



AEROSPACE STANDARD

AS4842™/1**REV. A**Issued 1995-05
Revised 2016-06

Superseding AS4842/1

(R) Fittings, 37° Flared to Pipe Threaded, Fluid Connection

RATIONALE

This revision updated reference specifications, added PRI QML requirements, and general editorial revision.

1. SCOPE

This SAE Aerospace Standard (AS) establishes the requirements for fluid fittings that combine both 37 degree flared and pipe threaded connections for use in all types of fluid systems.

1.1 Classification

Fittings shall be furnished in the types and styles designated by the applicable AN, AS, MS, NAS, and other engineering standard drawings. This specification is the same as MIL-F-5509 as applicable to 37 degree flared to pipe threaded fittings except for updated materials and process specifications and industry coordinated general improvements. It is intended to serve as a procurement specification for the fittings described herein and in Section 6.

2. APPLICABLE DOCUMENTS

The following publications form a part of this document to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order. In the event of conflict between the text of this document and references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

2.1 SAE Publications

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or +1 724-776-4970 (outside USA), www.sae.org.

AS4395	Fitting End, Flared, Tube Connection, Design Standard
AS4841	Fittings, 37° Internal Flare, Fluid Connection, Procurement Specification
AS4842	Fittings and Bosses, Pipe Threaded, Fluid Connection
AS5201	Fitting End, External Taper Pipe Thread, Design Standard

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Documents

Document Sharing Hub

2.2 PRI Publications

Available from Performance Review Institute, 161 Thorn Hill Road, Warrendale, PA 15086-7527, Tel: 724-772-1616, www.pri-network.org.

AC7112 Nadcap Audit Criteria for Fluid Systems Component Manufacturers

AC7112/2 Nadcap Audit Criteria for Fittings and other Machined Components

PD1100 Nadcap Program Requirements

3. TECHNICAL REQUIREMENTS

3.1 Qualification

3.1.1 Manufacturer Qualification

A manufacturer producing a product shall be listed in a Performance Review Institute (PRI) Qualified Manufacturers List (QML). PRI accreditation to this procurement specification shall be in accordance with the requirements of PD1100, AC7112, and AC7112/2. See www.eAuditNet.com.

3.2 Material

See AS4842.

3.3 Heat Treatment

See AS4842.

3.4 Finish

See AS4842.

3.5 Design and Fabrication

The design and fabrication of the fittings shall be in accordance with the applicable drawings. The 37 degree cone and pipe threaded ends of fittings shall be in accordance with AS4395 or AS5201, as applicable. The 37 degree cone flared fitting ends shall meet the requirements of AS4841, as applicable.

3.6 Performance

See AS4842.

3.7 Identification of Product

See AS4842.

3.8 Workmanship

See AS4842.

4. QUALITY ASSURANCE PROVISIONS

See AS4842 for pipe threaded fitting ends and AS4841 for the fitting body and flared ends.