

RATIONALE

AS931B HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

REV.
B

SAE AS931

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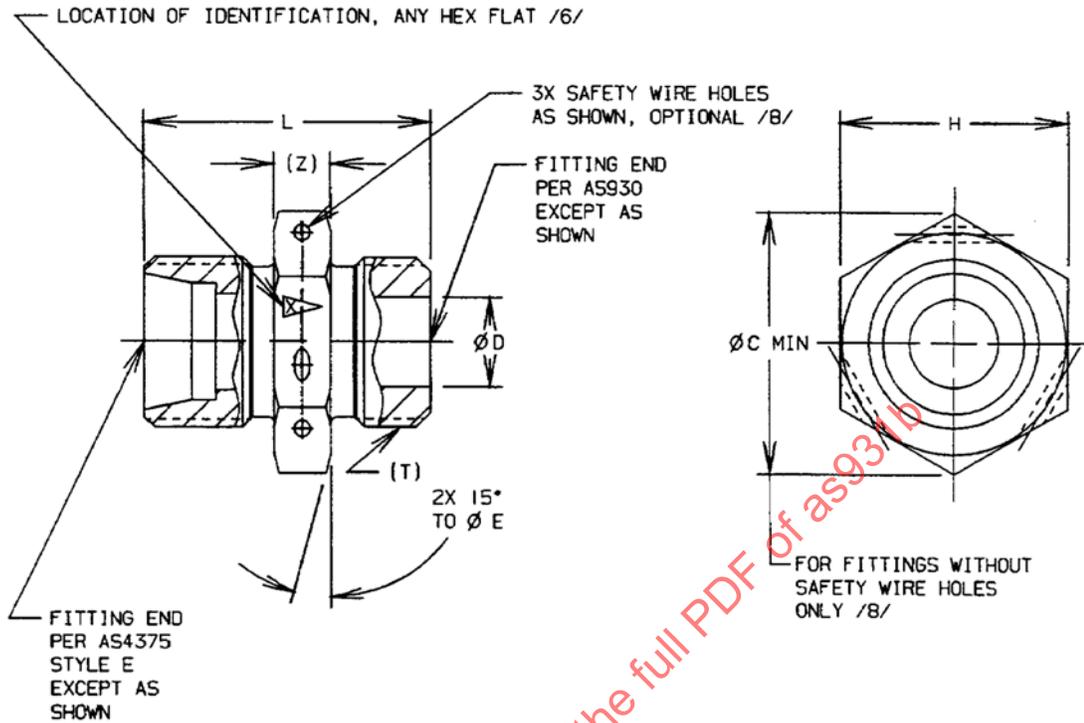


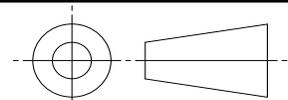
FIGURE 1 - FITTING ADAPTER, UNION

TABLE 1A - DIMENSIONS

BASIC NO. AS931 /15/ SIZE CODE	(NOMINAL TUBE SIZE)	T THREAD PER MIL-S-8879	C	D ±.003	E ±.010
02	.125	.3125-24 UNJF	.638	.093	.542
03	.188	.3750-24 UNJF	.709	.125	.605
04	.250	.4375-20 UNJF	.780	.187	.668
05	.312	.5000-20 UNJF	.851	.234	.730
06	.375	.5625-18 UNJF	.922	.297	.792
08	.500	.7500-16 UNJF	1.120	.422	.980
10	.625	.8750-14 UNJF	1.260	.500	1.103
12	.750	1.0625-12 UNJ	1.540	.656	1.353
16	1.000	1.3125-12 UNJ	1.788	.875	1.603
20	1.250	1.6250-12 UNJ	2.063	1.093	1.853
24	1.500	1.8750-12 UNJ	2.338	1.344	2.099
32	2.000	2.5000-12 UNJ	3.025	1.813	2.724

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS931B>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS4444

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

FITTING, ADAPTER, UNION,
FLARELESS TO BOSS

SAE AS931
SHEET 1 OF 3

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TABLE 1B - DIMENSIONS AND WEIGHTS

BASIC NO. AS931 /15/ SIZE CODE	H	L	Z	LB/EA MAX AL	LB/EA MAX STEEL	LB/EA MAX TI
02	.552- .565	.955	.220	.0111	.0318	.0175
03	.615- .628	1.002	.220	.0148	.0426	.0235
04	.678- .691	1.088	.235	.0193	.0553	.0305
05	.740- .753	1.088	.235	.0232	.0666	.0367
06	.802- .815	1.119	.250	.0272	.0781	.0431
08	.990-1.003	1.252	.250	.0482	.138	.0764
10	1.113-1.128	1.377	.312	.0704	.202	.111
12	1.363-1.380	1.543	.375	.113	.325	.179
16	1.613-1.630	1.543	.375	.153	.439	.242
20	1.863-1.880	1.543	.375	.214	.614	.339
24	2.109-2.135	1.543	.375	.255	.733	.404
32	2.734-2.760	1.605	.437	.464	1.33	.735

