

RATIONALE

AS5805 HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

AS5805

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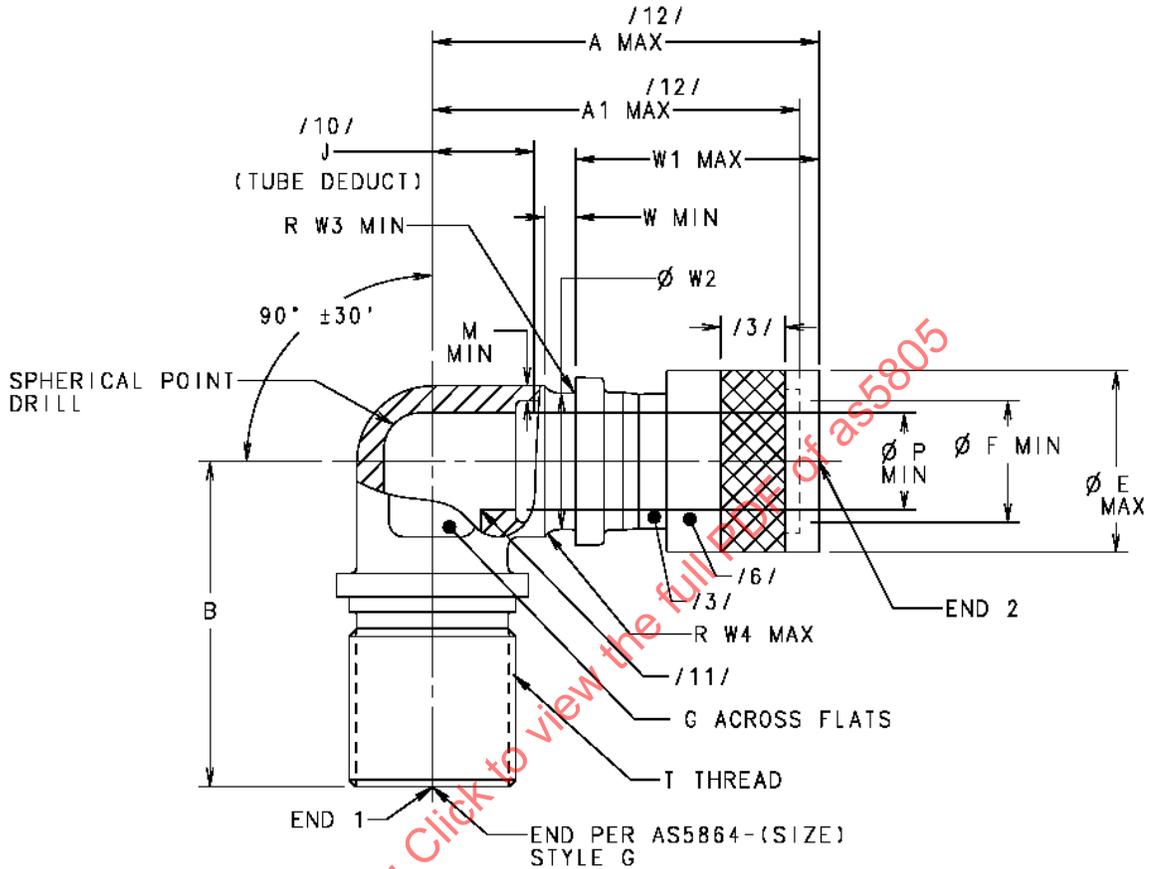
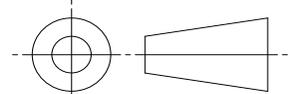


FIGURE 1-ELBOW, 90 DEGREE, FLARELESS BULKHEAD, SWAGE

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THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS5958 /4/



