

RATIONALE

FEDERAL SUPPLY CLASS
4730

1. FIX TYPOS, RETYPE TABLES, REVISE GRAPHICS AND GENERAL UPDATES.
2. REVISE NOTE 5 TO CHANGE PROCUREMENT SPECIFICATIONS AND TO CLARIFY QPL REQUIREMENTS. FOR THE REDUCED WELD WALL THICKNESS FITTINGS SHOWN IN TABLE 2B (SIZE 03-018, 08-022, ETC...), REFER TO AS4510/2 FOR REDUCED PRESSURE TESTING (LESS THAN AS85421) QUALIFICATION REQUIREMENTS.
3. REVISE TABLE 1 AND 2 TO CLARIFY PROCUREMENT SPECIFICATION, MATERIAL, RECOMMENDED OPERATING PRESSURES AND APPLICABLE SIZE AND TUBE WALL CODES.
4. SIZE 03-018 WAS INCORRECTLY RATED AT 5000 PSI, CHANGE TO 3000 PSI IN BOTH CRES AND TITANIUM TO MATCH PROCUREMENT SPECIFICATION. USERS SHOULD USE SIZE 03-022 FOR 5000 PSI APPLICATIONS.

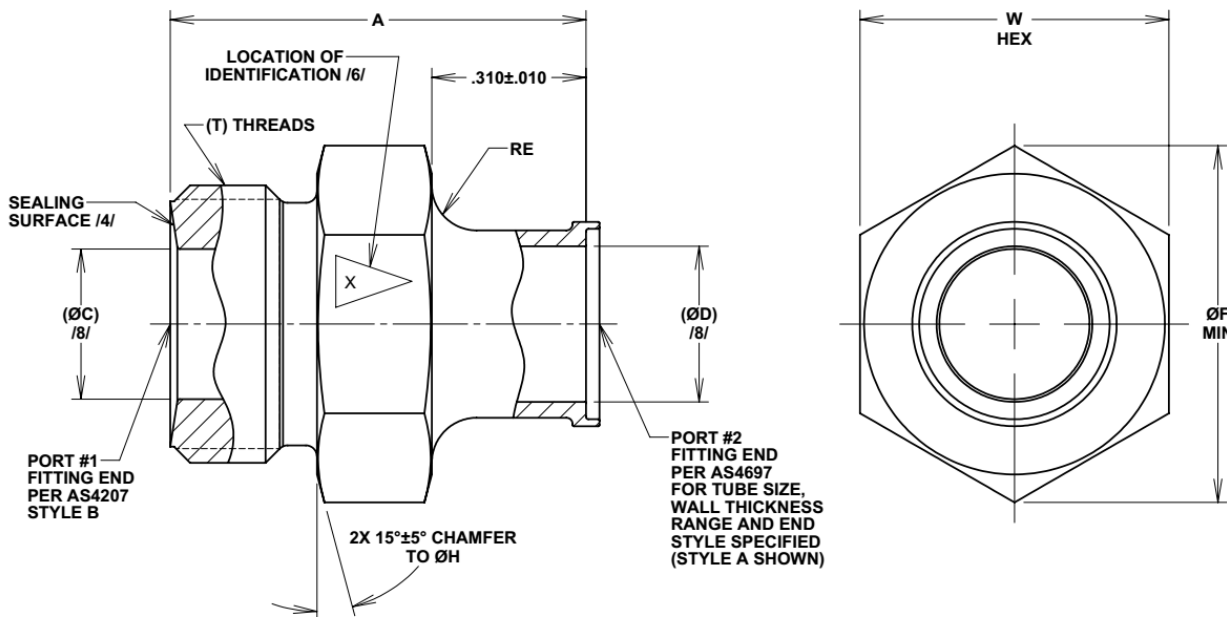
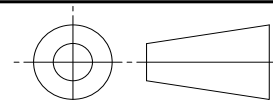


FIGURE 1 - FITTING, ADAPTER

SAE values your input. To provide feedback on this Technical Report, please visit <http://standards.sae.org/AS4228D>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS85421 OR AS85720 /5/



