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REV.
D

AS4678™

FEDERAL SUPPLY CLASS
4730

RATIONALE

ADDED CONDUCTIVE HIGH PURITY ALUMINUM COATING FOR ALUMINUM ALLOY FITTINGS.

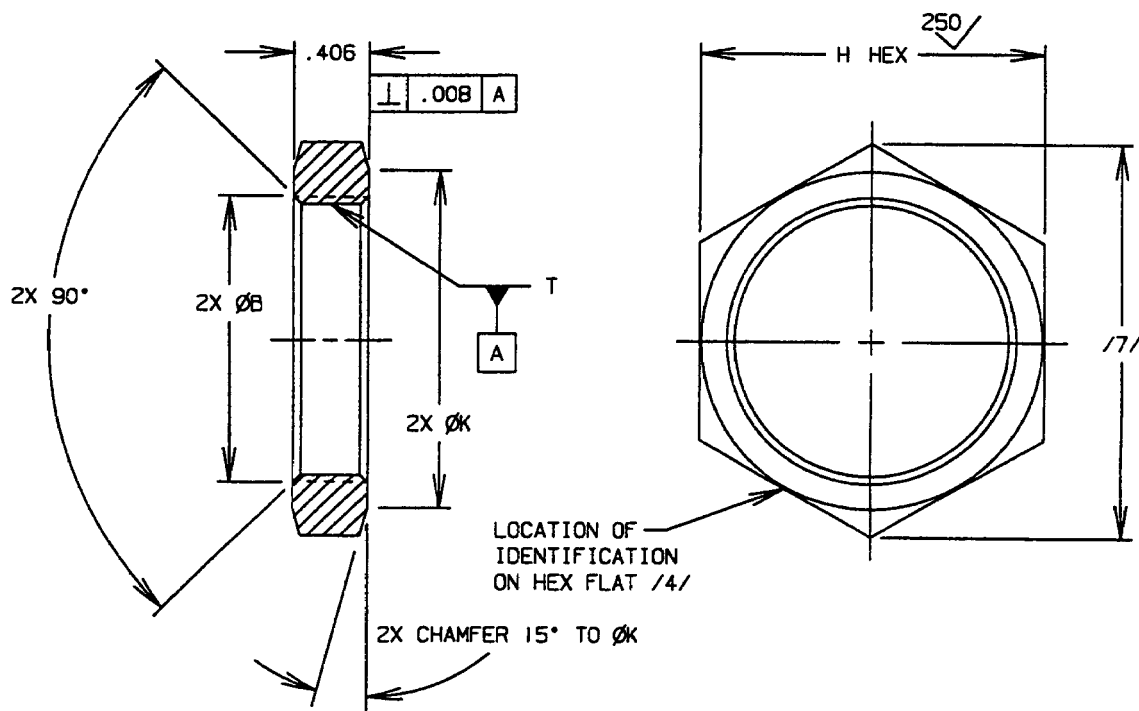


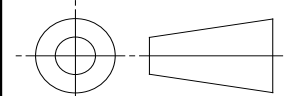
FIGURE 1 - NUT, BULKHEAD

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4678	(NOMINAL TUBE SIZE)	T THREAD PER AS8879	B	H	K	LB/EA APPROX REF ALUM	LB/EA APPROX REF CRES	LB/EA APPROX REF TI
/16/ SIZE CODE								
20	1.250	1.5625-12 UNJ-3B	1.572	1.863- 1.880	1.853	.0570	.158	.090
24	1.500	1.8125-12 UNJ-3B	1.822	2.109- 2.135	2.099	.0671	.186	.106
28	1.750	2.1250-12 UNJ-3B	2.135	2.422- 2.448	2.412	.0808	.224	.128

SAE values your input. To provide feedback on this
Technical Report, please visit
<http://standards.sae.org/AS4678D>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS18280 /5/



AEROSPACE STANDARD

NUT, BULKHEAD,
SHORT FLARELESS

AS4678™
SHEET 1 OF 3

REV.
D

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NOTES

NOTICE

THIS DOCUMENT REFERENCES A PART WHICH CONTAINS CADMIUM AS A PLATING MATERIAL. CONSULT LOCAL OFFICIALS IF YOU HAVE QUESTIONS CONCERNING CADMIUM'S USE.

/1/ MATERIAL:

- a. CODE LETTER T - TYPE 6Al-4V TITANIUM ALLOY BAR PER AMS4928
- b. CODE LETTER V - TYPE 15-5PH CORROSION RESISTANT STEEL BAR PER AMS5659
- c. CODE LETTER W - TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS4124 OR TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9

2 HEAT TREATMENT:

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

/3/ FINISH:

- a. MATERIAL CODE LETTER T - ANODIZE PER AMS2488 OR FLUORIDE PHOSPHATE CONVERSION COAT PER AMS2486.
- b. MATERIAL CODE LETTER V:
 - (1) V CODE PARTS TO BE PASSIVATED ONLY WILL HAVE NO FINISH CODE LETTER AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE: PASSIVATE PER AMS2700 PER PROCUREMENT SPECIFICATION.
 - (2) V CODE PARTS TO BE CADMIUM PLATED ONLY WILL HAVE THE FINISH CODE LETTER "P" AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
- c. MATERIAL CODE LETTER W
 - (1) W CODE PARTS TO BE ANODIZED ONLY WILL HAVE NO FINISH CODE LETTER AFTER THE SIZE CODE IN THE PART NUMBER. THE FINISH WILL BE ANODIZE PER AMS2472 OR PER MIL-A-8625, TYPE II, CLASS 2 DYED BROWN, SIMILAR TO COLOR 10080 OF AMS-STD-595.
 - (2) W CODE PARTS TO BE COATED WITH HIGH PURITY ALUMINUM ONLY WILL HAVE THE FINISH CODE LETTER "V" AFTER THE SIZE CODE IN THE PART NUMBER. SEE PROCUREMENT SPECIFICATION FOR REQUIREMENTS.

/4/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B. MANUFACTURER'S NAME, TRADEMARK OR CAGE CODE, BASIC PART NUMBER, AND MATERIAL CODE LETTER.

/5/ PROCUREMENT SPECIFICATION: AS18280 EXCEPT AS SPECIFIED ON THIS STANDARD. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER AS LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST PRI-QPL-AS18280 FOR THIS STANDARD. SEE www.eauditnet.com FOR CURRENT QPL ONLINE.

NOTE: PRI-QPL LIMITATION - WITH REVISION C OF THIS STANDARD THE PROCUREMENT SPECIFICATION HAS BEEN CHANGED FROM AS4444 FOR 5000 PSI TO AS18280 FOR 3000 PSI. USERS OF THIS FITTING FOR 5000 PSI APPLICATIONS PER AS4444 ARE ADVISED TO CONTROL SOURCE APPROVAL BY STANDARD PAGE SUPPLEMENT OR SIMILAR MEANS.

6. INTENDED USE: THIS PART IS DESIGNED FOR USE WITH AS4659 FITTING ENDS WITH OR WITHOUT AN AS4679 WASHER IN TUBING CONNECTION SYSTEMS WITH NOMINAL OPERATING PRESSURES AS FOLLOWS:

- a. SIZES -20 AND -24 TITANIUM ALLOY AND CORROSION RESISTANT STEEL AT 3000 PSI.
- b. SIZE -28 TITANIUM ALLOY AND CORROSION RESISTANT STEEL AND SIZES -20, -24, AND -28 ALUMINUM ALLOY AT 600 PSI.

	AEROSPACE STANDARD		AS4678™ SHEET 2 OF 3	REV. D.
	NUT, BULKHEAD, SHORT FLARELESS			