

REV.  
A

AS6322™

FEDERAL SUPPLY CLASS  
4730

# RATIONALE

1. REVISE FINISH NOTE 3 TO ALLOW ANODIZE RING OPTION FOR NO CODE PART NUMBERS AND CLARIFY THE INTENDED USAGE OF BLUE COLOR MARKING.
2. REVISE NOTE 13 AND 14 TO CLARIFY THE USAGE OF ANODIZE RINGS.
3. UPDATING STANDARD TO INCLUDE NEW CLASS "D" CODE TO DENOTE USE ON ALUMINUM TUBING. SEE NOTE 17 FOR DETAILS.
4. REVISE NOTE 4 TO CLARIFY PROCUREMENT. WORDING IN ACCORDANCE WITH AS5969 REVISION F.

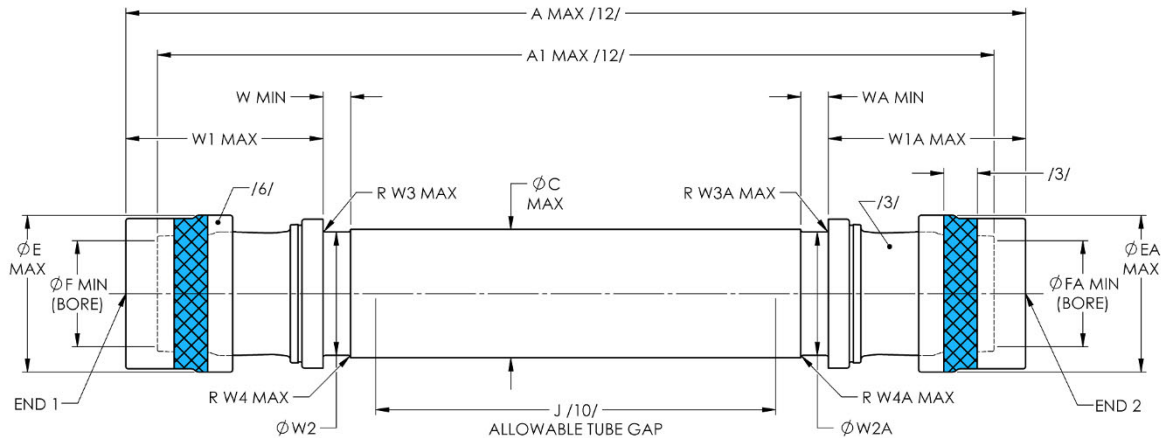


FIGURE 1 - EXTENDED UNION, BEFORE SWAGE

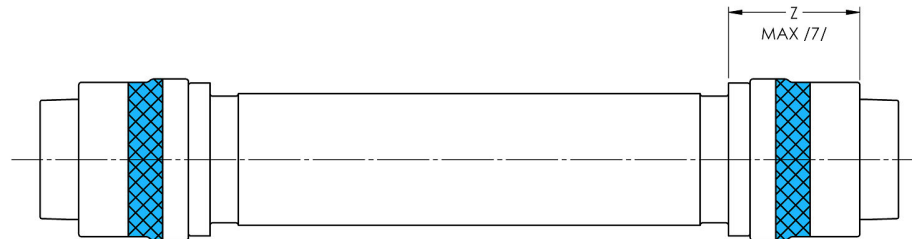
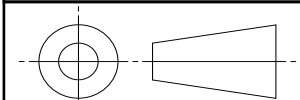


FIGURE 2 - EXTENDED UNION, AFTER SWAGE

(SEE TABLES 1A AND 1B FOR DIMENSIONAL INFORMATION)

For more information on this standard, visit  
<https://www.sae.org/standards/content/AS6322A/>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS5958 /4/



## AEROSPACE STANDARD

FITTING ASSEMBLY, EXTENDED UNION,  
AXIALLY SWAGED, HYDRAULIC,  
5080 PSI

AS6322™  
SHEET 1 OF 4

REV.  
A

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TABLE 1A - DIMENSIONS A THRU J

| BASIC NO.<br>AS6322 /13/<br>SIZE CODE | NOMINAL<br>TUBE SIZE<br>END 1 | NOMINAL<br>TUBE SIZE<br>END 2 | A<br>MAX<br>STANDARD<br>LENGTH /15/ | A1<br>MAX<br>EXTENDED<br>LENGTH /15/ | A<br>MAX<br>STANDARD<br>LENGTH /15/ | A1<br>MAX<br>EXTENDED<br>LENGTH /15/ | C<br>MAX | E<br>MAX | EA<br>MAX | F<br>MIN | FA<br>MIN | J /10/<br>ALLOWABLE<br>TUBE GAP<br>STANDARD<br>LENGTH /15/ | J /10/<br>ALLOWABLE<br>TUBE GAP<br>EXTENDED<br>LENGTH /15/ |
|---------------------------------------|-------------------------------|-------------------------------|-------------------------------------|--------------------------------------|-------------------------------------|--------------------------------------|----------|----------|-----------|----------|-----------|------------------------------------------------------------|------------------------------------------------------------|
| 0404                                  | .2500                         | .2500                         | 1.844                               | 1.675                                | 3.204                               | 3.035                                | .350     | .466     | .466      | .253     | .253      | 0-1.000                                                    | 0-2.360                                                    |
| 0606                                  | .3750                         | .3750                         | 2.278                               | 2.051                                | 4.014                               | 3.787                                | .525     | .609     | .609      | .378     | .378      | 0-1.000                                                    | 0-2.736                                                    |
| 0808                                  | .5000                         | .5000                         | 2.628                               | 2.341                                | 4.778                               | 4.491                                | .675     | .783     | .783      | .504     | .504      | 0-1.000                                                    | 0-3.150                                                    |
| 1010                                  | .6250                         | .6250                         | 3.216                               | 2.813                                | 5.863                               | 5.460                                | .840     | .939     | .939      | .629     | .629      | 0-1.000                                                    | 0-3.647                                                    |
| 1212                                  | .7500                         | .7500                         | 3.504                               | 3.099                                | 6.437                               | 6.032                                | .985     | 1.122    | 1.122     | .754     | .754      | 0-1.000                                                    | 0-3.933                                                    |
| 1616                                  | 1.0000                        | 1.0000                        | 4.036                               | 3.613                                | 8.084                               | 7.661                                | 1.275    | 1.495    | 1.495     | 1.004    | 1.004     | 0-1.000                                                    | 0-5.048                                                    |
| 2020                                  | 1.2500                        | 1.2500                        | 4.602                               | 4.159                                | 9.196                               | 8.753                                | 1.550    | 1.758    | 1.758     | 1.255    | 1.255     | 0-1.000                                                    | 0-5.594                                                    |

