

RATIONALE

FEDERAL SUPPLY CLASS
4730

NEW STANDARD FOR OPERATING PRESSURES UP TO AND INCLUDING 1500 PSI.

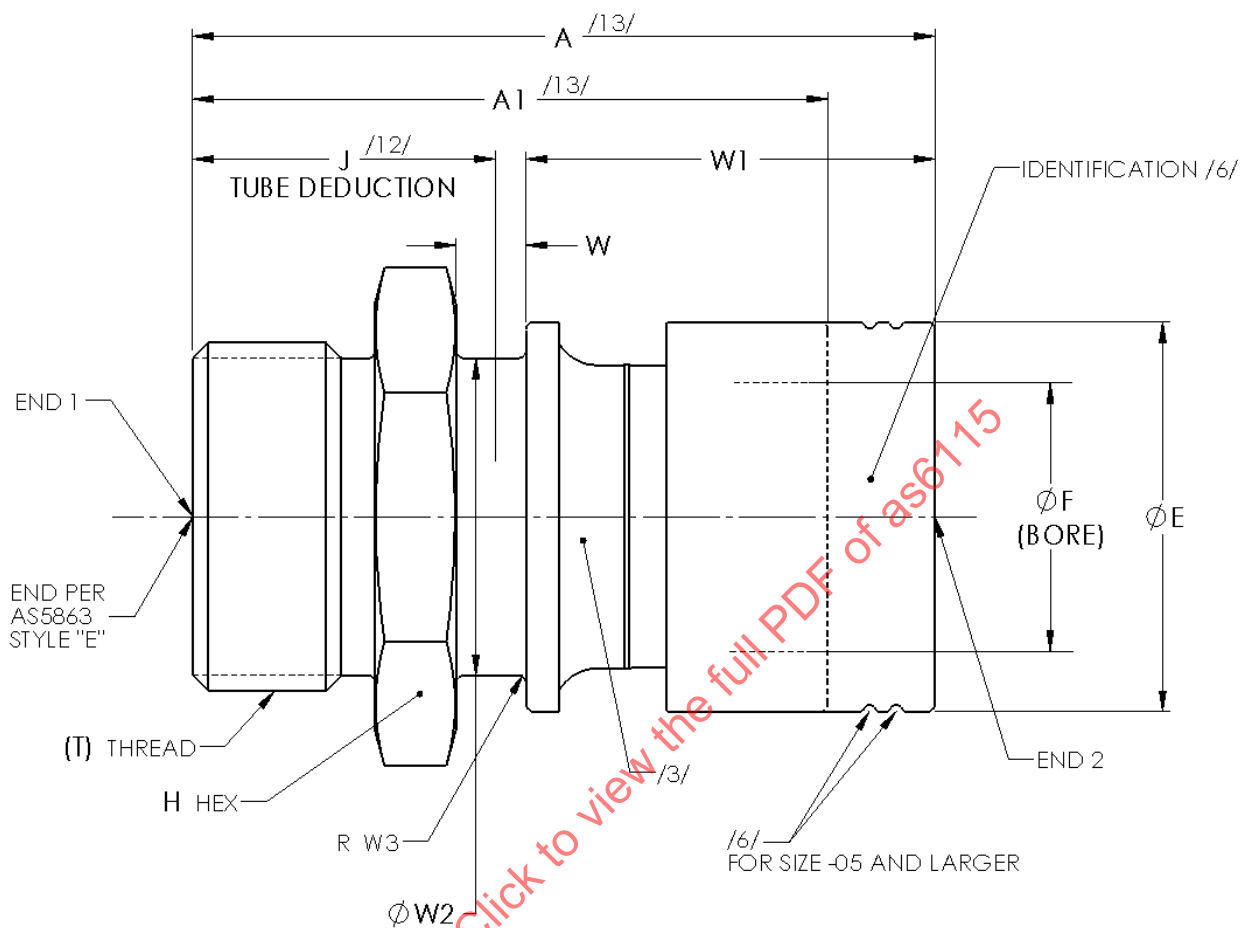
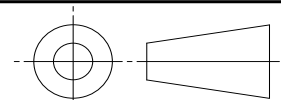


FIGURE - 1 FITTING ASSEMBLY, ADAPTER, SWAGE

SAE values your input. To provide feedback
on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS6115>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS6116

