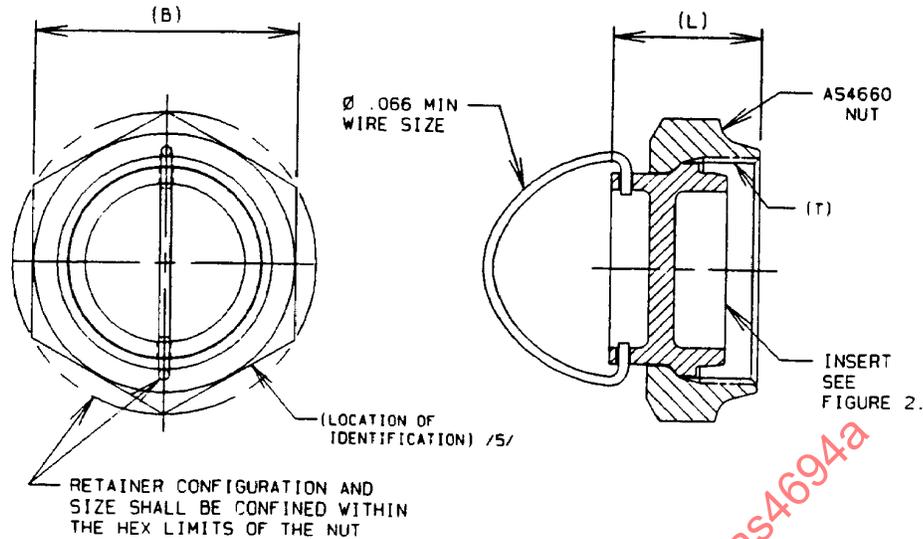


RATIONALE

THIS DOCUMENT HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE 5-YEAR REVIEW POLICY.

REV.  
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AS4694



(R) FIGURE 1 - FITTING ASSEMBLY, CAP

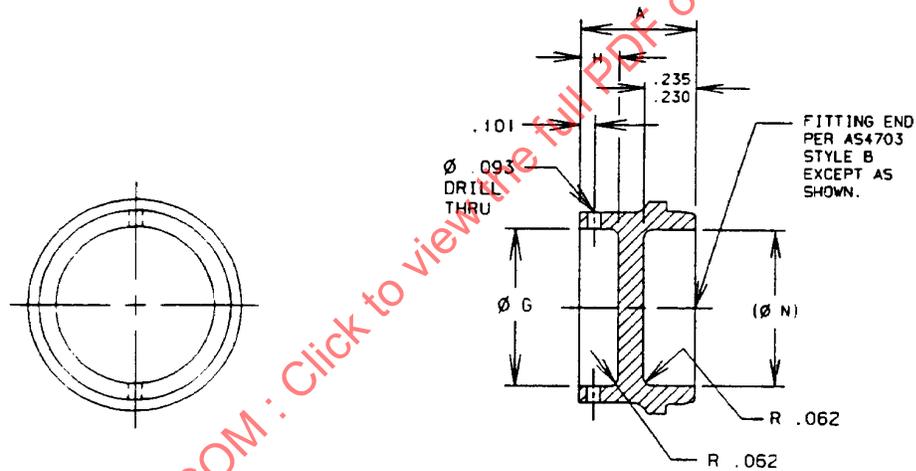
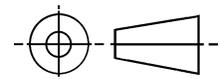


FIGURE 2 - CAP INSERT

TABLE 1 - DIMENSIONS AND WEIGHTS

| BASIC NO.<br>AS4694 | (NOMINAL<br>/14/<br>SIZE CODE | TUBE<br>SIZE) | T THREAD<br>PER MIL-S-8879 | DIMENSIONS |       |       |      |       | LB/EA | LB/EA       | LB/EA       |           |
|---------------------|-------------------------------|---------------|----------------------------|------------|-------|-------|------|-------|-------|-------------|-------------|-----------|
|                     |                               |               |                            | A          | B     | G     | H    | L     | N     | MAX<br>ALUM | MAX<br>CRES | MAX<br>TI |
| 20                  |                               | 1.250         | 1.5625-12 UNJ              | .800       | 1.812 | 1.093 | .355 | 1.035 | 1.152 | .118        | .321        | .185      |
| 24                  |                               | 1.500         | 1.8125-12 UNJ              | .800       | 2.062 | 1.343 | .290 | 1.035 | 1.380 | .171        | .473        | .258      |

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, HOLLOW END,  
ACORN, SHORT FLARELESS

**AS4694**  
SHEET 1 OF 3

**REV.  
A**

SAE Technical Standards Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user." SAE reviews each technical report at least every five years at which time it may be reaffirmed, revised, or cancelled. SAE invites your written comments and suggestions.

ISSUED 1993-12 REVISED 1994-12 REAFFIRMED 2007-10

## 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 H 1075 PER AMS 2759/3
    - (2) NUT: MATERIAL CODE LETTER V OF AS4660 REFERENCE (HEAT TREAT TO CONDITION H 1075)
    - (3) WIRE: NONE
  - c. MATERIAL CODE LETTER W
    - (1) INSERT, NUT, AND WIRE: NONE
- (R) /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 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 OR PER MIL-A-8625, TYPE II, CLASS 2 DYED BROWN SIMILAR TO COLOR 10080 OF FED-STD-595
    - (2) NUT: CODE LETTER W OF AS4660 REFERENCE (ANODIZE DYED BROWN AND COAT WITH DRY LUBRICANT ON ID)
    - (3) WIRE: PASSIVATE PER QQ-P-35 TYPE 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/ THE AS4660 NUT USED WITH THIS CAP ASSEMBLY SHALL BE IDENTIFIED WITH THE MANUFACTURER'S NAME, TRADEMARK OR CAGE CODE, "AS4660," AND THE MATERIAL CODE LETTER. ADDITIONAL IDENTIFICATION IS NOT REQUIRED.
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. SIZES -20 AND -24 ALUMINUM ALLOY AT 600 psi