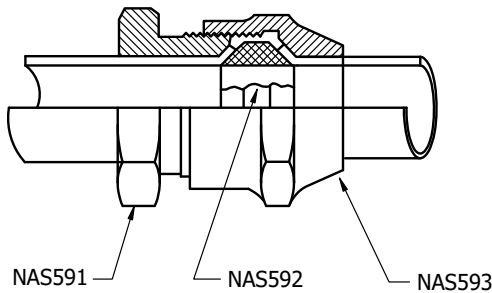
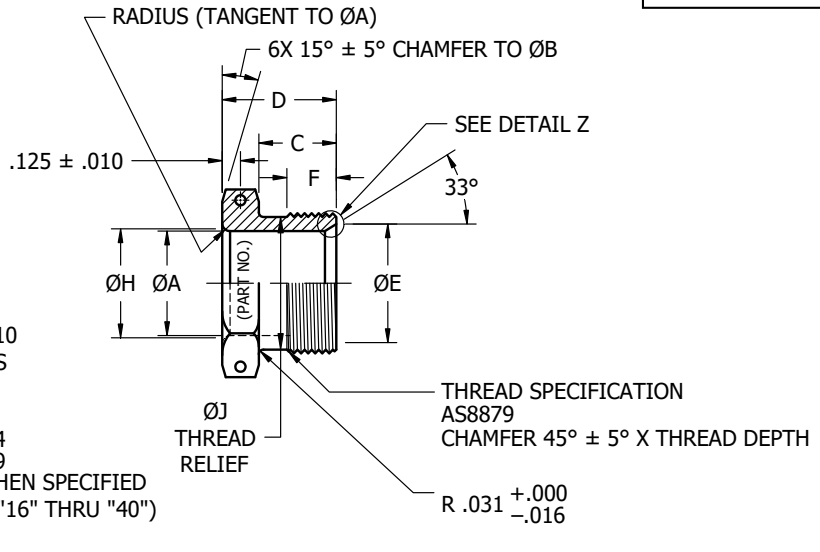
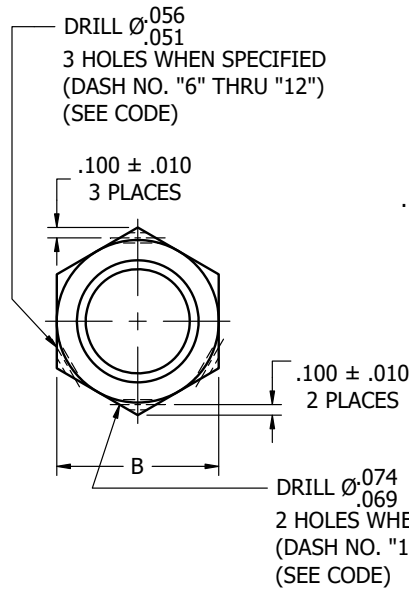
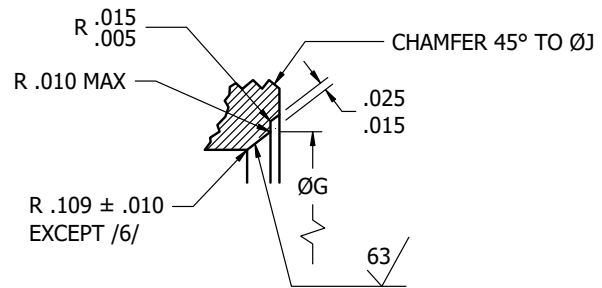


FED. SUPPLY CLASS

4730



CONNECTOR ASSEMBLY
(REF)



