

AS4327 HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

**AS4327**

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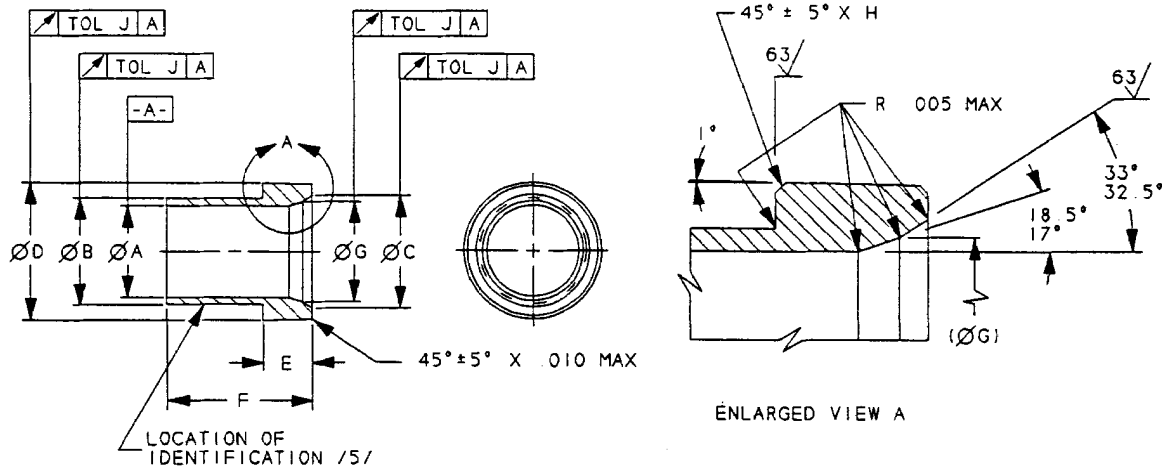


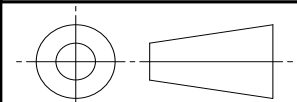
FIGURE 1 - SLEEVE, FLARED TUBE FITTING

### TABLE 1 - DIMENSIONS

| BASIC<br>NUMBER<br>AS4327 |            |                     |                     |            |                     |            |       |                     |           |      |
|---------------------------|------------|---------------------|---------------------|------------|---------------------|------------|-------|---------------------|-----------|------|
| /11/<br>SIZE<br>CODE      | TUBE<br>OD | A<br>+.003<br>-.000 | B<br>+.000<br>-.003 | C<br>±.002 | D<br>+.000<br>-.003 | E<br>±.005 | F     | G<br>+.000<br>-.005 | H         | J    |
| 02                        | .125       | .130                | .172                | .205       | .267                | .125       | .344  | .178                | .005-.010 | .005 |
| 03                        | .188       | .193                | .234                | .267       | .329                | .141       | .406  | .240                | .005-.010 | .005 |
| 04                        | .250       | .255                | .297                | .315       | .383                | .141       | .406  | .280                | .005-.010 | .005 |
| 05                        | .312       | .318                | .366                | .375       | .445                | .156       | .438  | .348                | .005-.010 | .005 |
| 06                        | .375       | .380                | .432                | .441       | .502                | .172       | .500  | .406                | .005-.010 | .005 |
| 08                        | .500       | .506                | .562                | .589       | .682                | .219       | .562  | .538                | .005-.015 | .005 |
| 10                        | .625       | .631                | .690                | .705       | .797                | .234       | .656  | .663                | .005-.015 | .005 |
| 12                        | .750       | .756                | .826                | .880       | .972                | .266       | .688  | .794                | .005-.015 | .005 |
| 16                        | 1.000      | 1.006               | 1.081               | 1.130      | 1.222               | .281       | .781  | 1.050               | .005-.015 | .010 |
| 20                        | 1.250      | 1.260               | 1.339               | 1.412      | 1.534               | .312       | .906  | 1.310               | .005-.015 | .010 |
| 24                        | 1.500      | 1.510               | 1.609               | 1.630      | 1.784               | .344       | 1.125 | 1.564               | .005-.015 | .010 |
| 28                        | 1.750      | 1.762               | 1.882               | 1.945      | 2.159               | .375       | 1.125 | 1.818               | .005-.015 | .010 |
| 32                        | 2.000      | 2.014               | 2.159               | 2.195      | 2.409               | .406       | 1.188 | 2.070               | .005-.015 | .010 |

