

REV.  
A

AS4661

FEDERAL SUPPLY CLASS  
4730

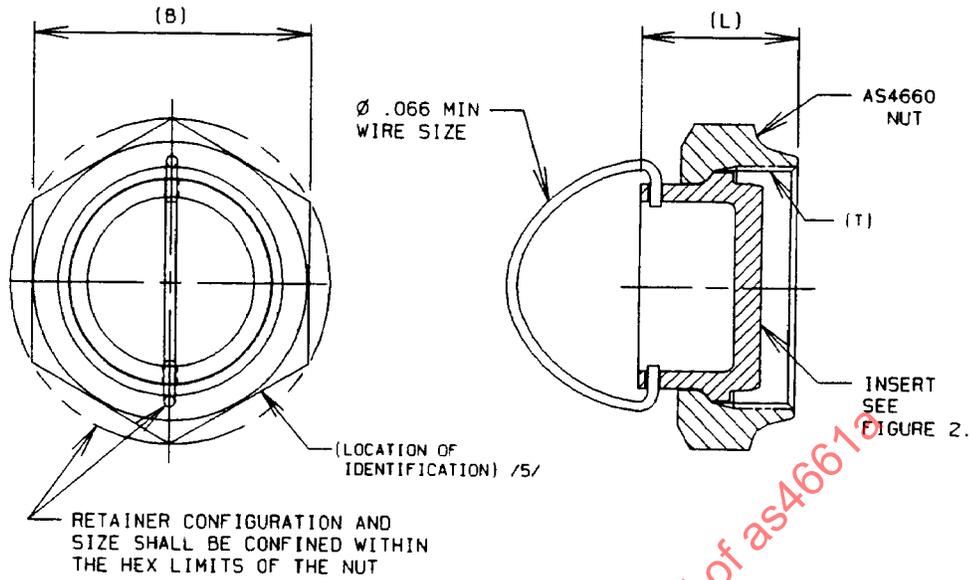


FIGURE 1 - FITTING ASSEMBLY, CAP

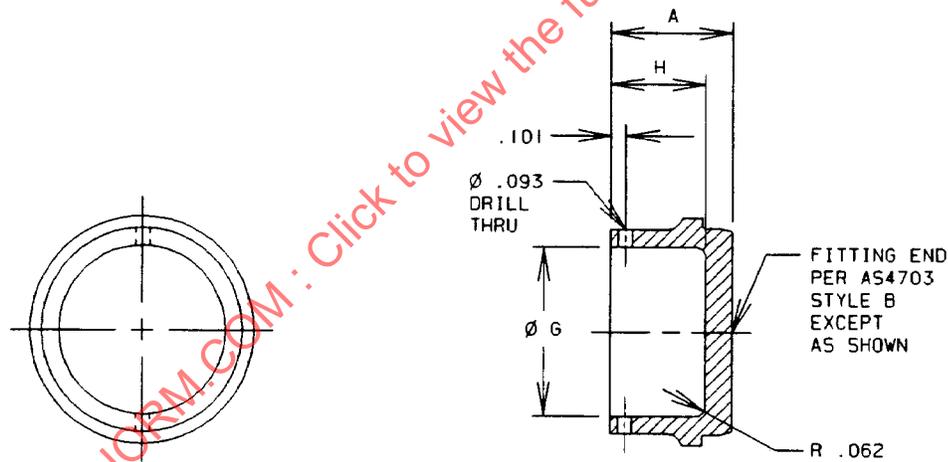
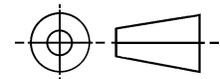


FIGURE 2 - CAP INSERT

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ MIL-F-18280

**SAE Aerospace**  
An SAE International Group

**AEROSPACE STANDARD**

FITTING ASSEMBLY, CAP, SHORT FLARELESS

**AS4661**  
SHEET 1 OF 3

**REV.  
A**

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ISSUED 1992-06 REVISED 1994-12 REAFFIRMED 2004-07

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TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4661 /14/ SIZE CODE	(NOMINAL TUBE SIZE)	T THREAD PER MIL-S-8879	T					LB/EA	LB/EA	LB/EA
			A	B	G	H	L	MAX ALUM	MAX CRES	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

## 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 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