

REV.
B

AS5231

RATIONALE

MATERIAL OPTION FOR 15-5PH CORROSION RESISTANT STEEL HAS BEEN ADDED. UPDATED.

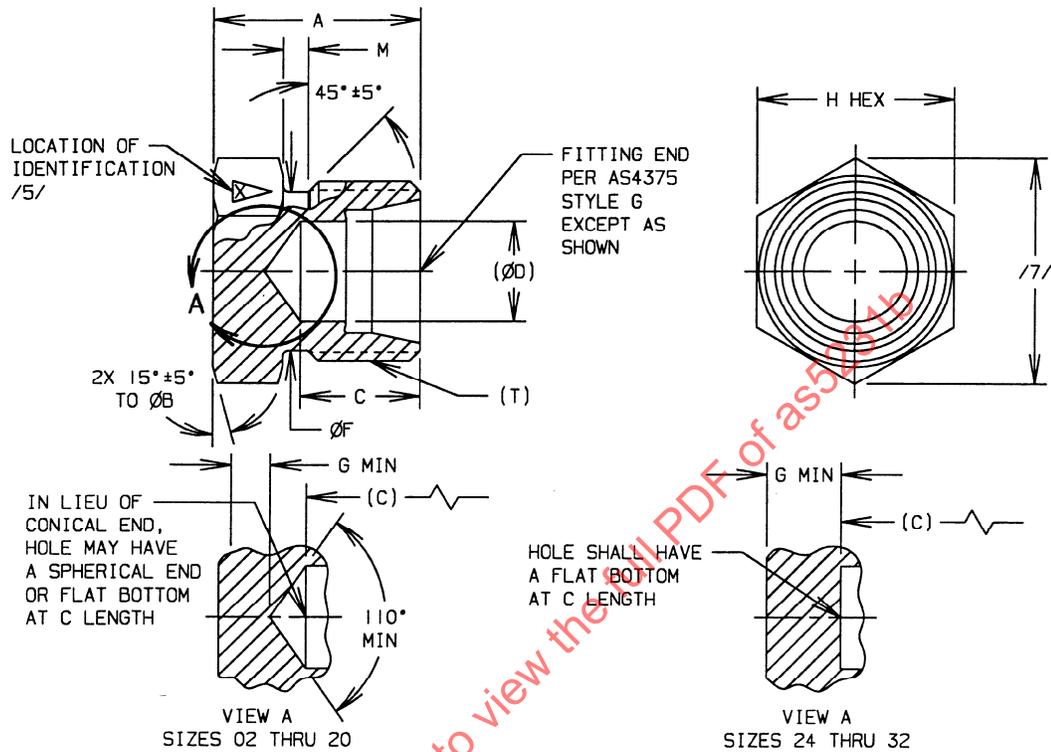
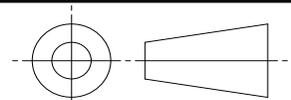


FIGURE 1 - FITTING, PLUG

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THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS18280 /4/



AEROSPACE STANDARD

FITTING, PLUG, TUBE END, FLARELESS

AS5231
SHEET 1 OF 4

REV. B

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TABLE 1 - DIMENSIONS

BASIC NO. AS5231 /14/ SIZE CODE	(NOMINAL TUBE SIZE)	T THREAD PER AS8879 CLASS 3A	A	B ±.010	C	D
02	.125	.3125-24 UNJF	.562	.418	.371	.093
03	.188	.3750-24 UNJF	.609	.418	.407	.125
04	.250	.4375-20 UNJF	.641	.480	.417	.187
05	.312	.5000-20 UNJF	.672	.542	.416	.234
06	.375	.5625-18 UNJF	.719	.605	.441	.297
08	.500	.7500-16 UNJF	.844	.792	.491	.422
10	.625	.8750-14 UNJF	.984	.918	.604	.500
12	.750	1.0625-12 UNJ	1.031	1.103	.564	.656
14	.875	1.1875-12 UNJ	1.062	1.228	.557	.765
16	1.000	1.3125-12 UNJ	1.062	1.353	.519	.875
20	1.250	1.6250-12 UNJ	1.094	1.666	.428	1.093
24	1.500	1.8750-12 UNJ	1.094	1.978	.812	1.344
32	2.000	2.5000-12 UNJ	1.094	2.599	.812	1.813

