

REV. B

AS85421/2

FEDERAL SUPPLY CLASS  
4730

RATIONALE

THIS STANDARD IS TAKEN DIRECTLY FROM MILITARY STANDARD MIL-F-85421/2  
CORRECT ERROR DIMENSION G FOR -14 IN TABLE 1 FROM .264 TO .221  
CORRECT ERROR RELOCATING "DETAIL A" TO LOWER SIDE OF THE MAIN DRAWINGS ON BOTH STYLE 1 AND  
STYLE 2 TO CONFORM WITH THE ENLARGED VIEW SHOWN  
CORRECT ERROR CHANGE IDENTIFICATION NUMBER FROM MIL-F-85421/2 TO AS85421/2  
COMPLETELY REVISED, REDRAWN, AND REFORMATED FOR CLARITY

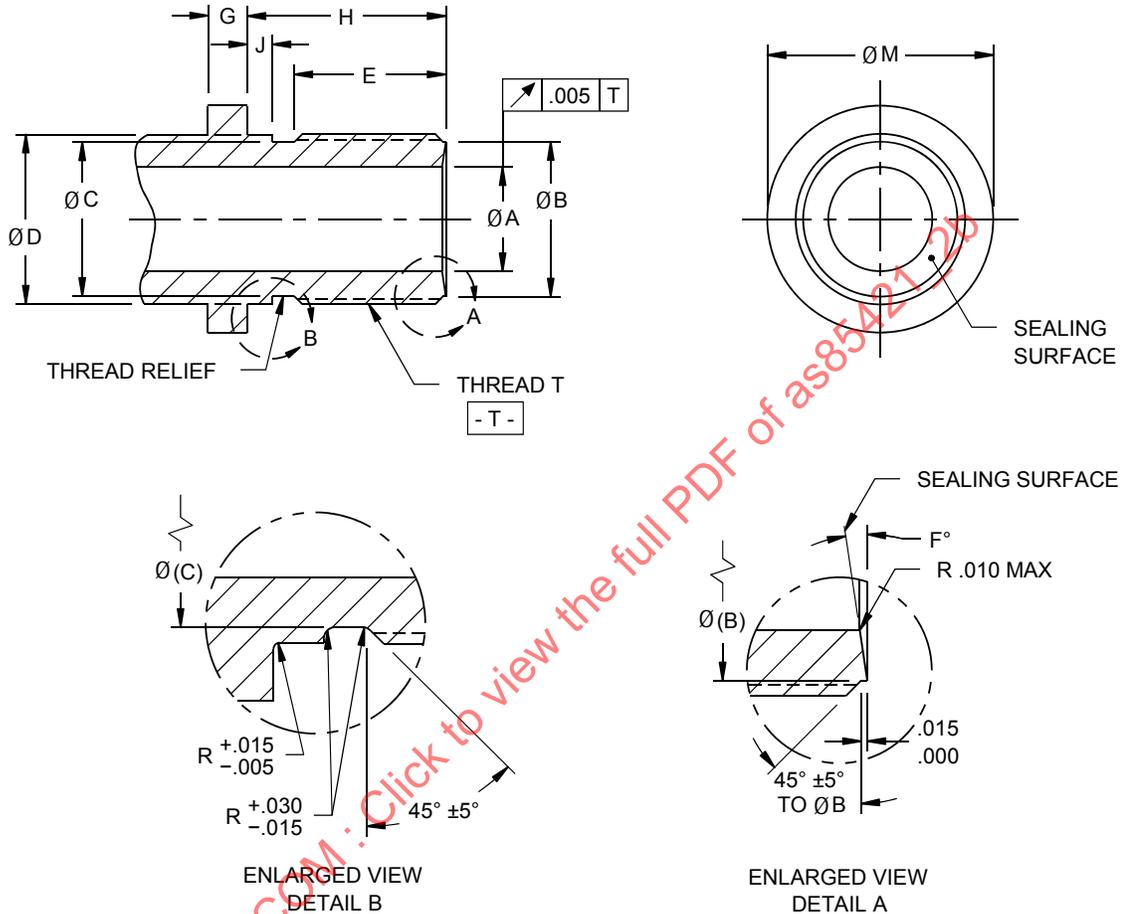
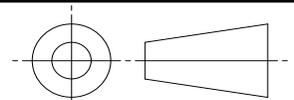


FIGURE 1 - FITTING END, BULKHEAD, DESIGN STANDARD, STYLE 1

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS85421/2B>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: NONE



AEROSPACE STANDARD

(R) FITTING END,  
STANDARD DIMENSIONS FOR,  
BULKHEAD, DYNAMIC BEAM SEAL, MALE

AS85421/2  
SHEET 1 OF 3

REV. B

SAE Technical Standards Board 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.

