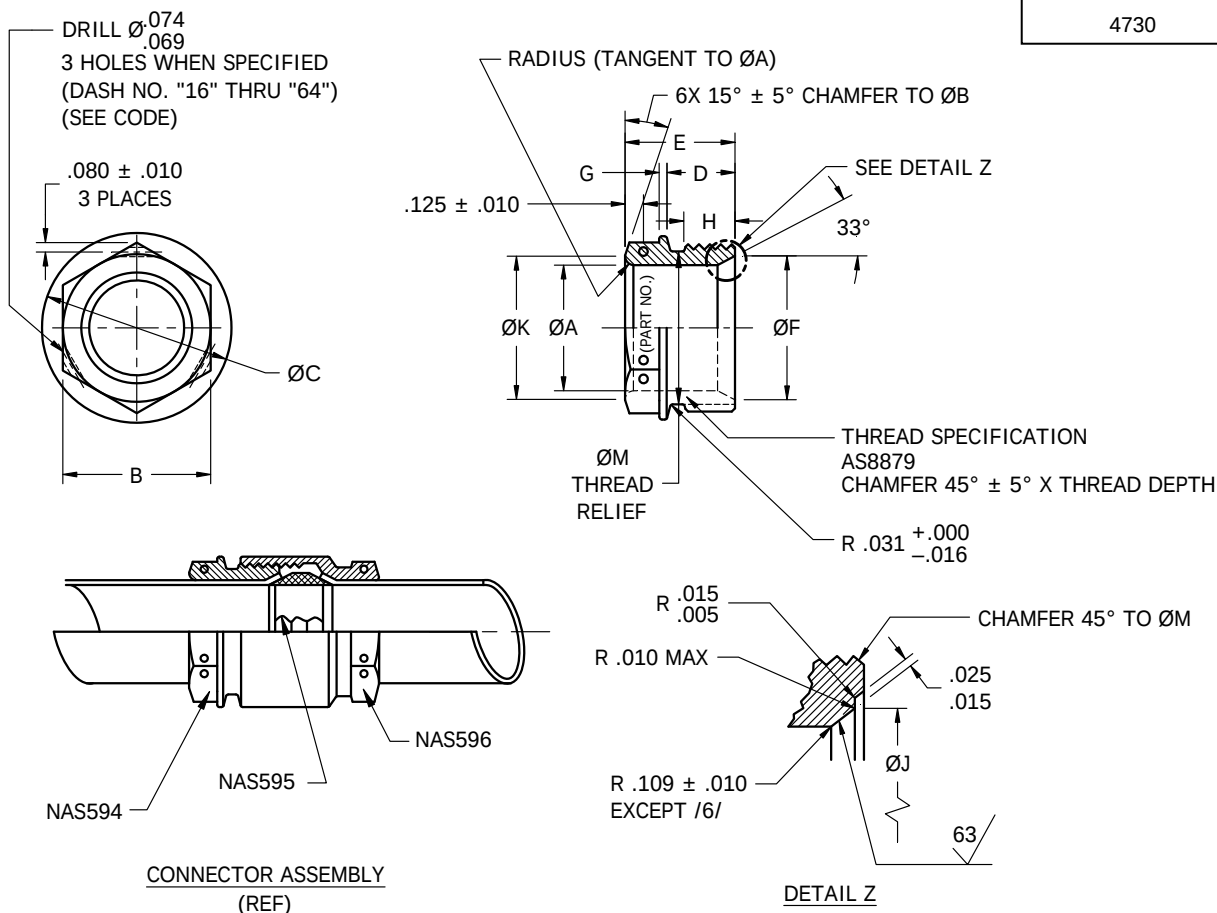


FED. SUPPLY CLASS

4730



6 COMPLETELY REVISED

TABLE I - DIMENSIONS

DASH NO.	TUBE O.D.	THREAD SIZE	ØA I.D. +.003 -.000	B HEXAGON SIZE	ØC ±.005	D ±.010	E LENGTH ±.03	ØF FLARE ±.005	G FLARE THKNS ±.010	H THREAD LENGTH ±.020	ØJ FLARE STEP ±.005	ØK OF RAD CENTER ±.010	WT LBS MAX	M ±.005	
4	1/4	.4375-20 UNJF-3A	.255	.340	±.010	.478	.298	.610	.315 /9/	.062	.228	/7/	.280	.015	.359
5	5/16	.5000-20 UNJF-3A	.317	.402		.568	.298	.610	.377 /9/	.062	.228	/7/	.342	.015	.421
6	3/8	.5625-18 UNJF-3A	.380	.465		.658	.298	.610	.441 /9/	.062	.228	/7/	.405	.018	.476
8	1/2	.7500-16 UNJF-3A	.505	.590		.858	.298	.610	.589 /9/	.062	.228	/7/	.530	.025	.654
10	5/8	.8750-14 UNJF-3A	.631	.750		1.031	.516	.813	.730	.062	.294	/7/	.690	.045	.767
12	3/4	1.0625-12 UNJ-3A	.755	.875	±.016	1.156	.516	.813	.906	.062	.294	/7/	.815	.060	.938
16	1	1.3125-12 UNJ-3A	1.020	1.125		1.406	.516	.813	1.169	.062	.294	/7/	1.065	.100	1.188
20	1 1/4	1.6250-12 UNJ-3A	1.270	1.375		1.719	.516	.844	1.469	.062	.294	/7/	1.315	.105	1.501
24	1 1/2	1.8750-12 UNJ-3A	1.520	1.625		1.984	.516	.844	1.719	.062	.294	/7/	1.565	.110	1.750
28	1 3/4	2.2500-12 UNJ-3A	1.772	1.875		2.344	.536	.906	2.084	.109	.314	/7/	1.815	.200	2.125
32	2	2.5000-12 UNJ-3A	2.020	2.125	±.020	2.594	.536	.906	/8/	.109	.314	2.203	2.065	.250	2.375
40	2 1/2	3.0000-12 UNJ-3A	2.520	2.625		3.094	.536	.906	/8/	.109	.314	2.703	2.565	.280	2.882
48	3	3.5000-12 UNJ-3A	3.014	3.125		3.594	.536	.906	/8/	.109	.314	3.203	3.065	.355	3.382
