FEDERAL SUPPLY CLASS
4730

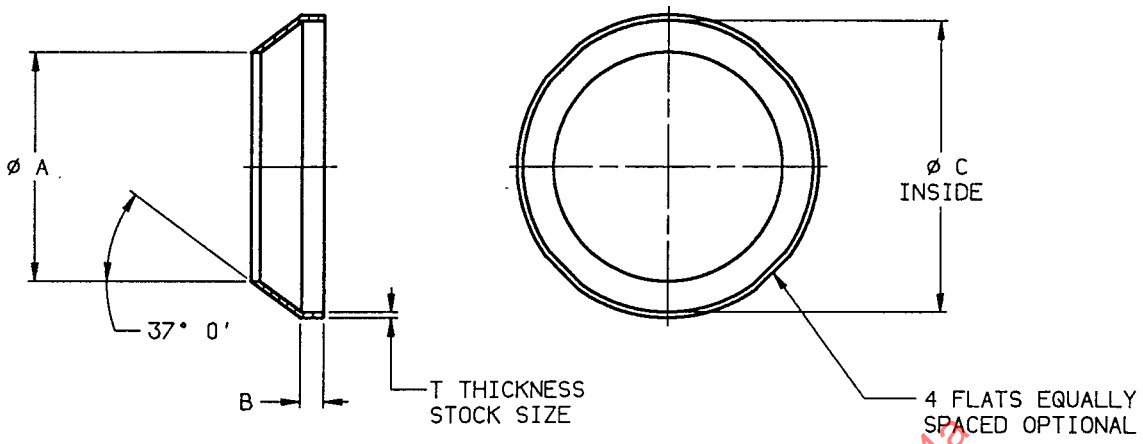


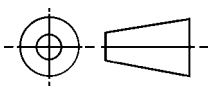
FIGURE 1 - GASKET

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4824 /13/ SIZE CODE	(NOMINAL TUBE SIZE)	A /5/	B /5/	C /5/	T	LB/100 MAX ALUM	LB/100 MAX COPPER	LB/100 MAX CRES	LB/100 MAX NICKEL
02	.125	.103	.045	.245	.005	.0100	.0330	.0296	.0328
03	.188	.166	.045	.307	.005	.0127	.0420	.0377	.0417
04	.250	.213	.060	.359	.005	.0179	.0590	.0530	.0586
05	.312	.275	.060	.421	.005	.0252	.0830	.0745	.0825
06	.375	.338	.060	.476	.005	.0349	.115	.103	.114
07	.438	.401	.060	.539	.005	.0455	.150	.135	.149
08	.500	.446	.080	.654	.010	.0558	.184	.165	.183
09	.562	.529	.080	.722	.010	.0789	.260	.233	.258
10	.625	.562	.090	.767	.010	.106	.349	.313	.347
11	.688	.625	.090	.882	.010	.129	.425	.382	.422
12	.750	.687	.090	.938	.010	.162	.534	.479	.531
14	.875	.826	.090	1.070	.010	.186	.612	.479	.608
16	1.000	.936	.110	1.188	.010	.221	.730	.655	.725
18	1.125	1.046	.060	1.375	.010	.248	.817	.734	.812
20	1.250	1.175	.110	1.501	.010	.295	.971	.872	.965
24	1.500	1.410	.110	1.750	.010	.394	1.30	1.17	1.29
28	1.750	1.680	.110	2.125	.010	.543	1.79	1.61	1.78
32	2.000	1.913	.110	2.375	.010	.646	2.13	1.91	2.12

ISSUED 1995-09 REVISED 1997-09 REAFFIRMED 2007-11

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B /7/

PROCUREMENT SPECIFICATION: NONE /4/

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

GASKET, FITTING END,
37° FLARED

NOTES:

/1/ MATERIAL CODE LETTER:

a. CODE LETTER A -
TYPE 1100-0, ANNEALED ALUMINUM GRADE B FOIL PER QQ-A-1876, FOR .005 THICK.
TYPE 1100-0, ANNEALED ALUMINUM SHEET PER AMS 4001, FOR .010 THICK.

b. CODE LETTER C -
TYPE C10100, C10200 OR C11000, COLD-ROLLED ANNEALED COPPER FOIL OR STRIP, CHEMICAL COMPOSITION PER ASTM B 152 AND MECHANICAL PROPERTIES PER ASTM B 451.

c. CODE LETTER N -
TYPE N02201 COLD-ROLLED ANNEALED NICKEL SHEET OR STRIP PER ASTM B 162 OR AMS 5553.

d. CODE LETTER S -
TYPE S30500 ANNEALED CORROSION RESISTANT STEEL SHEET OR STRIP PER QQ-S-766 OR ASTM A 240.

