

REV.
C

AS4328

RATIONALE

CORRECTED END 1 & 2 TO STYLE "E" IN FIGURE 1. UPDATED NOTE /4/ TO DELETE THE "PRI" STATEMENT AND CORRECT THE NADCAP SCOPE TO AC7112, AC7112/2.

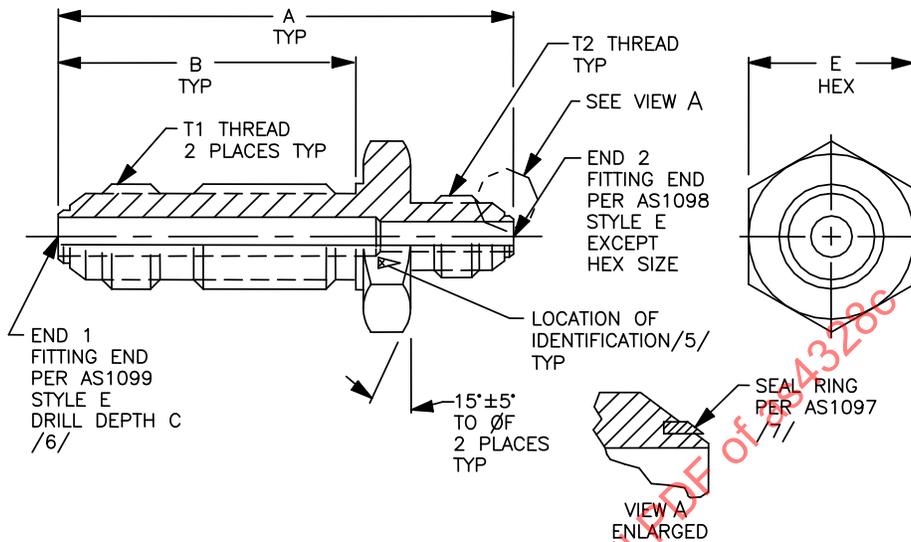


FIGURE 1 - FITTING, UNION, REDUCER, FLARED TUBE END REDUCED

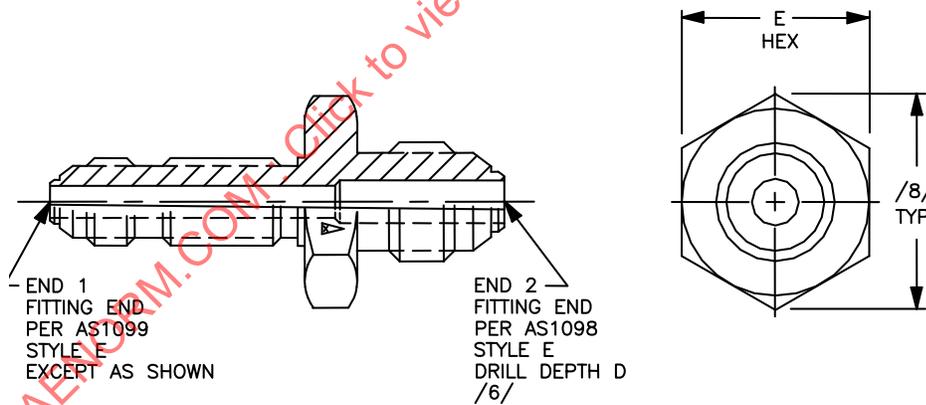
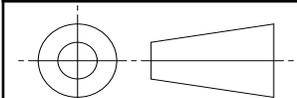


FIGURE 2 - FITTING, UNION, REDUCER, BULKHEAD END REDUCED SAME AS FIGURE 1 EXCEPT AS SHOWN

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THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ KSC-F-124



