

RATIONALE

CORRECTING TYPOS AND UPDATING TO THE LATEST FORMAT AND SPECIFICATION CHANGES.

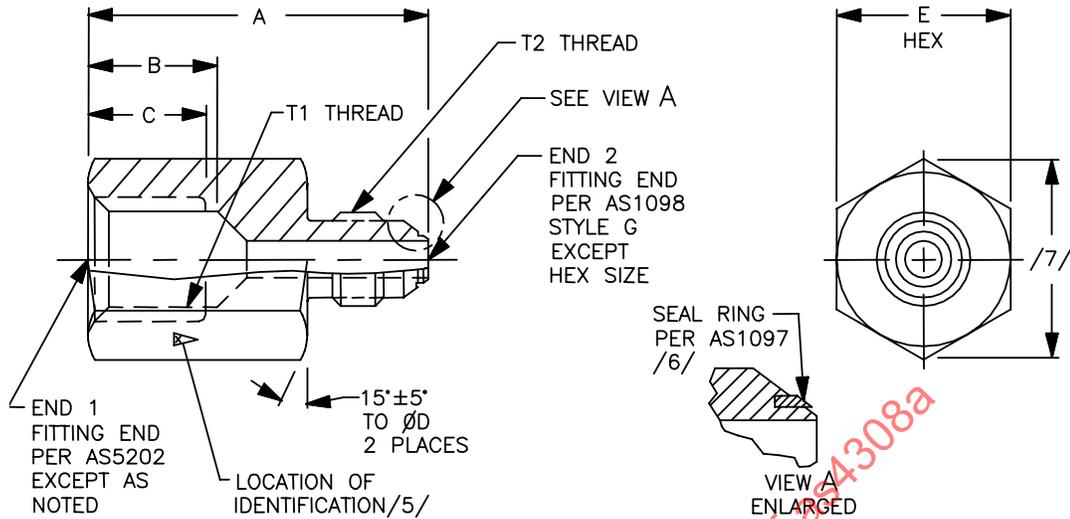
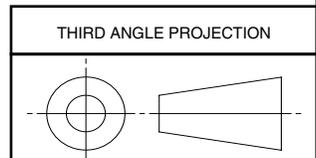


FIGURE 1 - FITTING, BUSHING-SCREW THREAD EXPANDER

TABLE 1 - DIMENSIONS AND WEIGHTS

| BASIC NUMBER AS4308 /15/ SIZE CODE | NOMINAL TUBE SIZE) END 1 | T1 THREAD PER AS8879 CLASS 3B END 1 | NOMINAL TUBE SIZE) END 2 | T2 THREAD PER AS8879 CLASS 3A END 2 | A<br>+.000<br>-.076 | B     | C<br>MIN | D<br>±.010 | E           | LB/EA APPROX REF ALUM | LB/EA APPROX REF CRES |
|------------------------------------|--------------------------|-------------------------------------|--------------------------|-------------------------------------|---------------------|-------|----------|------------|-------------|-----------------------|-----------------------|
|                                    |                          |                                     |                          |                                     |                     |       |          |            |             |                       |                       |
| 0604                               | .375                     | .5625-18UNJF                        | .250                     | .4375-20UNJF                        | 1.406               | .630  | .470     | .792       | .802-.815   | .0447                 | .124                  |
| 0804                               | .500                     | .7500-16UNJF                        | .250                     | .4375-20UNJF                        | 1.625               | .750  | .562     | .980       | .990-1.003  | .0729                 | .202                  |
| 0806                               | .500                     | .7500-16UNJF                        | .375                     | .5625-18UNJF                        | 1.562               | .750  | .562     | .980       | .990-1.003  | .0705                 | .196                  |
| 1004                               | .625                     | .8750-14UNJF                        | .250                     | .4375-20UNJF                        | 1.687               | .810  | .625     | 1.103      | 1.113-1.128 | .0955                 | .265                  |
| 1006                               | .625                     | .8750-14UNJF                        | .375                     | .5625-18UNJF                        | 1.656               | .810  | .625     | 1.103      | 1.113-1.128 | .0918                 | .255                  |
| 1008                               | .625                     | .8750-14UNJF                        | .500                     | .7500-16UNJF                        | 1.766               | .810  | .625     | 1.103      | 1.113-1.128 | .101                  | .279                  |
| 1206                               | .750                     | 1.0625-12UNJ                        | .375                     | .5625-18UNJF                        | 1.828               | .940  | .688     | 1.353      | 1.363-1.380 | .155                  | .429                  |
| 1208                               | .750                     | 1.0625-12UNJ                        | .500                     | .7500-16UNJF                        | 1.937               | .940  | .688     | 1.353      | 1.363-1.380 | .164                  | .453                  |
| 1210                               | .750                     | 1.0625-12UNJ                        | .625                     | .8750-14UNJF                        | 2.031               | .940  | .688     | 1.353      | 1.363-1.380 | .169                  | .468                  |
| 1606                               | 1.000                    | 1.3125-12UNJ                        | .375                     | .5625-18UNJF                        | 1.937               | .970  | .688     | 1.603      | 1.613-1.630 | .224                  | .620                  |
| 1608                               | 1.000                    | 1.3125-12UNJ                        | .500                     | .7500-16UNJF                        | 2.047               | .970  | .688     | 1.603      | 1.613-1.630 | .233                  | .645                  |
| 1610                               | 1.000                    | 1.3125-12UNJ                        | .625                     | .8750-14UNJF                        | 2.125               | .970  | .688     | 1.603      | 1.613-1.630 | .233                  | .646                  |
| 1612                               | 1.000                    | 1.3125-12UNJ                        | .750                     | 1.0625-12UNJ                        | 2.219               | .970  | .688     | 1.603      | 1.613-1.630 | .242                  | .671                  |
| 2008                               | 1.250                    | 1.6250-12UNJ                        | .500                     | .7500-16UNJF                        | 2.187               | 1.010 | .688     | 1.853      | 1.863-1.880 | .312                  | .865                  |
| 2010                               | 1.250                    | 1.6250-12UNJ                        | .625                     | .8750-14UNJF                        | 2.266               | 1.010 | .688     | 1.853      | 1.863-1.880 | .310                  | .860                  |
| 2012                               | 1.250                    | 1.6250-12UNJ                        | .750                     | 1.0625-12UNJ                        | 2.344               | 1.010 | .688     | 1.853      | 1.863-1.880 | .312                  | .865                  |
| 2016                               | 1.250                    | 1.6250-12UNJ                        | 1.000                    | 1.3125-12UNJ                        | 2.312               | 1.010 | .688     | 1.853      | 1.863-1.880 | .294                  | .816                  |



