

RATIONALE

NEW STANDARD FOR OPERATING PRESSURES UP TO AND INCLUDING 3000 PSI

AS6472™

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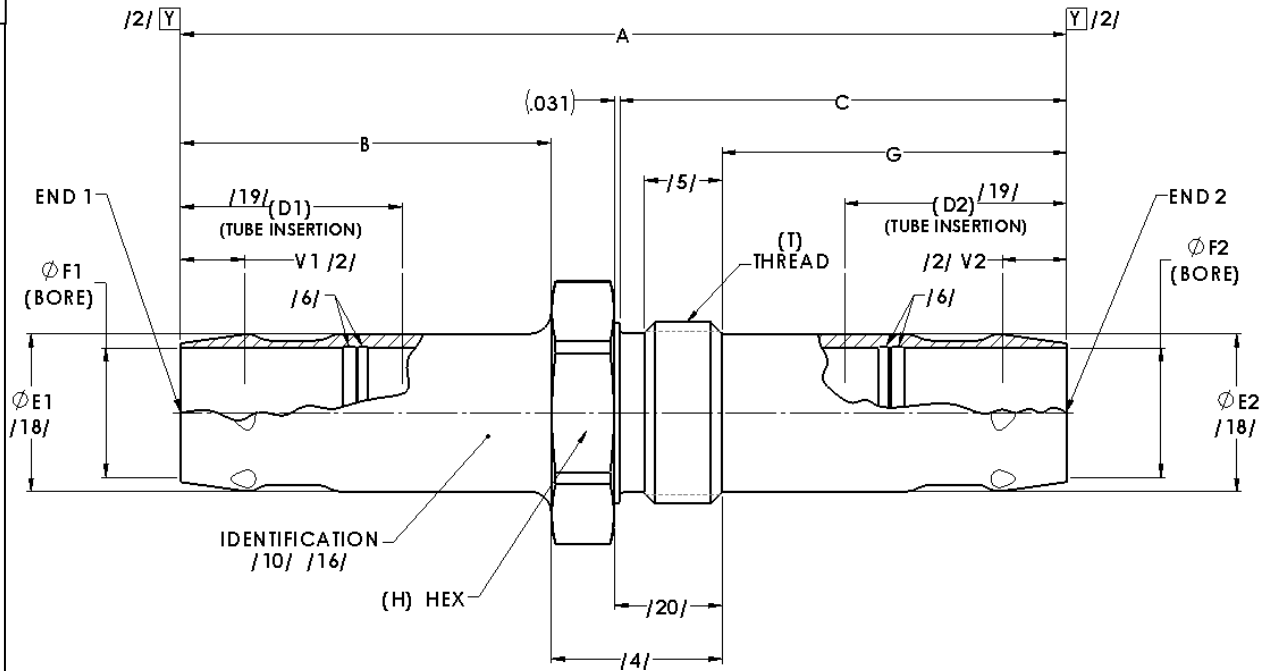
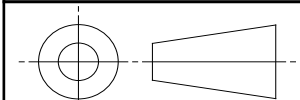


FIGURE 1 – UNION, BULKHEAD, EXTERNAL SWAGE

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THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /7/ AS4459



AEROSPACE STANDARD

FITTING, UNION, BULKHEAD,
EXTERNAL SWAGE, HYDRAULIC

AS6472™
SHEET 1 OF 3

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TABLE 1A - DIMENSIONS A THROUGH F2

BASIC NO. AS6472 /16/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	A	B +.015 -.000	C +.015 -.000	(D1) /19/	(D2) /19/	E1 +.000 -.003 /18/	E2 +.000 -.003 /18/	F1 /2/	F2 /2/
0404	.250	.250	3.110-3.140	1.200	1.650	.615	.615	.338	.338	.257-.260	.257-.260
0505	.3125	.3125	3.173-3.203	1.234	1.680	.655	.655	.413	.413	.319-.322	.319-.322
0606	.375	.375	3.310-3.340	1.260	1.720	.690	.690	.480	.480	.382-.385	.382-.385
0808	.500	.500	5.188-5.218	2.220	2.615	1.193	1.193	.655	.655	.508-.511	.508-.511
1010	.625	.625	5.188-5.218	2.220	2.615	1.233	1.233	.787	.787	.633-.636	.633-.636
1212	.750	.750	5.188-5.218	2.170	2.615	1.303	1.303	.929	.929	.758-.761	.758-.761
1616	1.000	1.000	6.395-6.425	2.770	3.235	1.448	1.448	1.257	1.257	1.008-1.011	1.008-1.011
2020	1.250	1.250	6.395-6.425	2.770	3.235	1.550	1.550	1.489	1.489	1.258-1.262	1.258-1.262
2424	1.500	1.500	6.357-6.387	2.696	3.280	1.675	1.675	1.786	1.786	1.513-1.517	1.513-1.517

