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SAE AS6120

RATIONALE

FEDERAL SUPPLY CLASS
4730

NEW STANDARD FOR OPERATING PRESSURES UP TO AND INCLUDING 1500 PSI

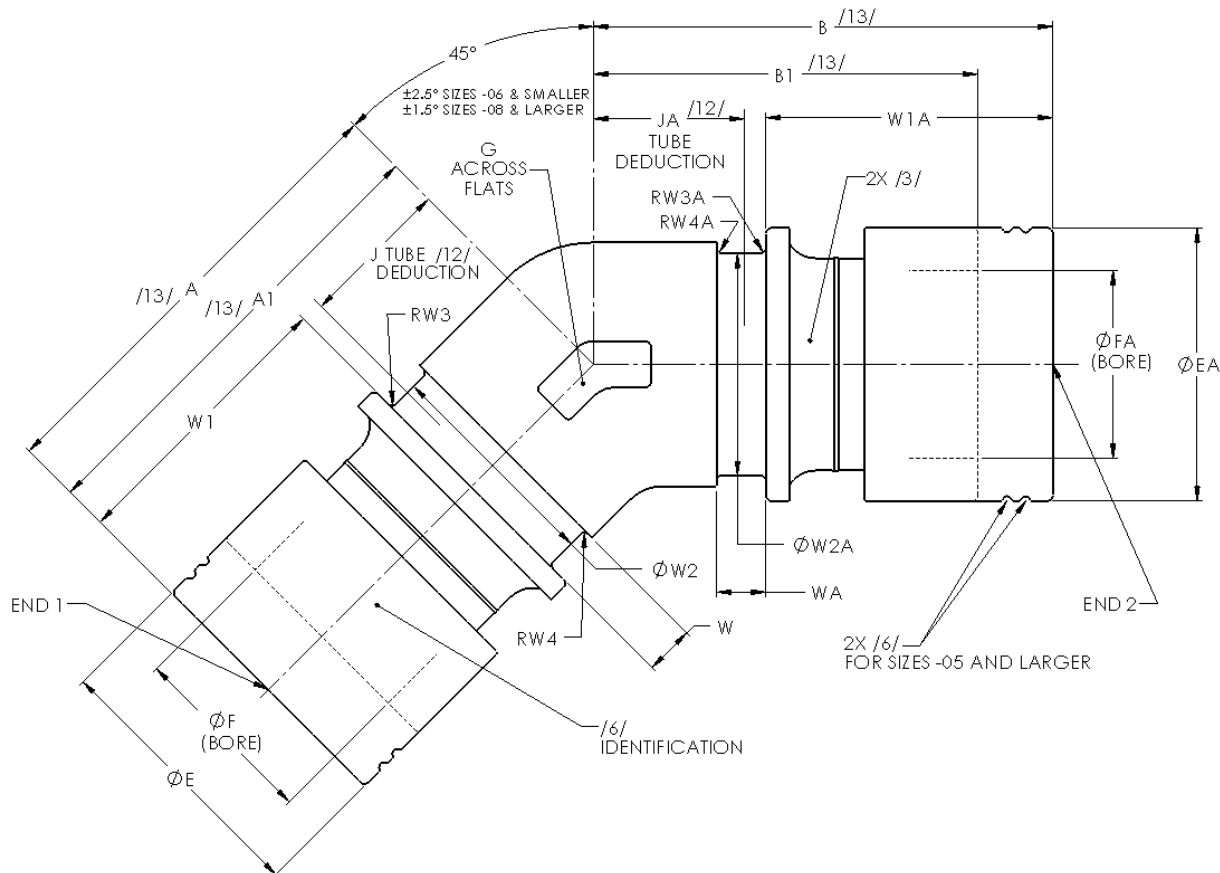
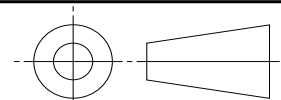


FIGURE - 1 FITTING ASSEMBLY, ELBOW, 45 DEGREES

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THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS6116

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD
FITTING ASSEMBLY, ELBOW, 45°
AXIALLY SWAGED, HYDRAULIC, UP TO 1500 PSI

SAE AS6120
SHEET 1 OF 3

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TABLE 1A - DIMENSIONS A THROUGH G

BASIC NO. AS6120 /15/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	A MAX	A1 MAX	B MAX	B1 MAX	ØE MAX	ØEA MAX	ØF MIN	ØFA MIN	G ±.015
0404	.250	.250	1.043	.885	1.043	.885	.435	.435	.253	.253	.438
0505	.3125	.3125	1.213	1.060	1.213	1.060	.503	.503	.3155	.3155	.465
0606	.375	.375	1.402	1.170	1.402	1.170	.580	.580	.378	.378	.563
0808	.500	.500	1.655	1.390	1.655	1.390	.755	.755	.503	.503	.750
1010	.625	.625	1.715	1.475	1.715	1.475	.929	.929	.629	.629	.875
1212	.750	.750	1.965	1.685	1.965	1.685	1.150	1.150	.754	.754	1.063
1616	1.000	1.000	2.505	2.125	2.505	2.125	1.474	1.474	1.004	1.004	1.304
2020	1.250	1.250	2.935	2.520	2.935	2.520	1.768	1.768	1.255	1.255	1.618

TABLE 1B - DIMENSIONS J THROUGH W1A

BASIC NO. AS6120 /15/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	J /12/ TUBE DEDUCTION		JA /12/ TUBE DEDUCTION		W MIN	WA MIN	W1 MAX	W1A MAX
0404	.250	.250	.350	+ .150/- .180	.350	+ .150/- .180	.185	.185	.604	.604
0505	.3125	.3125	.390	+ .150/- .180	.390	+ .150/- .180	.180	1.80	.724	.724
0606	.375	.375	.430	+ .150/- .195	.430	+ .150/- .195	.195	.195	.883	.883
0808	.500	.500	.480	+ .150/- .210	.480	+ .150/- .210	.210	.210	1.076	1.076
1010	.625	.625	.535	+ .150/- .200	.535	+ .150/- .200	.225	.225	1.076	1.076
1212	.750	.750	.645	+ .150/- .245	.645	+ .150/- .245	.235	.235	1.201	1.201
1616	1.000	1.000	.815	+ .150/- .330	.815	+ .150/- .330	.260	.260	1.566	1.566
2020	1.250	1.250	.970	+ .150/- .375	.970	+ .150/- .375	.285	.285	1.829	1.829

TABLE 1C - DIMENSIONS W2 THROUGH W4A AND WEIGHTS

BASIC NO. AS6120 /15/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	ØW2 ±.002	ØW2A ±.002	W3 MAX	W3A MAX	W4 MAX	W4A MAX	WEIGHT APPROX LB/EA
0404	.250	.250	.320	.320	.020	.020	.020	.020	.015
0505	.3125	.3125	.371	.371	.020	.020	.020	.020	.020
0606	.375	.375	.463	.463	.020	.020	.020	.020	.030
0808	.500	.500	.595	.595	.020	.020	.020	.020	.060
1010	.625	.625	.758	.758	.020	.020	.020	.020	.085
1212	.750	.750	.903	.903	.025	.025	.025	.025	.150
1616	1.000	1.000	1.196	1.196	.035	.035	.035	.035	.300
2020	1.250	1.250	1.460	1.460	.035	.035	.035	.035	.470

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.

RINGS - 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.

 An SAE International Group	AEROSPACE STANDARD		 SAE AS6120 SHEET 2 OF 3	
	FITTING ASSEMBLY, ELBOW, 45° AXIALLY SWAGED, HYDRAULIC, UP TO 1500 PSI			