

AS5233

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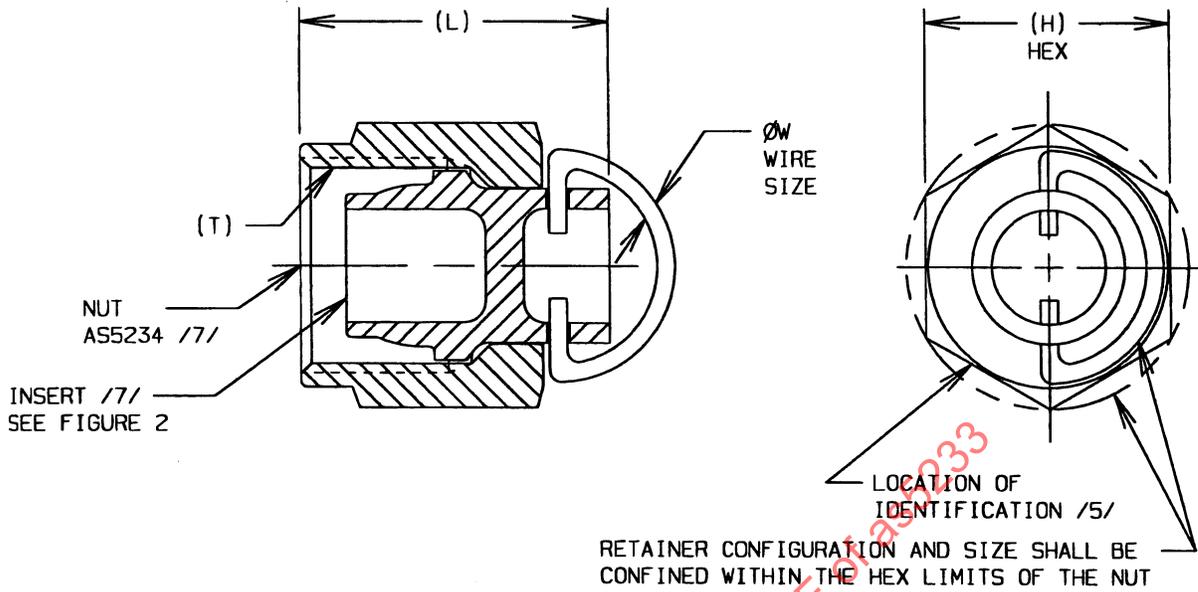
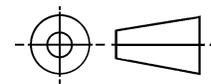


FIGURE 1 - FITTING ASSEMBLY, CAP

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THIRD ANGLE PROJECTION



ISSUED 2000-08 REAFFIRMED 2004-07

CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS18280

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

FITTING ASSEMBLY,
CAP, FLARELESS

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SHEET 1 OF 5

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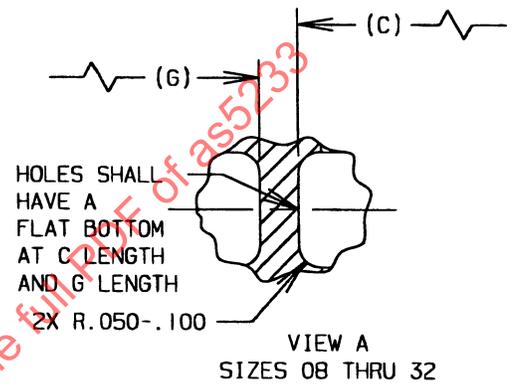
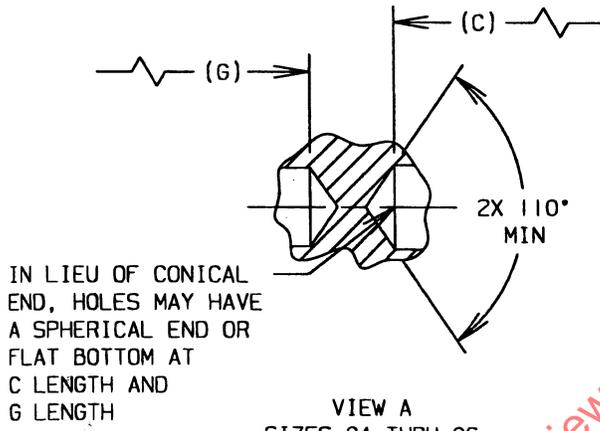
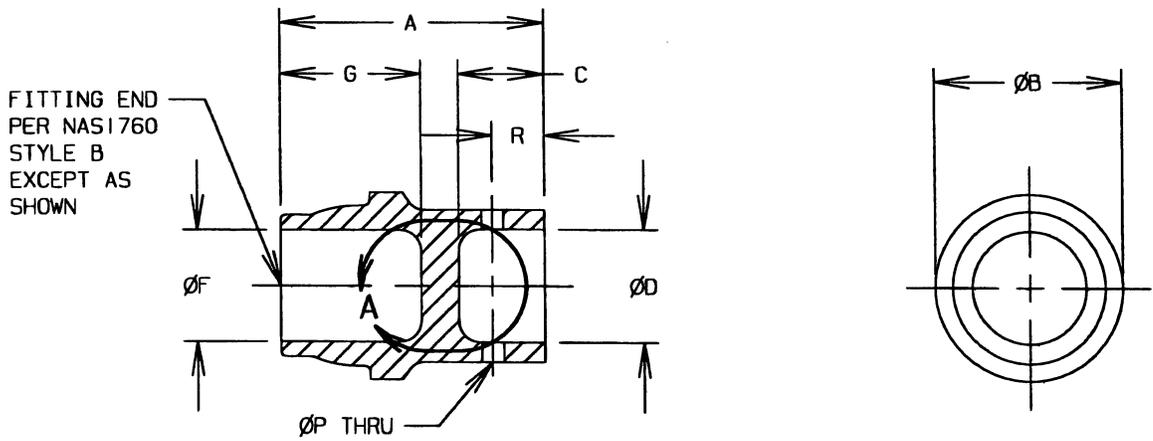