64	4	4.5000-12 UNJ-3A	4.020	4.250		4.609	.606	.906	/8/	.109	.384	4.203	4.136	.605	4.382

THIRD ANGLE PROJECTION

CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION
6

PROCUREMENT SPECIFICATION

TITLE

6

CLASSIFICATION
PART STANDARD

NAS597

COUPLING, RIGID TUBE CONNECTOR, CRES

NAS597
SHEET 1 OF 2



Documents
Document Sharing Hub

MATERIAL:

CRES. SEE PROCUREMENT SPECIFICATION.

FINISH:

SEE PROCUREMENT SPECIFICATION.

CODE:

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

EXAMPLES OF PART NUMBER:

NAS594-16 = CRES COUPLING WITHOUT DRILLED HEXAGON FOR 1 INCH TUBE

NAS594-16H = CRES COUPLING WITH DRILLED HEXAGON FOR 1 INCH TUBE

NOTES:

- (1) REMOVE ALL BURRS AND SHARP EDGES.
- (2) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (3) TOLERANCES UNLESS OTHERWISE SPECIFIED: ANGLES $\pm 0^{\circ}30'$.
- (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: MACHINED SURFACE EXCEPT FLARE CONTACT AREA OF COUPLING, 125 MICROINCHES Ra PER ASME B46.1. SURFACE ROUGHNESS SYMBOLS SHALL BE IN ACCORDANCE WITH ASME Y14.36.
- /6/ "-4" = R .032; "-5" = R .032; "-6" = R .047; "-8" = R .062.
- /7/ CONE NOT STEPPED.
- /8/ CONE STEPPED.
- /9/ TOLERANCE: +.002, -.000.
- (10) ENGINEERING INFORMATION:
 - (A) TO BE USED WITH TUBING FLARE THICKNESSES OF .010 TO .065 INCHES EXCEPT "-64" WHICH IS .010 TO .080 INCHES.
 - (B) DO NOT USE AT TEMPERATURE IN EXCESS OF 700 °F.
- (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
6
NAS594
SHEET 2

⑥ COMPLETELY REVISED