AEROSPACE STANDARD

FITTING ASSEMBLY, 90°, FLARELESS BULKHEAD, AXIALLY SWAGED, HYDRAULIC, 3000 PSI

AS5805
SHEET 1 OF 4

TABLE 1A - DIMENSIONS A THROUGH J

BASIC NO. AS5805 /13/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	A MAX.	A1 MAX.	B ±.015	E MAX.	F MIN.	G		J /10/ TUBE DEDUCT	
0404	.2500	.2500	.935	.848	1.523	.466	.253	.348-	.380	.353	±.150
0604	.3750	.2500	.998	.911	1.711	.466	.253	.477-	.509	.416	±.150
0406	.2500	.3750	1.215	1.099	1.665	.609	.378	.477-	.509	.416	±.150
0606	.3750	.3750	1.215	1.099	1.711	.609	.378	.477-	.509	.416	±.150
0806	.5000	.3750	1.308	1.192	1.992	.609	.378	.615-	.647	.509	±.150
0608	.3750	.5000	1.516	1.370	1.820	.783	.504	.615-	.647	.517	±.175
0808	.5000	.5000	1.516	1.370	1.992	.783	.504	.615-	.647	.517	±.175
1008	.6250	.5000	1.579	1.433	2.273	.783	.504	.751-	.783	.580	±.175
0810	.5000	.6250	1.873	1.669	2.132	.939	.629	.751-	.783	.580	±.175
1010	.6250	.6250	1.873	1.669	2.273	.939	.629	.751-	.783	.580	±.175
1210	.7500	.6250	1.998	1.794	2.492	.939	.629	.893-	.925	.705	±.175
1012	.6250	.7500	2.149	1.944	2.383	1.122	.754	.893-	.925	.712	±.175
1212	.7500	.7500	2.149	1.944	2.492	1.122	.754	.893-	.925	.712	±.175
1612	1.0000	.7500	2.308	2.103	2.617	1.122	.754	1.181-	1.213	.871	±.175
1216	.7500	1.0000	2.606	2.392	2.617	1.495	1.004	1.181-	1.213	.878	±.200
1616	1.0000	1.0000	2.606	2.392	2.617	1.495	1.004	1.181-	1.213	.878	±.200
2016	1.2500	1.0000	2.728	2.514	2.898	1.495	1.004	1.609-	1.641	1.000	±.200
1620	1.0000	1.2500	3.020	2.796	2.898	1.758	1.255	1.609-	1.641	1.009	±.200
2020	1.2500	1.2500	3.020	2.796	2.898	1.758	1.255	1.609-	1.641	1.009	±.200

TABLE 1B - DIMENSIONS M THROUGH W4 AND WEIGHTS

BASIC NO. AS5805 /13/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	M MIN.	P MIN.	T THREAD PER AS8879	W MIN.	W1 MAX.	W2 ±.0015	W3 MAX.	W4 MAX.	WEIGHT LB/EA APPROX. REF.
0404	.2500	.2500	.043	.198	.4375-20UNJF-3A	.123	.488	.3005	.018	.065	.023
0604	.3750	.2500	.045	.198	.5625-18UNJF-3A	.123	.488	.3005	.018	.065	.034
0406	.2500	.3750	.045	.302	.4375-20UNJF-3A	.153	.675	.4475	.033	.065	.035
0606	.3750	.3750	.045	.302	.5625-18UNJF-3A	.153	.675	.4475	.033	.065	.044
0806	.5000	.3750	.052	.302	.7500-16UNJF-3A	.153	.675	.4475	.033	.065	.064
0608	.3750	.5000	.052	.401	.5625-18UNJF-3A	.165	.871	.5945	.033	.129	.061
0808	.5000	.5000	.052	.401	.7500-16UNJF-3A	.165	.871	.5945	.033	.129	.084
1008	.6250	.5000	.057	.401	.8750-14UNJF-3A	.165	.871	.5945	.033	.129	.120
0810	.5000	.6250	.057	.507	.7500-16UNJF-3A	.140	1.190	.7365	.021	.078	.106
1010	.6250	.6250	.057	.507	.8750-14UNJF-3A	.140	1.190	.7365	.021	.078	.144
1210	.7500	.6250	.065	.507	1.0625-12UNJ-3A	.140	1.190	.7365	.021	.078	.220
1012	.6250	.7500	.065	.604	.8750-14UNJF-3A	.154	1.327	.8805	.024	.089	.212
1212	.7500	.7500	.065	.604	1.0625-12UNJ-3A	.154	1.327	.8805	.024	.089	.224
1612	1.0000	.7500	.084	.604	1.3125-12UNJ-3A	.154	1.327	.8805	.024	.089	.334
1216	.7500	1.0000	.084	.802	1.0625-12UNJ-3A	.167	1.612	1.1725	.027	.099	.343
1616	1.0000	1.0000	.084	.802	1.3125-12UNJ-3A	.167	1.612	1.1725	.027	.099	.461
2016	1.2500	1.0000	.174	.802	1.6250-12UNJ-3A	.167	1.612	1.1725	.027	.099	.637
1620	1.0000	1.2500	.174	1.011	1.3125-12UNJ-3A	.185	1.886	1.4345	.030	.113	.652
2020	1.2500	1.2500	.174	1.011	1.6250-12UNJ-3A	.185	1.886	1.4345	.030	.113	.688

NOTES:

/1/ MATERIALS:

CODE LETTER "T"

RING - AMS4965 TITANIUM ALLOY, 6.0AL 4.0V SOLUTION HEAT TREATED AND AGED OR AMS4928 TITANIUM ALLOY 6.0AL 4.0V ANNEALED WITH HIGH STRENGTH CARBON FIBER/EPOXY RESIN COMPOSITE REINFORCEMENT.