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ KSC-F-124



**AEROSPACE STANDARD**

(R) FITTING, BUSHING-SCREW  
THREAD EXPANDER  
FOR SEAL RING

**AS4308**  
SHEET 1 OF 3

**REV. A**

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## NOTES:

## /1/ MATERIAL:

- a. CODE LETTER D: TYPE 2024-T6 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6 OR AMS 4112; OR, TYPE 2024-T851 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6.
- b. CODE LETTER J: 304 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS 5639.
- c. CODE LETTER K: 316 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS 5648.
- d. CODE LETTER R: 321 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS 5645.
- e. CODE LETTER S: 347 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS 5646.
- f. CODE LETTER W: TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9 OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS 4124.

## 2. HEAT TREAT:

- a. ALL CODE LETTERS: NONE

## 3. FINISH:

- a. MATERIAL CODE LETTER D: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2, DYE BLUE AND DUPLEX SEAL PER PROCURMENT SPECIFICATION.
- b. MATERIAL CODE LETTERS J, K, R AND S; PASSIVATE PER AMS 2700, TYPE 6 OR TYPE 7.
- c. MATERIAL CODE LETTER W: ANODIZE PER AMS 2472 OR MIL-A-8625, TYPE II, CLASS 2, DYE BROWN, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.

/4/ PROCUREMENT SPECIFICATION: KSC-F-124 JOHN F KENNEDY SPACE CENTER, NASA, SPECIFICATION FOR FITTINGS (PRESSURE CONNECTIONS), FLARED TUBE. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER LISTED IN "PERFORMANCE REVIEW INSTITUTE" (PRI) "QUALIFIED MANUFACTURER LIST" (QML) FOR THIS TYPE PRODUCT. THE QML IS AVAILABLE AT [www.eauditnet.com](http://www.eauditnet.com). NADCAP QML AS7112, 7112/2.

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

- a. FOR SIZES 06 (.375 OD TUBE SIZE) AND SMALLER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, LETTERS "AS" AND MATERIAL CODE LETTER.
- b. FOR SIZES 08 (.500 OD TUBE SIZE) AND LARGER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, BASIC PART NUMBER AND MATERIAL CODE LETTER.

/6/ THE SEAL RING IS ORDERED SEPARATELY AS AN AS1097.

/7/ HEX CORNERS MAY BE ROUNDED PER ARP1942.

8. INTERPRETATION OF DRAWING PER ARP4296.

9. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M: REQUIREMENTS PER ASME B46.1 UNLESS OTHERWISE SPECIFIED; MACHINED SURFACES ARE TO BE 125  $\mu$ in Ra.

10. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.