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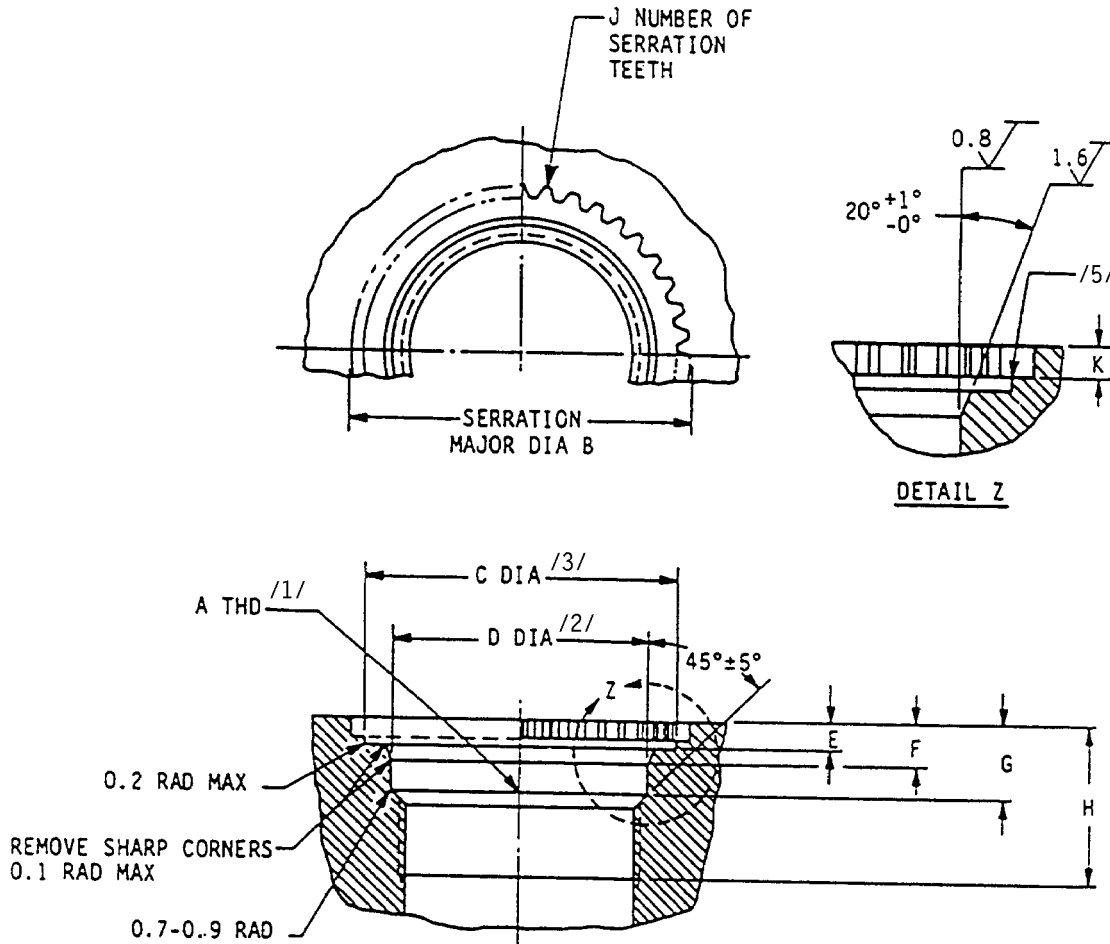
REV.
A

MA2110

FEDERAL SUPPLY CLASS
4730

RATIONALE

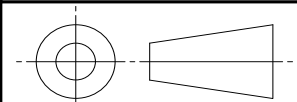
MA2110A HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.



AECMA interest: Future revisions of this Standard shall be coordinated with AECMA C-4.

SAE values your input. To provide feedback
on this Technical Report, please visit
<http://www.sae.org/technical/standards/MA2110A>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: MA2005 (ISO 7169)



