

REV.
A

AS6446™

RATIONALE

CORRECT TYPO FOR B1 DIMENSION IN TABLE 1A. STANDARDS UPDATED TO CURRENT NOMENCLATURE. QPL STATEMENT UPDATED TO CURRENT VERBIAGE IN THE PROCUREMENT SPECIFICATION NOTE. INVENTORIED PARTS DISPOSITION NOTE /17/ ADDED.

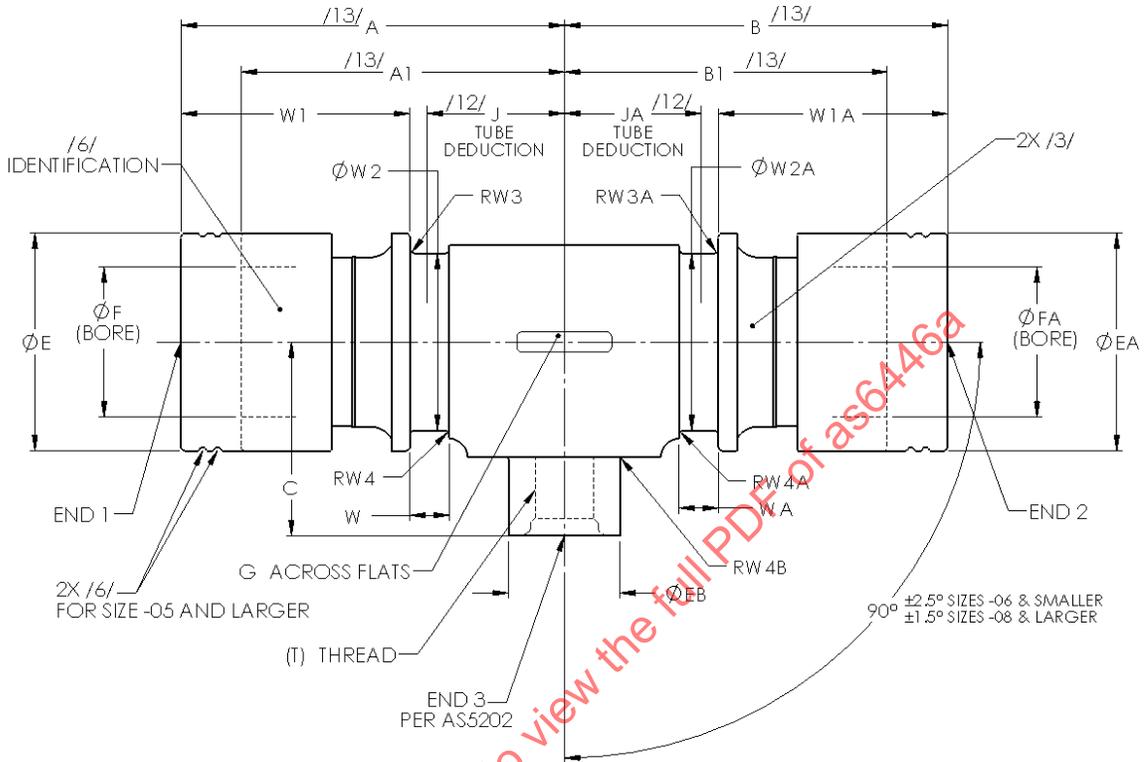
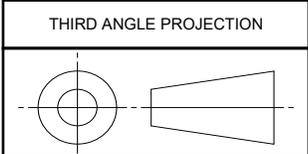


FIGURE 1 - FITTING ASSEMBLY, TEE, AXIALLY SWAGED ON THE RUN, INTERNAL PORT ON THE SIDE

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CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS6116 /4/



AEROSPACE STANDARD
 FITTING ASSEMBLY, TEE,
 AXIALLY SWAGED ON THE RUN, INTERNAL PORT END
 ON THE SIDE, HYDRAULIC, UP TO 1500 PSI

AS6446™
 SHEET 1 OF 4

REV.

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TABLE 1A - DIMENSIONS A-C

BASIC NO. AS6446 /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
080804	.500	.500	.250	1.725	1.465	1.725	1.465	1.015
101004	.625	.625	.250	1.805	1.565	1.805	1.565	1.150
121204	.750	.750	.250	2.050	1.770	2.050	1.770	1.200
161604	1.000	1.000	.250	2.615	2.235	2.615	2.235	1.307
161604E	1.000	1.000	.250	2.615	2.235	2.615	2.235	1.555
161606	1.000	1.000	.375	2.615	2.235	2.615	2.235	1.200
202004	1.250	1.250	.250	3.060	2.645	3.060	2.645	1.700

TABLE 1B - DIMENSIONS E-G

BASIC NO. AS6446 /15/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	NOMINAL TUBE SIZE END 3	ØE MAX	ØEA MAX	ØEB ±.015	ØF MIN	ØFA MIN	G ±.015
080804	.500	.500	.250	.755	.755	.750	.503	.503	.750
101004	.625	.625	.250	.929	.929	.750	.629	.629	.875
121204	.750	.750	.250	1.150	1.150	.750	.754	.754	1.063
161604	1.000	1.000	.250	1.474	1.474	.750	1.004	1.004	1.304
161604E	1.000	1.000	.250	1.474	1.474	.750	1.004	1.004	1.304
161606	1.000	1.000	.375	1.474	1.474	.875	1.004	1.004	1.304
202004	1.250	1.250	.250	1.768	1.768	.750	1.255	1.255	1.618