2. HEAT TREATMENT:

a. ALUMINUM - FULL ANNEAL AFTER FORMING PER AMS 2770.

b. COPPER - BRIGHT ANNEAL TO FULL SOFT CONDITION AFTER FORMING AT 1200 °F ± 25 °F FOR 45 TO 60 min IN A VACUUM FURNACE. PYROMETRY SHALL BE IN ACCORDANCE WITH AMS 2750.

c. NICKEL - BRIGHT ANNEAL TO FULL SOFT CONDITION AFTER FORMING AT 1500 °F ± 25 °F FOR 30 TO 60 min IN A VACUUM FURNACE, AND GASEOUS NITROGEN QUENCH. PYROMETRY SHALL BE IN ACCORDANCE WITH AMS 2750.

d. CORROSION RESISTANT STEEL - BRIGHT ANNEAL AFTER FORMING AT 1950 °F ± 25 °F FOR 15 TO 20 min IN A VACUUM FURNACE, AND GASEOUS NITROGEN QUENCH. PYROMETRY SHALL BE IN ACCORDANCE WITH AMS 2750.

3. CLEANING, PACKAGING, AND IDENTIFICATION: SURFACES OF PART SHALL BE FREE OF OIL, GREASE, DIRT, AND OTHER FOREIGN MATERIALS. CAUTION: THESE PARTS ARE SOFT AND CAN BE EASILY DEFORMED OR DAMAGED. PACKAGE TO PREVENT DAMAGE IN HANDLING OR SHIPMENT. IDENTIFY PACKAGE WITH MANUFACTURER'S NAME, TRADEMARK OR CAGE CODE, BASIC PART NUMBER, AND QUANTITY OF PARTS.

/4/ THIS PART IS INTENDED FOR USE WITH 37° FLARED FITTING ENDS PER AS4395 OR SIMILAR FITTING ENDS FOR POWER PLANT APPLICATIONS, FUEL SYSTEMS, GROUND SUPPORT AND TEST EQUIPMENT AND FOR USE IN TESTING OF COMPONENTS. IT MAY BE USED FOR ONE TIME TEMPORARY REPAIR OF LEAKING FITTING JOINTS IN SERVICE UNTIL THE JOINT CAN BE REWORKED OR REPLACED TO ELIMINATE THE GASKET. IT IS INTENDED THAT THE GASKET SHALL BE ASSEMBLED IN A FITTING JOINT ONE TIME ONLY AND, IF THE JOINT MUST BE DISASSEMBLED, A NEW GASKET SHALL BE USED UPON REASSEMBLY.

/5/ THESE PARTS ARE SOFT AND EASILY DEFORMED, THEREFORE, DIMENSIONS "A", "B", AND "C" SHALL NOT BE CONFIRMED IN THE FREE STATE CONDITION. FUNCTIONALITY AND FIT MAY BE VERIFIED BY INSTALLING THE GASKET ON A STANDARD FITTING END OF THE APPROPRIATE SIZE. AN OUT-OF-ROUND CONDITION, WHICH DOES NOT PREVENT INSTALLATION OF THE SEAL, SHALL NOT BE CAUSE FOR REJECTION.

6. ASSEMBLY TORQUE TECHNIQUE: IN ORDER TO COMPENSATE FOR YIELDING OF THE GASKET, RE-TORQUE THE NUT TO THE ORIGINAL TORQUE VALUE WITHIN 10 TO 15 s AFTER APPLICATION OF THE INITIAL TORQUE.

/7/ REVISIONS OF THIS STANDARD SHALL BE COORDINATED WITH SAE COMMITTEE E-25.

8. THE CHANGE BAR (**I**) LOCATED IN THE LEFT MARGIN IS FOR THE CONVENIENCE OF THE USER IN LOCATING AREAS WHERE TECHNICAL REVISIONS, NOT EDITORIAL CHANGES, HAVE BEEN MADE TO THE PREVIOUS ISSUE OF THIS DOCUMENT. AN (R) SYMBOL TO THE LEFT OF THE DOCUMENT TITLE INDICATES A COMPLETE REVISION OF THE DOCUMENT.

9. INVENTORIED PARTS CONFORMING TO THE PREVIOUS "LETTER CHANGE" MAY BE USED TO DEPLETION.

10. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36; REQUIREMENTS PER ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, FORMED SURFACES TO BE 125 µm Ra.

11. DIMENSIONING AND TOLERANCING: ASME Y14.5M