AEROSPACE STANDARD

(R) FITTING, ADAPTER, EXTERNAL THREAD, BEAM SEAL TO INTEGRAL WELD RING

AS4228™
SHEET 1 OF 4

REV.
D



TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4228 /14/ SIZE AND TUBE WALL CODES	(NOM TUBE SIZE)	T THREAD PER AS8879 CLASS 3A	PORT #2 STYLE /8/	A ±.010	C	D	E	F	H ±.010	W	APPROX WEIGHT CRES LB/100	APPROX WEIGHT TI LB/100
03-018	.188	.3750-28 UNJS	A	.733	-	.146	.080	.495	.418	.428-.440	1.54	.882
03-022	.188	.3750-28 UNJS	A	.733	-	.138	.080	.495	.418	.428-.440	1.54	.882
04-022	.250	.4375-24 UNJS	B	.775	.189	.200	.080	.568	.480	.490-.502	2.25	1.29
05-022	.312	.5000-24 UNJS	B	.806	.237	.262	.080	.638	.542	.552-.565	3.04	1.74
05-028	.312	.5000-24 UNJS	B	.806	.237	.250	.080	.638	.542	.552-.565	3.04	1.74
06-022	.375	.5625-20 UNJS	B	.836	.302	.325	.090	.709	.605	.615-.628	3.70	2.11
06-028	.375	.5625-20 UNJS	B	.836	.302	.313	.090	.709	.605	.615-.628	3.70	2.11
06-032	.375	.5625-20 UNJS	B	.836	.302	.305	.090	.709	.605	.615-.628	3.70	2.11
08-022	.500	.7188-20 UNJS	B	.895	.403	.450	.090	.851	.730	.740-.753	6.17	3.52
08-043	.500	.7188-20 UNJS	A	.895	-	.408	.090	.851	.730	.740-.753	6.17	3.52
10-028	.625	.8438-18 UNJS	B	.977	.518	.563	.125	.993	.855	.865-.878	8.64	4.94
10-043	.625	.8438-18 UNJS	B	.977	.518	.533	.125	.993	.855	.865-.878	8.64	4.94
10-055	.625	.8438-18 UNJS	A	.977	-	.509	.125	.993	.855	.865-.878	8.64	4.94
12-028	.750	1.0000-16 UNJ	B	1.014	.654	.688	.125	1.190	1.040	1.050-1.065	12.00	6.85
12-055	.750	1.0000-16 UNJ	A	1.014	-	.634	.125	1.190	1.040	1.050-1.065	12.00	6.85
12-065	.750	1.0000-16 UNJ	A	1.014	-	.614	.125	1.190	1.040	1.050-1.065	12.00	6.85
14-032	.875	1.1250-16 UNJ	B	1.036	.774	.805	.125	1.330	1.166	1.176-1.191	14.60	8.35
14-065	.875	1.1250-16 UNJ	A	1.036	-	.739	.125	1.330	1.166	1.176-1.191	14.60	8.35
16-043	1.000	1.2500-14 UNJS	B	1.065	.868	.908	.125	1.470	1.290	1.300-1.317	18.30	10.50
16-078	1.000	1.2500-14 UNJS	A	1.065	-	.838	.125	1.470	1.290	1.300-1.317	18.30	10.50
16-089	1.000	1.2500-14 UNJS	A	1.065	-	.816	.125	1.470	1.290	1.300-1.317	18.30	10.50
20-055	1.250	1.5781-14 UNJS	B	1.125	1.122	1.134	.180	1.788	1.603	1.613-1.630	30.60	17.50
20-089	1.250	1.5781-14 UNJS	A	1.125	-	1.066	.180	1.788	1.603	1.613-1.630	30.60	17.50
24-055	1.500	1.8438-14 UNJS	B	1.210	1.330	1.384	.180	2.063	1.853	1.863-1.880	43.30	24.80

TABLE 2 - SIZE AND TUBE WALL CODES, RECOMMENDED MAXIMUM SYSTEM PRESSURE

TABLE 2A - SIZE AND TUBE WALL CODES FOR AS85720, AS4510, AND AS4510/2

BASIC NO. AS4228 /14/ SIZE AND TUBE WALL CODES	RANGE OF NOMINAL TUBE WALL FOR PORT #2 /7/ /14/	RECOMMENDED MAXIMUM SYSTEM PRESSURE (PSI) /5/ /7/	
		TI	CRES
03-022	.019-.022	5000	5000
04-022	.019-.022	5000	5000
05-028	.023-.028	5000	5000
06-032	.029-.032	5000	5000
08-043	.033-.043	5000	5000
10-055	.044-.055	5000	5000
12-065	.056-.065	5000	5000
16-089	.079-.089	5000	5000

	AEROSPACE STANDARD	AS4228™ SHEET 1 OF 1 	REV.
	(R) FITTING, ADAPTER, EXTERNAL THREAD, BEAM SEAL TO INTEGRAL WELD RING		



Document Sharing Hub