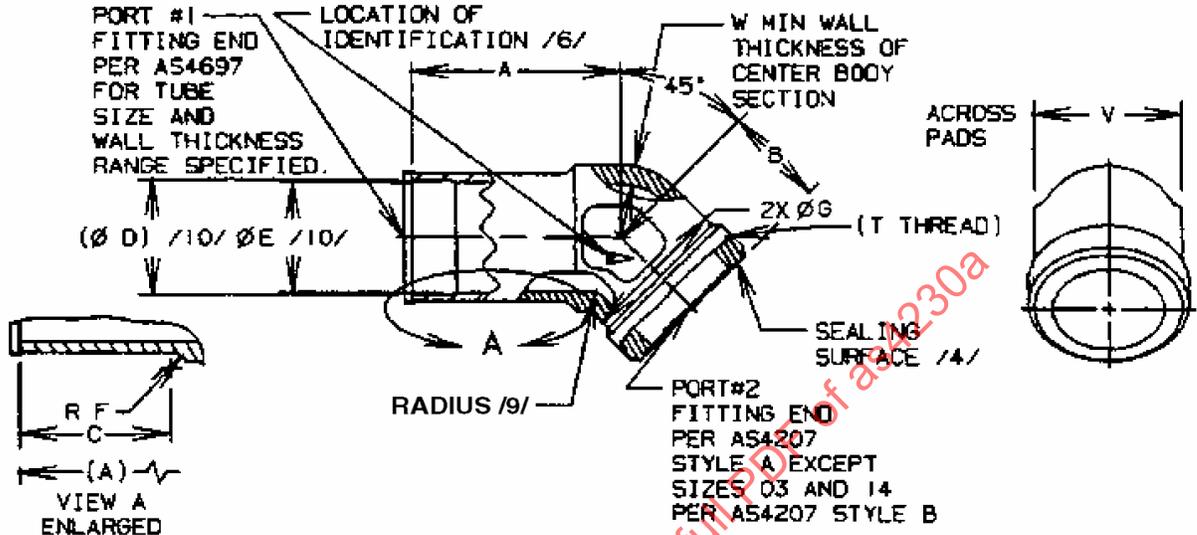
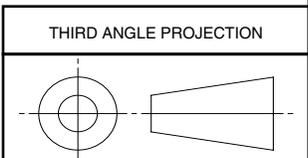


FIGURE 1 - FITTING, ELBOW, 45°

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CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /5/ AS4510

SAE Aerospace
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AEROSPACE STANDARD

(R) FITTING, ELBOW, 45°, EXTERNAL THREAD,
BEAM SEAL TO INTEGRAL WELD RING

AS4230
SHEET 1 OF 4

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ISSUED 1996-05 RREAFFIRMED 2001-12 REVISED 2006-06

