

REV.
A

AS85421™/1

RATIONALE

UPDATE SOLID FILM LUBRICATION NOTE AND ALIGN BOTH MALE BEAM SEAL FITTINGS WITH THE SAME SOLID FILM LUBRICATION REQUIREMENTS.

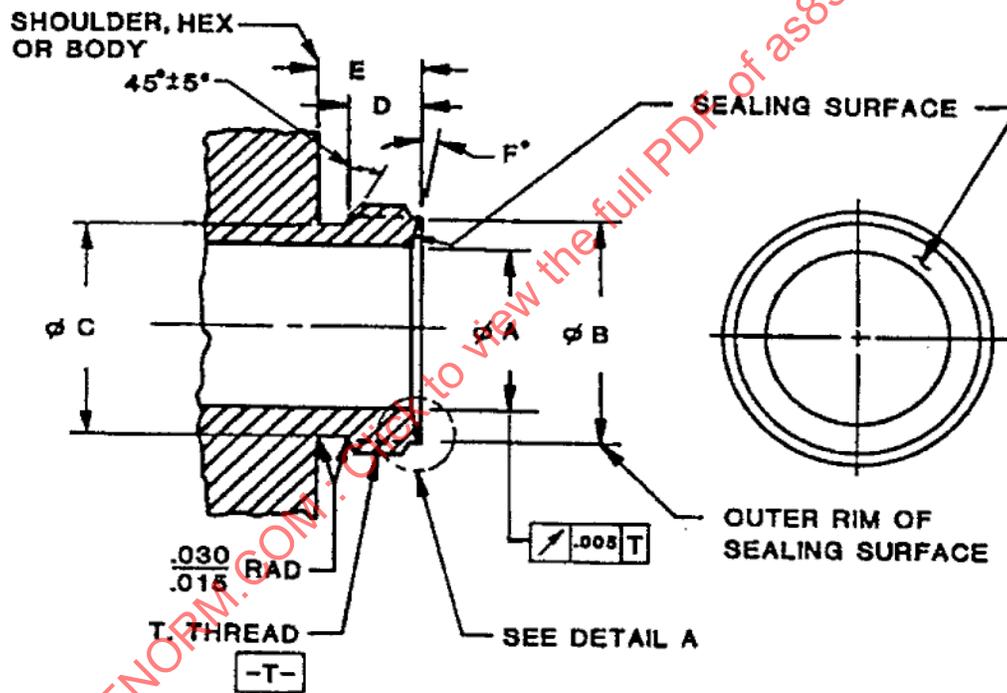
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THE REQUIREMENTS FOR ACQUIRING THE DESIGN STANDARD DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION: MIL-F-85421.

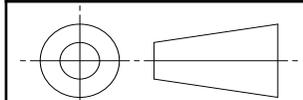


STYLE 1

FIGURE 1

For more information on this standard, visit
<https://www.sae.org/standards/content/AS85421/1A/>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3



