

AS5230

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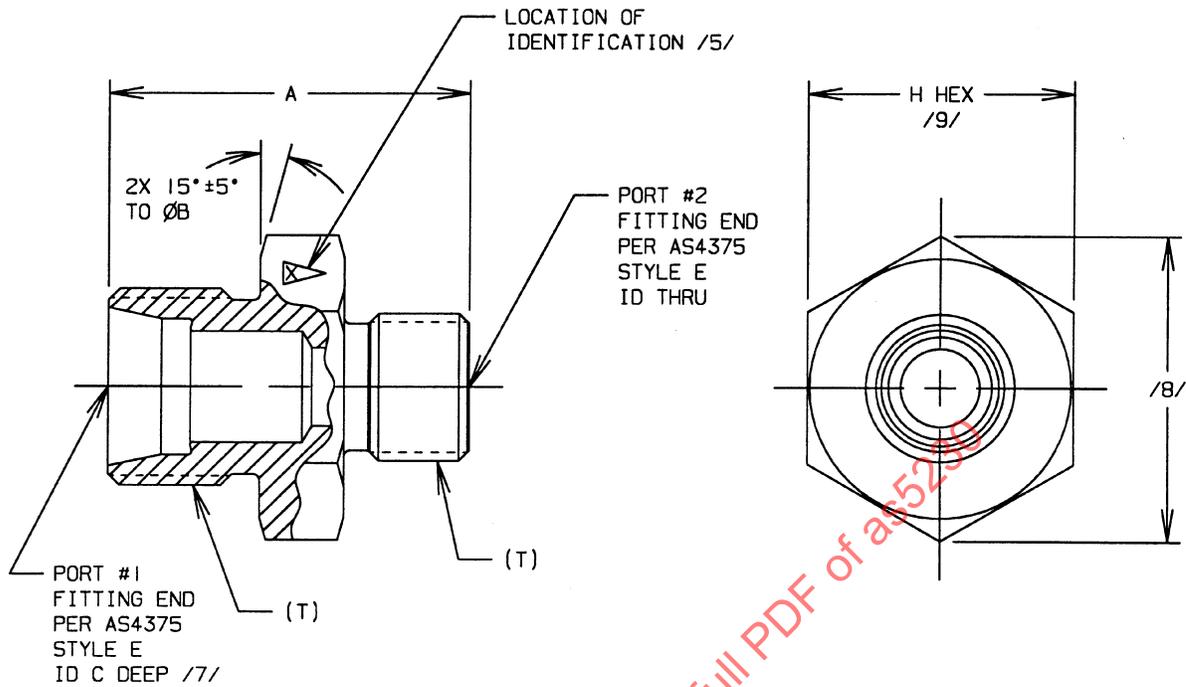
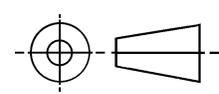


FIGURE 1 - FITTING, UNION AND REDUCER

TABLE 1 - DIMENSIONS /11/

PORT #1 /17/ SIZE CODE	A PORT #2 SIZE CODE												
02	03	04	05	06	08	10	12	14	16	20	24	32	
02	1.063	-	-	-	-	-	-	-	-	-	-	-	-
03	1.047	1.094	-	-	-	-	-	-	-	-	-	-	-
04	1.094	1.141	1.063	-	-	-	-	-	-	-	-	-	-
05	-	-	1.156	1.063	-	-	-	-	-	-	-	-	-
06	1.156	1.203	1.219	1.219	1.188	-	-	-	-	-	-	-	-
08	1.250	1.297	1.344	1.344	1.344	1.375	-	-	-	-	-	-	-
10	-	-	1.438	-	1.625	1.531	1.563	-	-	-	-	-	-
12	-	-	1.531	1.531	1.531	1.625	1.688	1.750	-	-	-	-	-
14	-	-	1.531	1.531	1.531	1.625	1.688	1.750	1.750	-	-	-	-
16	-	-	1.531	-	-	-	1.688	1.750	-	1.750	-	-	-
20	-	-	1.531	-	-	-	-	1.813	-	1.750	1.750	-	-
24	-	-	-	-	-	-	-	-	-	1.750	1.750	1.750	-
32	-	-	-	-	-	-	-	-	-	-	-	-	1.813

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS4444

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD
FITTING, UNION AND REDUCER, FLARELESS