ISSUED 2002-02 REAFFIRME 2007-10 REVISED 2014-02

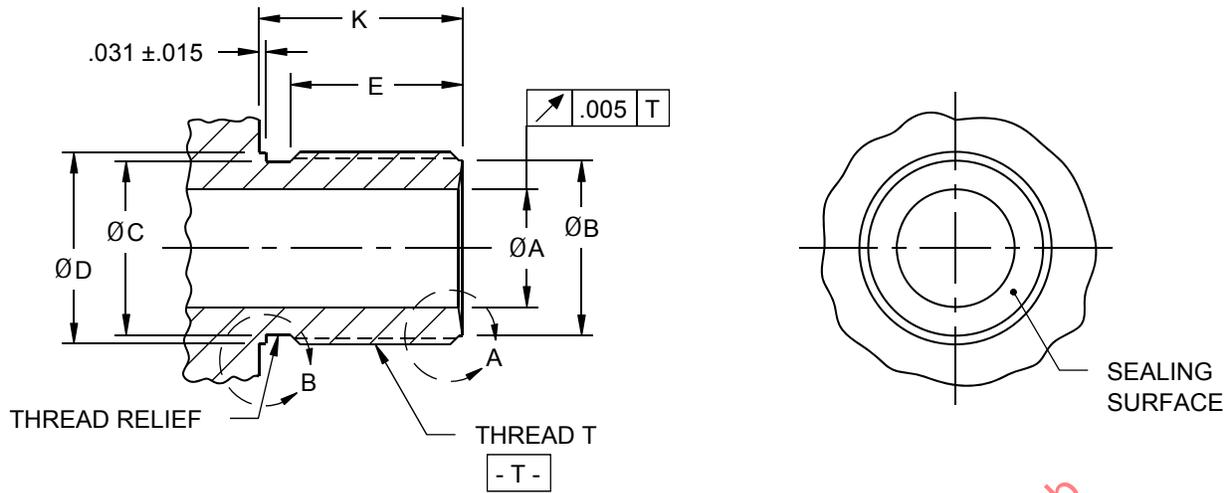


FIGURE 2 - FITTING END, BULKHEAD, DESIGN STANDARD, STYLE 2

TABLE 1 - DIMENSIONS

DASH (NOMINAL SIZE /12/)	TUBE SIZE)	T THREAD PER AS8879 CLASS 3A	T										
			A	B	C ±.005	D	E ±.015	F +5° -0°	(G)	H ±.015	J ±.016	K ±.015	M
03	.188	.3750-28 UNJS	.154- .164	.323- .329	.318	.369- .375	.501	3°00'	.137	.649	.094	.568	.621- .628
04	.250	.4375-24 UNJS	.184- .194	.377- .383	.373	.431- .438	.583	8°30'	.147	.743	.094	.680	.684- .691
05	.312	.5000-24 UNJS	.232- .242	.440- .446	.436	.493- .500	.583	8°30'	.150	.743	.094	.680	.746- .753
06	.375	.5625-20 UNJS	.297- .307	.490- .497	.488	.555- .563	.603	8°30'	.173	.782	.094	.719	.809- .816
08	.500	.7188-20 UNJS	.398- .408	.646- .654	.644	.711- .719	.629	8°30'	.186	.849	.125	.755	.996-1.003
10	.625	.8438-18 UNJS	.512- .523	.763- .772	.762	.835- .844	.755	8°30'	.196	.988	.125	.894	1.121-1.128
12	.750	1.0000-16 UNJ	.649- .660	.910- .919	.910	.991-1.000	.833	8°30'	.221	1.084	.125	.990	1.371-1.378
14	.875	1.1250-16 UNJ	.769- .780	1.034-1.044	1.035	1.116-1.125	.885	8°30'	.221	1.136	.125	1.042	1.609-1.641
16	1.000	1.2500-14 UNJS	.862- .874	1.148-1.158	1.149	1.240-1.250	.925	8°30'	.223	1.176	.125	1.082	1.609-1.641
20	1.250	1.5781-14 UNJS	1.115-1.128	1.476-1.486	1.477	1.568-1.578	.919	8°30'	.223	1.170	.125	1.076	1.859-1.891
24	1.500	1.8438-14 UNJS	1.324-1.337	1.741-1.751	1.742	1.834-1.844	1.089	8°30'	.223	1.340	.125	1.246	2.105-2.145

NOTES:

- DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS ±.010; ANGLES ±.5°.
- REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
- ALL MACHINED SURFACES SHALL BE SMOOTH TO 125 MICRONS Ra PER ASME B46.1 EXCEPT AS NOTED HEREIN.
- SEALING SURFACE SHALL BE FREE FROM LONGITUDINAL AND SPIRAL TOOL MARKS AND SHALL BE SMOOTH TO 45 MICRONS Ra PER ASME B46.1.
- SEALING SURFACE SHALL BE COATED WITH SOLID FILM LUBRICANT PER MIL-PRF-46010 OR AS5272 TYPE III. OVERSPRAY IN BORE IS NOT PERMITTED.
- DIMENSIONS A, B, C, D, AND T (PITCH DIA) SHALL BE CONCENTRIC TO EACH OTHER WITH F° ANGLE, MEASURED AND CALCULATED AS AN INCLUDED ANGLE, WITHIN .005 FIM.

	<b>AEROSPACE STANDARD</b>	<b>AS85421/2</b> SHEET 2 OF 3	<b>REV.</b> <b>B</b>
	(R) FITTING END, STANDARD DIMENSIONS FOR, BULKHEAD, DYNAMIC BEAM SEAL, MALE		