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REV.
A

AS6115

FEDERAL SUPPLY CLASS
4730

RATIONALE

ADDED STANDARD CONFIGURATION 2424. ADDED REDUCER CONFIGURATIONS 1216, 2024 & 2420. ADDED "RW4" CALLOUT TO FIGURE. ADDED COLUMN "W4 MAX" TO TABLE 1B. ERROR CORRECTION DIMENSION "(H)" SIZE CODE 0404.

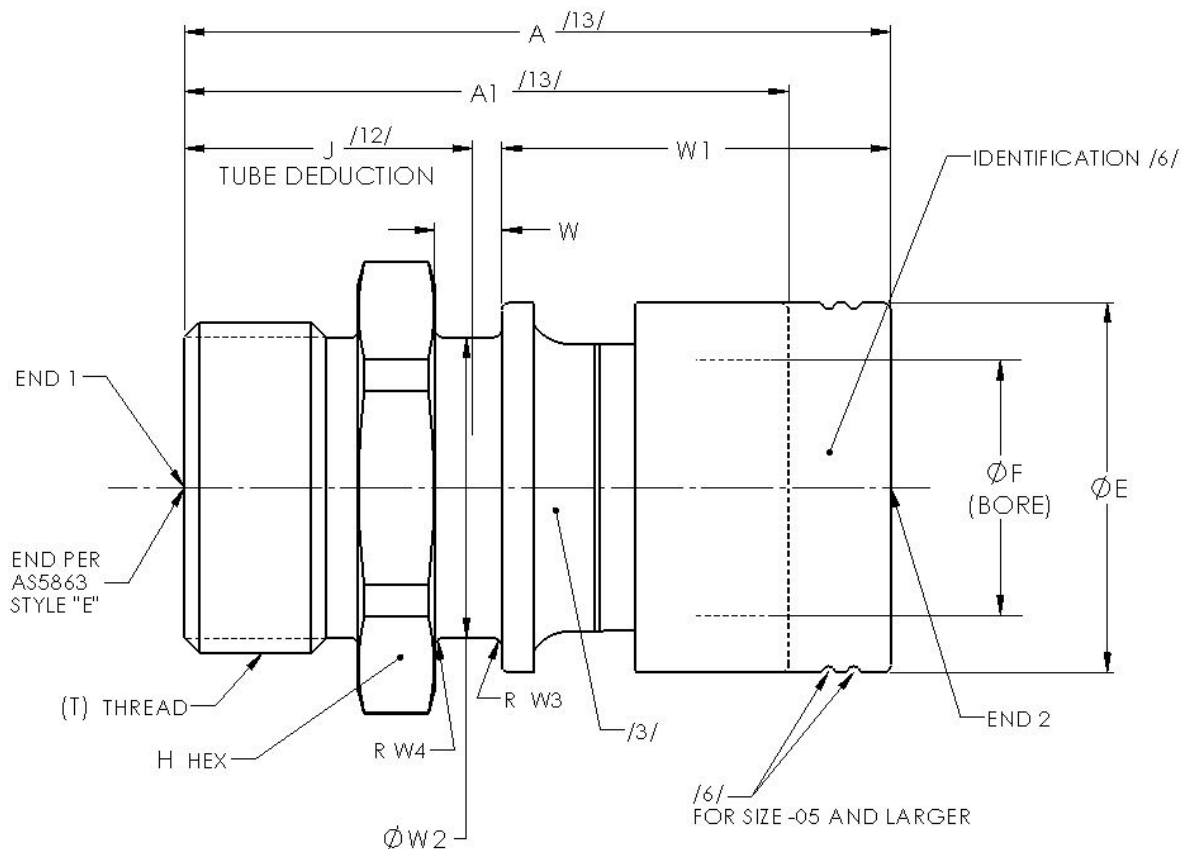
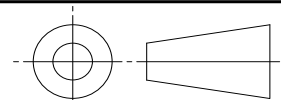


FIGURE - 1 FITTING ASSEMBLY, ADAPTER, SWAGE

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THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS6116



AEROSPACE STANDARD

(R) FITTING ASSEMBLY, STRAIGHT, MALE
FLARELESS, AXIALLY SWAGED,
HYDRAULIC, UP TO 1500 PSI

AS6115
SHEET 1 OF 3

REV.
A

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TABLE 1A - DIMENSIONS A THROUGH J