TABLE 1C - DIMENSIONS J-T

BASIC NO. AS6446 /15/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	NOMINAL TUBE SIZE END 3	J /12/ TUBE DEDUCTION	JA /12/ TUBE DEDUCTION	(T) THREAD PER AS8879
080804	.500	.500	.250	.550 +.150/-.210	.550 +.150/-.210	.4375-20 UNJF-3B
101004	.625	.625	.250	.625 +.150/-.200	.625 +.150/-.200	.4375-20 UNJF-3B
121204	.750	.750	.250	.730 +.150/-.245	.730 +.150/-.245	.4375-20 UNJF-3B
161604	1.000	1.000	.250	.925 +.150/-.330	.925 +.150/-.330	.4375-20 UNJF-3B
161604E	1.000	1.000	.250	.925 +.150/-.330	.925 +.150/-.330	.4375-20 UNJF-3B
161606	1.000	1.000	.375	.925 +.150/-.330	.925 +.150/-.330	.5625-18 UNJF-3B
202004	1.250	1.250	.250	1.095 +.150/-.375	1.095 +.150/-.375	.4375-20 UNJF-3B

TABLE 1D - DIMENSIONS W-W2A

BASIC NO. AS6446 /15/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	NOMINAL TUBE SIZE END 3	W MIN	WA MIN	W1 MAX	W1A MAX	ØW2 ±.002	ØW2A ±.002
080804	.500	.500	.250	.210	.210	1.076	1.076	.595	.595
101004	.625	.625	.250	.225	.225	1.076	1.076	.758	.758
121204	.750	.750	.250	.235	.235	1.201	1.201	.903	.903
161604	1.000	1.000	.250	.260	.260	1.566	1.566	1.196	1.196
161604E	1.000	1.000	.250	.260	.260	1.566	1.566	1.196	1.196
161606	1.000	1.000	.375	.260	.260	1.566	1.566	1.196	1.196
202004	1.250	1.250	.250	.285	.285	1.829	1.829	1.460	1.460

TABLE 1E - DIMENSIONS W3-W4B AND WEIGHTS

BASIC NO. AS6446 /15/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	NOMINAL TUBE SIZE END 3	W3 MAX	W3A MAX	W4 MAX	W4A MAX	W4B MAX	WEIGHT APPROX LB/EA
080804	.500	.500	.250	.020	.020	.020	.020	--	.080
101004	.625	.625	.250	.020	.020	.020	.020	.020	.110
121204	.750	.750	.250	.025	.025	.025	.025	.020	.180
161604	1.000	1.000	.250	.035	.035	.035	.035	.020	.350
161604E	1.000	1.000	.250	.035	.035	.035	.035	.020	.357
161606	1.000	1.000	.375	.035	.035	.035	.035	.020	.350
202004	1.250	1.250	.250	.035	.035	.035	.035	.020	.570

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-PRF-8625, TYPE II, CLASS 2, DYED GREEN, SIMILAR TO NO. 14187, 14193, OR 14223 OF AMS-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 IN THIS STANDARD. PRODUCT MANUFACTURED TO THIS STANDARD SHALL MEET THE REQUIREMENTS SPECIFIED HEREIN AND THE PROCUREMENT SPECIFICATION. ORIGINAL COMPONENT MANUFACTURERS (OCM) SHALL BE LISTED IN THE PRI QUALIFIED PRODUCTS LIST (QPL) PRI-QPL-AS6116 FOR THIS STANDARD. See www.eAuditNet.com FOR THE CURRENT QPL ONLINE.

5. DIMENSIONS AND TOLERANCES NOT DEFINED IN 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, MACHINED SURFACES TO BE 125 MICRONS Ra.

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

10. DIMENSIONING AND TOLERANCING: ASME Y14.5M-1994.

11. DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS $\pm .015$, ANGULAR DIMENSIONS $\pm 0^{\circ}30'$.

/12/ DIMENSIONS "J" AND "JA" ARE THE ALLOWABLE TUBE END POSITIONING FOR SYSTEM LAYOUT DESIGN.

/13/ DIMENSIONS "A" AND "B" ARE THE FITTING ASSEMBLY LENGTHS PRIOR TO SWAGING AND "A1" AND "B1" ARE THE AFTER SWAGING. ASSEMBLY LENGTHS MEASURED FROM THE SWAGED RINGS.

/14/ PARTS FOR OXYGEN SYSTEMS SHALL BE IDENTIFIED IN THE PART NUMBER AS SUFFIX CODE "A" AND SHALL BE FURNISHED CLEANED, PACKAGED, AND LABELED IN ACCORDANCE WITH ARP1176, CATEGORY 1A.

	AEROSPACE STANDARD	AS6446™ SHEET 3 OF 4	REV. A
	FITTING ASSEMBLY, TEE, AXIALLY SWAGED ON THE RUN, INTERNAL PORT END ON THE SIDE, HYDRAULIC, UP TO 1500 PSI		