

RATIONALE

AS4234 HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

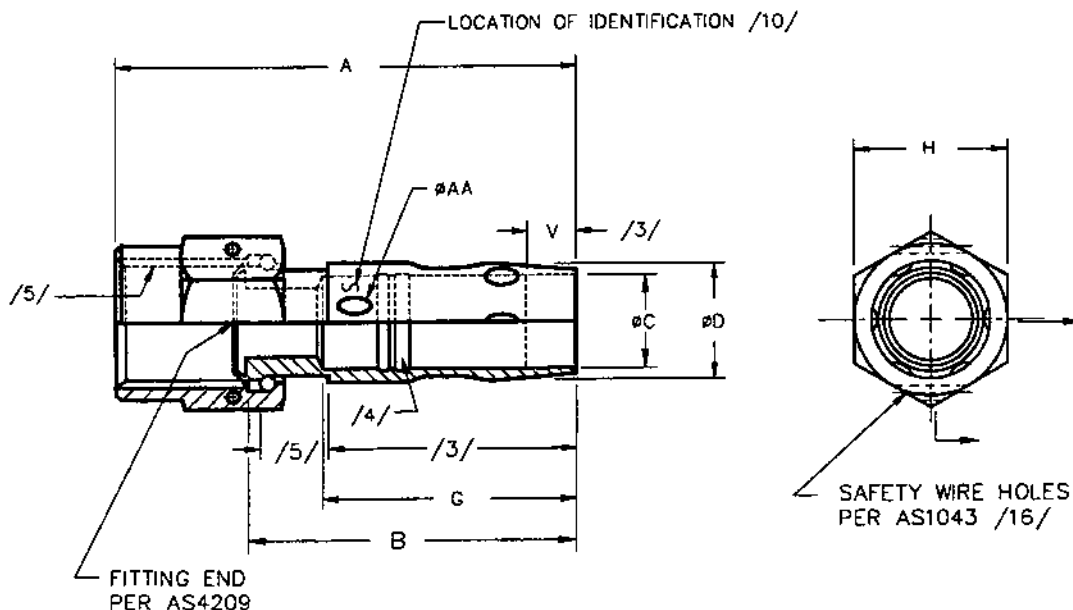


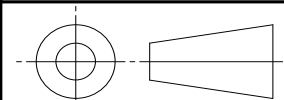
FIGURE 1 - ADAPTER, BEAM SEAL, SWIVEL NUT, EXTERNAL SWAGE TUBE END

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4234 /16/ SIZE CODE	NOMINAL TUBE SIZE	A ±.030	B ±.030	C	D +.000 -.003	G BORE DEPTH ±.015	H	V /3/	AA /2/	LB/EA MAX CRES	LB/EA MAX TI
03	.188	1.219	1.047	.195 - .198	.275	.773	.500	.170 - .220	.13	.0240	.0130
04	.250	1.414	1.216	.257 - .260	.338	.915	.562	.190 - .240	.22	.0320	.0180
05	.312	1.490	1.277	.319 - .322	.413	.955	.625	.200 - .250	.22	.0390	.0220
06	.375	1.569	1.341	.382 - .385	.480	.990	.688	.220 - .270	.22	.0480	.0270
08	.500	2.153	1.907	.508 - .511	.655	1.493	.875	.410 - .435	.50	.0820	.0460
10	.625	2.391	2.067	.633 - .636	.787	1.533	1.000	.410 - .435	.50	.116	.0660
12	.750	2.462	2.127	.758 - .761	.929	1.603	1.125	.365 - .390	.50	.175	.0990
16	1.000	2.755	2.435	1.008 - 1.011	1.257	1.748	1.500	.325 - .350	.50	.328	.186
20	1.250	2.904	2.568	1.258 - 1.262	1.489	1.850	1.875	.325 - .350	.50	.592	.338
24	1.500	3.323	2.901	1.513 - 1.517	1.786	1.975	2.125	.325 - .350	.50	.795	.453

SAE values your input. To provide feedback
on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS4234>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /6/ AS4459



