FEDERAL SUPPLY CLASS
4730

RATIONALE

ADDED STANDARD CONFIGURATION 242424.

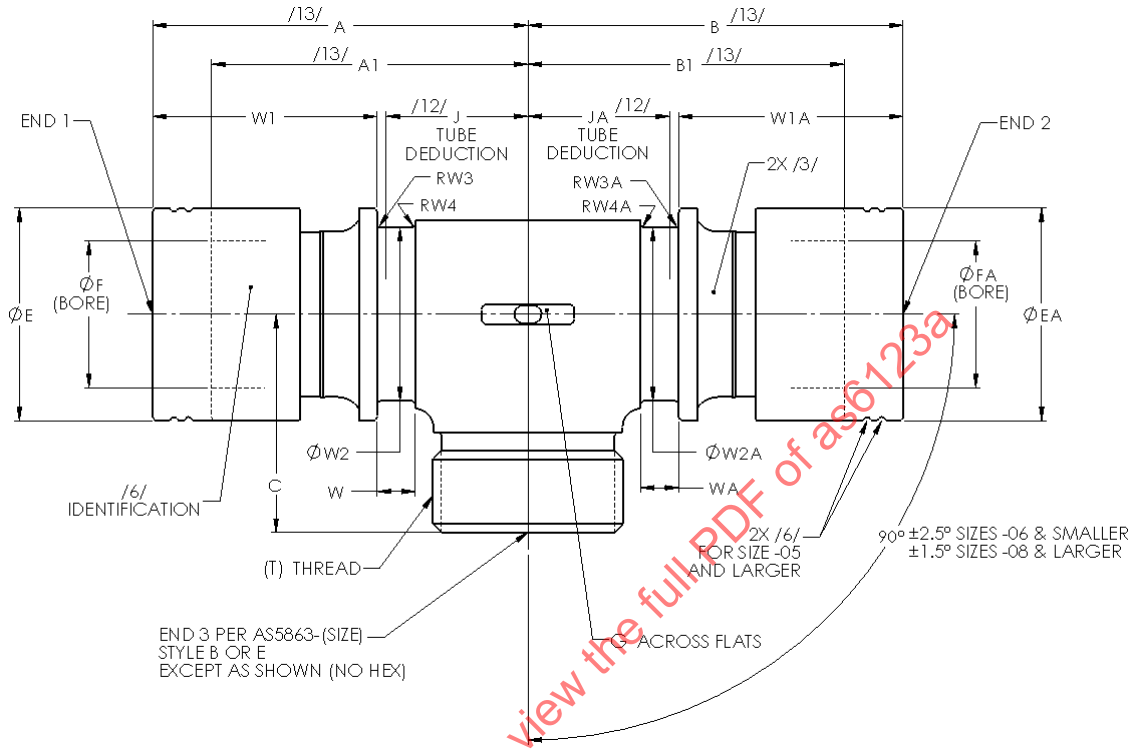

FIGURE 1 - FITTING ASSEMBLY, TEE, AXIALLY SWAGED ON THE RUN, MALE FLARELESS ON THE SIDE

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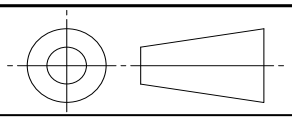
THIRD ANGLE PROJECTION



ISSUED 2011-07 REVISED 2015-06

CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS6116

AEROSPACE STANDARD

FITTING ASSEMBLY, TEE, AXIALLY SWAGED ON THE RUN, MALE FLARELESS ON THE SIDE, HYDRAULIC, UP TO 1500 PSI

AS6123
SHEET 1 OF 4

REV. A

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TABLE 1A - DIMENSIONS A THROUGH EA

BASIC NO. AS6123 /15/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	NOMINAL TUBE SIZE END 3	A MAX	A1 MAX	B MAX	B1 MAX	C ±.015	ØE MAX	ØEA MAX
040404	.250	.250	.250	1.112	.959	1.112	.959	.767	.435	.435
050505	.3125	.3125	.3125	1.258	1.110	1.258	1.110	.786	.503	.503
060606	.375	.375	.375	1.464	1.237	1.464	1.237	.846	.580	.580
080808	.500	.500	.500	1.765	1.505	1.765	1.505	1.032	.755	.755
100808	.625	.500	.500	1.780	1.540	1.765	1.505	1.095	.929	.755
101008	.625	.625	.500	1.780	1.540	1.780	1.540	1.095	.929	.929
101010	.625	.625	.625	1.843	1.603	1.843	1.603	1.158	.929	.929
101012	.625	.625	.750	1.968	1.728	1.968	1.728	1.331	.929	.929
101016	.625	.625	1.000	2.093	1.853	2.093	1.853	1.465	.929	.929
121206	.750	.750	.375	2.103	1.823	2.103	1.823	1.112	1.150	1.150
121212	.750	.750	.750	2.103	1.823	2.103	1.823	1.346	1.150	1.150
161616	1.000	1.000	1.000	2.618	2.238	2.618	2.238	1.505	1.474	1.474
202020	1.250	1.250	1.250	3.069	2.654	3.069	2.654	1.627	1.768	1.768
242424	1.500	1.500	1.500	3.600	3.105	3.600	3.105	1.747	2.070	2.070

