

AS85421/6

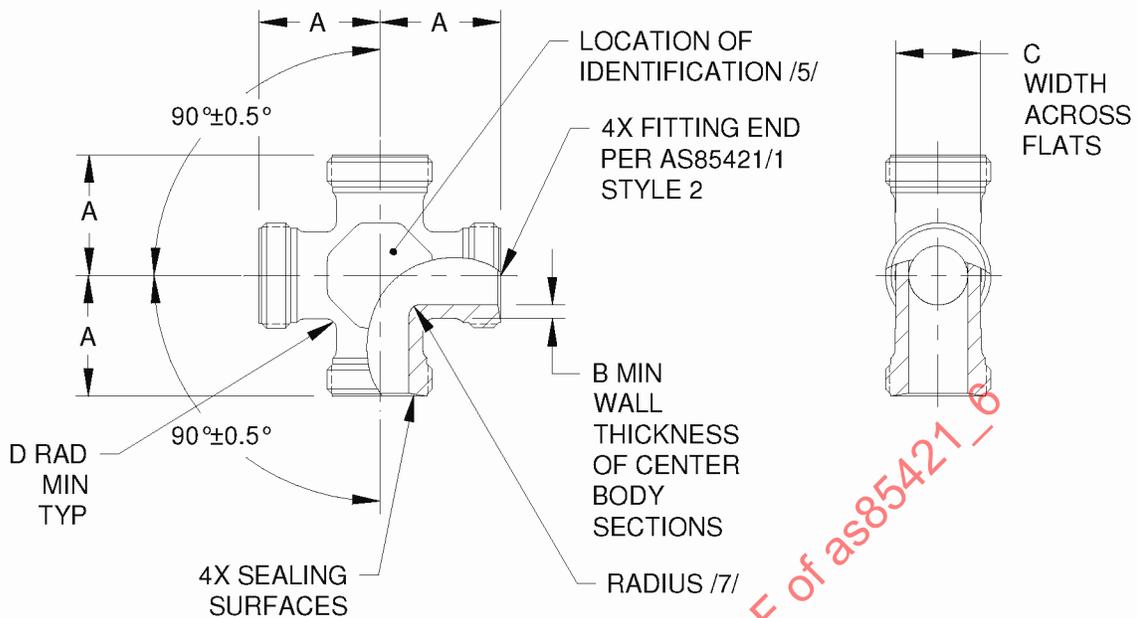


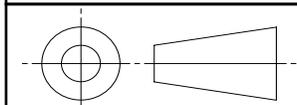
FIGURE 1 - FITTING, CROSS

TABLE 1

BASIC NO. AS85421/6						WEIGHT LB/100 APPROX	WEIGHT LB/100 APPROX
SIZE /15/ CODE	TUBE O.D.	A	B	C	D	TI REF	CRES REF
03	.188	.575	.055	.360 - .377	.042	3.03	5.31
04	.250	.617	.060	.360 - .377	.042	3.48	6.09
05	.312	.653	.060	.423 - .440	.042	4.59	8.04
06	.375	.704	.060	.485 - .502	.042	5.71	9.98
08	.500	.824	.065	.547 - .565	.070	8.14	14.20
10	.625	.955	.070	.673 - .691	.070	12.40	21.70
12	.750	1.065	.095	.860 - .878	.098	19.40	33.90
14	.875	1.216	.105	1.110 - 1.128	.098	35.30	61.70
16	1.000	1.246	.110	1.110 - 1.128	.098	33.60	58.90
20	1.250	1.387	.110	1.355 - 1.380	.098	51.10	83.40
24	1.500	1.688	.130	1.605 - 1.630	.098	85.30	149.00



THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: AS85421 /4/



**AEROSPACE STANDARD**

FITTING, CROSS,  
BEAM SEAL,  
3000/4000 PSI, MALE ENDS

**AS85421/6**  
SHEET 1 OF 3

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ISSUED 2005-09

## NOTES:

## /1/ MATERIAL:

- a. CODE LETTER P – TYPE 17-4PH CORROSION RESISTANT STEEL BAR OR FORGING PER AMS 5643.
- b. CODE LETTER T – TYPE 6AL-4V TITANIUM ALLOY BAR OR FORGING PER AMS 4965.
- c. CODE LETTER V – TYPE 15-5PH CORROSION RESISTANT STEEL BAR OR FORGING 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 – CONDITION H1075 PER AMS-H-6875 OR AMS 2759/3.

## 3. FINISH:

- a. MATERIAL CODE LETTER P – PASSIVATE PER AMS 2700, TYPE 6 OR 7.
- b. MATERIAL CODE LETTER T – NONE.
- c. MATERIAL CODE LETTER V – PASSIVATE PER AMS 2700, TYPE 6 OR 7.

/4/ PROCUREMENT SPECIFICATION: AS85421 EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PRODUCT SHALL BE QUALIFIED IN ACCORDANCE WITH SPECIFICATION AS85421. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER LISTED IN PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED MANUFACTURER LIST (QML) FOR THIS TYPE PRODUCT. THE QML IS AVAILABLE AT [www.eauditnet.com](http://www.eauditnet.com).

/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. INTENDED USE: THIS PART IS DESIGNED FOR USE IN SYSTEMS WITH MAXIMUM OPERATING PRESSURES AS FOLLOWS:

- a. CORROSION RESISTANT STEEL AT 3000 PSI MAX.
- b. TITANIUM ALLOY AT 4000 PSI MAX.

/7/ .030 MIN. RADIUS UNLESS QUALIFICATION OF SPECIAL PROCESS WITH SMALLER RADIUS, APPLICABLE FOR TITANIUM ALLOY PARTS ONLY.

8. DRY FILM LUBRICANT: APPLY DRY FILM LUBRICANT PER AS5272, TYPE I TO SEALING SURFACE. OVERSPRAY IN BORE IS NOT PERMITTED.