

REV.  
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AS6445

RATIONALE

ADDED STANDARD CONFIGURATIONS 202020 & 242424. ADDED REDUCER CONFIGURATION 101008. ERROR CORRECTION DIMENSION "JA" SIZE CODE 101012.

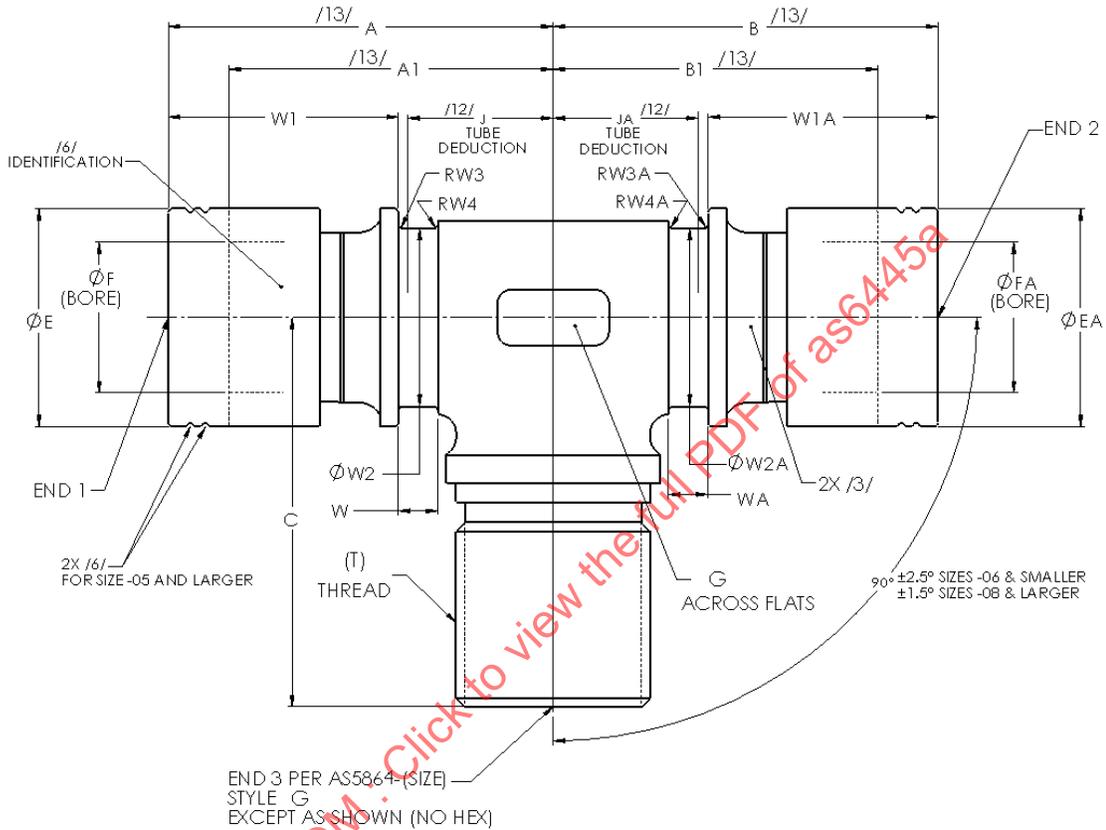
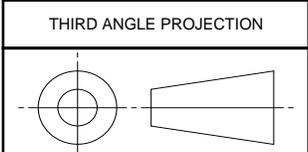


FIGURE 1 - FITTING ASSEMBLY, TEE, AXIALLY SWAGED ON THE RUN, BULKHEAD FLARELESS ON THE SIDE

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CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS6116



**AEROSPACE STANDARD**

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

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**TABLE 1A - DIMENSIONS A THROUGH EA**

BASIC NO. AS6445 /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	1.123	.970	1.123	.970	1.523	.435	.435
050505	.3125	.3125	.3125	1.283	1.135	1.283	1.135	1.555	.503	.503
060606	.375	.375	.375	1.470	1.243	1.470	1.243	1.711	.580	.580
080808	.500	.500	.500	1.771	1.511	1.771	1.511	1.992	.755	.755
101008	.625	.625	.500	1.856	1.616	1.856	1.616	1.982	.929	.929
101010	.625	.625	.625	1.856	1.616	1.856	1.616	2.243	.929	.929
101012	.625	.625	.750	1.942	1.702	1.942	1.702	2.492	.929	.929
121210	.750	.750	.625	2.085	1.805	2.085	1.805	2.383	1.150	1.150
121212	.750	.750	.750	2.085	1.805	2.085	1.805	2.492	1.150	1.150
161616	1.000	1.000	1.000	2.615	2.235	2.615	2.235	2.617	1.474	1.474
202020	1.250	1.250	1.250	3.060	2.645	3.060	2.645	2.898	1.768	1.768
242424	1.500	1.500	1.500	3.540	3.045	3.540	3.045	2.975	2.070	2.070

**TABLE 1B - DIMENSIONS F THROUGH JA**

BASIC NO. AS6445 /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	.430 +.150/-.180	.430 +.150/-.180
050505	.3125	.3125	.3125	.3155	.3155	.465	.460 +.150/-.180	.460 +.150/-.180
060606	.375	.375	.375	.378	.378	.563	.498 +.150/-.195	.498 +.150/-.195
080808	.500	.500	.500	.503	.503	.750	.596 +.150/-.210	.596 +.150/-.210
101008	.625	.625	.500	.629	.629	.875	.676 +.150/-.200	.676 +.150/-.200
101010	.625	.625	.625	.629	.629	.875	.676 +.150/-.200	.676 +.150/-.200
101012	.625	.625	.750	.629	.629	1.063	.762 +.150/-.200	.762 +.150/-.200
121210	.750	.750	.625	.754	.754	1.063	.765 +.150/-.245	.765 +.150/-.245
121212	.750	.750	.750	.754	.754	1.063	.765 +.150/-.245	.765 +.150/-.245
161616	1.000	1.000	1.000	1.004	1.004	1.304	.925 +.150/-.330	.925 +.150/-.330
202020	1.250	1.250	1.250	1.255	1.255	1.618	1.095 +.150/-.375	1.095 +.150/-.375
242424	1.500	1.500	1.500	1.505	1.505	1.806	1.215 +.150/-.425	1.215 +.150/-.425

**TABLE 1C - DIMENSIONS T THROUGH W1A**

BASIC NO. AS6445 /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
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
121210	.750	.750	.625	.8750-14 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. AS6445 /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	.030
050505	.3125	.3125	.3125	.371	.371	.020	.020	.020	.020	.045
060606	.375	.375	.375	.463	.463	.020	.020	.020	.020	.060
080808	.500	.500	.500	.595	.595	.020	.020	.020	.020	.110
101008	.625	.625	.500	.758	.758	.020	.020	.020	.020	.145
101010	.625	.625	.625	.758	.758	.020	.020	.020	.020	.165
101012	.625	.625	.750	.758	.758	.020	.020	.020	.020	.230
121210	.750	.750	.625	.903	.903	.025	.025	.025	.025	.240
121212	.750	.750	.750	.903	.903	.025	.025	.025	.025	.270
161616	1.000	1.000	1.000	1.196	1.196	.035	.035	.035	.035	.450
202020	1.250	1.250	1.250	1.460	1.460	.035	.035	.035	.035	.745
242424	1.500	1.500	1.500	1.704	1.704	.035	.035	.035	.035	.980

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](http://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 O.D. 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.

9. BREAK ALL EDGES .003 TO .010 INCHES UNLESS OTHERWISE SPECIFIED.

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