TABLE 1B - DIMENSIONS F THROUGH JA

BASIC NO. AS6123 /15/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	NOMINAL TUBE SIZE END 3	ØF MIN	ØFA MIN	G ±.015	J /12/ TUBE DEDUCTION		JA /12/ TUBE DEDUCTION	
040404	.250	.250	.250	.253	.253	.438	.419	+.150/-.180	.419	+.150/-.180
050505	.3125	.3125	.3125	.3155	.3155	.465	.435	+.150/-.180	.435	+.150/-.180
060606	.375	.375	.375	.378	.378	.563	.492	+.150/-.195	.492	+.150/-.195
080808	.500	.500	.500	.503	.503	.750	.590	+.150/-.210	.590	+.150/-.210
100808	.625	.500	.500	.629	.503	.875	.600	+.150/-.200	.590	+.150/-.210
101008	.625	.625	.500	.629	.629	.875	.600	+.150/-.200	.600	+.150/-.200
101010	.625	.625	.625	.629	.629	.875	.663	+.150/-.200	.663	+.150/-.200
101012	.625	.625	.750	.629	.629	1.063	.788	+.150/-.200	.788	+.150/-.200
101016	.625	.625	1.000	.629	.629	1.304	.913	+.150/-.200	.913	+.150/-.200
121206	.750	.750	.375	.754	.754	1.063	.783	+.150/-.245	.783	+.150/-.245
121212	.750	.750	.750	.754	.754	1.063	.783	+.150/-.245	.783	+.150/-.245
161616	1.000	1.000	1.000	1.004	1.004	1.304	.928	+.150/-.330	.928	+.150/-.330
202020	1.250	1.250	1.250	1.255	1.255	1.618	1.104	+.150/-.375	1.104	+.150/-.375
242424	1.500	1.500	1.500	1.505	1.505	1.806	1.275	+.150/-.425	1.275	+.150/-.425

TABLE 1C - DIMENSIONS T THROUGH W1A

BASIC NO. AS6123 /15/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	NOMINAL TUBE SIZE END 3	(T) THREAD PER AS8879	W MIN	WA MIN	W1 MAX	W1A MAX
040404	.250	.250	.250	.4375-20 UNJF-3A	.185	.185	.604	.604
050505	.3125	.3125	.3125	.5000-20 UNJF-3A	.180	.180	.724	.724
060606	.375	.375	.375	.5625-18 UNJF-3A	.195	.195	.883	.883
080808	.500	.500	.500	.7500-16 UNJF-3A	.210	.210	1.076	1.076
100808	.625	.500	.500	.7500-16 UNJF-3A	.225	.210	1.076	1.076
101008	.625	.625	.500	.7500-16 UNJF-3A	.225	.225	1.076	1.076
101010	.625	.625	.625	.8750-14 UNJF-3A	.225	.225	1.076	1.076
101012	.625	.625	.750	1.0625-12 UNJ-3A	.225	.225	1.076	1.076
101016	.625	.625	1.000	1.3125-12 UNJ-3A	.225	.225	1.076	1.076
121206	.750	.750	.375	.5625-18 UNJF-3A	.235	.235	1.201	1.201
121212	.750	.750	.750	1.0625-12 UNJ-3A	.235	.235	1.201	1.201
161616	1.000	1.000	1.000	1.3125-12 UNJ-3A	.260	.260	1.566	1.566
202020	1.250	1.250	1.250	1.6250-12 UNJ-3A	.285	.285	1.829	1.829
242424	1.500	1.500	1.500	1.8750-12 UNJ-3A	.310	.310	2.178	2.178

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TABLE 1D - DIMENSIONS W2 THROUGH W4A AND WEIGHTS

BASIC NO. AS6123 /15/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	NOMINAL TUBE SIZE END 3	ØW2 ±.002	ØW2A ±.002	W3 MAX	W3A MAX	W4 MAX	W4A MAX	WEIGHT APPROX LB/EA
040404	.250	.250	.250	.320	.320	.020	.020	.020	.020	.020
050505	.3125	.3125	.3125	.371	.371	.020	.020	.020	.020	.025
060606	.375	.375	.375	.463	.463	.020	.020	.020	.020	.040
080808	.500	.500	.500	.595	.595	.020	.020	.020	.020	.080
100808	.625	.500	.500	.758	.595	.020	.020	.020	.020	.100
101008	.625	.625	.500	.758	.758	.020	.020	.020	.020	.105
101010	.625	.625	.625	.758	.758	.020	.020	.020	.020	.115
101012	.625	.625	.750	.758	.758	.020	.020	.020	.020	.170
101016	.625	.625	1.000	.758	.758	.020	.020	.020	.020	.255
121206	.750	.750	.375	.903	.903	.025	.025	.025	.025	.190
121212	.750	.750	.750	.903	.903	.025	.025	.025	.025	.200
161616	1.000	1.000	1.000	1.196	1.196	.035	.035	.035	.035	.365
202020	1.250	1.250	1.250	1.460	1.460	.035	.035	.035	.035	.580
242424	1.500	1.500	1.500	1.704	1.704	.035	.035	.035	.035	.700

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.

RINGS - 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.

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 AS6116 AND SHALL BE IDENTIFIED ON EITHER RING IN THE AREA SHOWN. FOR SIZE -05 AND LARGER, THE RING OD SHALL HAVE TWO GROOVES INDICATING DUAL SEALING BACK UP FEATURE.

7. FITTINGS SHALL BE INSTALLED IN ACCORDANCE WITH AS6124.

8. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, THE MAXIMUM MACHINED SURFACES SHALL BE 125 MICROINCHES Ra.

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