

REV.
B

AS85421/13

FEDERAL SUPPLY CLASS
4730

RATIONALE

THIS DOCUMENT IS REVISED TO INCLUDE PRI-QPL REQUIREMENTS AND REFORMATTED TO BE IN ACCORDANCE WITH SAE GUIDELINES.

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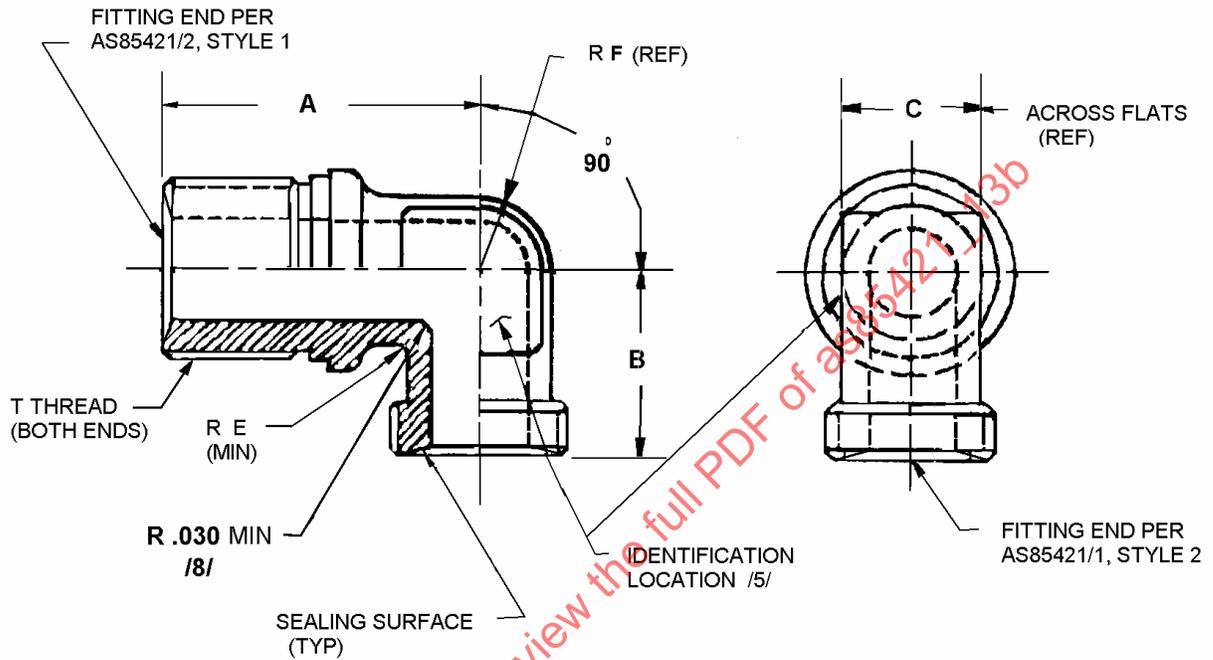
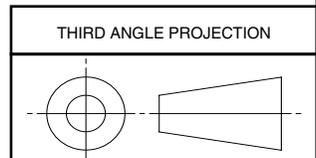


FIGURE 1



CUSTODIAN: SAE G-3

PROCUREMENT SPECIFICATION: AS85421 /4/

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

(R) FITTING, ELBOW, 90°, BEAM SEAL,
3000/4000 PSI, BULKHEAD MALE ENDS

AS85421/13
SHEET 1 OF 3

**REV.
B**

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ISSUED 2001-05 REVISED 2006-11

TABLE 1 - DIMENSIONAL DATA

DASH NO.	TUBE OD	T THREAD AS8879	A	B (REF)	C (REF)	E RAD (MIN)	F RAD (REF)	WT. LB (MAX)	
								TI	CRES
-03	.188	.3750-28UNJS-3A	1.143	.575	.375	.042	.188	.023	.041
-04	.250	.4375-24UNJS-3A	1.225	.617	.375	.042	.188	.032	.050
-05	.312	.5000-24UNJS-3A	1.261	.653	.438	.042	.219	.041	.074
-06	.375	.5625-20UNJS-3A	1.353	.704	.500	.042	.250	.050	.089
-08	.500	.7188-20UNJS-3A	1.542	.824	.562	.070	.281	.092	.163
-10	.625	.8438-18UNJS-3A	1.769	.955	.688	.070	.344	.135	.240
-12	.750	1.0000-16UNJ-3A	1.953	1.062	.875	.098	.438	.176	.317
-14	.875	1.1250-16UNJ-3A	2.188	1.216	1.125	.098	.563	.250	.442
-16	1.000	1.2500-14UNJS-3A	2.188	1.246	1.125	.098	.563	.330	.584
-20	1.250	1.5781-14UNJS-3A	2.326	1.387	1.375	.098	.688	.517	.914
-24	1.500	1.8438-14UNJS-3A	2.712	1.688	1.625	.098	.813	.772	1.365

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 6.4 IN THE PROCUREMENT SPECIFICATION FOR ADDITIONAL INFORMATION.

NOTES:

/1/ MATERIAL:

- a. CODE LETTER P - TYPE 17-4PH CORROSION RESISTANT STEEL PER AMS 5643.
- b. CODE LETTER T - TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS 4928 OR AMS 4965.
- c. CODE LETTER V - TYPE 15-5PH, CORROSION RESISTANT STEEL PER AMS 5659.

2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER P - CONDITION H1075 PER AMS 2759/3.
- b. MATERIAL CODE LETTER T - NONE.
- c. MATERIAL CODE LETTER V - AGE TO CONDITION H 1076 PER AMS-H-6875 OR AMS 2759/3.

3. FINISH:

- a. MATERIAL CODE LETTER P - PASSIVATE PER AMS-QQ-P-35, TYPE VI OR VII.
- b. MATERIAL CODE LETTER T - NONE.
- c. MATERIAL CODE LETTER V - PASSIVATE PER AMS-QQ-P-35, TYPE VI OR VII.

/4/ PROCUREMENT SPECIFICATION: AS85421 EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PRODUCT SHALL BE QUALIFIED IN ACCORDANCE WITH SPECIFICATION AS85421. USERS OF THIS STANDARD SHALL PROCURE THE PRODUCT FROM ACCREDITED MANUFACTURER(S), OR ACCREDITED DISTRIBUTOR(S), AS LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST (QPL) PRI-QPL-AS85421 FOR THIS STANDARD. SEE <http://www.pri.sae.org/QPL-AS85421/> FOR CURRENT QPL ON LINE.

/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.