

MA2263

FEDERAL SUPPLY CLASS
4730

RATIONALE

MA2263 HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

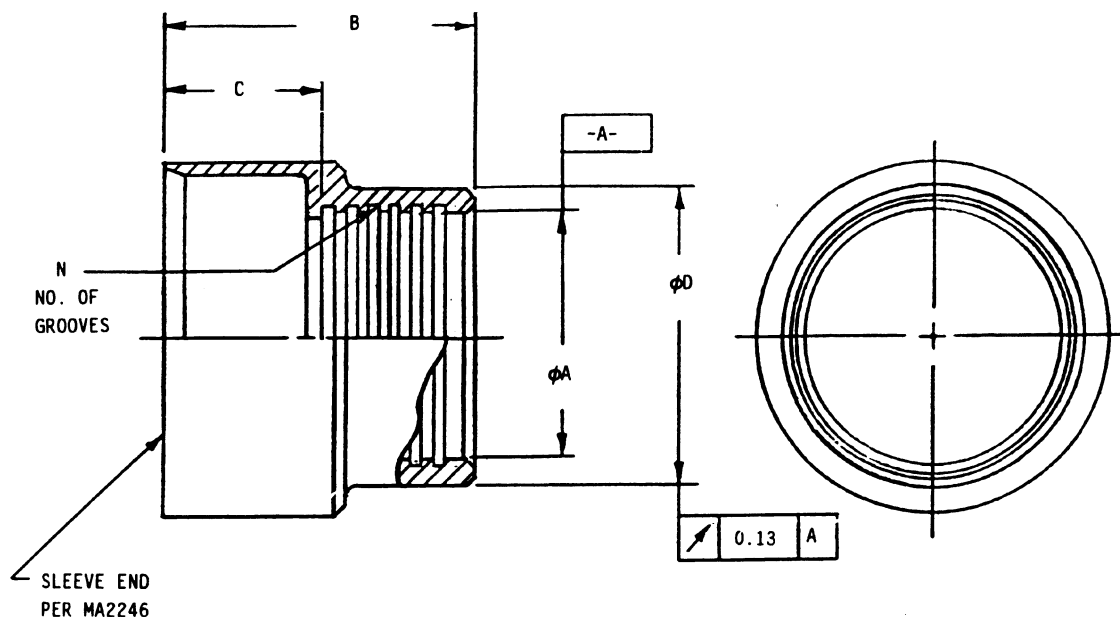


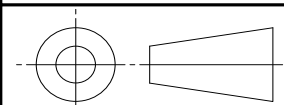
FIGURE 1 - SLEEVE FERRULE SWAGED

TABLE 1 - FERRULE DIMENSIONS IN MM AND WEIGHT IN KG

BASIC NUMBER MA2263	DN SIZE CODE	TUBE SIZE MM	(TUBE SIZE IN)	/6/ A MIN	/6/ B MAX	C	/6/ D MAX	/6/ N MAX	MAXIMUM WEIGHT KG/EA ALUMINUM	MAXIMUM WEIGHT KG/EA CRES	MAXIMUM WEIGHT KG/EA TITANIUM
	12	12	.500	12.10	24.51	13.12	15.88	4	0.005	0.014	0.008
	16	16	.625	16.13	24.51	13.12	19.05	4	0.006	0.017	0.010
	18	18	.750	18.13	26.54	15.14	22.61	4	0.008	0.023	0.013
	25	25	1.000	25.13	30.56	17.17	29.01	5	0.012	0.034	0.020
	32	32	1.250	32.15	30.56	17.17	35.36	5	0.015	0.041	0.023
	38	38	1.500	38.15	32.82	17.17	41.01	6	0.019	0.053	0.031
	45	45	1.750	45.15	32.82	17.17	48.06	6	0.022	0.061	0.034
	50	50	2.000	50.15	33.83	17.93	54.48	6	0.026	0.073	0.041
	56	56	2.250	56.15	34.24	17.93	60.83	6	0.029	0.082	0.046
	63	63	2.500	63.18	34.24	17.93	67.18	6	0.032	0.090	0.057
	76	76	3.000	76.18	34.24	17.93	79.88	6	0.038	0.107	0.060
	88	88	3.500	88.23	35.00	17.93	92.58	7	0.044	0.126	0.072
	100	100	4.000	100.23	39.52	17.93	105.51	8	0.059	0.168	0.095

