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REV.
A

AS4324™

FEDERAL SUPPLY CLASS
4730

RATIONALE

GRAPHICS REDRAWN. INSIDE DIAMETER "A" ADDED TO GRAPHICS AND TABLE 1. MATERIAL CALLOUT FOR 2024-T3 UPDATED TO INCLUDE AMS4037. MATERIALS AND FINISH FOR CRES 316, 321, TITANIUM 6AL-4V AND 7075 ALUMINUM ADDED AS ADDITIONAL OPTIONS TO MEET CURRENT MATERIAL OPTIONS ON FITTING ASSEMBLY STANDARDS. CURRENT KSC PROCUREMENT SPECIFICATION NOTE ADDED. INSTRUCTIONAL NOTE /10/, INVENTORY DISPOSITION, AND REVISION INDICATOR NOTES ADDED.

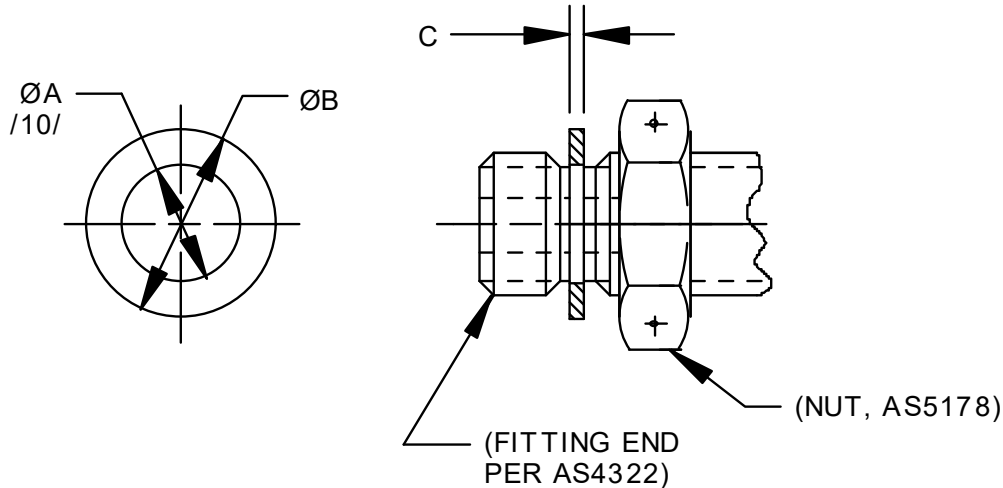


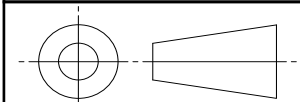
FIGURE 1 - WASHER, ADJUSTABLE END

TABLE 1 - DIMENSIONS A-D

BASIC NUMBER AS4324	(NOMINAL TUBE SIZE)	A +.0005 -.0010	B	C ±.003	D /3/
/9/ SIZE CODE					
04	.250	.364	.650	.031	.015
06	.375	.482	.794	.031	.015
08	.500	.660	1.010	.040	.020
10	.625	.773	1.155	.050	.025
12	.750	.945	1.444	.050	.025
16	1.000	1.195	1.732	.050	.025
20	1.250	1.507	2.165	.050	.025
24	1.500	1.756	2.454	.050	.025
28	1.750	2.131	2.868	.050	.025
32	2.000	2.381	3.160	.050	.025

For more information on this standard, visit
<https://www.sae.org/standards/content/AS4324A/>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: KSC-F-124



AEROSPACE STANDARD

(R) WASHER, FLARED TUBE FITTING
ADJUSTABLE END,
DEFINITION AND INSTALLATION

AS4324™
SHEET 1 OF 2

REV.
A

Documents
Document Sharing Hub

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NOTES:

/1/ MATERIAL:

- a. CODE LETTER D: TYPE 2024-T3 ALUMINUM ALLOY SHEET PER AMS-QQ-A-250/4 OR AMS4037.
- b. CODE LETTER J: TYPE 302 OR 304 CORROSION-RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5637 (302) OR AMS5639 (304).
- c. CODE LETTER K: TYPE 316 CORROSION-RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5648.
- d. CODE LETTER R: TYPE 321 CORROSION-RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5645.
- e. CODE LETTER T: TYPE 6AL-4V TITANIUM ALLOY FORGING OR BAR PER AMS4928.
- f. CODE LETTER W: TYPE 7075-T73 ALUMINUM ALLOY FORGING PER AMS-QQ-A-367 OR AMS4141; OR 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9; OR 7075-T7351 ALUMINUM ALLOY BAR PER AMS4124.

2. FINISH:

- a. MATERIAL CODE LETTER D: ANODIZE PER AMS2472 OR MIL-PRF-8625, TYPE II, CLASS 2, DYE BLUE, DUPLEX SEAL.
- b. MATERIAL CODE LETTERS J, K & R: PASSIVATE PER AMS2700, TYPE 6 OR TYPE 7.
- c. MATERIAL CODE LETTER T: ANODIZE PER AMS2488, TYPE 2, OR FLUORIDE PHOSPHATE CONVERSION COAT PER AMS2486.
- d. MATERIAL CODE LETTER W: ANODIZE PER AMS2472 OR MIL-PRF-8625, TYPE II, CLASS 2, DYE BROWN, DUPLEX SEAL.

/3/ WASHER SHALL BE FLAT WITHIN VALUE "D" AFTER INSTALLATION ON FITTING END.

4. INTERPRETATION OF DRAWING PER AS4296.

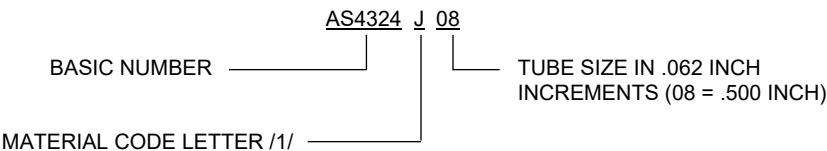
5. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 MICROINCHES Ra.

6. BREAK EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.

7. DIMENSIONING AND TOLERANCING: ASME Y14.5M-1982.

8. DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS $\pm .015$, ANGULAR DIMENSIONS $\pm 0^{\circ}30'$.

/9/ EXAMPLE OF PART NUMBER:



/10/ DIMENSIONS FOR DIAMETER "A" IN TABLE 1 ARE FOR FINAL INSTALLED POSITION. /3/

- 11. PROCUREMENT SPECIFICATION: KSC-F-124: JOHN F. KENNEDY SPACE CENTER, NASA. SPECIFICATION FOR FITTINGS (PRESSURE CONNECTIONS), FLARED TUBE. PRODUCT MANUFACTURED TO THIS STANDARD SHALL MEET THE REQUIREMENTS SPECIFIED HEREIN AND THE PROCUREMENT SPECIFICATION. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL BY STANDARD PAGE SUPPLEMENT OR SIMILAR MEANS.
- 12. 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.
- 13. INVENTORIED PARTS CONFORMING TO THE PREVIOUS LETTER CHANGE MAY BE USED TO DEPLETION.

	AEROSPACE STANDARD	AS4324™ SHEET 2 OF 2	REV. A
	(R) WASHER, FLARED TUBE FITTING ADJUSTABLE END, DEFINITION AND INSTALLATION		