AS5230
SHEET 1 OF 4

ISSUED 1998-03 REAFFIRMED 2004-07

TABLE 1A - DIMENSIONS

PORT #1 /17/ SIZE CODE	C ± .031 PORT #2 SIZE CODE 02	C ± .031 PORT #2 SIZE CODE 03	C ± .031 PORT #2 SIZE CODE 04	C ± .031 PORT #2 SIZE CODE 05	C ± .031 PORT #2 SIZE CODE 06	C ± .031 PORT #2 SIZE CODE 08	C ± .031 PORT #2 SIZE CODE 10	C ± .031 PORT #2 SIZE CODE 12	C ± .031 PORT #2 SIZE CODE 14	C ± .031 PORT #2 SIZE CODE 16	C ± .031 PORT #2 SIZE CODE 20	C ± .031 PORT #2 SIZE CODE 24	C ± .031 PORT #2 SIZE CODE 32
02	-	-	-	-	-	-	-	-	-	-	-	-	-
03	.547	-	-	-	-	-	-	-	-	-	-	-	-
04	.594	.594	-	-	-	-	-	-	-	-	-	-	-
05	-	-	.578	-	-	-	-	-	-	-	-	-	-
06	.625	.625	.625	.625	-	-	-	-	-	-	-	-	-
08	.719	.719	.719	.719	.719	-	-	-	-	-	-	-	-
10	-	-	.781	-	.781	.781	-	-	-	-	-	-	-
12	-	-	.875	.875	.875	.875	.875	-	-	-	-	-	-
14	-	-	.875	.875	.875	.875	.875	.875	-	-	-	-	-
16	-	-	.875	-	-	-	.875	.875	-	-	-	-	-
20	-	-	.875	-	-	-	-	.875	-	.875	-	-	-
24	-	-	-	-	-	-	-	-	-	.875	.875	-	-
32	-	-	-	-	-	-	-	-	-	-	-	-	-

TABLE 1B - DIMENSIONS AND WEIGHTS /10/

PORT SIZE CODE	(NOMINAL TUBE SIZE)	T THREAD PER MIL-S-8879 CLASS 3A	B ±.010	H	LB/EA MAX AL	LB/EA MAX STEEL	LB/EA MAX TI
02	.125	.3125-24 UNJF	.542	.552-.565	.0138	.0396	.0218
03	.188	.3750-24 UNJF	.605	.615-.628	.0165	.0474	.0261
04	.250	.4375-20 UNJF	.668	.678-.691	.0164	.0470	.0259
05	.312	.5000-20 UNJF	.730	.740-.753	.0201	.0577	.0319
06	.375	.5625-18 UNJF	.792	.802-.815	.0286	.0821	.0453
08	.500	.7500-16 UNJF	.980	.990-1.003	.0508	.146	.0805
10	.625	.8750-14 UNJF	1.103	1.113-1.128	.0769	.221	.122
12	.750	1.0625-12 UNJ	1.353	1.363-1.380	.121	.348	.192
14	.875	1.1875-12 UNJ	1.478	1.488-1.505	.142	.408	.225
16	1.000	1.3125-12 UNJ	1.603	1.613-1.630	.167	.478	.264
20	1.250	1.6250-12 UNJ	1.853	1.863-1.880	.235	.676	.373
24	1.500	1.8750-12 UNJ	2.099	2.109-2.225	.279	.801	.442
32	2.000	2.5000-12 UNJ	2.724	2.734-2.760	.509	1.46	.807

NOTES:

/1/ MATERIAL:

- a. DASH AS CODE LETTER - TYPE 4130 CARBON STEEL BAR PER MIL-S-6758 OR AMS 6370. /2/
- b. CODE LETTER D - TYPE 2024-T6 ALUMINUM ALLOY BAR PER QQ-A-225/6 OR AMS 4112 OR TYPE 2024-T851 ALUMINUM ALLOY BAR PER QQ-A-225/6. /2/
- c. CODE LETTER J - TYPE 304 CORROSION RESISTANT STEEL BAR PER QQ-S-763 OR AMS 5639.
- d. CODE LETTER K - TYPE 316 CORROSION RESISTANT STEEL BAR PER QQ-S-763 OR AMS 5648.
- e. CODE LETTER R - TYPE 321 CORROSION RESISTANT STEEL BAR PER QQ-S-763 OR AMS 5645.
- f. CODE LETTER T - TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS 4928.
- g. CODE LETTER W - TYPE 7075-T73 ALUMINUM ALLOY BAR PER QQ-A-225/9 OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS 4124. /2/

/2/ HEAT TREATMENT:

- a. DASH AS CODE LETTER - SEE HARDNESS REQUIREMENT PER PROCUREMENT SPECIFICATION.
- b. CODE LETTERS D AND W - SEE ELECTRICAL CONDUCTIVITY AND HARDNESS REQUIREMENT PER PROCUREMENT SPECIFICATION.
- c. OTHER CODE LETTERS - NONE.

3. FINISH:

- a. DASH AS CODE LETTER - CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2 AND COAT WITH A LIGHT FILM OF OIL PER PROCUREMENT SPECIFICATION.
- b. CODE LETTER D - ANODIZE PER MIL-A-8625, TYPE II, CLASS 2, DYE GREEN, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.
- c. CODE LETTER J, K AND R - PASSIVATE PER QQ-P-35, TYPE VI OR VII.
- d. CODE LETTER T - ANODIZE PER AMS 2488 OR FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486 WITH COLOR PER PROCUREMENT SPECIFICATION.
- e. CODE LETTER W - ANODIZE PER MIL-A-8625, TYPE II, CLASS 2, DYE BROWN, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.

/4/ PROCUREMENT SPECIFICATION: AS4444 EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION IN A COMPLETE ASSEMBLY AS APPLICABLE. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.

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

- a. FOR SIZE 06 AND SMALLER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, LETTER "AS" AND MATERIAL CODE LETTER.
- b. FOR SIZE 08 AND LARGER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, BASIC PART NUMBER AND MATERIAL CODE LETTER.