

REV.
D

AS85421™/12

RATIONALE

CUSTODIAN NOTE REVISED TO INCLUDE SUB-COMMITTEE GROUP. HEADINGS IN TABLE 1 REVISED. REFERENCE TO NOTE 6.4 OF THE PROCUREMENT SPECIFICATION MENTIONED BELOW TABLE 1 HAS BEEN REVISED TO POINT READER TO ACTUAL NAME OF PARAGRAPH (SAE PRACTICE IS TO NOT REFER TO PARAGRAPHS WITHIN ANOTHER DOCUMENT). FINISH FOR MATERIAL CODE LETTERS P AND V CHANGED FROM TYPE 6 OR 7 TO 2 OR 8. UPDATED PROCUREMENT SPECIFICATION NOTE TO CURRENT QPL VERBIAGE. ADDED NEW NOTE 11: WHEN MACHINED FROM BAR STOCK OR OVERSIZED FORGING, THE CENTER BODY DIMENSIONS SHALL CONFORM TO AS1376, TABLE 4. TITANIUM USAGE NOTE 17 REMOVED. (THIS NOTE SHOULD NOT BE PART OF THE PART STANDARD). REVISION INDICATOR NOTE REVISED TO CURRENT VERBIAGE.

SAE Executive Standards Committee Rules provide that: " This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user." SAE reviews each technical report at least every five years at which time it may be revised, reaffirmed, stabilized, or cancelled. SAE invites your written comments and suggestions.

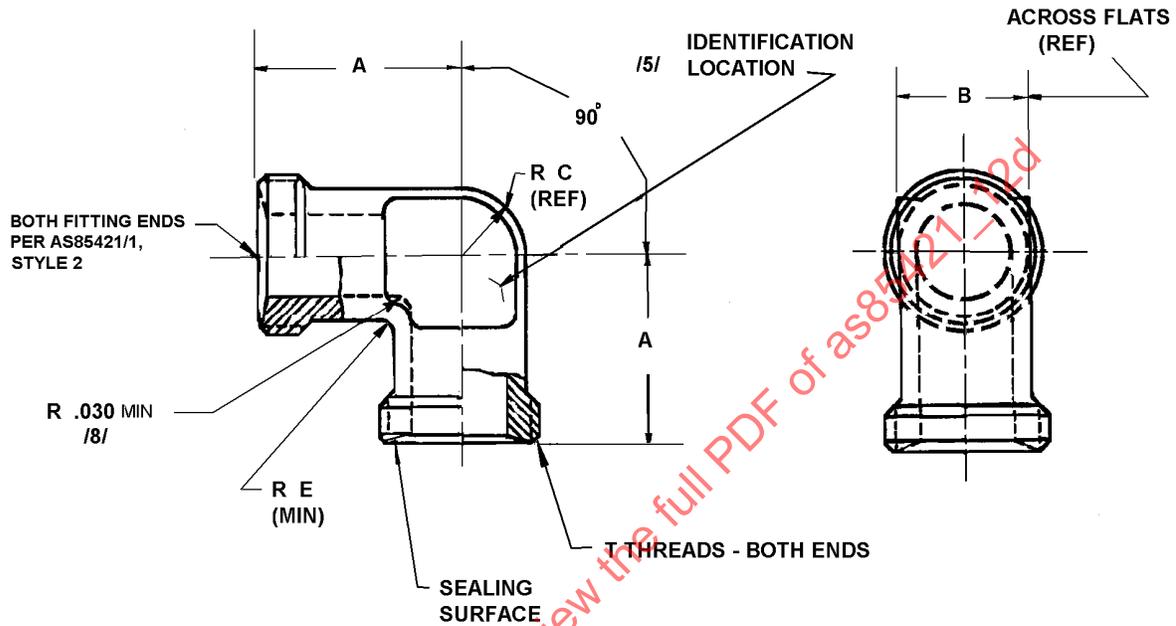
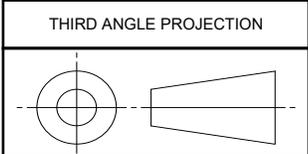


FIGURE 1

SAENORM.COM : Click to view the full PDF of as85421-12d

For more information on this standard, visit
<https://www.sae.org/standards/content/AS85421/12D/>



