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REV.
B

AS85421™/6

FEDERAL SUPPLY CLASS
4730

RATIONALE

CORRECT TYPO, CHANGE AMS2700 TYPE 6 OR 7 TO 2 OR 8. UPDATE PROCUREMENT SPECIFICATION NOTE TO CURRENT QPL VERBIAGE. REVISE OUTDATED SPECIFICATIONS BY CURRENT REPLACEMENT. INVENTORY DISPOSITION NOTE 17 ADDED.

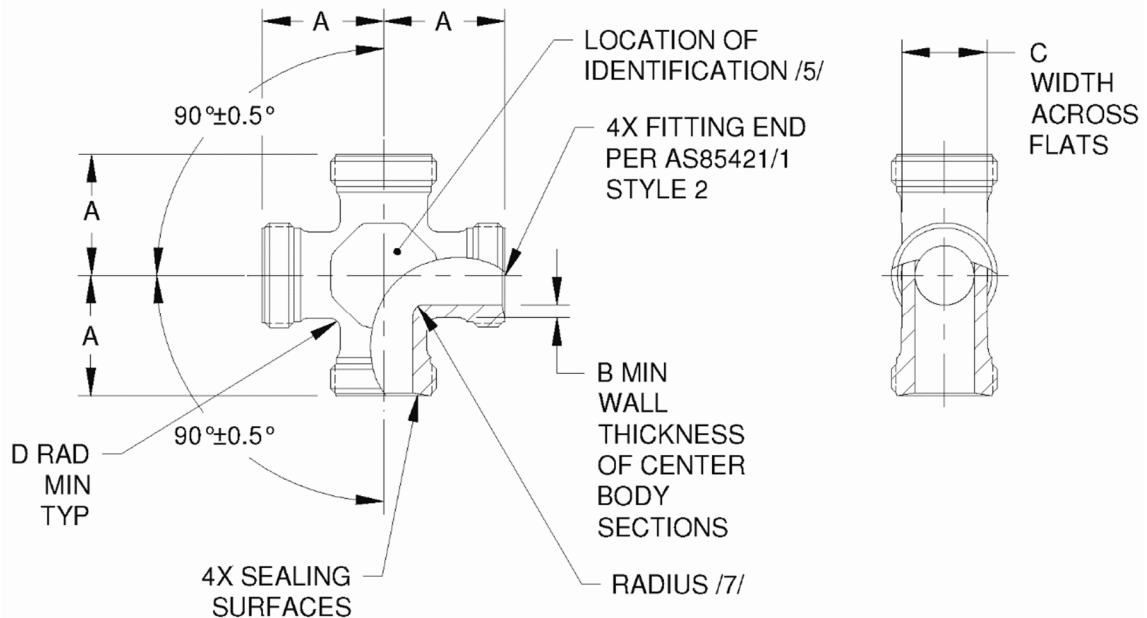


FIGURE 1 - FITTING, CROSS

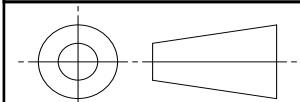
TABLE 1 - DIMENSIONS A-D AND WEIGHTS

BASIC NO. AS85421/6 /15/ SIZE CODE	TUBE OD	A	B	C	D	MASS LB/EA APPROX REF TI	MASS LB/EA APPROX REF CRES
03	.188	.575	.055	.360- .377	.042	.030	.054
04	.250	.617	.060	.360- .377	.042	.036	.063
05	.312	.653	.060	.423- .440	.042	.047	.084
06	.375	.704	.060	.485- .502	.042	.058	.103
08	.500	.824	.065	.547- .565	.070	.092	.163
10	.625	.955	.070	.673- .691	.070	.130	.230
12	.750	1.065	.095	.860- .878	.098	.191	.339
14	.875	1.216	.105	1.110-1.128	.098	.343	.608
16	1.000	1.246	.110	1.110-1.128	.098	.316	.559
20	1.250	1.387	.110	1.355-1.380	.098	.483	.855
24	1.500	1.688	.130	1.605-1.630	.098	.827	1.463

