

AS4661

FEDERAL SUPPLY CLASS  
4730

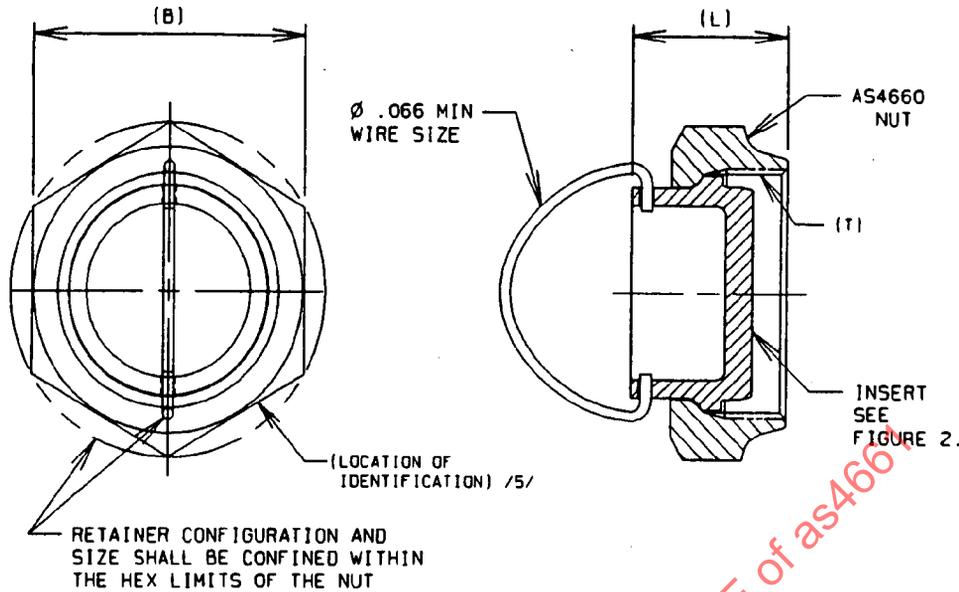


FIGURE 1 - CAP ASSEMBLY

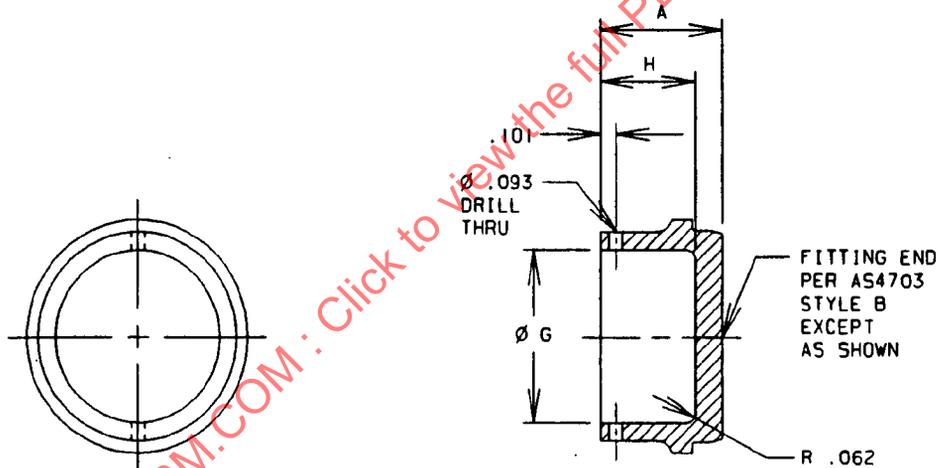
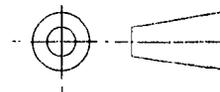


FIGURE 2 - CAP INSERT

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4661 /11/ SIZE CODE	(NOMINAL TUBE SIZE)	T THREAD PER MIL-S-8879	DIMENSIONS					WEIGHTS		
			A	B	G	H	L	LB/EA MAX ALUM	LB/EA MAX CRES	LB/EA MAX TI
20	1.250	1.5625-12 UNJ	.800	1.812	1.093	.590	1.035	.118	.321	.185
24	1.500	1.8125-12 UNJ	.800	2.062	1.343	.525	1.035	.171	.473	.258
28	1.750	2.1250-12 UNJ	.820	2.375	1.585	.520	1.065	.325	.892	.512