FIGURE 2 - CAP INSERT

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AS5233

TABLE 1A - DIMENSIONS

BASIC NO. AS5233 /13/ SIZE CODE	(NOMINAL TUBE SIZE)	T THREAD PER AS8879 CLASS 3B							
		A ±.010	B	C ±.010	D ±.010	F ±.010	G ±.010	H	
02	.125	.3125-24 UNJF	.600	.256	--	--	--	--	.375
03	.188	.3750-24 UNJF	.672	.318	--	--	--	--	.438
04	.250	.4375-20 UNJF	.745	.371	.232	.187	.166	.322	.562
05	.312	.5000-20 UNJF	.845	.434	.265	.234	.213	.365	.625
06	.375	.5625-18 UNJF	.885	.490	.243	.297	.276	.343	.688
08	.500	.7500-16 UNJF	.935	.670	.300	.406	.401	.500	.875
10	.625	.8750-14 UNJF	1.062	.786	.374	.500	.432	.530	1.000
12	.750	1.0625-12 UNJ	1.082	.960	.400	.656	.620	.510	1.250
14	.875	1.1875-12 UNJ	.990	1.080	.420	.765	.760	.375	1.375
16	1.000	1.3125-12 UNJ	1.218	1.210	.460	.906	.807	.560	1.500
20	1.250	1.6250-12 UNJ	1.193	1.470	.478	1.093	.995	.540	2.000
24	1.500	1.8750-12 UNJ	1.271	1.719	.570	1.343	1.245	.500	2.250
32	2.000	2.5000-12 UNJ	1.481	2.283	.570	1.813	1.720	.500	2.875

TABLE 1B - DIMENSIONS AND WEIGHTS

BASIC NO. AS5233 /13/ SIZE CODE	L	P	R	W STOCK SIZE	LB/EA	LB/EA	LB/EA
					APPROX. REF AL	APPROX. REF STEEL	APPROX. REF TI
02	.720	.047	.065	.032	.00488	.0138	.00764
03	.767	.047	.065	.032	.00771	.0219	.0122
04	.893	.047	.087	.032	.0149	.0424	.0237
05	.977	.078	.101	.062	.0206	.0575	.0321
06	.965	.078	.101	.062	.0259	.0727	.0406
08	1.077	.078	.101	.062	.0396	.112	.0619
10	1.210	.078	.101	.062	.0604	.171	.0945
12	1.208	.078	.101	.062	.0909	.257	.143
14	1.180	.093	.101	.072	.0869	.244	.136
16	1.189	.093	.101	.072	.138	.390	.216
20	1.288	.093	.101	.072	.251	.716	.396
24	1.305	.093	.101	.072	.303	.864	.479
32	1.422	.093	.101	.072	.566	1.62	.895

NOTES:

/1/ MATERIAL:

a. DASH AS CODE LETTER -

1. INSERT: TYPE 4130 CARBON STEEL BAR PER AMS-S-6758 OR AMS 6370.
2. NUT: DASH AS CODE LETTER OF AS5234 REFERENCE (TYPE 4130 CARBON STEEL).
3. WIRE: TYPE 302 CORROSION RESISTANT STEEL PER ASTM-A-493 OR TYPE 305 PER AMS 5685.

b. CODE LETTER T -

1. INSERT: TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS 4928.
2. NUT: CODE LETTER T OF AS5234 REFERENCE (TYPE 6AL-4V TITANIUM ALLOY).
3. WIRE: TYPE 302 CORROSION RESISTANT STEEL PER ASTM-A-493 OR TYPE 305 PER AMS 5685.

c. CODE LETTER V -

1. INSERT: TYPE 15-5PH CORROSION RESISTANT STEEL BAR PER AMS 5659.
2. NUT: CODE LETTER V OF AS5234 REFERENCE (TYPE 15-5PH CORROSION RESISTANT STEEL).
3. WIRE: TYPE 302 CORROSION RESISTANT STEEL PER ASTM-A-493 OR TYPE 305 PER AMS 5685.

d. CODE LETTER W -

1. INSERT: TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS 4124, OR TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9.
2. NUT: CODE LETTER W OF AS5234 REFERENCE (TYPE 7075 ALUMINUM ALLOY).
3. WIRE: TYPE 302 CORROSION RESISTANT STEEL PER ASTM-A-493 OR TYPE 305 PER AMS 5685.

2. HEAT TREATMENT:

a. DASH AS CODE LETTER -

1. INSERT, NUT AND WIRE: NONE.

b. MATERIAL CODE LETTER T -

1. INSERT, NUT AND WIRE: NONE.

c. MATERIAL CODE LETTER V -

1. INSERT: HEAT TREAT TO CONDITION H 1075 PER AMS 2759/3.
2. NUT: MATERIAL CODE LETTER V OF AS5234 REFERENCE (HEAT TREAT TO CONDITION H 1075).
3. WIRE: NONE.

d. MATERIAL CODE LETTER W -

1. INSERT, NUT AND WIRE: NONE.

3. FINISH:

a. MATERIAL CODE LETTER T -

1. INSERT: ANODIZE PER AMS 2488 OR FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486 WITH COLOR PER PROCUREMENT SPECIFICATION.
2. NUT: CODE LETTER T OF AS5234 REFERENCE (FLUORIDE PHOSPHATE COAT AND COAT WITH SOLID FILM LUBRICANT).
3. WIRE: PASSIVATE PER AMS-QQ-P-35, TYPE VI OR 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 AMS-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.