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REV.
E

AS4210™

FEDERAL SUPPLY CLASS
4730

RATIONALE

REMOVE "DUAL" PROCUREMENT SPECIFICATION REQUIREMENTS BY REMOVING AS85720 AND 5000 PSI PRESSURE REQUIREMENTS. MAKE REFERENCE TO AS8528 (5000 PSI) ALTERNATIVE.

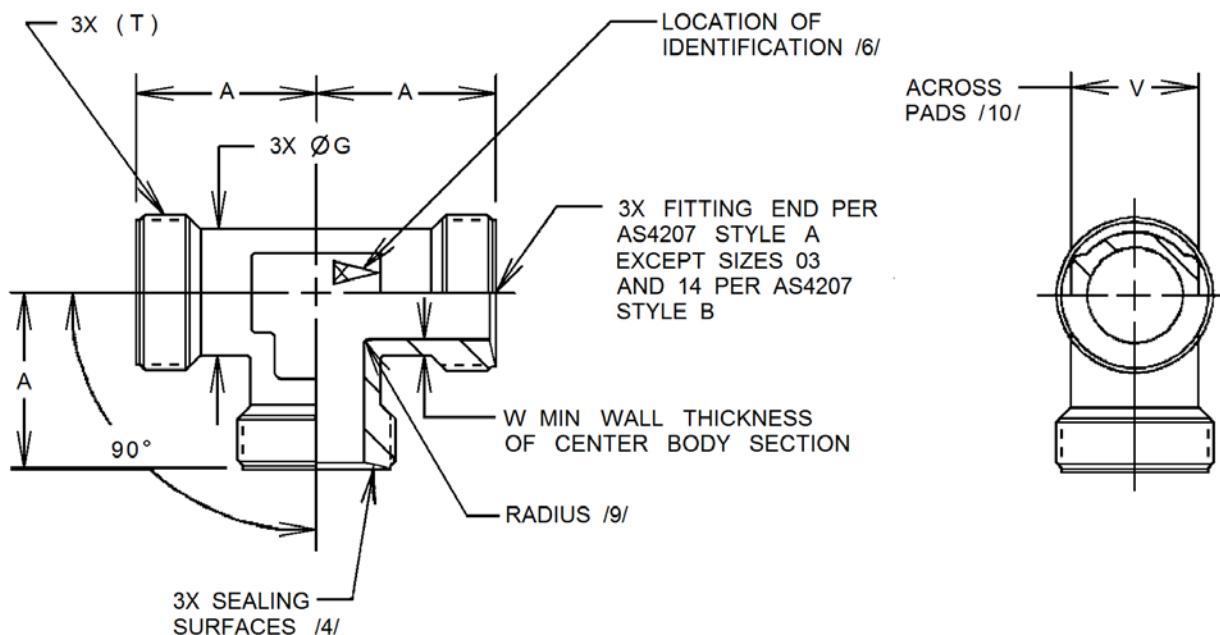


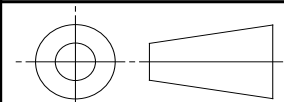
FIGURE 1 - FITTING, TEE

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4210 /18/ SIZE CODE	(NOMINAL TUBE SIZE)	T THREAD PER AS8879 CLASS A	A	G MIN	V1 /10/	V2 /10/	W	LB/EA APPROX REF CRES	LB/EA APPROX REF TI
03	.188	.3750-28 UNJS	.575	.285	.360-.377	.375	.055	.0419	.0239
04	.250	.4375-24 UNJS	.617	.329	.360-.377	.375	.060	.0476	.0272
05	.312	.5000-24 UNJS	.653	.391	.423-.440	.438	.060	.0631	.0361
06	.375	.5625-20 UNJS	.704	.454	.485-.502	.500	.060	.0787	.0450
08	.500	.7188-20 UNJS	.824	.547	.547-.565	.562	.065	.111	.0632
10	.625	.8438-18 UNJS	.955	.673	.673-.691	.688	.070	.168	.0963
12	.750	1.0000-16 UNJ	1.062	.860	.860-.878	.875	.095	.267	.152
14	.875	1.1250-16 UNJ	1.216	1.110	1.110-1.128	1.125	.105	.498	.284
16	1.000	1.2500-14 UNJS	1.246	1.110	1.110-1.128	1.125	.110	.464	.265
20	1.250	1.5781-14 UNJS	1.387	1.360	1.355-1.380	1.375	.110	.700	.400
24	1.500	1.8438-14 UNJS	1.688	1.610	1.605-1.630	1.625	.130	1.17	.666

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on this Technical Report, please visit
<http://standards.sae.org/AS4210E>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS85421 /5/



AEROSPACE STANDARD

(R) FITTING, TEE, BEAM SEAL

AS4210™
SHEET 1 OF 3

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NOTES:

/1/ MATERIAL:

- a. CODE LETTER T - TYPE 6Al-4V TITANIUM ALLOY FORGING OR BAR PER AMS4965.
- b. CODE LETTER P - TYPE 17-4PH CORROSION RESISTANT STEEL FORGING OR BAR PER AMS5643.
- c. CODE LETTER V - TYPE 15-5PH CORROSION RESISTANT STEEL FORGING OR BAR PER AMS5659.