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TABLE 1A - DIMENSIONS

BASIC NO. AS4230 /16/ SIZE AND TUBE WALL CODES	RANGE OF NOMINAL TUBE WALL FOR PORT #2 /7/ /16/	(NOMINAL TUBE SIZE)	PORT #1 STYLE /10/	T THREAD PER AS8879 CLASS 3A	A	B	C	D /10/
03-018	.016-.018	.188	A	.3750-28 UNJS	.832	.378	.610	.146
03-022	.019-.022	.188	A	.3750-28 UNJS	.832	.378	.610	.138
04-022	.019-.022	.250	B	.4375-24 UNJS	.832	.420	.680	.200
05-022	.019-.022	.312	B	.5000-24 UNJS	.887	.438	.650	.262
05-028	.023-.028	.312	B	.5000-24 UNJS	.887	.438	.650	.250
06-022	.019-.022	.375	B	.5625-20 UNJS	1.005	.471	.740	.325
06-028	.023-.028	.375	B	.5625-20 UNJS	1.005	.471	.740	.313
06-032	.029-.032	.375	B	.5625-20 UNJS	1.005	.471	.740	.305
08-022	.019-.022	.500	B	.7188-20 UNJS	1.180	.528	.820	.450
08-043	.033-.043	.500	B	.7188-20 UNJS	1.180	.528	.820	.408
10-028	.023-.028	.625	B	.8438-18 UNJS	1.243	.619	.880	.563
10-043	.033-.043	.625	B	.8438-18 UNJS	1.243	.619	.880	.533
10-055	.044-.055	.625	A	.8438-18 UNJS	1.243	.619	.880	.509
12-028	.023-.028	.750	B	1.0000-16 UNJ	1.392	.685	.980	.688
12-055	.044-.055	.750	A	1.0000-16 UNJ	1.392	.685	.980	.634
12-065	.056-.065	.750	A	1.0000-16 UNJ	1.392	.685	.980	.614
14-032	.029-.032	.875	B	1.1250-16 UNJ	1.562	.753	1.090	.805
14-065	.056-.065	.875	A	1.1250-16 UNJ	1.562	.753	1.090	.739
16-043	.033-.043	1.000	B	1.2500-14 UNJS	1.617	.783	1.150	.908
16-078	.066-.078	1.000	A	1.2500-14 UNJS	1.617	.783	1.150	.838
16-089	.079-.089	1.000	A	1.2500-14 UNJS	1.617	.783	1.150	.816
20-055	.044-.055	1.250	B	1.5781-14 UNJS	1.750	.836	1.170	1.134
20-089	.079-.089	1.250	A	1.5781-14 UNJS	1.750	.836	1.170	1.066
24-055	.044-.055	1.500	B	1.8438-14 UNJS	1.900	1.003	1.270	1.384

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TABLE 1B - DIMENSIONS AND WEIGHTS

BASIC NO. AS4230 /16/ SIZE AND TUBE WALL CODES	E /10/	F ±.005	G MIN	V	W	RECOMMENDED MAXIMUM PRESSURE PSI /7/	LB/EA MAX CRES	LB/EA MAX TI
03-018	--	.080	.330	.360- .377	.055	5000	.0175	.0100
03-022	--	.080	.330	.360- .377	.055	5000	.0175	.0100
04-022	.184- .194	.080	.374	.360- .377	.060	5000	.0204	.0116
05-022	.232- .242	.080	.436	.423- .440	.060	4000	.0300	.0171
05-028	.232- .242	.080	.436	.423- .440	.060	5000	.0300	.0171
06-022	.297- .307	.090	.499	.485- .502	.060	3000	.0388	.0222
06-028	.297- .307	.090	.499	.485- .502	.060	4000	.0388	.0222
06-032	.297- .307	.090	.499	.485- .502	.060	5000	.0388	.0222
08-022	.398- .408	.090	.650	.547- .565	.065	2000	.0592	.0338
08-043	.398- .408	.090	.650	.547- .565	.065	5000	.0592	.0338
10-028	.512- .523	.125	.748	.673- .691	.070	2000	.0874	.0500
10-043	.512- .523	.125	.748	.673- .691	.070	4000	.0874	.0500
10-055	--	.125	.748	.673- .691	.070	5000	.0874	.0500
12-028	.649- .660	.125	.955	.860- .878	.095	2000	.132	.0753
12-055	--	.125	.955	.860- .878	.095	4000	.132	.0753
12-065	--	.125	.955	.860- .878	.095	5000	.132	.0753
14-032	.769- .780	.125	1.219	1.110-1.128	.105	2000	.234	.134
14-065	--	.125	1.219	1.110-1.128	.105	4000	.234	.134
16-043	.862- .874	.125	1.219	1.110-1.128	.110	2000	.239	.136
16-078	--	.125	1.219	1.110-1.128	.110	4000	.239	.136
16-089	--	.125	1.219	1.110-1.128	.110	5000	.239	.136
20-055	1.115-1.128	.180	1.480	1.355-1.380	.110	2000	.344	.197
20-089	--	.180	1.480	1.355-1.380	.110	4000	.344	.197
24-055	1.324-1.337	.180	1.740	1.605-1.630	.130	2000	.557	.318

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 LETTER P AND V - PASSIVATE PER AMS 2700.



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AEROSPACE STANDARD

(R) FITTING, ELBOW, 45°, EXTERNAL THREAD,
BEAM SEAL TO INTEGRAL WELD RINGAS4230
SHEET 3 OF 4REV.
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