NOTES:

- 1/ MATERIAL:
- a. DASH AS CODE LETTER - TYPE 4130 CARBON STEEL BAR PER MIL-S-6758 OR AMS 6370. TYPES 1137 AND 1141 CARBON STEEL ARE SUPERSEDED BY TYPE 4130. /2/
 - b. CODE LETTER D - TYPE 2024-T6 ALUMINUM ALLOY BAR PER QQ-A-225/6 OR AMS 4112 OR TYPE 2024-T851 ALUMINUM ALLOY BAR PER QQ-A-225/6. /2/
 - c. CODE LETTER J - TYPE 304 CORROSION RESISTANT STEEL BAR PER QQ-S-763 OR AMS 5639.
 - d. CODE LETTER K - TYPE 316 CORROSION RESISTANT STEEL BAR PER QQ-S-763 OR AMS 5648.
 - e. CODE LETTER R - TYPE 321 CORROSION RESISTANT STEEL BAR PER QQ-S-763 OR AMS 5645. /7/
 - f. CODE LETTER S - TYPE 347 CORROSION RESISTANT STEEL BAR IS INACTIVE FOR DESIGN AND SUPERSEDED BY TYPE 321 CORROSION RESISTANT STEEL (CODE LETTER R). /7/
 - g. CODE LETTER T - TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS 4928.
 - h. CODE LETTER W - TYPE 7075-T73 ALUMINUM ALLOY BAR PER QQ-A-225/9 OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS 4124. /2/
- 2/ HEAT TREATMENT:
- a. DASH AS CODE LETTER - SEE HARDNESS REQUIREMENT PER PROCUREMENT SPECIFICATION.
 - b. CODE LETTERS D AND W - SEE ELECTRICAL CONDUCTIVITY AND HARDNESS REQUIREMENT PER PROCUREMENT SPECIFICATION.
 - c. OTHER CODE LETTERS - NONE.
3. FINISH:
- a. DASH AS CODE LETTER - CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2 AND COAT WITH A LIGHT FILM OF OIL PER PROCUREMENT SPECIFICATION.
 - b. CODE LETTER D - ANODIZE PER MIL-A-8625, TYPE II, CLASS 2, DYED GREEN PER PROCUREMENT SPECIFICATION.
 - c. CODE LETTERS J, K, AND R - PASSIVATE PER QQ-P-35, TYPE VI OR VII.
 - d. CODE LETTER T - ANODIZE PER AMS 2488 OR FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486 WITH COLOR PER PROCUREMENT SPECIFICATION.
 - e. CODE LETTER W - ANODIZE PER MIL-A-8625, TYPE II, CLASS 2, DYED BROWN PER PROCUREMENT SPECIFICATION.
- 4/ PROCUREMENT SPECIFICATION: AS4444 EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION IN A COMPLETE ASSEMBLY AS APPLICABLE. THE AS930 FITTING END SHALL MEET THE APPLICABLE REQUIREMENTS OF AS4875. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.
5. INTENDED USE: THIS PART IS DESIGNED FOR USE IN SYSTEMS WITH MAXIMUM OPERATING PRESSURES AS FOLLOWS:
- a. SIZES 02 THROUGH 10 AT 3000 psi.
 - b. SIZES 12 THROUGH 20 IN ALUMINUM ALLOY AND SIZES 12 THROUGH 32 IN OTHER MATERIALS AT 1500 psi.
 - c. SIZE 24 IN ALUMINUM ALLOY AT 1000 psi.
 - d. SIZE 32 IN ALUMINUM ALLOY AT 600 psi.
- 6/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C, D OR METHOD 7A3, 15A3, OR 15B. MARK MANUFACTURER'S NAME, TRADEMARK OR CAGE NUMBER, LETTERS "AS" FOR SIZES 06 AND SMALLER AND "AS931" FOR SIZES 08 AND LARGER AND MATERIAL CODE LETTER.
- 7/ INVENTORIED PARTS CONFORMING TO THE PREVIOUS "LETTER CHANGE" MAY BE USED TO DEPLETION. PARTS FORMERLY CODED "S" MAY BE SUPPLIED IN PLACE OF PARTS CODED "R" UNTIL STOCK IS DEPLETED.
- 8/ SUFFIX LETTER L: CODE L PARTS SHALL HAVE SAFETY WIRE HOLES PER AS1043 STYLE B.