AEROSPACE STANDARD

PORT, RING LOCKED DESIGN STANDARD
DIMENSIONS FOR

MA2110
SHEET 1 OF 2

REV.
A

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PORT NUMBER	A THREAD		B SERRATION MAJOR DIA MIN	C DIA /3/	D DIA /2/	E
	-4H5H	CONTROLLED MINOR DIA				
MA2110-077	MJ6x1	5.065- 5.141	13.13	12.01-12.09	7.37- 7.42	2.90-3.15
MA2110-098	MJ8x1	7.065- 7.141	15.01	14.02-14.10	9.33- 9.38	3.30-3.55
MA2110-125	MJ10x1	9.065- 9.141	18.08	17.04-17.12	11.34-11.39	3.80-4.05
MA2110-136	MJ12x1.25	10.821-10.898	19.76	18.64-18.72	13.06-13.11	3.80-4.05
MA2110-153	MJ14x1.5	12.576-12.652	21.29	20.22-20.30	14.66-14.71	3.80-4.05
MA2110-170	MJ16x1.5	14.576-14.652	22.89	21.82-21.90	16.64-16.69	3.80-4.05
MA2110-192	MJ18x1.5	16.576-16.652	26.72	25.40-25.48	18.65-18.70	3.80-4.05
MA2110-214	MJ20x1.5	18.576-18.652	28.30	27.05-27.13	20.66-20.71	3.80-4.05
MA2110-231	MJ22x1.5	20.576-20.652	30.45	29.36-29.44	22.68-22.73	3.80-4.05
MA2110-253	MJ24x1.5	22.576-22.652	34.01	32.54-32.62	24.66-24.71	3.80-4.05
MA2110-295	MJ27x1.5	25.576-25.652	37.34	36.04-36.12	27.66-27.71	3.80-4.05
MA2110-320	MJ30x1.5	28.576-28.652	41.25	39.67-39.75	30.68-30.73	3.80-4.05
MA2110-350	MJ33x1.5	31.576-31.652	43.33	42.06-42.14	33.68-33.73	3.80-4.05
MA2110-381	MJ36x1.5	34.576-34.652	50.82	49.20-49.28	36.66-36.71	4.10-4.35
MA2110-452	MJ42x2	40.088-40.164	59.44	57.93-58.01	42.04-42.09	4.10-4.35

PORT NUMBER	F	G	H MIN FULL THREAD DEPTH	J NO. OF TEETH	K MIN	TOOLING /6/	
						PORTING TOOL NO. REF	PREBROACH TOOL NO. REF
MA2110-077	5.26- 5.39	8.40- 8.53	14.20	23	1.9	RPTM077	RFMOPB077
MA2110-098	5.82- 5.95	9.00- 9.13	15.40	27	2.3	RPTM098	RFMOPB098
MA2110-125	6.36- 6.49	9.50- 9.63	16.65	31	2.7	RPTM125	RFMOPB125
MA2110-136	6.36- 6.49	9.50- 9.63	17.35	40	2.7	RPTM136	RFMOPB136
MA2110-153	6.36- 6.49	9.50- 9.63	18.00	38	2.7	RPTM153	RFMOPB153
MA2110-170	6.36- 6.49	9.50- 9.63	18.65	40	2.7	RPTM170	RFMOPB170
MA2110-192	6.36- 6.49	9.50- 9.63	19.30	38	2.7	RPTM192	RFMOPB192
MA2110-214	7.36- 7.49	10.50-10.63	21.00	43	2.7	RPTM214	RFMOPB214
MA2110-231	7.36- 7.49	10.50-10.63	21.70	46	2.7	RPTM231	RFMOPB231
MA2110-253	7.36- 7.49	10.50-10.63	22.35	36	2.7	RPTM253	RFMOPB253
MA2110-295	7.36- 7.49	10.50-10.63	23.40	47	2.7	RPTM295	RFMOPB295
MA2110-320	7.36- 7.49	10.50-10.63	24.40	32	2.7	RPTM320	RFMOPB320
MA2110-350	7.36- 7.49	10.50-10.63	25.40	53	2.7	RPTM350	RFMOPB350
MA2110-381	9.76- 9.89	13.10-13.23	28.90	40	3.9	RPTM381	RFMOPB381
MA2110-452	12.66-12.79	16.00-16.13	33.70	40	3.9	RPTM452	RFMOPB452

NOTES:

- /1/ THREADS IN ACCORDANCE WITH AS1370 (ISO 5855).
- /2/ THREAD PITCH DIA AND "D" MUST BE CONCENTRIC WITHIN 0.08 FIM.
- /3/ THREAD PITCH DIA MUST BE CONCENTRIC WITHIN 0.08 FIM TO "C" DIA.
4. THE DRILL AND PORTING TOOL METHOD OF PREPARING THE MACHINED CAVITY IS MANDATORY. DRILL 0.4-0.7 SMALLER THAN CONTROLLED MINOR DIA SPECIFIED. THE PORTING TOOL WILL SIZE THE MINOR DIA AND PROVIDE BALANCE OF CAVITY CONFIGURATION READY FOR BROACHING SERRATION. USE OF PREBROACH TOOL SPECIFIED IS MANDATORY TO PROVIDE PROPER SERRATIONS.
- /5/ AFTER SERRATIONS ARE BROACHED, CHIP REMOVAL IS REQUIRED.
- /6/ THIS PORT REQUIRES SPECIAL TOOLING FOR PROPER INSTALLATION. THIS TOOLING IS AVAILABLE FROM ROSAN PRODUCTS, 3130 W. HARVARD ST., SANTA ANA, CA. 92704.

	AEROSPACE STANDARD		MA2110 SHEET 2 OF 3	REV. A
	PORT, RING LOCKED DESIGN STANDARD DIMENSIONS FOR			



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