BODY - AMS4928 TITANIUM ALLOY, 6.0AL 4.0V ANNEALED

2. FINISH:

TITANIUM - NONE REQUIRED

/3/ COATINGS/LUBRICANTS:

RING - THE OUTER SURFACE SHALL HAVE A .125 in MINIMUM WIDTH BLUE COLORED RING OR COMPLETELY COLORED BLUE TO MATCH THE ASSEMBLY TOOLING COLOR SPECIFIED IN THE AS5959 ASSEMBLY PROCEDURE. AN AS1241 FLUID RESISTANT PTFE COATING OR PAINT SHALL BE USED. THE SWAGE RING IS COLOR CODED BLUE TO INDICATE THE AXIALLY SWAGE END IS QUALIFIED TO 5080 PSI AND IS INSTALLED WITH THE SAME TOOLING AS THE 5080 PSI RATED FITTING.

BODY - SOLID FILM LUBRICANT PER AS5272, TYPE I OR II, PTFE OR PTFE BASED LUBRICANT MAY BE APPLIED TO PORTIONS OF THE ID AND OD. THE AS5272 OR PTFE BASED LUBRICANT SHALL NOT BE IN CONTACT WITH THE SYSTEM FLUID.

/4/ PRODUCT SPECIFICATION: AS5958 EXCEPT AS SPECIFIED ON THIS STANDARD. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED AND ASSEMBLED BY AN ACCREDITED MANUFACTURER OR ASSEMBLED BY AN ACCREDITED ASSEMBLING DISTRIBUTOR LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST (QPL) PRI-QPL-AS5958 FOR THIS STANDARD. See www.eauditnet.com FOR THE CURRENT QPL ON-LINE.

5. DIMENSIONS AND TOLERANCES NOT DEFINED ON THIS STANDARD SHALL BE SPECIFIED AND CONTROLLED BY THE MANUFACTURER. THE MANUFACTURER IS RESPONSIBLE TO ENSURE COMPLIANCE WITH THE PROCUREMENT SPECIFICATION.

/6/ IDENTIFICATION SHALL BE IN ACCORDANCE WITH AS5958 AND SHALL BE IDENTIFIED ON RING IN THE AREA SHOWN.

7. FITTINGS SHALL BE INSTALLED IN ACCORDANCE WITH AS5959.

8. SURFACE TEXTURE SHALL BE IN ACCORDANCE WITH AMERICAN SOCIETY OF MECHANICAL ENGINEERS, ASME B46.1 AND THE SYMBOLS IN ACCORDANCE WITH ASME Y14.36M. UNLESS OTHERWISE SPECIFIED, THE MAXIMUM MACHINED SURFACES SHALL BE 125 µin Ra AND THE FORGED SURFACES SHALL BE 250 µin Ra.

9. DIMENSIONS AND TOLERANCES PER AMERICAN SOCIETY OF MECHANICAL ENGINEERS, ASME Y14.5M -1994.

- a. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
- b. DIMENSIONAL TOLERANCES SHALL BE ±.005 in UNLESS OTHERWISE SPECIFIED
- c. ANGULAR TOLERANCES SHALL BE ±0.50 degrees UNLESS OTHERWISE SPECIFIED
- d. BREAK ALL EDGES .003 TO .010 in UNLESS OTHERWISE SPECIFIED

/10/ THIS DIMENSION IS THE ALLOWABLE TUBE END POSITIONING FOR SYSTEM LAYOUT DESIGN.

/11/ .030 MIN RADIUS UNLESS QUALIFICATION OF SPECIAL PROCESS WITH SMALLER RADIUS.

	AEROSPACE STANDARD		AS5805 SHEET 3 OF 4
	FITTING ASSEMBLY, 90°, FLARELESS BULKHEAD, AXIALLY SWAGED, HYDRAULIC, 3000 PSI		