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

FITTING ASSEMBLY, STRAIGHT, MALE
FLARELESS, AXIALLY SWAGED,
HYDRAULIC, UP TO 1500 PSI

SAE AS6115
SHEET 1 OF 3

TABLE 1A - DIMENSIONS A THROUGH J

BASIC NO. AS6115 /15/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	A MAX	A1 MAX	ØE MAX	ØF MIN	(H)	J /12/ TUBE DEDUCTION
0404	.250	.250	1.498	1.345	.435	.253	.688	.805 ±.150
0505	.3125	.3125	1.633	1.485	.503	.3155	.750	.810 ±.150
0604	.375	.250	1.470	1.317	.435	.253	.813	.777 ±.150
0606	.375	.375	1.772	1.545	.580	.378	.813	.800 ±.150
0808	.500	.500	2.095	1.835	.755	.503	1.000	.920 ±.150
1010	.625	.625	2.165	1.925	.929	.629	1.125	.985 ±.150
1212	.750	.750	2.370	2.090	1.150	.754	1.375	1.050 ±.150
1616	1.000	1.000	2.835	2.455	1.474	1.004	1.625	1.145 ±.150
2020	1.250	1.250	3.152	2.732	1.768	1.255	1.875	1.187 ±.150

TABLE 1B - DIMENSIONS T THROUGH W3 AND WEIGHTS

BASIC NO. AS6115 /15/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	(T) THREAD PER AS8879	W MIN	W1 MAX	ØW2 ±.002	W3 MAX	WEIGHT APPROX LB/EA
0404	.250	.250	.4375-20 UNJF-3A	.185	.604	.320	.020	.017
0505	.3125	.3125	.5000-20 UNJF-3A	.180	.724	.371	.020	.023
0604	.375	.250	.5625-18 UNJF-3A	.185	.604	.320	.020	.020
0606	.375	.375	.5625-18 UNJF-3A	.195	.883	.463	.020	.040
0808	.500	.500	.7500-16 UNJF-3A	.210	1.076	.595	.020	.051
1010	.625	.625	.8750-14 UNJF-3A	.225	1.076	.758	.020	.064
1212	.750	.750	1.0625-12 UNJ-3A	.235	1.201	.903	.025	.109
1616	1.000	1.000	1.3125-12 UNJ-3A	.260	1.566	1.196	.035	.190
2020	1.250	1.250	1.6250-12 UNJ-3A	.285	1.829	1.460	.035	.289

NOTES:

/1/ MATERIALS:

CODE LETTER "D"

BODY - TYPE 6061-T6 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/8.

RING - TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9.

2. FINISH:

BODY- CHEMICAL CONVERSION COATED PER MIL-DTL-5541 TYPE I CLASS 3.

RING - ANODIZE PER MIL-A-8625, TYPE II, CLASS 2, DYED GREEN, SIMILAR TO NO. 14187, 14193, OR 14223 OF FED-STD-595 AND SHALL BE DUPLEX SEALED.

/3/ COATINGS/LUBRICANTS:

BODY

- A. DRY FILM LUBRICANT PER AS5272 TYPE I SHALL BE APPLIED TO THE OD OF THE AXIALLY SWAGED FITTING END. ADDITIONAL LUBRICANT APPLIED SHALL BE SPECIFIED BY MANUFACTURER. THE LUBRICANTS SHALL NOT BE IN CONTACT WITH THE SYSTEM FLUID.
- B. POLYTETRAFLUOROETHYLENE (PTFE) COAT, LIGHT GREEN, SHALL BE APPLIED TO PORTIONS OF ID (BORE) UP TO THE FIRST GROOVE. OVERSPRAY IN GROOVE IS NOT PERMITTED.
- C. A MINIMUM OF TWO GROOVES (END SIZE -.05 AND LARGER) SHALL BE FILLED WITH ELASTOMERIC DIMETHYL SILOXANE COMPOUND. FOR SMALLER SIZE ENDS, A MINIMUM OF ONE GROOVE SHALL BE FILLED WITH THE COMPOUND.

- /4/ PROCUREMENT SPECIFICATION: AS6116 EXCEPT AS SPECIFIED ON THIS STANDARD. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST (QPL) PRI-QPL-AS6116 FOR THIS STANDARD. SEE WWW.EAUDITNET.COM FOR THE CURRENT QPL ON-LINE.

 <i>An SAE International Group</i>	AEROSPACE STANDARD	SAE AS6115 SHEET 2 OF 3
	FITTING ASSEMBLY, STRAIGHT, MALE FLARELESS, AXIALLY SWAGED, HYDRAULIC, UP TO 1500 PSI	