TABLE 1A - DIMENSIONS AND WEIGHTS

BASIC NO. AS5231 /14/ SIZE CODE	F +.002/- .003	G	H	M +.015/- .000	LB/EA APPROX REF AL	LB/EA APPROX REF STEEL	LB/EA APPROX REF TI
02	.250	.109	.428-.440	.063	.00571	.0164	.00904
03	.312	.109	.428-.440	.063	.00717	.0206	.0114
04	.364	.109	.490-.502	.075	.00938	.0269	.0148
05	.426	.125	.552-.565	.075	.0128	.0369	.0203
06	.481	.125	.615-.628	.083	.0167	.0480	.0265
08	.660	.156	.802-.815	.094	.0332	.0952	.0525
10	.773	.156	.928-.941	.107	.0532	.153	.0843
12	.945	.188	1.113-1.128	.125	.0801	.230	.127
14	1.070	.188	1.238-1.253	.125	.103	.295	.163
16	1.195	.188	1.363-1.380	.125	.128	.366	.202
20	1.507	.234	1.676-1.693	.125	.212	.610	.336
24	1.756	.234	1.988-2.005	.125	.224	.644	.355
32	2.381	.328	2.609-2.635	.125	.391	1.12	.620

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	FITTING, PLUG, TUBE END, FLARELESS		

NOTES:

NOTICE

THIS DOCUMENT REFERENCES A PART WHICH CONTAINS CADMIUM AS A PLATING MATERIAL. CONSULT LOCAL OFFICIALS IF YOU HAVE QUESTIONS CONCERNING CADMIUM'S USE.

/1/ MATERIAL:

- a. DASH AS CODE LETTER - TYPE 4130 ALLOY STEEL BAR PER AMS6370. /2/
- b. CODE LETTER D - TYPE 2024-T6 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6 OR AMS4339 OR TYPE 2024-T851 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6. /2/
- c. CODE LETTER J - TYPE 304 CORROSION RESISTANT STEEL BAR PER AMS5639.
- d. CODE LETTER K - TYPE 316 CORROSION RESISTANT STEEL BAR PER AMS5648.
- e. CODE LETTER R - TYPE 321 CORROSION RESISTANT STEEL BAR PER AMS5645.
- f. CODE LETTER T - TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS4928.
- g. CODE LETTER V - TYPE 15-5PH CORROSION RESISTANT STEEL BAR PER AMS5659. /2/
- h. CODE LETTER W - TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9 OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS4124. /2/

/2/ HEAT TREATMENT:

- a. DASH AS MATERIAL CODE LETTER - SEE HARDNESS REQUIREMENT PER PROCUREMENT SPECIFICATION.
- b. MATERIAL CODE LETTERS D AND W - SEE ELECTRICAL CONDUCTIVITY AND HARDNESS REQUIREMENT PER PROCUREMENT SPECIFICATION.
- c. MATERIAL CODE LETTER V - HEAT TREAT TO CONDITION H-1075 PER AMS2759/3
- d. OTHER MATERIAL CODE LETTERS - NONE.

3. FINISH:

- a. DASH AS MATERIAL CODE LETTER - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 AND COAT WITH A LIGHT FILM OF OIL PER PROCUREMENT SPECIFICATION.
- b. MATERIAL CODE LETTER D - ANODIZE PER MIL-A-8625, TYPE II, CLASS 2, DYE GREEN, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.
- c. MATERIAL CODE LETTER J, K, AND R - PASSIVATE PER AMS2700 PER PROCUREMENT SPECIFICATION.
- d. MATERIAL CODE LETTER T - ANODIZE PER AMS2488 OR FLUORIDE PHOSPHATE CONVERSION COAT PER AMS2486 WITH COLOR PER PROCUREMENT SPECIFICATION.
- e. MATERIAL CODE LETTER V:
 - (1) PASSIVATE PER AMS2700, TYPE 2 OR 8.
 - (2) SUFFIX FINISH CODE LETTER "P": CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
- f. MATERIAL CODE LETTER W - ANODIZE PER MIL-A-8625, TYPE II, CLASS 2, DYE BROWN, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.

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