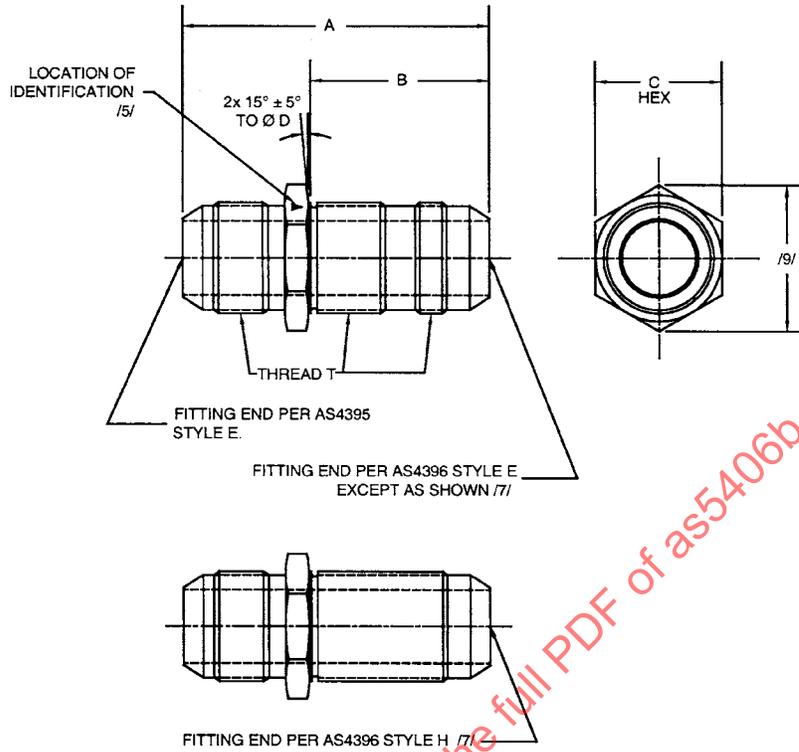


REV.  
B

AS5406



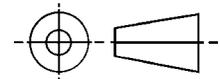
INACTIVE IN PART - SEE NOTE /18/

FIGURE 1- UNION

TABLE 1 - DIMENSIONS

BASIC NO. AS5406 /17/ SIZE CODE	NOMINAL TUBE SIZE	T THREAD PER MIL-S-8879	A	B	C	D ±.010
02	.125	.3125-24 UNJF-3A	1.828	1.109	.552 - .565	.542
03	.188	.3750-24 UNJF-3A	1.859	1.109	.615 - .628	.605
04	.250	.4375-20 UNJF-3A	2.047	1.203	.678 - .691	.668
05	.312	.5000-20 UNJF-3A	2.047	1.203	.740 - .753	.730
06	.375	.5625-18 UNJF-3A	2.219	1.281	.802 - .815	.792
08	.500	.7500-16 UNJF-3A	2.453	1.437	.990 - 1.003	.980
10	.625	.8750-14 UNJF-3A	2.719	1.578	1.113 - 1.128	1.103
12	.750	1.0625-12 UNJ-3A	3.031	1.750	1.363 - 1.380	1.353
16	1.000	1.3125-12 UNJ-3A	3.078	1.750	1.613 - 1.630	1.603
20	1.250	1.6250-12 UNJ-3A	3.156	1.797	1.863 - 1.880	1.853
24	1.500	1.8750-12 UNJ-3A	3.312	1.812	2.109 - 2.135	2.099
28	1.750	2.2500-12 UNJ-3A	3.578	1.969	2.484 - 2.510	2.474
32	2.000	2.5000-12 UNJ-3A	3.828	2.094	2.734 - 2.760	2.724

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS4841

**SAE Aerospace**  
An SAE International Group

**AEROSPACE STANDARD**

FITTING, UNION, TUBE, .375 BULKHEAD

**AS5406**  
SHEET 1 OF 3

**REV.  
B**

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ISSUED 1999-07 REVISED 2003-08

## NOTES:

## /1/ MATERIAL:

- a. DASH AS CODE LETTER – TYPE 4130 PER AMS 6370 OR TYPE 4140 PER AMS 6382. /2/
- b. CODE LETTER D –TYPE 2024-T6 OR –T851 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6 OR 2024 ALUMINUM ALLOY BAR PER AMS 4112. /18/
- c. CODE LETTER J – TYPE 304 CORROSION RESISTANT STEEL BAR PER AMS 5639 OR AMS-QQ-S-763.
- d. CODE LETTER K – TYPE 316 CORROSION RESISTANT STEEL BAR PER AMS 5648 OR AMS-QQ-S-763.
- e. CODE LETTER R – TYPE 321 CORROSION RESISTANT STEEL BAR PER AMS 5645 OR AMS-QQ-S-763.
- f. CODE LETTER T – TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS 4928.
- g. CODE LETTER W – TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9 OR TYPE 7075-T351 ALUMINUM ALLOY BAR PER AMS 4124.

## /2/ HEAT TREATMENT:

- a. DASH AS CODE LETTER – SEE HARDNESS REQUIREMENT PER PROCUREMENT SPECIFICATION.
- b. OTHER CODE LETTERS – NONE.

## 3. FINISH:

- a. DASH AS CODE LETTER - CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2, DYE BLACK 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 BLUE, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.
- c. MATERIAL CODE LETTERS J, K, AND R - PASSIVATE PER AMS-QQ-P-35, TYPE VI OR VII.
- d. MATERIAL CODE LETTER T – ANODIZE PER AMS 2488 OR FLOURIDE PHOSPHATE CONVERSION COAT PER AMS 2486 WITH COLOR PER PROCUREMENT SPECIFICATION.
- e. MATERIAL CODE LETTER W - ANODIZE PER MIL-A-8625, TYPE II, CLASS 2, DYE BROWN, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.

/4/ PROCUREMENT SPECIFICATION: AS4841 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 PRODUCT.

/5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS 478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B.

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

6. INVENTORIED PARTS CONFORMING TO THE PREVIOUS ISSUE (CONTAINING MATERIAL CODE LETTER D) MAY BE USED TO DEPLETION.

/7/ FITTINGS WITH AS4396 STYLE E ENDS MAY BE ASSEMBLED INTO INTERNALLY THREADED PORTS BUT ARE HISTORICALLY UNRELIABLE AND ARE ONLY SUITABLE IN THAT APPLICATION FOR 1500 PSI MAX PRESSURE. FITTINGS WITH AS4396 STYLE H ENDS MAY BE DESIGNATED WITH THE SUFFIX H AFTER THE PART NUMBER AND CANNOT BE USED IN PORTS.

8. INTENDED USE: THIS PART IS DESIGNED FOR USE IN TUBING CONNECTION SYSTEMS WITH MAXIMUM OPERATING PRESSURE AS FOLLOWS: (CAUTION: AS 4396 STYLE APPLICATION IN INTERNALLY THREADED PORTS IS SUITABLE FOR 1500 psi MAXIMUM PRESSURE ONLY.)

- a. SIZES 02 THROUGH 16 IN LOW ALLOY STEEL, CORROSION RESISTANT STEEL AND TITANIUM ALLOY AT 3000 psi.
- b. SIZES 02 THROUGH 12 IN ALUMINUM ALLOY AT 3000 psi.
- c. SIZE 16 IN ALUMINUM ALLOY AND SIZES 20 THROUGH 32 IN ALL MATERIALS AT 1500 psi.

/9/ THE HEX CORNERS MAY BE ROUNDED PER ARP 1942.