TABLE 1B - DIMENSIONS W THRU W4A AND WEIGHTS

| BASIC NO.<br>AS6322 /13/<br>SIZE CODE | NOMINAL<br>TUBE SIZE<br>END 1 | NOMINAL<br>TUBE SIZE<br>END 2 | W<br>MIN | WA<br>MIN | W1<br>MAX | W1A<br>MAX | W2<br>±.0015 | W2A<br>±.0015 | W3<br>MAX | W3A<br>MAX | W4<br>MAX | W4A<br>MAX | WEIGHT<br>LB/EA<br>APPROX REF<br>STANDARD<br>LENGTH /15/ | WEIGHT<br>LB/EA<br>APPROX REF<br>EXTENDED<br>LENGTH /15/ |
|---------------------------------------|-------------------------------|-------------------------------|----------|-----------|-----------|------------|--------------|---------------|-----------|------------|-----------|------------|----------------------------------------------------------|----------------------------------------------------------|
| 0404                                  | .2500                         | .2500                         | .123     | .123      | .488      | .488       | .3005        | .3005         | .018      | .018       | .065      | .065       | .016                                                     | .022                                                     |
| 0606                                  | .3750                         | .3750                         | .153     | .153      | .675      | .675       | .4475        | .4475         | .033      | .033       | .065      | .065       | .036                                                     | .055                                                     |
| 0808                                  | .5000                         | .5000                         | .165     | .165      | .871      | .871       | .5945        | .5945         | .033      | .033       | .129      | .129       | .068                                                     | .118                                                     |
| 1010                                  | .6250                         | .6250                         | .140     | .140      | 1.190     | 1.190      | .7365        | .7365         | .021      | .021       | .078      | .078       | .116                                                     | .201                                                     |
| 1212                                  | .7500                         | .7500                         | .154     | .154      | 1.327     | 1.327      | .8805        | .8805         | .024      | .024       | .089      | .089       | .180                                                     | .310                                                     |
| 1616                                  | 1.0000                        | 1.0000                        | .167     | .167      | 1.612     | 1.612      | 1.1725       | 1.1725        | .027      | .027       | .099      | .099       | .382                                                     | .636                                                     |
| 2020                                  | 1.2500                        | 1.2500                        | .185     | .185      | 1.886     | 1.886      | 1.4345       | 1.4345        | .030      | .030       | .113      | .113       | .540                                                     | .907                                                     |

## NOTES:

## /1/ MATERIALS:

CODE LETTER "T"

RINGS - AMS4965 TITANIUM ALLOY 6.0AI - 4.0V SOLUTION HEAT TREATED AND AGED OR AMS4928 TITANIUM ALLOY 6.0AI - 4.0V ANNEALED WITH HIGH STRENGTH CARBON FIBER/EPOXY RESIN COMPOSITE REINFORCEMENT.

BODY - AMS4928 TITANIUM ALLOY 6.0AI - 4.0V ANNEALED

## 2. FINISH:

TITANIUM - NONE

## /3/ COATINGS/LUBRICANTS /14/:

## a. NO SUFFIX CODE LETTER

- (1) RINGS - THE OUTER SURFACE SHALL HAVE A .125 INCH MINIMUM WIDTH BLUE BAND OR COMPLETELY COLORED BLUE PER AS5958. MARKING AND COLOR METHODS SHALL BE IN ACCORDANCE WITH AS5958. BLUE COLOR MARKING SHALL EXHIBIT CHEMICAL RESISTANCE PER AS5958. BLUE COLOR ON RING CORRESPONDS TO TOOLING COLOR SPECIFIED IN THE AS5959 INSTALLATION PROCEDURE AND DENOTES 5080 PSI CAPABILITY ON SWAGED END.
- (2) BODY - LEAD FREE SOLID FILM LUBRICANT PER AS5272 TYPE I OR II, OR PER AS6449 TYPE III OR IV, PTFE OR PETROLEUM-BASED LUBRICANT SHALL BE APPLIED TO PORTIONS OF THE ID AND OD. THE PETROLEUM-BASED LUBRICANT SHALL NOT BE IN CONTACT WITH THE SYSTEM FLUID.

|                                                                                     |                                                                             |  |                                |                         |
|-------------------------------------------------------------------------------------|-----------------------------------------------------------------------------|--|--------------------------------|-------------------------|
|  | <b>AEROSPACE STANDARD</b>                                                   |  | <b>AS6322™</b><br>SHEET 2 OF 4 | <b>REV.</b><br><b>A</b> |
|                                                                                     | FITTING ASSEMBLY, EXTENDED UNION,<br>AXIALLY SWAGED, HYDRAULIC,<br>5080 PSI |  |                                |                         |


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