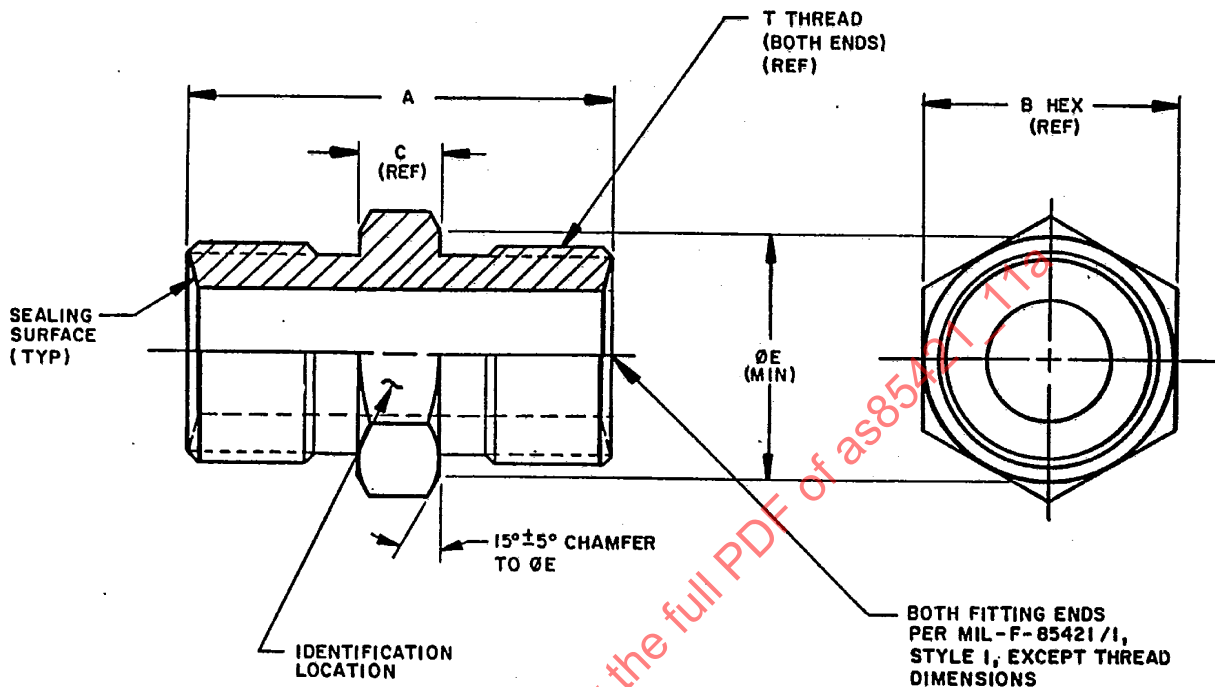


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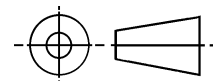
AS85421/11

FEDERAL SUPPLY CLASS
4730

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



THIRD ANGLE PROJECTION



PREPARED BY SAE COMMITTEE G-3

PROCUREMENT SPECIFICATION: AS85421

SAE The Engineering Society
For Advancing Mobility
Land Sea Air and Space
INTERNATIONAL
400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARD

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

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TABLE I. DIMENSIONAL DATA

Dash No.	Tube O.D.	T Thread MIL-S-8879 (Ref)	A	B (Ref)	C (Ref)	ØE (Min)	Wt Lbs (Max)	
							Ti	Cres
-03	.188	.3750-28UNJS-3A	.637	.375	.156	.350	.017	.030
-04	.250	.4375-24UNJS-3A	.727	.438	.162	.413	.018	.031
-05	.312	.5000-24UNJS-3A	.739	.500	.174	.475	.021	.037
-06	.375	.5625-20UNJS-3A	.793	.562	.188	.537	.025	.045
-08	.500	.7188-20UNJS-3A	.873	.750	.242	.725	.041	.072
-10	.625	.8438-18UNJS-3A	1.051	.875	.292	.850	.073	.130
-12	.750	1.0000-16UNJ-3A	1.139	1.000	.300	.975	.102	.180
-14	.875	1.1250-16UNJ-3A	1.181	1.125	.306	1.100	.113	.200
-16	1.000	1.2500-14UNJS-3A	1.307	1.250	.372	1.225	.138	.244
-20	1.250	1.5781-14UNJS-3A	1.341	1.625	.412	1.600	.178	.316
-24	1.500	1.8438-14UNJS-3A	1.537	1.875	.438	1.850	.262	.463

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 paragraph 6.9 in the procurement specification for additional information.

REQUIREMENTS:

- Materials: Titanium Alloy } See procurement
Corrosion Resistant Steel } specification
- Finish: Titanium: Fluoride phosphate coat per AMS 2486.
Corrosion Resistant Steel: Surface shall be treated and passivated per QQ-P-35.

NOTES:

- Dimensions are in inches. Unless otherwise specified, tolerances: decimals $\pm .015$.
- Remove all burrs and break all sharp edges.
- All machined surfaces shall be smooth to 125 microinches R_a per ANSI/ASME B46.1 unless otherwise specified.