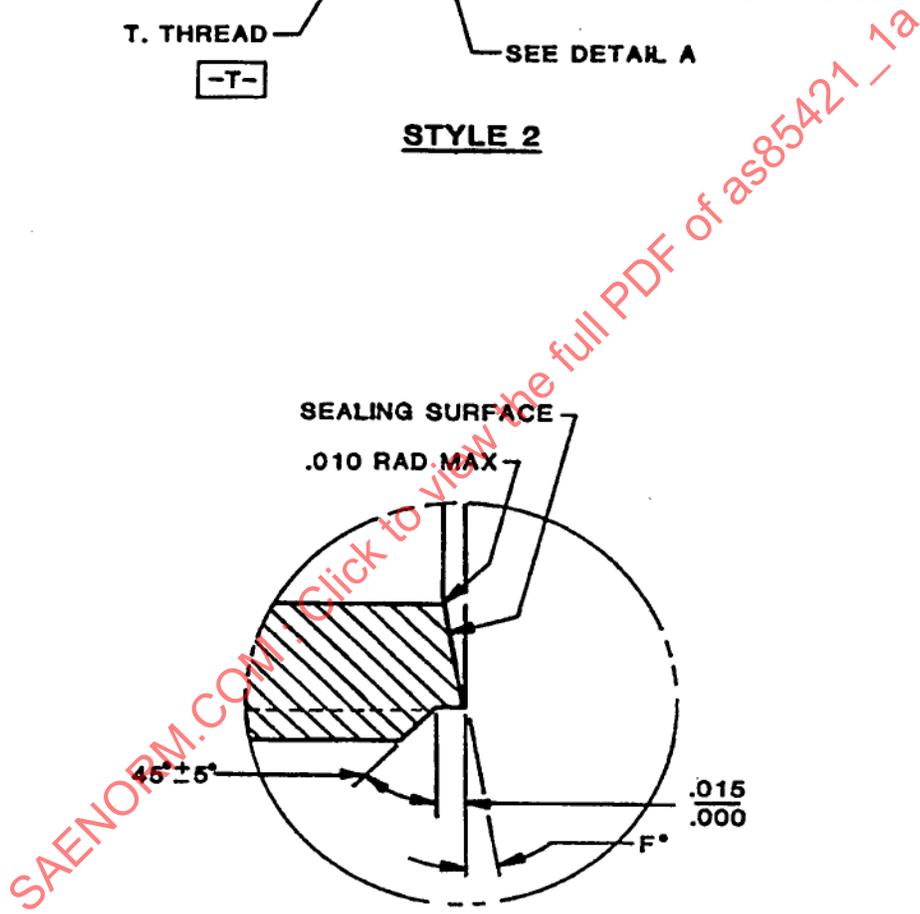
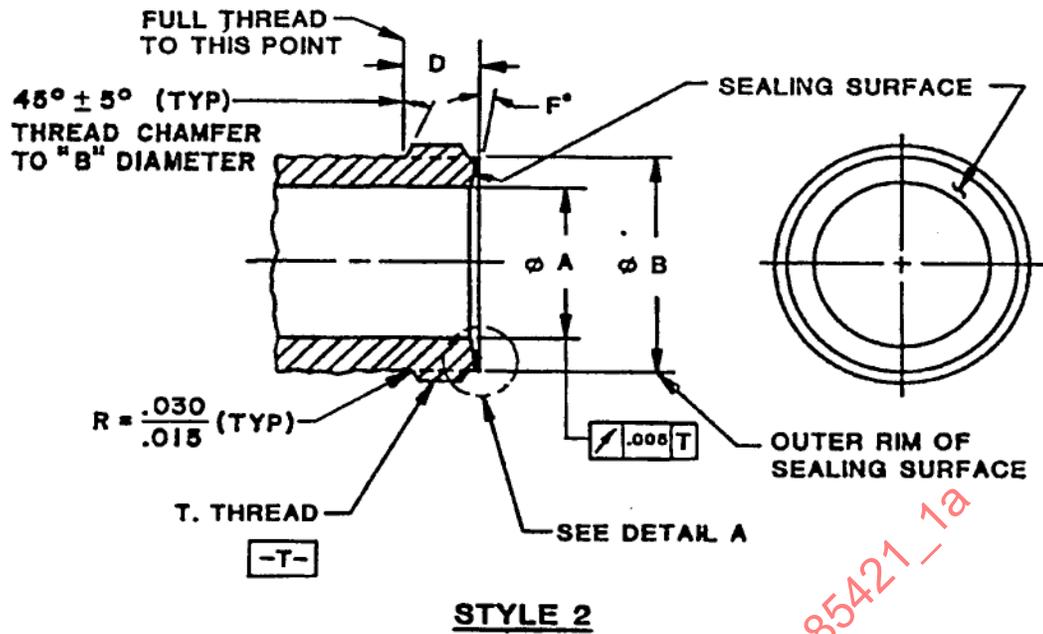
AEROSPACE STANDARD