DETAIL Z

⑦

TABLE I - DIMENSIONS

DASH NO.	TUBE O.D.	THREAD SIZE	ØA I.D. +.003 - .000	B HEXAGON SIZE	C ± .010	D LENGTH ± .010	ØE FLARE	F THREAD LENGTH ± .020	ØG FLARE STEP ± .005	ØH RADIUS CENTER	WT. (MAX) LB	J ± .005
4	.250	.4375-20 UNJF-3A	.255	.562	± .010	.300	.500	.315	± .002	.230	.0075	.359
5	.313	.5000-20 UNJF-3A	.317	.625		.300	.500	.377		.230	.0082	.421
6	.375	.5625-18 UNJF-3A	.380	.688		.300	.500	.440		.230	.0087	.476
8	.500	.7500-16 UNJF-3A	.505	.875	± .012	.394	.660	.589	± .005	.227	.019	.654
10	.625	.8750-14 UNJF-3A	.632	1.125		.547	.813	.730		.390	.030	.767
12	.750	1.0625-12 UNJ-3A	.757	1.250	± .016	.547	.813	.906		.380	.042	.938
16	1.000	1.3125-12 UNJ-3A	1.012	1.500		.547	.813	1.156		.380	.050	1.188
20	1.250	1.6250-12 UNJ-3A	1.262	1.750		.506	.750	.8/		.339	.065	1.501
24	1.500	1.8750-12 UNJ-3A	1.512	2.000	± .020	.531	.813	1.653	± .005	.364	.080	1.750
28	1.750	2.2500-12 UNJ-3A	1.764	2.500		.531	.906	.8/		.365	.174	2.125
32	2.000	2.5000-12 UNJ-3A	2.014	2.750		.531	.906	.8/		.365	.200	2.375
40	2.500	3.0000-12 UNJ-3A	2.514	3.375		.531	.906	.8/		.365	.270	2.882

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 7
PROCUREMENT SPECIFICATION NAS597	TITLE COUPLING, RIGID TUBE CONNECTOR, ALUMINUM	CLASSIFICATION PART STANDARD

THIRD ANGLE PROJECTION		CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 7
PROCUREMENT SPECIFICATION NAS597		TITLE COUPLING, RIGID TUBE CONNECTOR, ALUMINUM	CLASSIFICATION PART STANDARD

THIRD ANGLE PROJECTION		CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 7
PROCUREMENT SPECIFICATION NAS597		TITLE COUPLING, RIGID TUBE CONNECTOR, ALUMINUM	CLASSIFICATION PART STANDARD

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209

THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST REVISION DATE.

FORM 12-01

REVISION DATE: JANUARY 31, 2017

ISSUE DATE: AUGUST 1955

MATERIAL:

ALUMINUM ALLOY PER PROCUREMENT SPECIFICATION.

FINISH:

PER PROCUREMENT SPECIFICATION.

CODE:

- ⑦ ADD "H" AFTER DASH NUMBER FOR COUPLING WITH DRILLED HEXAGON.

EXAMPLES OF PART NUMBERS:

NAS591-16 = ALUMINUM COUPLING WITHOUT DRILLED HEXAGON FOR 1 INCH TUBE
 NAS591-16H = ALUMINUM COUPLING WITH DRILLED HEXAGON FOR 1 INCH TUBE

NOTES:

- (1) REMOVE ALL BURRS AND SHARP EDGES.
- (2) NO PORTION OF COUPLING TO BE LARGER IN DIAMETER THAN ACROSS CORNERS OF HEXAGON.
- (3) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (4) ~~SURFACE MAKING CONTACT WITH TUBING FLARE SHALL BE FREE FROM BURRS, LONGITUDINAL FLATS, LONGITUDINAL AND SPIRAL TOOL MARKS, EXCEPT THAT ANNULAR TOOL MARKS WILL BE ALLOWED IF 90% OF CONTACT AREA IS INDICATED BY BLUEING METHOD OF INSPECTION.~~
- (5) SURFACE ROUGHNESS: FOR MACHINED SURFACE EXCEPT FLARE CONTACT AREA OF COUPLING: 125 MICROINCHES Ra PER ASME B46.1. SURFACE TEXTURE SYMBOLS SHALL BE IN ACCORDANCE WITH ASME Y14.36M.
- /6/ DASH NO. "4" = R .032; "5" = R .046; "6" = R .062; "8" = R .094; "40" = R .130
- /7/ CONE NOT STEPPED
- /8/ CONE STEPPED
- (9) TOLERANCES UNLESS OTHERWISE SPECIFIED: ANGLES $\pm 0^{\circ}30'$.
- (10) ENGINEERING INFORMATION: TO BE USED WITH TUBING FLARE THICKNESSES OF .010 TO .065.
- (11) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (12) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (13) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- (14) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

REVISION

7

NAS591
 SHEET 2



Document Sharing Hub