

RATIONALE

AS4861A HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

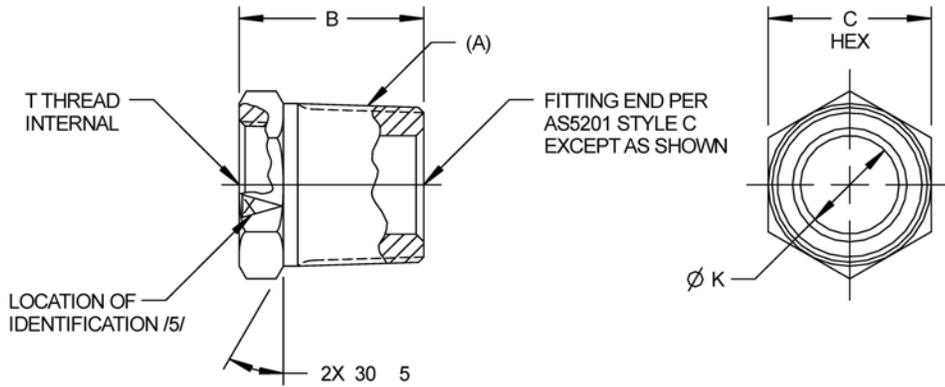


FIGURE 1 – FITTING, BUSHING, PIPE, INTERNAL AND EXTERNAL THREAD

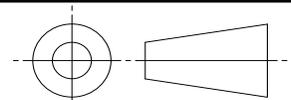
TABLE 1 – DIMENSIONS

BASIC NO. AS4861 /14/ SIZE CODE	A THREAD PER AS71051 ANPT	T THREAD PER AS71051 ANPT	B ±.031	C	K
01	1/4-18	1/8-27	.781	.615-.628	.311-.327
02	3/8-18	1/4-18	.781	.740-.753	.404-.423
03	3/8-18	1/8-27	.781	.740-.753	.311-.327
04	1/2-14	3/8-18	1.016	.928-.941	.529-.557
05	1/2-14	1/4-18	1.016	.928-.941	.404-.423
06	1/2-14	1/8-27	1.016	.928-.941	.311-.327
07	3/4-14	1/2-14	1.063	1.113-1.128	.654-.688
08	3/4-14	3/8-18	1.063	1.113-1.128	.529-.557
09	3/4-14	1/4-18	1.063	1.113-1.128	.404-.423
10	1-11 1/2	3/4-14	1.250	1.363-1.380	.857-.897
11	1-11 1/2	1/2-14	1.250	1.363-1.380	.654-.688
12	1-11 1/2	3/8-18	1.250	1.363-1.380	.529-.557
13	1 1/4-11 1/2	3/4-14	1.281	1.738-1.755	.857-.897

INACTIVE IN PART - SEE NOTE /15/

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS4861A>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /5/ AS4842

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

FITTING, BUSHING, PIPE,
INTERNAL AND EXTERNAL THREAD

SAE AS4861
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 revised, reaffirmed, stabilized, or cancelled. SAE invites your written comments and suggestions.

NOTES:

/1/ MATERIAL:

- a. DASH AS CODE LETTER – TYPE 377 COPPER ALLOY FORGING PER ASTM B 124, OR HALF HARD FORGING OR BAR PER ASTM B 138, OR BAR PER AMS 4614.
- b. CODE LETTER D – TYPE 2014-T6 ALUMINUM ALLOY FORGING PER AMS-QQ-A-367 OR AMS 4133, OR TYPE 2024-T6 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6, OR TYPE 2024-T851 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6 OR AMS 4339. /15/
- c. CODE LETTER J – TYPE 304 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS 5639.
- d. CODE LETTER K – TYPE 316 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS 5648.
- e. CODE LETTER R – TYPE 321 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS 5645.
- f. CODE LETTER S – TYPE 347 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS 5646. /15/
- g. CODE LETTER W – TYPE 7075-T73 ALUMINUM ALLOY FORGING PER AMS-QQ-A-367 OR AMS 4141, OR TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9, OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS 4124.

2. FINISH:

- a. DASH AS CODE LETTER – CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 3 OR NONE. /16/
- b. MATERIAL CODE LETTER D – ANODIZE PER MIL-A-8625, TYPE II, CLASS 2 OR AMS 2472, DYE BLUE.
- c. MATERIAL CODE LETTER J – PASSIVATE PER AMS-QQ-P-35, TYPE VI OR VII.
- d. MATERIAL CODE LETTER K – PASSIVATE PER AMS-QQ-P-35, TYPE VI OR VII.
- e. MATERIAL CODE LETTER R – PASSIVATE PER AMS-QQ-P-35, TYPE VI OR VII.
- f. MATERIAL CODE LETTER S – PASSIVATE PER AMS-QQ-P-35, TYPE VI OR VII.
- g. MATERIAL CODE LETTER W – ANODIZE PER MIL-A-8625, TYPE II, CLASS 2 OR AMS 2472, DYE BROWN SIMILAR TO COLOR 10080 OF FED-STD-595.

/3/ INTENDED USE: OXYGEN SYSTEMS AND GROUND SUPPORT EQUIPMENT ONLY. PARTS FOR OXYGEN SYSTEMS SHALL BE IDENTIFIED IN THE PART NUMBER AS CODE "A" AND SHALL BE FURNISHED CLEANED, PACKAGED, AND LABELED IN ACCORDANCE WITH AIR1176 TO A PROCESS APPROVED BY THE USER.

/4/ PROCUREMENT SPECIFICATION: AS4842 EXCEPT AS SPECIFIED ON THIS STANDARD. USERS OF THIS STANDARD SHALL PROCURE THIS PRODUCT FROM ACCREDITED MANUFACTURER(S), OR ACCREDITED DISTRIBUTOR(S), AS LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED MANUFACTURERS LIST (QML) FOR THIS TYPE OF PRODUCT.

/5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D, OR METHOD 7A3, 15A3, OR 15B.

- a. FOR SIZES 03 AND SMALLER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, LETTERS "AS", MATERIAL CODE LETTER, AND FORGING MANUFACTURER'S IDENTIFICATION, WHEN MADE FROM FORGING.
- b. FOR SIZES 04 AND LARGER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, BASIC PART NUMBER, MATERIAL CODE LETTER, AND FORGING MANUFACTURER'S IDENTIFICATION, WHEN MADE FROM FORGING.

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

7. THIS STANDARD IS A FUNCTIONAL EQUIVALENT OF AN912.

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. INTERPRETATION OF DRAWING PER ARP4296.

 An SAE International Group	AEROSPACE STANDARD	SAE AS4861 SHEET 2 OF 3	REV. A
	FITTING, BUSHING, PIPE, INTERNAL AND EXTERNAL THREAD		