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REV.
B

AS4861™

FEDERAL SUPPLY CLASS
4730

RATIONALE

ADDED TYPE 360 COPPER ALLOY PER ASTM B16/16M TO MATERIAL CALLOUT FOR BRASS BAR STOCK BECAUSE CURRENT TYPE 360 COPPER ALLOY CALLOUT IS NOT AVAILABLE. ASTM B16/16M IS ALREADY CALLED OUT IN PROCUREMENT SPECIFICATION AS4842.

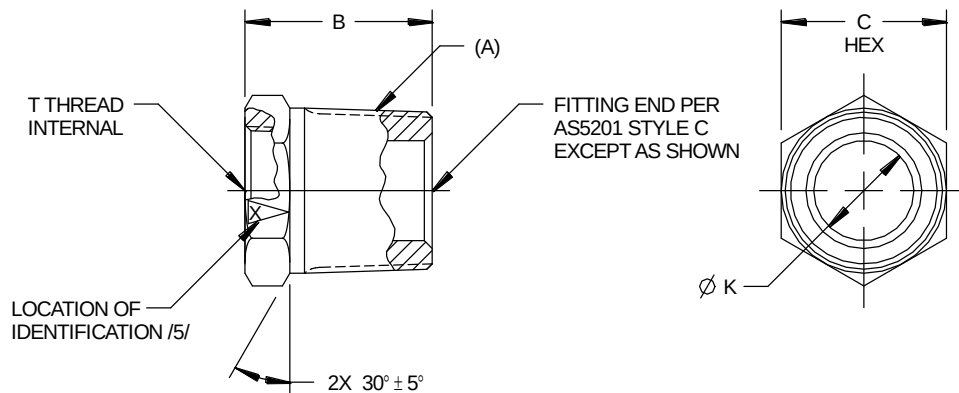


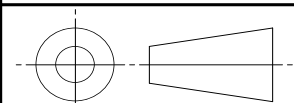
FIGURE 1 – FITTING, BUSHING, PIPE, INTERNAL AND EXTERNAL THREAD

TABLE 1 – DIMENSIONS

BASIC NO. AS4861 /14/ SIZE CODE	A THREAD PER AS71051 ANPT	T THREAD PER AS71051 ANPT	B ±.031	C	K
01	1/4 -18	1/8 -27	.781	.615-.628	.311-.327
02	3/8 -18	1/4 -18	.781	.740-.753	.404-.423
03	3/8 -18	1/8 -27	.781	.740-.753	.311-.327
04	1/2 -14	3/8 -18	1.016	.928-.941	.529-.557
05	1/2 -14	1/4 -18	1.016	.928-.941	.404-.423
06	1/2 -14	1/8 -27	1.016	.928-.941	.311-.327
07	3/4 -14	1/2 -14	1.063	1.113-1.128	.654-.688
08	3/4 -14	3/8 -18	1.063	1.113-1.128	.529-.557
09	3/4 -14	1/4 -18	1.063	1.113-1.128	.404-.423
10	1 -11 1/2	3/4 -14	1.250	1.363-1.380	.857-.897
11	1 -11 1/2	1/2 -14	1.250	1.363-1.380	.654-.688
12	1 -11 1/2	3/8 -18	1.250	1.363-1.380	.529-.557
13	1 1/4 -11 1/2	3/4 -14	1.281	1.738-1.755	.857-.897

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on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS4861B>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS4842, SEE NOTE 4



AEROSPACE STANDARD

(R) FITTING, BUSHING, PIPE,
INTERNAL AND EXTERNAL THREAD

AS4861™
SHEET 1 OF 3

REV.
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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. DASH AS CODE LETTER – TYPE 377 COPPER ALLOY FORGING PER ASTM B124/B124BM, OR AMS4614, OR TYPE 360 HALF HARD FORGING OR BAR PER ASTM B16/16BM, OR BAR PER AMS4610, OR TYPE 675 HALF HARD FORGING PER ASTM B138/138M.
- b. CODE LETTER D – TYPE 2014-T6 ALUMINUM ALLOY FORGING PER AMS-QQ-A-367 OR AMS4133, OR TYPE 2024-T6 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6, OR TYPE 2024-T851 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6 OR AMS4339.
- c. CODE LETTER J – TYPE 304 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5639.
- d. CODE LETTER K – TYPE 316 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5648.
- e. CODE LETTER R – TYPE 321 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5645.
- f. CODE LETTER S – TYPE 347 CORROSION RESISTANT STEEL FORGING OR BAR PER AMS-QQ-S-763 OR AMS5646.
- g. CODE LETTER W – TYPE 7075-T73 ALUMINUM ALLOY FORGING PER AMS-QQ-A-367 OR AMS4141, OR TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9, OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS4124.

2. FINISH:

- a. DASH AS CODE LETTER – CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 3 OR NONE.
- b. MATERIAL CODE LETTER D – ANODIZE PER MIL-A-8625, TYPE II, CLASS 2 OR AMS2472, DYE BLUE.
- c. MATERIAL CODE LETTER J – PASSIVATE PER AMS2700, TYPE 6 OR 7.
- d. MATERIAL CODE LETTER K – PASSIVATE PER AMS2700, TYPE 6 OR 7.
- e. MATERIAL CODE LETTER R – PASSIVATE PER AMS2700, TYPE 6 OR 7.
- f. MATERIAL CODE LETTER S – PASSIVATE PER AMS2700, TYPE 6 OR 7.
- g. MATERIAL CODE LETTER W – ANODIZE PER MIL-A-8625, TYPE II, CLASS 2 OR AMS2472, DYE BROWN SIMILAR TO COLOR 10080 OF FED-STD-595.

/3/ INTENDED USE: OXYGEN SYSTEMS AND GROUND SUPPORT EQUIPMENT ONLY. PARTS FOR OXYGEN SYSTEMS SHALL BE IDENTIFIED IN THE PART NUMBER AS CODE "A" AND SHALL BE FURNISHED CLEANED, PACKAGED, AND LABELED IN ACCORDANCE WITH AIR1176 TO A PROCESS APPROVED BY THE USER.

/4/ PROCUREMENT SPECIFICATION: AS4842 EXCEPT AS SPECIFIED ON THIS STANDARD. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER LISTED IN THE NATIONAL AEROSPACE AND DEFENSE CONTRACTORS ACCREDITATION PROGRAM (NADCAP) QUALIFIED MANUFACTURER LIST (QML) FOR THIS PRODUCT TYPE. THE QML IS AVAILABLE AT www.eAuditNet.com.

/5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D, OR METHOD 7A3, 15A3, OR 15B.

- a. FOR SIZES 03 AND SMALLER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, LETTERS "AS", MATERIAL CODE LETTER, AND FORGING MANUFACTURER'S IDENTIFICATION, WHEN MADE FROM FORGING.
- b. FOR SIZES 04 AND LARGER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, BASIC PART NUMBER, MATERIAL CODE LETTER, AND FORGING MANUFACTURER'S IDENTIFICATION, WHEN MADE FROM FORGING.

6. INVENTORIED PARTS CONFORMING TO THE PREVIOUS "LETTER CHANGE" MAY BE USED TO DEPLETION.

7. THIS STANDARD IS A FUNCTIONAL EQUIVALENT OF AN912.

8. 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.

9. INTERPRETATION OF DRAWING PER AS4296.

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

	AEROSPACE STANDARD (R) FITTING, BUSHING, PIPE, INTERNAL AND EXTERNAL THREAD	AS4861™ SHEET 2 OF 3	REV. B
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