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS85421 /4/



AEROSPACE STANDARD

FITTING, ELBOW,
90°, BEAM SEAL,
3000/4000 PSI, MALE TO MALE

AS85421™/12
SHEET 1 OF 3

REV.
D

TABLE 1 - DIMENSIONS A TO E

AS85421/12 SIZE CODE /16/	TUBE OD	T THREAD AS8879	A	B (REF)	C RAD (REF)	E RAD (MIN)	MASS LB/EA APPROX (REF)	
							TI	CRES
03	.188	.3750-28UNJS-3A	.575	.375	.188	.042	.017	.030
04	.250	.4375-24UNJS-3A	.617	.375	.188	.042	.019	.034
05	.312	.5000-24UNJS-3A	.653	.438	.219	.042	.026	.047
06	.375	.5625-20UNJS-3A	.704	.500	.250	.042	.033	.059
08	.500	.7188-20UNJS-3A	.824	.562	.281	.070	.055	.097
10	.625	.8438-18UNJS-3A	.955	.688	.344	.070	.080	.141
12	.750	1.0000-16UNJ-3A	1.062	.875	.438	.098	.121	.214
14	.875	1.1250-16UNJ-3A	1.216	1.125	.563	.098	.226	.400
16	1.000	1.2500-14UNJS-3A	1.246	1.125	.563	.098	.210	.372
20	1.250	1.5781-14UNJS-3A	1.387	1.375	.688	.098	.330	.584
24	1.500	1.8438-14UNJS-3A	1.688	1.625	.813	.098	.561	.992

SIZES -20 AND -24 WERE ORIGINALLY DESIGNATED AS SIZES -21 AND -25 ON SOME MANUFACTURER'S DRAWINGS. THESE SIZES WILL NOT CONNECT WITH THE ORIGINAL -20 AND -24 FITTINGS. SEE "DELETION OF SIZES 21 AND 25" NOTE IN THE PROCUREMENT SPECIFICATION FOR ADDITIONAL INFORMATION.

NOTES:

/1/ MATERIAL:

- a. CODE LETTER P: TYPE 17-4PH CORROSION RESISTANT STEEL PER AMS5643.
- b. CODE LETTER T: TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS4928 OR AMS4965.
- c. CODE LETTER V: TYPE 15-5PH, CORROSION RESISTANT STEEL PER AMS5659.

2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER P: CONDITION H1075 PER AMS2759/3.
- b. MATERIAL CODE LETTER T: NONE.
- c. MATERIAL CODE LETTER V: AGE TO CONDITION H 1075 PER AMS-H-6875 OR AMS2759/3.

3. FINISH:

- a. MATERIAL CODE LETTER P: PASSIVATE PER AMS2700, TYPE 2 OR 8.
- b. MATERIAL CODE LETTER T: NONE.
- c. MATERIAL CODE LETTER V: PASSIVATE PER AMS2700, TYPE 2 OR 8.

/4/ PROCUREMENT SPECIFICATION: AS85421 EXCEPT AS SPECIFIED ON THIS STANDARD. PRODUCT MANUFACTURED TO THIS STANDARD SHALL MEET THE REQUIREMENTS SPECIFIED HEREIN AND THE PROCUREMENT SPECIFICATION. ORIGINAL COMPONENT MANUFACTURERS (OCM) AND VALUE ADDED DISTRIBUTORS (VAD) SHALL BE LISTED IN THE PRI QUALIFIED PRODUCTS LIST (QPL) PRI-QPL-AS85421 FOR THIS STANDARD. SEE www.eAuditNet.com FOR CURRENT QPL ONLINE.

/5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D, OR METHOD 7A3, 15A3, OR 15B.

- a. FOR SIZES 06 AND SMALLER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, LETTERS "AS" AND MATERIAL CODE LETTER, AND FORGING MANUFACTURER'S IDENTIFICATION WHEN MADE FROM FORGING.
- b. FOR SIZES 08 AND LARGER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, BASIC PART NUMBER AND MATERIAL CODE LETTER, AND FORGING MANUFACTURER'S IDENTIFICATION WHEN MADE FROM FORGING.

6. INVENTORIED PARTS CONFORMING TO THE PREVIOUS "LETTER CHANGE" MAY BE USED TO DEPLETION.

	AEROSPACE STANDARD	AS85421™/12 SHEET 2 OF 3	REV. D
	FITTING, ELBOW, 90°, BEAM SEAL, 3000/4000 PSI, MALE TO MALE		