

RATIONALE

NEW STANDARD FOR OPERATING PRESSURES UP TO AND INCLUDING 1500 PSI.

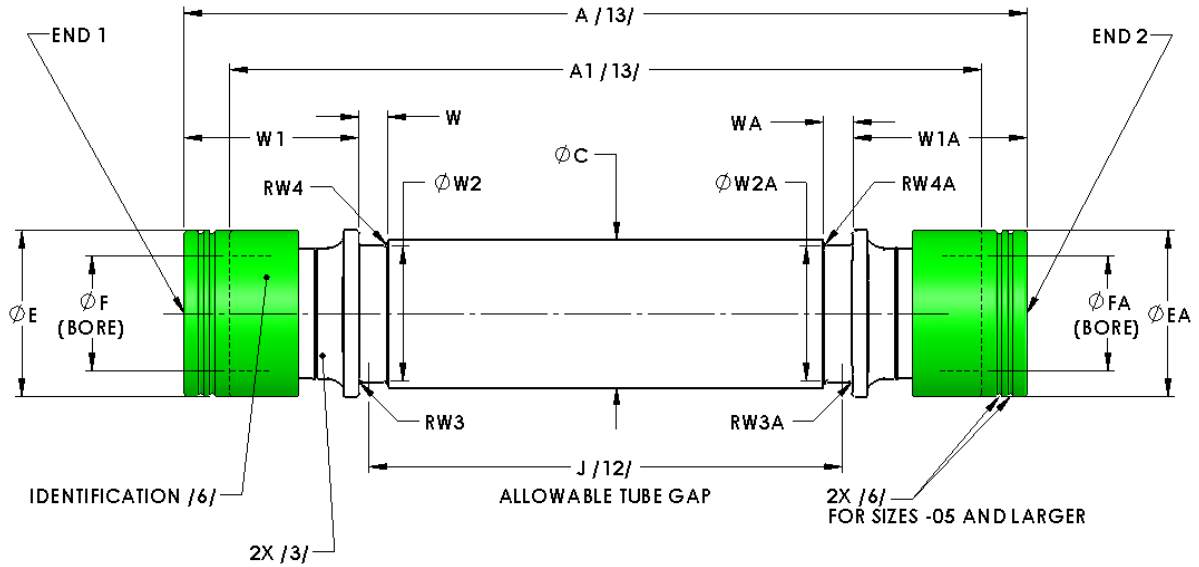
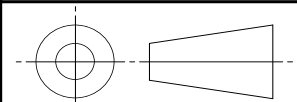


FIGURE 1 – FITTING ASSEMBLY, EXTENDED UNION

SAE values your input. To provide feedback
on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS6323>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS6116 /4/



AEROSPACE STANDARD

FITTING ASSEMBLY, EXTENDED UNION,
AXIALLY SWAGED, HYDRAULIC,
UP TO 1500 PSI

AS6323™
SHEET 1 OF 3

Documents

TABLE 1A - DIMENSIONS A THROUGH J

BASIC NO. AS6323 /15/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	A MAX	A1 MAX	A MAX	A1 MAX	ØC MAX	ØE MAX	ØEA MAX	ØF MIN	ØFA MIN	J /12/ ALLOWABLE TUBE GAP STANDARD LENGTH /16/	J /12/ ALLOWABLE TUBE GAP EXTENDED LENGTH /16/
			STANDARD LENGTH /16/	EXTENDED LENGTH /16/	STANDARD LENGTH /16/	EXTENDED LENGTH /16/							
0404	.250	.250	2.156	1.830	3.536	3.210	.406	.435	.435	.253	.253	0 – 1.000	0 – 2.380
0505	.3125	.3125	2.416	2.106	4.066	3.756	.471	.503	.503	.3155	.3155	0 – 1.000	0 – 2.650
0606	.375	.375	2.714	2.244	4.504	4.034	.563	.580	.580	.378	.378	0 – 1.000	0 – 2.790
0808	.500	.500	3.120	2.592	5.250	4.722	.695	.755	.755	.503	.503	0 – 1.000	0 – 3.130
1010	.625	.625	3.130	2.626	5.310	4.806	.857	.929	.929	.629	.629	0 – 1.000	0 – 3.180
1212	.750	.750	3.410	2.830	5.790	5.210	1.002	1.150	1.150	.754	.754	0 – 1.000	0 – 3.380
1616	1.000	1.000	4.150	3.378	7.525	6.753	1.324	1.474	1.474	1.004	1.004	0 – 1.000	0 – 4.375
2020	1.250	1.250	4.700	3.836	8.540	7.676	1.588	1.768	1.768	1.255	1.255	0 – 1.000	0 – 4.840
2424	1.500	1.500	5.420	4.404	9.820	8.804	1.832	2.070	2.070	1.505	1.505	0 – 1.000	0 – 5.400

TABLE 1B - DIMENSIONS W THROUGH W4A AND WEIGHTS

BASIC NO. AS6323 /15/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	W MIN	WA MIN	W1 MAX	W1A MAX	ØW2 ±.002	ØW2A ±.002	RW3 MAX	RW3A MAX	RW4 MAX	RW4A MAX	WEIGHT APPROX LB/EA STANDARD LENGTH	WEIGHT APPROX LB/EA EXTENDED LENGTH
0404	.250	.250	.185	.185	.604	.604	.320	.320	.020	.020	.020	.020	.015	.025
0505	.3125	.3125	.180	.180	.724	.724	.371	.371	.020	.020	.020	.020	.020	.035
0606	.375	.375	.195	.195	.883	.883	.463	.463	.020	.020	.020	.020	.030	.050
0808	.500	.500	.210	.210	1.076	1.076	.595	.595	.020	.020	.020	.020	.055	.085
1010	.625	.625	.225	.225	1.076	1.076	.758	.758	.020	.020	.020	.020	.080	.130
1212	.750	.750	.235	.235	1.201	1.201	.903	.903	.025	.025	.025	.025	.130	.205
1616	1.000	1.000	.260	.260	1.566	1.566	1.196	1.196	.035	.035	.035	.035	.255	.440
2020	1.250	1.250	.285	.285	1.829	1.829	1.460	1.460	.035	.035	.035	.035	.395	.665
2424	1.500	1.500	.310	.310	2.178	2.178	1.704	1.704	.035	.035	.035	.035	.595	.950

NOTES:

/1/ MATERIALS:

CODE LETTER "D"

BODY - TYPE 6061-T6 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/8 OR AMS4117.

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.

/3/ COATINGS/LUBRICANTS:

BODY

- DRY FILM LUBRICANT PER AS5272 TYPE I SHALL BE APPLIED TO THE OD 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.
- POLYTETRAFLUOROETHYLENE (PTFE) COAT, LIGHT GREEN, SHALL BE APPLIED TO PORTIONS OF ID (BORE) UP TO THE FIRST GROOVE. OVERSPRAY IN GROOVE IS NOT PERMITTED.
- A MINIMUM OF TWO GROOVES (END SIZE -.05 AND LARGER) SHALL BE FILLED WITH ELASTOMERIC DIMETHYL SILOXANE COMPOUND. FOR SMALLER SIZE ENDS, A MINIMUM OF ONE GROOVE SHALL BE FILLED WITH THE COMPOUND.

	AEROSPACE STANDARD		AS6323™ SHEET 2 OF 3 
	FITTING ASSEMBLY, EXTENDED UNION, AXIALLY SWAGED, HYDRAULIC, UP TO 1500 PSI		