AEROSPACE STANDARD

FITTING, UNION, REDUCER, BULKHEAD, FLARED TUBE, FOR SEAL RING

AS4328
SHEET 1 OF 4

REV.
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TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NUMBER AS4328 /16/ SIZE CODE	(NOMINAL TUBE SIZE) END 1	T1 THREAD PER AS8879 CLASS 3A END 1	(NOMINAL TUBE SIZE) END 2	T2 THREAD PER AS8879 CLASS 3A END 2	A		B		C		D		E	F ±.010	LB/EA APPROX REF ALUM	LB/EA APPROX REF CRES
					+0.00 -0.090	+0.000 -0.045	+0.000 -0.045	+0.000 -0.045	+0.000 -0.045	+0.000 -0.045						
0406	.250	.4375-20UNJF	.375	.5625-18UNJF	2.147	1.208	--	.457	.802-	.815	.792	.0442	.122			
0408	.250	.4375-20UNJF	.500	.7500-16UNJF	2.225	1.208	--	.538	.990-1.003	.980	.0639	.177				
0410	.250	.4375-20UNJF	.625	.8750-14UNJF	2.350	1.208	--	.618	1.113-1.128	1.103	.0958	.266				
0412	.250	.4375-20UNJF	.750	1.0625-12UNJ	2.491	1.208	--	.703	1.363-1.380	1.353	.131	.362				
0416	.250	.4375-20UNJF	1.000	1.3125-12UNJ	2.538	1.208	--	.741	1.613-1.630	1.603	.179	.497				
0420	.250	.4375-20UNJF	1.250	1.6250-12UNJ	2.569	1.208	--	.778	1.863-1.880	1.853	.243	.674				
0604	.375	.5625-18UNJF	.250	.4375-20UNJF	2.219	1.286	.883	--	.802-	.815	.792	.0466	.129			
0608	.375	.5625-18UNJF	.500	.7500-16UNJF	2.303	1.286	--	.538	.990-1.003	.980	.0690	.191				
0610	.375	.5625-18UNJF	.625	.8750-14UNJF	2.428	1.286	--	.618	1.113-1.128	1.103	.0898	.249				
0612	.375	.5625-18UNJF	.750	1.0625-12UNJ	2.569	1.286	--	.703	1.363-1.380	1.353	.136	.376				
0804	.500	.7500-16UNJF	.250	.4375-20UNJF	2.352	1.442	1.008	--	.990-1.003	.980	.0771	.214				
0806	.500	.7500-16UNJF	.375	.5625-18UNJF	2.358	1.442	1.008	--	.990-1.003	.980	.0796	.221				
0810	.500	.7500-16UNJF	.625	.8750-14UNJF	2.584	1.442	--	.618	1.113-1.128	1.103	.110	.304				
0812	.500	.7500-16UNJF	.750	1.0625-12UNJ	2.725	1.442	--	.703	1.363-1.380	1.353	.155	.430				
0816	.500	.7500-16UNJF	1.000	1.3125-12UNJ	2.772	1.442	--	.741	1.613-1.630	1.603	.204	.565				
1004	.625	.8750-14UNJF	.250	.4375-20UNJF	2.517	1.583	1.121	--	1.113-1.128	1.103	.103	.286				
1006	.625	.8750-14UNJF	.375	.5625-18UNJF	2.523	1.583	1.121	--	1.113-1.128	1.103	.106	.293				
1008	.625	.8750-14UNJF	.500	.7500-16UNJF	2.624	1.583	1.121	--	1.113-1.128	1.103	.115	.319				
1012	.625	.8750-14UNJF	.750	1.0625-12UNJ	2.866	1.583	--	.703	1.363-1.380	1.353	.169	.469				
1016	.625	.8750-14UNJF	1.000	1.3125-12UNJ	2.913	1.583	--	.741	1.613-1.630	1.603	.218	.604				
1204	.750	1.0625-12UNJ	.250	.4375-20UNJF	2.723	1.755	1.258	--	1.363-1.380	1.353	.161	.448				
1206	.750	1.0625-12UNJ	.375	.5625-18UNJF	2.729	1.755	1.258	--	1.363-1.380	1.353	.164	.455				
1208	.750	1.0625-12UNJ	.500	.7500-16UNJF	2.830	1.755	1.258	--	1.363-1.380	1.353	.173	.481				
1210	.750	1.0625-12UNJ	.625	.8750-14UNJF	2.931	1.755	1.258	--	1.363-1.380	1.353	.182	.505				
1216	.750	1.0625-12UNJ	1.000	1.3125-12UNJ	3.084	1.755	--	.741	1.613-1.630	1.603	.247	.686				
1220	.750	1.0625-12UNJ	1.250	1.6250-12UNJ	3.115	1.755	--	.778	1.863-1.880	1.853	.312	.864				
1604	1.000	1.3125-12UNJ	.250	.4375-20UNJF	2.723	1.755	1.258	--	1.613-1.630	1.603	.212	.589				
1608	1.000	1.3125-12UNJ	.500	.7500-16UNJF	2.830	1.755	1.258	--	1.613-1.630	1.603	.244	.676				
1610	1.000	1.3125-12UNJ	.625	.8750-14UNJF	2.931	1.755	1.258	--	1.613-1.630	1.603	.233	.646				
1612	1.000	1.3125-12UNJ	.750	1.0625-12UNJ	3.037	1.755	1.258	--	1.613-1.630	1.603	.250	.692				
1620	1.000	1.3125-12UNJ	1.250	1.6250-12UNJ	3.115	1.755	--	.778	1.863-1.880	1.853	.333	.923				
1624	1.000	1.3125-12UNJ	1.500	1.8750-12UNJ	3.256	1.755	--	.878	2.109-2.135	2.099	.415	1.150				
2004	1.250	1.6250-12UNJ	.250	.4375-20UNJF	2.754	1.802	1.295	--	1.863-1.880	1.853	.299	.828				
2012	1.250	1.6250-12UNJ	.750	1.0625-12UNJ	3.068	1.802	1.295	--	1.863-1.880	1.853	.336	.931				
2016	1.250	1.6250-12UNJ	1.000	1.3125-12UNJ	3.015	1.802	1.295	--	1.863-1.880	1.853	.331	.917				
2024	1.250	1.6250-12UNJ	1.500	1.8750-12UNJ	3.303	1.802	--	.878	2.109-2.135	2.099	.470	1.300				
2416	1.500	1.8750-12UNJ	1.000	1.3125-12UNJ	3.147	1.817	1.308	--	2.109-2.135	2.099	.425	1.180				
2420	1.500	1.8750-12UNJ	1.250	1.6250-12UNJ	3.194	1.817	1.308	--	2.109-2.135	2.099	.459	1.270				
2820	1.750	2.2500-12UNJ	1.250	1.6250-12UNJ	3.379	1.973	1.433	--	2.484-2.510	2.474	.549	1.540				
2824	1.750	2.2500-12UNJ	1.500	1.8750-12UNJ	3.504	1.973	1.433	--	2.484-2.510	2.474	.584	1.640				
3224	2.000	2.5000-12UNJ	1.500	1.8750-12UNJ	3.629	2.098	1.533	--	2.734-2.760	2.724	.679	1.900				
3228	2.000	2.5000-12UNJ	1.750	2.2500-12UNJ	3.754	2.098	1.533	--	2.734-2.760	2.724	.731	2.050				