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### THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ KSC-F-124



## AEROSPACE STANDARD

## SLEEVE, FLARED TUBE FITTING

**AS4327**  
SHEET 1 OF 2

## Documents

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TABLE 2 - WEIGHTS

| BASIC NUMBER |         |        |
|--------------|---------|--------|
| AS4327       | LB/EA   | LB/EA  |
| /11/         | MAX     | MAX    |
| SIZE CODE    | ALUM    | CRES   |
| 02           | .000836 | .00232 |
| 03           | .00128  | .00354 |
| 04           | .00154  | .00427 |
| 05           | .00213  | .00590 |
| 06           | .00282  | .00783 |
| 08           | .00579  | .0160  |
| 10           | .00771  | .0214  |
| 12           | .0127   | .0353  |
| 16           | .0186   | .0516  |
| 20           | .0315   | .0873  |
| 24           | .0481   | .133   |
| 28           | .0796   | .221   |
| 32           | .103    | .286   |

## NOTES:

## /1/ MATERIAL:

- a. CODE LETTER D: 2024T6 OR T851 ALUMINUM ALLOY BAR PER QQ-A-225/6
- b. CODE LETTER J: 304 CORROSION RESISTANT STEEL BAR PER QQ-S-763
- c. CODE LETTER K: 316 CORROSION RESISTANT STEEL BAR PER QQ-S-763
- d. CODE LETTER S: 347 CORROSION RESISTANT STEEL BAR PER QQ-S-763

## 2. HEAT TREAT PER PROCUREMENT SPECIFICATION.

## 3. FINISH:

- a. ALUMINUM ALLOY: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2, COLOR BLUE
- b. CORROSION RESISTANT STEEL: PASSIVATE PER QQ-P-35, TYPE VI

## /4/ PROCUREMENT SPECIFICATION: KSC-F-124 - JOHN F. KENNEDY SPACE CENTER, NASA, SPECIFICATION FOR FITTINGS (PRESSURE CONNECTIONS), FLARED TUBE.

## /5/ IDENTIFICATION: MARK PER AS478-7A3, -15A3, -15B, CLASS C OR CLASS D

- a. FOR SIZES 06 (.375 OD TUBE SIZE) AND SMALLER: MANUFACTURER'S NAME, CAGE CODE NUMBER OR TRADEMARK AND MATERIAL CODE LETTER
- b. FOR SIZES 08 (.500 OD TUBE SIZE) AND LARGER: MANUFACTURER'S NAME, CAGE CODE NUMBER OR TRADEMARK, BASIC PART NUMBER AND MATERIAL CODE LETTER

## 6. INTERPRETATION OF DRAWING PER ARP4296.

7. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36: REQUIREMENTS PER ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125  $\mu$ in Ra.

## 8. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.

## 9. DIMENSIONING AND TOLERANCING: ANSI Y14.5M

10. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS  $\pm$ .016, ANGULAR DIMENSIONS  $\pm$ 0.5°.

## /11/ EXAMPLE OF PART NUMBER: AS4327 K 08

BASIC PART NUMBER \_\_\_\_\_ | \_\_\_\_\_ TUBE SIZE IN .062 in  
 \_\_\_\_\_ | INCREMENTS (08 = .500)  
 MATERIAL CODE LETTER /1/ \_\_\_\_\_



## AEROSPACE STANDARD

SLEEVE, FLARED TUBE FITTING

AS4327

SHEET 2 OF 2



Documents

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