For more information on this standard, visit

<https://www.sae.org/standards/content/AS85421/6B/>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS85421 /4/



AEROSPACE STANDARD

FITTING, CROSS,
BEAM SEAL, 3000/4000 PSI,
MALE ENDS

AS85421™/6
SHEET 1 OF 3

REV.
B

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NOTES:

/1/ MATERIAL:

- a. CODE LETTER P: TYPE 17-4PH CORROSION RESISTANT STEEL BAR OR FORGING PER AMS5643.
- b. CODE LETTER T: TYPE 6AL-4V TITANIUM ALLOY BAR OR FORGING PER AMS4965.
- c. CODE LETTER V: TYPE 15-5PH CORROSION RESISTANT STEEL BAR OR FORGING PER AMS5659.

2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER P: CONDITION H1075 PER AMS2759/3.
- b. MATERIAL CODE LETTER T: NONE.
- c. MATERIAL CODE LETTER V: CONDITION H1075 PER AMS-H-6875 OR AMS2759/3.

3. FINISH:

- a. MATERIAL CODE LETTER P: PASSIVATE PER AMS2700, TYPE 2 OR 8.
- b. MATERIAL CODE LETTER T: NONE.
- c. MATERIAL CODE LETTER V: PASSIVATE PER AMS2700, TYPE 2 OR 8.

/4/ PROCUREMENT SPECIFICATION: AS85421, EXCEPT AS SPECIFIED ON THIS STANDARD. PRODUCT MANUFACTURED TO THIS STANDARD SHALL MEET THE REQUIREMENTS SPECIFIED HEREIN AND THE PROCUREMENT SPECIFICATION. ORIGINAL COMPONENT MANUFACTURERS (OCM) SHALL BE LISTED IN THE PRI QUALIFIED PRODUCTS LIST (QPL) PRI-QPL-AS85421 FOR THIS STANDARD. SEE www.eAuditNet.com FOR CURRENT QPL ONLINE.

/5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D, OR METHOD 7A3, 15A3, OR 15B.

- a. FOR SIZES 06 AND SMALLER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, LETTERS "AS" AND MATERIAL CODE LETTER, AND FORGING MANUFACTURER'S IDENTIFICATION, WHEN MADE FROM FORGING.
- b. FOR SIZES 08 AND LARGER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, BASIC PART NUMBER AND MATERIAL CODE LETTER, AND FORGING MANUFACTURER'S IDENTIFICATION, WHEN MADE FROM FORGING.

6. INTENDED USE: THIS PART IS DESIGNED FOR USE IN SYSTEMS WITH MAXIMUM OPERATING PRESSURES AS FOLLOWS:

- a. CORROSION RESISTANT STEEL AT 3000 PSI MAX.
- b. TITANIUM ALLOY AT 4000 PSI MAX.

/7/ .030 MIN RADIUS, UNLESS QUALIFICATION OF SPECIAL PROCESS WITH SMALLER RADIUS. APPLICABLE FOR TITANIUM ALLOY PARTS ONLY.

8. DRY FILM LUBRICANT: APPLY DRY FILM LUBRICANT PER AS5272, TYPE I TO SEALING SURFACE. OVERSPRAY IN BORE IS NOT PERMITTED.

9. INTERPRETATION OF DRAWING PER AS4296.

10. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 MICROINCHES Ra. FORGED SURFACES MAY BE 250 MICROINCHES Ra.

11. BREAK EDGES .003 TO .010, UNLESS OTHERWISE SPECIFIED.

12. DIMENSIONING AND TOLERANCING: ASME Y14.5M-1994.

13. DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS ± 0.015 , ANGULAR DIMENSIONS $\pm 0^{\circ}30'$.

14. WHEN MACHINED FROM BAR OR OVERSIZED FORGINGS, THE CENTER BODY SECTION SHALL CONFORM TO AS1376 TABLE 4.

	AEROSPACE STANDARD	AS85421™/6	REV.
	FITTING, CROSS, BEAM SEAL, 3000/4000 PSI, MALE ENDS	SHEET 2 OF 3	B



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