2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER T - NONE.
- b. MATERIAL CODE LETTERS P AND V - HEAT TREAT TO CONDITION H 1075 PER AMS2759/3.

3. FINISH:

- a. MATERIAL CODE LETTER T - NONE.
- b. MATERIAL CODE LETTERS P AND V - PASSIVATE PER AMS2700, TYPE 2 OR 8.

/4/ SOLID FILM LUBRICANT: APPLY SOLID FILM LUBRICANT PER AS5272, TYPE I TO SEALING SURFACE. OVERSPRAY IN BORE IS NOT PERMITTED.

/5/ PROCUREMENT SPECIFICATION: AS85421 FOR OPERATING PRESSURES TO 4000 PSI, EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION AS APPLICABLE IN A COMPLETE ASSEMBLY. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY THE ACCREDITED MANUFACTURER LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCT LIST (QPL) PRI-QPL-AS85421 AS APPLICABLE FOR THIS STANDARD. REFER TO www.eAuditNet.com FOR CURRENT QPL ONLINE.

/6/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B. /7/

- a. FOR SIZES 06 (.375 OD TUBE SIZE) AND SMALLER: MANUFACTURER'S NAME OR TRADEMARK, MATERIAL CODE LETTER, AND MAXIMUM PRESSURE RATING. (EXAMPLE: 4K = 4000 PSI.)
- b. FOR SIZES 08 (.500 OD TUBE SIZE) AND LARGER: MANUFACTURER'S NAME OR TRADEMARK, BASIC PART NUMBER, MATERIAL CODE LETTER, AND MAXIMUM PRESSURE RATING. (EXAMPLE: 4K = 4000 PSI.)

/7/ THIS PART IS DESIGNED FOR USE IN SYSTEMS WITH MAXIMUM OPERATING PRESSURES AS FOLLOWS:

- a. SIZES 03 THROUGH 16 AT 4000 PSI.
- b. SIZE 20 AT 3000 PSI.
- c. SIZE 24 AT 2000 PSI.
- d. FOR OPERATING PRESSURES UP TO 5000 PSI, REFER TO AS8528.

8. WHEN MACHINED FROM BAR OR OVERSIZED FORGINGS, THE CENTER BODY SECTION SHALL CONFORM TO AS1376, TABLE 4.

/9/ .030 TO .125 RADIUS UNLESS QUALIFICATION OF SPECIAL PROCESS WITH SMALLER RADIUS. APPLICABLE FOR TITANIUM ALLOY PARTS ONLY.

/10/ DIMENSIONS FOR V1 AS SHOWN ARE PREFERRED BUT PREVIOUS INDUSTRY DIMENSIONS OF $V2 \pm .015$ MAY BE USED UNTIL FORGING DIES ARE REWORKED AND FORGING STOCKS ARE DEPLETED.

11. REVISION INDICATOR: A CHANGE BAR (I) LOCATED IN THE LEFT MARGIN IS FOR THE CONVENIENCE OF THE USER IN LOCATING AREAS WHERE TECHNICAL REVISIONS, NOT EDITORIAL CHANGES, HAVE BEEN MADE TO THE PREVIOUS ISSUE OF THIS DOCUMENT. AN (R) SYMBOL TO THE LEFT OF THE DOCUMENT TITLE INDICATES A COMPLETE REVISION OF THE DOCUMENT, INCLUDING TECHNICAL REVISIONS. CHANGE BARS AND (R) ARE NOT USED IN ORIGINAL PUBLICATIONS, NOR IN DOCUMENTS THAT CONTAIN EDITORIAL CHANGES ONLY.

12. INVENTORIED PARTS CONFORMING TO THE PREVIOUS "LETTER CHANGE" MAY BE USED TO DEPLETION.

13. INTERPRETATION OF DRAWING PER AS4296.

	AEROSPACE STANDARD	AS4210™ SHEET 2 OF 3	REV. F
	(R) FITTING, TEE, BEAM SEAL		



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