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MA2306

FEDERAL SUPPLY CLASS
4730

RATIONALE

MA2306 HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

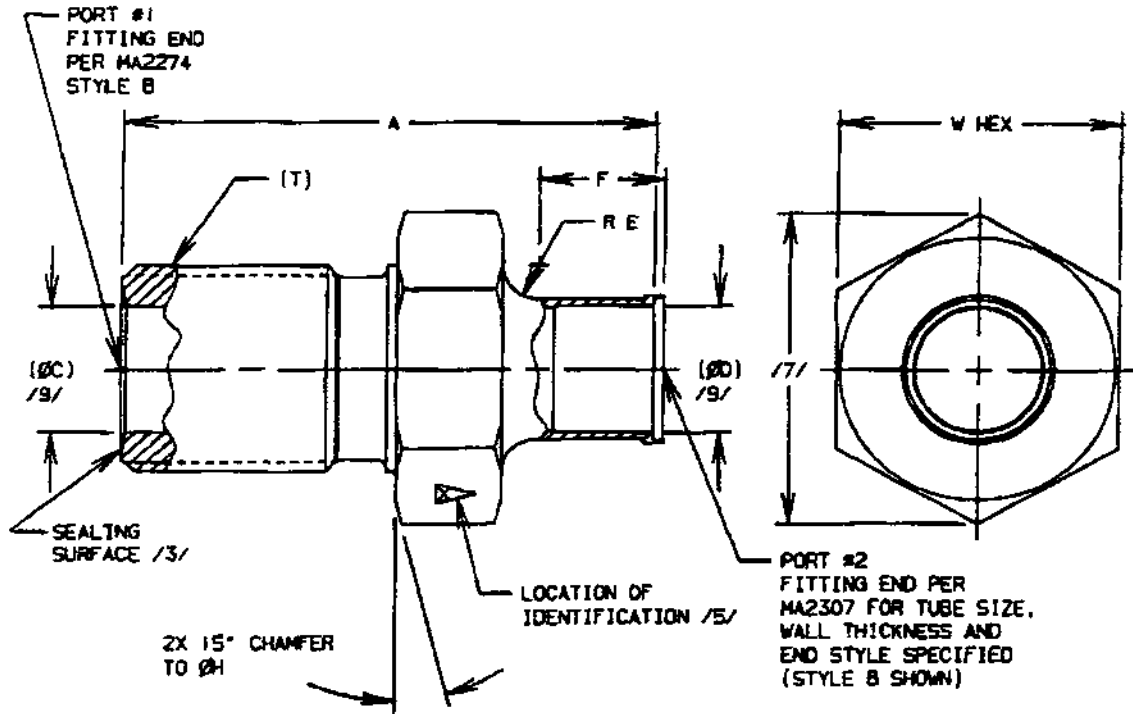


FIGURE 1 - FITTING, ADAPTER, BULKHEAD

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CUSTODIAN: G-3/G-3B /8/

PROCUREMENT SPECIFICATION: /4/ MA4510



AEROSPACE STANDARD

FITTING, ADAPTER, BULKHEAD, EXTERNAL THREAD
BEAM SEAL TO INTEGRAL WELD RING, METRIC

MA2306
SHEET 1 OF 3

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TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. MA2306 /15/	(NOMINAL TUBE SIZE DN) /1/	Y THREAD PER MA1370 (ISO 585/3) 4g 6g	PORT #2 STYLE	A ±0.3	C	D	E +0.2 0	F	H ±0.25	W	OPERATING PRESSURE kPa	Kg/EA MAX Tl
0504	5	MJ 10 X 1	A	38.0	-	4.15	2.5	11.2	13.35	13.60-14.06	28,000	.0119
0605	6	MJ 12 X 1.25	A	40.0	-	4.95	3.0	10.7	16.35	16.6 -17.1	28,000	.0178
0805	8	MJ 14 X 1.5	B	42.0	6.8	6.95	3.0	10.7	18.35	18.6 -19.1	21,000	.0218
0806	8	MJ 14 X 1.5	A	42.0	-	6.75	3.0	10.7	18.35	18.6 -19.1	28,000	.0220
1005	10	MJ 16 X 1.5	B	43.0	8.8	8.95	3.0	10.7	21.35	21.6 -22.1	21,000	.0277
1008	10	MJ 16 X 1.5	A	43.0	-	8.35	3.0	10.7	21.35	21.6 -22.1	28,000	.0384
1205	12	MJ 18 X 1.5	B	45.0	10.7	10.95	3.0	10.8	23.35	23.6 -24.1	14,000	.0347
1206	12	MJ 18 X 1.5	B	45.0	10.7	10.75	3.0	10.8	23.35	23.6 -24.1	21,000	.0349
1209	12	MJ 18 X 1.5	A	45.0	-	10.15	3.0	10.8	23.35	23.6 -24.1	28,000	.0357
1405	14	MJ 20 X 1.5	B	46.0	11.5	12.95	3.0	11.8	26.35	26.6 -27.1	14,000	.0438
1408	14	MJ 20 X 1.5	B	46.0	11.5	12.35	3.0	11.8	26.35	26.6 -27.1	21,000	.0449
1410	14	MJ 20 X 1.5	B	46.0	11.5	11.95	3.0	11.8	26.35	26.6 -27.1	28,000	.0455
1606	16	MJ 22 X 1.5	B	48.0	13.4	14.75	3.0	13.8	29.05	29.3 -30.1	14,000	.0559
1610	16	MJ 22 X 1.5	B	48.0	13.4	13.95	3.0	13.8	29.05	29.3 -30.1	21,000	.0576
1612	16	MJ 22 X 1.5	B	48.0	13.4	13.55	3.0	13.8	29.05	29.3 -30.1	28,000	.0584
1807	18	MJ 24 X 1.5	B	50.0	15.4	16.55	4.0	14.9	31.05	31.3 -32.1	14,000	.0590
1810	18	MJ 24 X 1.5	B	50.0	15.4	15.95	4.0	14.9	31.05	31.3 -32.1	21,000	.0606
1813	18	MJ 24 X 1.5	A	50.0	-	15.35	4.0	14.9	31.05	31.3 -32.1	28,000	.0621
2007	20	MJ 27 X 1.5	B	51.0	18.1	18.55	4.0	15.9	33.05	33.3 -34.1	14,000	.0671
2012	20	MJ 27 X 1.5	A	51.0	-	17.55	4.0	15.9	33.05	33.3 -34.1	21,000	.0701
2015	20	MJ 27 X 1.5	A	51.0	-	16.95	4.0	15.9	33.05	33.3 -34.1	28,000	.0718
2208	22	MJ 30 X 1.5	A	51.0	-	20.35	4.0	15.9	35.05	35.3 -36.2	14,000	.0755