FITTING END,
STANDARD DIMENSIONS FOR
DYNAMIC BEAM SEAL, MALE

AS85421™/1
SHEET 1 OF 4

REV.
A

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DETAIL A

FIGURE 2

	AEROSPACE STANDARD	AS85421™/1 SHEET 2 OF 4	REV. A
	FITTING END, STANDARD DIMENSIONS FOR DYNAMIC BEAM SEAL, MALE		

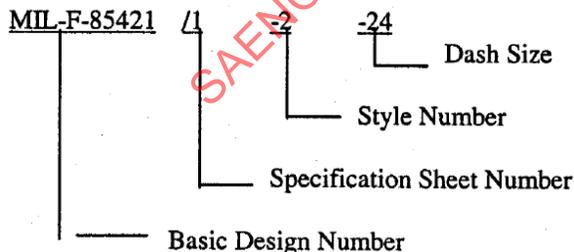
TABLE 1

DASH SIZE	TUBING OD	T-THREAD AS8879	A	B	C ±.005	D +.030 -.000	E +.030 -.000	F° +0° 30' -00
03	.188	.3750-28 UNJS-3A	.154 .164	.323 .329	.318	.164	.218	3°
04	.250	.4375-24 UNJS-3A	.184 .194	.377 .383	.373	.197	.260	8°30'
05	.312	.5000-24 UNJS-3A	.232 .242	.440 .446	.436	.197	.260	
06	.375	.5625-20 UNJS-3A	.297 .307	.490 .497	.488	.205	.280	
08	.500	.7188-20 UNJS-3A	.398 .408	.646 .654	.644	.218	.293	
10	.625	.8438-18 UNJS-3A	.512 .523	.763 .772	.762	.274	.357	
12	.750	1.0000-16 UNJ-3A	.649 .660	.910 .919	.910	.303	.397	
14	.875	1.1250-16 UNJ-3A	.769 .780	1.034 1.044	1.035	.318	.415	
16	1.000	1.2500-14 UNJS-3A	.862 .874	1.148 1.158	1.149	.338	.445	
20	1.250	1.5781-14 UNJS-3A	1.115 1.128	1.476 1.486	1.477	.335	.442	
24	1.500	1.8438-14 UNJS-3A	1.324 1.337	1.741 1.751	1.742	.420	.527	

SIZES -20 AND -24 WERE ORIGINALLY DESIGNATED AS SIZES -21 AND -25 ON SOME MANUFACTURERS' DRAWINGS. THESE SIZES WILL NOT CONNECT WITH THE ORIGINAL -20 AND -24 FITTINGS. SEE 6.8 OF MIL-F-85421B FOR ADDITIONAL INFORMATION.

NOTES:

- DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS +.010; ANGLES ±0°30'.
- REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
- ALL MACHINED SURFACES SHALL BE SMOOTH TO 125 MICRONS Ra PER ANSI B46.1, EXCEPT AS NOTED.
- SEALING SURFACE SHALL BE FREE FROM LONGITUDINAL AND SPIRAL TOOL MARKS AND SHALL BE SMOOTH TO 45 MICRONS Ra IN ACCORDANCE WITH ANSI B46.1.
- SEALING SURFACE SHALL BE COATED WITH SOLID FILM LUBRICANT PER AS5272 TYPE I, OR TYPE II, FOR -65 TO 275 °F, AND AS1701 TYPE IV FOR -65 TO 630 °F UNLESS OTHERWISE STATED ON PART STANDARD. OVERSPRAY IN BORE IS NOT PERMITTED.
- DIMENSIONS A, B, C, AND T (PITCH DIA) SHALL BE CONCENTRIC TO EACH OTHER WITH THE "F" ANGLE MEASURED AND CALCULATED AS AN INCLUDED ANGLE WITHIN .005 FIM.
- EXAMPLE OF DESIGN IDENTIFICATION NUMBER:



- IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS STANDARD AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE.
- REFERENCED GOVERNMENT OR NON-GOVERNMENT DOCUMENTS OF THE ISSUE LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN.

	AEROSPACE STANDARD	AS85421™/1 SHEET 3 OF 4	REV. A
	FITTING END, STANDARD DIMENSIONS FOR DYNAMIC BEAM SEAL, MALE		