AEROSPACE STANDARD

FITTING, ADAPTER, BEAM SEAL, SWIVEL
NUT, EXTERNAL SWAGE TUBE END,
HYDRAULIC, 3000 PSI

AS4234
SHEET 1 OF 2

Documents

NOTES:

/1/ MATERIAL:

- a. CODE LETTER "-": BODY: 21-6-9 CRES BAR PER AMS 5656
NUT: 17-4PH CRES PER AMS 5643
WIRE: 305 CRES PER AMS 5685
- b. CODE LETTER "E": BODY: COMMERCIALLY PURE TITANIUM BAR PER AMS 4921
NUT: 6AL-4V TITANIUM PER AMS 4965
WIRE: 305 CRES PER AMS 5685

/2/ HEAT TREATMENT: PER PROCUREMENT SPECIFICATIONS.

/3/ FINISH:

- a. MATERIAL CODE LETTER "-": BODY: PASSIVATE THE WHOLE PART PER QQ-P-35 TYPE VII. PTFE COAT (COLOR GREEN) FITTING ID TO "V" DEPTH. OVERSPRAY ON /Y/ PERMISSIBLE.
NUT: PASSIVATE PER QQ-P-35, SOLID FILM LUBRICATE PER AS1701.
WIRE: PASSIVATE PER QQ-P-35, SOLID FILM LUBRICATE PER AS1701.
- b. MATERIAL CODE LETTER "E": BODY: PTFE COAT (COLOR BLACK) EXTERNAL OD AS NOTED AND THE ID TO "V" DEPTH. ϕ AA FREE OF PTFE COATING. SOLID FILM LUBRICATE AS NOTED.
NUT: FLUORIDE PHOSPHATE ENTIRE PART PER AMS 2486, SOLID FILM LUBRICATE PER AS1701.
WIRE: PASSIVATE PER QQ-P-35, SOLID FILM LUBRICATE PER AS1701.

/4/ FILL OUTER GROOVE WITH SILICONE ELASTOMER.

/5/ SOLID FILM LUBRICANT: APPLY PER AS1701.

/6/ PROCUREMENT SPECIFICATIONS: AS4459 AND MIL-F-85421. THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATIONS IN A COMPLETE ASSEMBLY. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.

7. PACKAGING: INDIVIDUALLY PACKAGE IN CLEAN CONTAINER WITH IDENTIFICATION PER AS4459.
8. SPECIFIC DIMENSIONS AND TOLERANCES NOT DEFINED ON THIS STANDARD SHALL BE SPECIFIED AND CONTROLLED BY THE MANUFACTURER. THE MANUFACTURER IS RESPONSIBLE TO INSURE COMPATIBILITY WITH THE ASSEMBLY AND COMPLIANCE WITH THE REQUIREMENTS OF THE APPLICABLE PROCUREMENT SPECIFICATIONS.

9. INTENDED USE: PER AS4459.

/10/ IDENTIFICATION: PARTS SHALL BE IDENTIFIED IN THE AREA SHOWN PER AS4459.

11. INTERPRETATION OF DRAWING PER ARP4296.

12. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36; REQUIREMENT PER ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 μ in Ra.

13. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.

14. DIMENSIONING AND TOLERANCING: ASME Y14.5M-1994

15. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS $\pm$.010, ANGULAR DIMENSIONS $\pm$ 2°.

/16/ EXAMPLE OF PART NUMBER: AS4234 E 08 W N

BASIC PART NUMBER

MATERIAL CODE LETTER /1/

SIZE CODE

TUBE SIZE IN

.062 in INCREMENTS

(08 = .500 in)

N = EXTERIOR PTFE NOT REQUIRED
(TITANIUM ONLY)

BLANK = EXTERIOR PTFE REQUIRED

W = TWO SAFETY WIRE HOLES REQUIRED

X = SAFETY WIRE HOLES OPTIONAL



AEROSPACE STANDARD

FITTING, ADAPTER, BEAM SEAL, SWIVEL
NUT, EXTERNAL SWAGE TUBE END,
HYDRAULIC, 3000 PSI

AS4234

SHEET 2 OF 2



Documents

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