NOTES:

/1/ MATERIAL:

- a. CODE LETTER D: TYPE 2024-T6 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6 OR AMS4112; 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 AMS5639.
- c. CODE LETTER K: 316 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS5648.
- d. CODE LETTER R: 321 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS5645.
- e. CODE LETTER S: 347 CORROSION RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS5646.
- f. CODE LETTER W: TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9 OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS4124.

2. HEAT TREAT:

- a. ALL CODE LETTERS: NONE

3. FINISH:

- a. MATERIAL CODE LETTER D: ANODIZE PER AMS2472 OR MIL-A-8625 TYPE II, CLASS 2, DYE BLUE AND DUPLEX SEAL PER PROCUREMENT SPECIFICATION.
- b. MATERIAL CODE LETTERS J, K, R, AND S; PASSIVATE PER AMS2700, TYPE 6 OR TYPE 7.
- c. MATERIAL CODE LETTER W: ANODIZE PER AMS2472 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 THE NATIONAL AEROSPACE AND DEFENSE CONTRACTORS ACCREDITATION PROGRAM (NADCAP) QUALIFIED MANUFACTURERS LIST (QML) AC7112, AC7112/2 FOR SIMILAR FLARED FITTINGS. THE QML IS AVAILABLE AT www.eAuditNet.com.

/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.
- c. MATERIAL CODE LETTER W: ANODIZE PER AMS2472 OR MIL-A-8625, TYPE II, CLASS 2, DYE BROWN, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.

/6/ AT THE OPTION OF THE MANUFACTURER, THE SMALLER DIAMETER MAY BE DRILLED THRU.

/7/ THE SEAL RING IS ORDERED SEPARATELY AS AN AS1097.

/8/ HEX CORNERS MAY BE ROUNDED PER ARP1942.

9. INTERPRETATION OF DRAWING PER AS4296.

	AEROSPACE STANDARD	AS4328 SHEET 3 OF 4	REV. C
	FITTING, UNION, REDUCER, BULKHEAD, FLARED TUBE, FOR SEAL RING		