BASIC NO. AS6115 /15/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	A MAX	A1 MAX	ØE MAX	ØF MIN	(H)	J /12/ TUBE DEDUCTION
0404	.250	.250	1.498	1.345	.435	.253	.562	.805 ±.150
0505	.3125	.3125	1.633	1.485	.503	.3155	.750	.810 ±.150
0604	.375	.250	1.470	1.317	.435	.253	.813	.777 ±.150
0606	.375	.375	1.772	1.545	.580	.378	.813	.800 ±.150
0808	.500	.500	2.095	1.835	.755	.503	1.000	.920 ±.150
1010	.625	.625	2.165	1.925	.929	.629	1.125	.985 ±.150
1212	.750	.750	2.370	2.090	1.150	.754	1.375	1.050 ±.150
1216	.750	1.000	2.829	2.449	1.474	1.004	1.625	1.139 ±.150
1616	1.000	1.000	2.835	2.455	1.474	1.004	1.625	1.145 ±.150
2020	1.250	1.250	3.152	2.732	1.768	1.255	1.875	1.187 ±.150
2024	1.250	1.500	3.516	3.036	2.070	1.505	2.125	1.191 ±.150
2420	1.500	1.250	3.172	2.772	1.768	1.255	2.125	1.207 ±.150
2424	1.500	1.500	3.546	3.066	2.070	1.505	2.125	1.221 ±.150

TABLE 1B - DIMENSIONS T THROUGH W3 AND WEIGHTS

BASIC NO. AS6115 /15/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	(T) THREAD PER AS8879	W MIN	W1 MAX	ØW2 ±.002	W3 MAX	W4 MAX	WEIGHT APPROX LB/EA
0404	.250	.250	.4375-20 UNJF-3A	.185	.604	.320	.020	.020	.017
0505	.3125	.3125	.5000-20 UNJF-3A	.180	.724	.371	.020	.020	.023
0604	.375	.250	.5625-18 UNJF-3A	.185	.604	.320	.020	.020	.020
0606	.375	.375	.5625-18 UNJF-3A	.195	.883	.463	.020	.020	.040
0808	.500	.500	.7500-16 UNJF-3A	.210	1.076	.595	.020	.020	.051
1010	.625	.625	.8750-14 UNJF-3A	.225	1.076	.758	.020	.020	.064
1212	.750	.750	1.0625-12 UNJ-3A	.235	1.201	.903	.025	.025	.109
1216	.750	1.000	1.0625-12 UNJ-3A	.260	1.566	1.196	.035	.035	.200
1616	1.000	1.000	1.3125-12 UNJ-3A	.260	1.566	1.196	.035	.035	.190
2020	1.250	1.250	1.6250-12 UNJ-3A	.285	1.829	1.460	.035	.035	.289
2024	1.250	1.500	1.6250-12 UNJ-3A	.310	2.178	1.704	.035	.035	.400
2420	1.500	1.250	1.8750-12 UNJ-3A	.285	1.829	1.460	.035	.035	.335
2424	1.500	1.500	1.8750-12 UNJ-3A	.310	2.178	1.704	.035	.035	.430

NOTES:

/1/ MATERIALS:

CODE LETTER "D"

BODY - TYPE 6061-T6 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/8.

RING - TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9.

2. FINISH:

BODY - CHEMICAL CONVERSION COATED PER MIL-DTL-5541 TYPE I CLASS 3.

RING - ANODIZE PER MIL-A-8625, TYPE II, CLASS 2, DYED GREEN, SIMILAR TO NO. 14187, 14193, OR 14223 OF FED-STD-595 AND SHALL BE DUPLEX SEALED.

/3/ COATINGS/LUBRICANTS:

BODY

- a. DRY FILM LUBRICANT PER AS5272 TYPE I SHALL BE APPLIED TO THE O.D. OF THE AXIALLY SWAGED FITTING END. ADDITIONAL LUBRICANT APPLIED SHALL BE SPECIFIED BY MANUFACTURER. THE LUBRICANTS SHALL NOT BE IN CONTACT WITH THE SYSTEM FLUID.

	AEROSPACE STANDARD	AS6115 SHEET 2 OF 3 	REV. A 
	(R) FITTING ASSEMBLY, STRAIGHT, MALE FLARELESS, AXIALLY SWAGED, HYDRAULIC, UP TO 1500 PSI		