SAE values your input. To provide feedback
on this Technical Report, please visit
<http://www.sae.org/technical/standards/MA2263>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3A

PROCUREMENT SPECIFICATION: MA2241 /3/



AEROSPACE STANDARD

FERRULE, SLEEVE, SWAGED, THREADLESS,
COUPLING, FLEXIBLE, FIXED CAVITY, SELF-BONDING,
METRIC

MA2263
SHEET 1 OF 2

Documents

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NOTES:

/1/ MATERIAL:

- a. CODE "A" - 2024-T6 OR T851 ALUMINUM ALLOY PER QQ-A-225/6 OR 2024-T81 OR T8510 ALUMINUM ALLOY PER QQ-A-200/3
- b. CODE "C" - 17-4PH CORROSION RESISTING STEEL, COND. H1075, PER AMS 5643 OR 15-5PH CORROSION RESISTING STEEL, COND. H1150, PER AMS 5659
- c. CODE "T" - 6AL-4V TITANIUM ALLOY PER MIL-T-9047 OR AMS 4928

2. FINISH:

- a. MATERIAL CODE "A" - CHEMICAL CONVERSION COAT PER MIL-C-5541, CLASS 3
- b. MATERIAL CODE "C" - PASSIVATE PER QQ-P-35
- c. MATERIAL CODE "T" - NONE

/3/ THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION IN A COMPLETE ASSEMBLY (SEE MA2242). USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.

/4/ IDENTIFICATION: INK STAMP, 1.58 mm OR LARGER LETTERS, WITH THE FOLLOWING MINIMUM INFORMATION: MANUFACTURER'S NAME, TRADEMARK OR CAGE NUMBER, COMPLETE "MA" NUMBER, AND DATE OF MANUFACTURE IN QUARTERS (1Q91 - FIRST QUARTER 1991). SIZES 18 AND SMALLER MAY BE INDIVIDUALLY BAGGED WITH A TAG CONTAINING THE ABOVE INFORMATION.

5. RATED OPERATING CHARACTERISTICS: SEE MA2241.

/6/ SPECIFIC DIMENSIONS AND TOLERANCES ARE SPECIFIED AND CONTROLLED BY THE SUPPLIER. THE SUPPLIER IS RESPONSIBLE TO ENSURE COMPATIBILITY WITH THE ASSEMBLY AND COMPLIANCE WITH THE REQUIREMENTS OF THE PROCUREMENT SPECIFICATION.

7. TUBING SIZES ARE PER ISO 2964-1974 EXCEPT AS NOTED.

/8/ THESE FERRULES FIT COUPLING ASSEMBLIES THAT USE NONSTANDARD TUBING DIAMETERS.

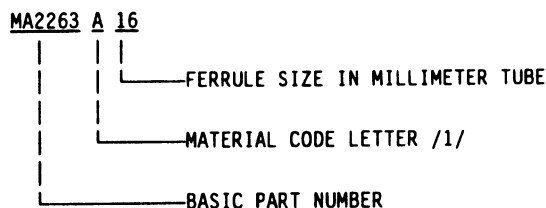
9. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36; REQUIREMENTS PER ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 3.2 μ m Ra.

10. BREAK EDGES 0.08 TO 0.38 UNLESS OTHERWISE SPECIFIED.

11. DIMENSIONING AND TOLERANCING: ANSI Y14.5M.

12. DIMENSIONS IN MILLIMETERS, UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS ± 0.13 , ANGULAR DIMENSIONS $\pm 0.5^\circ$.

13. EXAMPLE OF PART NUMBER:



	AEROSPACE STANDARD		MA2263 SHEET 2 OF 2	 Documents
	FERRULE, SLEEVE, BUTT WELD, THREADLESS, COUPLING, FLEXIBLE, FIXED CAVITY, SELF-BONDING, METRIC			