THIRD ANGLE PROJECTION



ISSUED 1992-05-22 REVISED

CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ MIL-F-18280

**SAE** The Engineering Society  
For Advancing Mobility  
Land Sea Air and Space  
**INTERNATIONAL**

400 Commonwealth Drive, Warrendale, PA 15096-0001

**AEROSPACE STANDARD**

CAP ASSEMBLY, SHORT FLARELESS

**AS4661**

SHEET 1 OF 3

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AS4661

NOTES:

- /1/ MATERIAL:
- a. CODE LETTER T:
    - (1) INSERT: TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS 4928
    - (2) NUT: CODE LETTER T OF AS4660 REFERENCE (TYPE 6AL-4V TITANIUM ALLOY)
    - (3) WIRE: CORROSION RESISTANT STEEL TYPE 302 PER ASTM A 493 OR CLASS 305 PER AMS 5685
  - b. CODE LETTER V:
    - (1) INSERT: TYPE 15-5PH CORROSION RESISTANT STEEL BAR PER AMS 5659
    - (2) NUT: CODE LETTER V OF AS4660 REFERENCE (TYPE 15-5PH CORROSION RESISTANT STEEL)
    - (3) WIRE: CORROSION RESISTANT STEEL TYPE 302 PER ASTM A 493 OR CLASS 305 PER AMS 5685
  - c. CODE LETTER W:
    - (1) INSERT: TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS 4124
    - (2) NUT: CODE LETTER W OF AS4660 REFERENCE (TYPE 7075T73 ALUMINUM ALLOY)
    - (3) WIRE: CORROSION RESISTANT STEEL TYPE 302 PER ASTM A 493 OR CLASS 305 PER AMS 5685
- /2/ HEAT TREATMENT:
- a. MATERIAL CODE LETTER T:
    - (1) INSERT, NUT, AND WIRE: NONE
  - b. MATERIAL CODE LETTER V:
    - (1) INSERT: HEAT TREAT TO CONDITION H1075 PER AMS 2759/3
    - (2) NUT: MATERIAL CODE LETTER V OF AS4660 REFERENCE (HEAT TREAT TO CONDITION H1075)
    - (3) WIRE: NONE
  - c. MATERIAL CODE LETTER W:
    - (1) INSERT, NUT, AND WIRE: NONE
- /3/ FINISH:
- a. MATERIAL CODE LETTER T:
    - (1) INSERT: FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486
    - (2) NUT: CODE LETTER T OF AS4660 REFERENCE (FLUORIDE PHOSPHATE COAT AND COAT WITH DRY LUBRICANT ON ID)
    - (3) WIRE: PASSIVATE PER QQ-P-35 TYPE VI OR VII
  - b. MATERIAL CODE LETTER V:
    - (1) INSERT:
      - (a) V CODE PARTS TO BE PASSIVATED ONLY WILL HAVE NO FINISH CODE LETTER AFTER THE PART NUMBER. THE FINISH WILL BE: PASSIVATE PER QQ-P-35, TYPE II OR VIII.
      - (b) V CODE PARTS TO BE CADMIUM PLATED ONLY WILL HAVE THE FINISH CODE LETTER "P" AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE: CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2.
    - (2) NUT: CODE LETTER V OF AS4660 REFERENCE (PASSIVATE AND COAT WITH DRY LUBRICANT ON ID)
    - (3) WIRE: PASSIVATE PER QQ-P-35, TYPE VI OR VII
  - c. MATERIAL CODE LETTER W:
    - (1) INSERT: ANODIZE PER AMS 2472 DYE BROWN SIMILAR TO COLOR 10080 OF FED-STO-595
    - (2) NUT: CODE LETTER W OF AS4660 REFERENCE (ANODIZE DYE BROWN AND COAT WITH DRY LUBRICANT ON ID)
    - (3) WIRE: PASSIVATE PER QQ-P-35 TYPE VI OR VII
- /4/ PROCUREMENT SPECIFICATION: MIL-F-18280 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.
- /5/ NUT SHALL BE IDENTIFIED WITH MANUFACTURER'S NAME, TRADEMARK OR CAGE CODE, "AS4660", AND MATERIAL CODE LETTER.
6. THIS PART IS DESIGNED FOR USE IN SYSTEMS WITH OPERATING PRESSURES AS FOLLOWS:
- a. SIZES -20 AND -24 TITANIUM ALLOY AND CORROSION RESISTANT STEEL AT 3000 psi
  - b. SIZE -28 TITANIUM ALLOY AND CORROSION RESISTANT STEEL AND SIZES -20, -24, AND -28 ALUMINUM ALLOY AT 600 psi
7. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36; REQUIREMENTS PER ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125  $\mu$ in Ra.