TABLE 1B - THREAD, DIMENSIONS G THROUGH V2 AND WEIGHTS

BASIC NO. AS6472 /16/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	G ±.015	(H)	(T) THREAD PER AS8879	V1 /2/	V2 /2/	WEIGHT APPROX LB/EA CRES	WEIGHT APPROX LB/EA TI	WEIGHT APPROX LB/EA AL
0404	.250	.250	1.203	.688	.4375-20 UNJF-3A	.190-.240	.190-.240	.072	.041	.025
0505	.3125	.3125	1.235	.750	.5000-20 UNJF-3A	.200-.250	.200-.250	.090	.051	.031
0606	.375	.375	1.256	.813	.5625-18 UNJF-3A	.220-.270	.220-.270	.108	.062	.038
0808	.500	.500	2.122	1.000	.7500-16 UNJF-3A	.410-.435	.410-.435	.250	.143	.089
1010	.625	.625	2.063	1.125	.8750-14 UNJF-3A	.410-.435	.410-.435	.319	.183	.114
1212	.750	.750	2.020	1.375	1.0625-12 UNJ-3A	.365-.390	.365-.390	.415	.238	.148
1616	1.000	1.000	2.640	1.625	1.3125-12 UNJ-3A	.325-.350	.325-.350	.553	.317	.197
2020	1.250	1.250	2.640	1.875	1.6250-12 UNJ-3A	.325-.350	.325-.350	.691	.396	.246
2424	1.500	1.500	2.606	2.500	2.5000-12 UNJ-3A	.325-.350	.325-.350	.829	.475	.295

NOTES:

/1/ MATERIAL:

- A. CODE LETTER "-": 21-6-9 CORROSION RESISTANT STEEL (CRES) BAR PER AMS5656
- B. CODE LETTER "E": COMMERCIALLY PURE TITANIUM BAR PER AMS4921
- C. CODE LETTER "D": 6061-T6 ALUMINUM ALLOY PER AMS4117

/2/ FINISH AND COATING:

- A. MATERIAL CODE "-": PASSIVATE THE WHOLE PART PER AMS2700. POLYTETRAFLUOROETHYLENE (PTFE) COATING (GREEN) SHALL BE APPLIED TO FITTING BORE DIAMETER TO "V" DEPTH. OVERSPRAY ON /Y/ IS PERMITTED. OVERSPRAY IN GROOVE IS NOT PERMITTED. DIMENSION "F" APPLIES BEFORE PTFE COATING.
- B. MATERIAL CODE "E": FLUORIDE CONVERSION COATING PER AMS2486 /5/. POLYTETRAFLUOROETHYLENE (PTFE) COATING (BLACK) SHALL BE APPLIED TO EXTERIOR SURFACES EXCEPT /4/, AND TO BORE DIAMETER TO "V" DEPTH. OVERSPRAY ON /Y/ IS PERMITTED. OVERSPRAY IN GROOVE IS NOT PERMITTED. DIMENSIONS "E" AND "F" APPLY BEFORE PTFE COATING. /18/
- C. MATERIAL CODE "D": CHEMICAL CONVERSION COAT ENTIRE PART (INCLUDING INTERNAL DIAMETERS) PER MIL-DTL-5541, CLASS 1A. POLYTETRAFLUOROETHYLENE (PTFE) COATING (GREEN) SHALL BE APPLIED TO EXTERIOR SURFACES EXCEPT /4/, AND TO BORE DIAMETER TO "V" DEPTH. OVERSPRAY ON /Y/ IS PERMITTED. OVERSPRAY IN GROOVE IS NOT PERMITTED. DIMENSIONS "E" AND "F" APPLY BEFORE PTFE COATING. /18/
PART NUMBERS WITH SUFFIX CODE "P" SHALL INCLUDE A PROTECTIVE ANODIZE LAYER (GREEN) PER MIL-A-8625, TYPE II CLASS 2 WITH SEAL. /5/

- 3. LIQUID PENETRANT INSPECT PER ASTM E1417/E1417M TYPE 1 SENSITIVITY LEVEL 2 MINIMUM, BEFORE COATING. THE PARTING PLANES SHALL NOT EXHIBIT TEARS OR CRACK LIKE INDICATIONS.

	AEROSPACE STANDARD		AS6472™ SHEET 2 OF 3	
	FITTING, UNION, BULKHEAD, EXTERNAL SWAGE, HYDRAULIC			