2212	22	MJ 30 X 1.5	A	51.0	-	19.55	4.0	15.9	35.05	35.3 -36.2	21,000	.0782
2216	22	MJ 30 X 1.5	A	51.0	-	18.75	4.0	15.9	35.05	35.3 -36.2	28,000	.0807
2509	25	MJ 33 X 1.5	B	52.0	22.5	23.15	4.0	17.0	40.05	40.3 -41.2	14,000	.0981
2514	25	MJ 33 X 1.5	A	52.0	-	22.15	4.0	17.0	40.05	40.3 -41.2	21,000	.102
2518	25	MJ 33 X 1.5	A	52.0	-	21.35	4.0	17.0	40.05	40.3 -41.2	28,000	.105
2810	28	MJ 36 X 1.5	B	53.5	25.7	25.95	4.0	17.1	45.05	45.3 -46.2	14,000	.118
2816	28	MJ 36 X 1.5	A	53.5	-	24.75	4.0	17.1	45.05	45.3 -46.2	21,000	.123
2820	28	MJ 36 X 1.5	A	53.5	-	23.95	4.0	17.1	45.05	45.3 -46.2	28,000	.126
3212	32	MJ 39 X 1.5	B	55.5	28.4	29.55	4.0	19.2	49.05	49.3 -50.2	14,000	.145

NOTES:

- /1/ DN = NOMINAL TUBE OUTSIDE DIAMETER.
- /2/ MATERIAL:
 - a. CODE LETTER T - TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS 4965.
- /3/ FINISH: NONE. APPLY DRY FILM LUBRICANT PER MIL-L-46010, TYPE I TO SEALING SURFACE OF THE MA2274 FITTING END. OVERSPRAY IN BORE IS NOT PERMITTED.
- /4/ PROCUREMENT SPECIFICATION: MA4510 EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION IN A COMPLETE ASSEMBLY. THE MA2274 FITTING END SHALL HAVE BEEN QUALIFIED TO THE APPLICABLE REQUIREMENTS. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.
- /5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B.
 - a. FOR SIZES DN10 AND SMALLER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, MATERIAL CODE LETTER AND PRESSURE RATING (EXAMPLE: 28K = 28,000 kPa).
 - b. FOR SIZES DN12 AND LARGER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, BASIC PART NUMBER, MATERIAL CODE LETTER AND PRESSURE RATING (EXAMPLE: 28K = 28,000 kPa).
6. THIS PART IS DESIGNED FOR USE IN SYSTEMS WITH OPERATING PRESSURES AS FOLLOWS:
 - a. SIZES DN05 THROUGH DN28 AT 28,000 kPa.
 - b. SIZE DN32 AT 14,000 kPa.
- /7/ THE HEX CORNERS MAY BE ROUNDED PER ARP1942.
- /8/ REVISIONS OF THIS STANDARD SHALL BE COORDINATED WITH SAE COMMITTEE E-25.
- /9/ IF PORT #2 IS STYLE A, ϕD WILL EXTEND THROUGHOUT THE PART AND ϕC WILL NOT APPLY.
10. INTERPRETATION OF DRAWING PER MAP4296.
11. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36; REQUIREMENTS PER ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 3.2 μm Ra.



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 BEAM SEAL TO INTEGRAL WELD RING, METRIC

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SHEET OF 3

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