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SAE AS5804

FEDERAL SUPPLY CLASS
4730

RATIONALE

NEW STANDARD FOR OPERATING PRESSURES UP TO AND INCLUDING 3000 PSI.

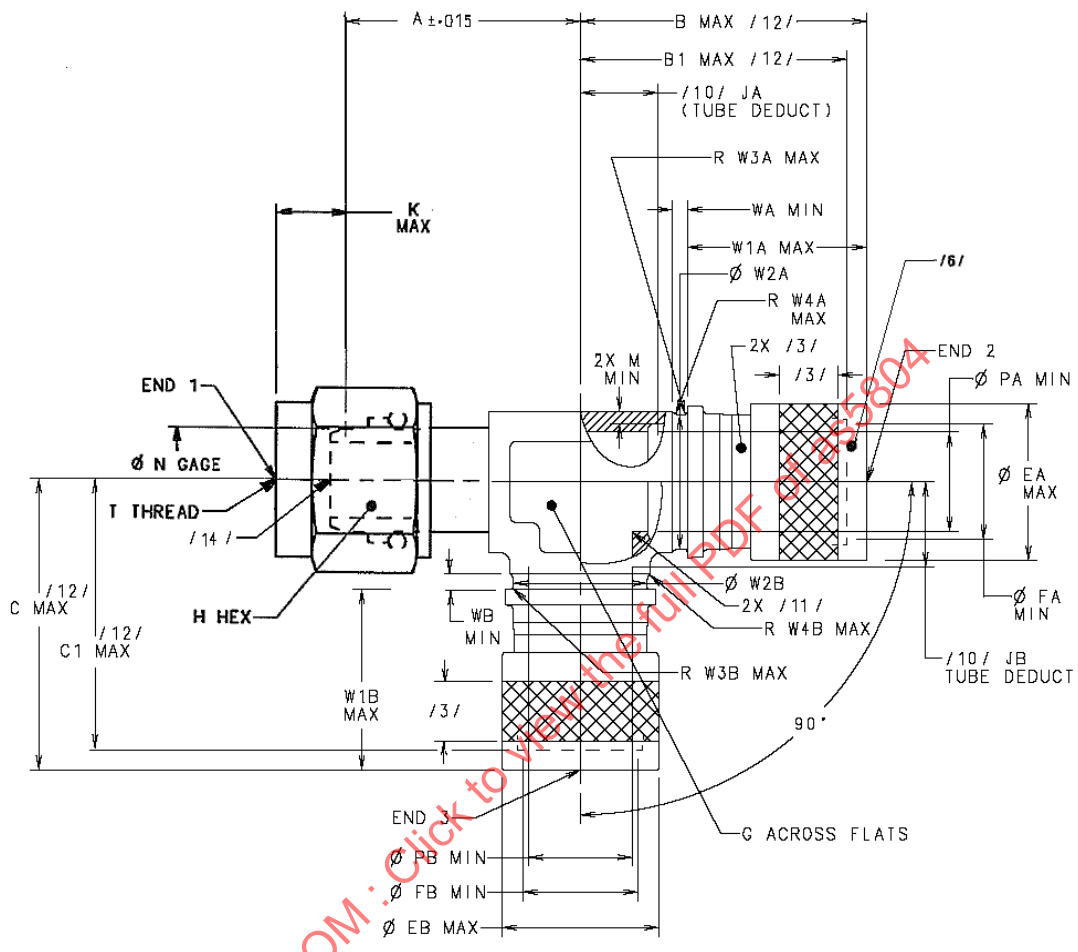
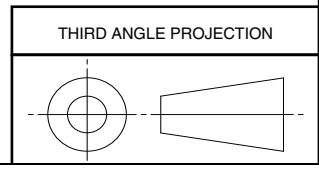


FIGURE 1 - TEE, FEMALE FLARELESS ON THE RUN, SWAGE



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: AS5958 /4/

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD
FITTING ASSEMBLY, TEE, FEMALE FLARELESS AND
AXIALLY SWAGED ON THE RUN, AXIALLY SWAGED
ON THE BRANCH, HYDRAULIC, 3000 PSI

SAE AS5804
SHEET 1 OF 4

ISSUED 2008-06

TABLE 1A - DIMENSIONS A THROUGH FB

BASIC NO. AS5804 /13/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	NOMINAL TUBE SIZE END 3	T THREAD PER AS8879	A ±.015	B MAX.	B1 MAX.	C MAX.	C1 MAX.	EA MAX.	EB MAX.	FA MIN.	FB MIN.
040404	.2500	.2500	.2500	.4375-20UNJF-3B	.878	.935	.848	.935	.848	.466	.466	.253	.253
060606	.3750	.3750	.3750	.5625-18UNJF-3B	1.040	1.215	1.099	1.215	1.099	.609	.609	.378	.378
080606	.5000	.3750	.3750	.7500-16UNJF-3B	1.229	1.308	1.192	1.308	1.192	.609	.609	.378	.378
080808	.5000	.5000	.5000	.7500-16UNJF-3B	1.229	1.516	1.370	1.516	1.370	.783	.783	.504	.504
101004	.6250	.6250	.2500	.8750-14UNJF-3B	1.435	1.873	1.669	1.154	1.067	.939	.466	.629	.253
101006	.6250	.6250	.3750	.8750-14UNJF-3B	1.435	1.873	1.669	1.371	1.255	.939	.609	.629	.378
101010	.6250	.6250	.6250	.8750-14UNJF-3B	1.435	1.873	1.669	1.873	1.669	.939	.939	.629	.629
121212	.7500	.7500	.7500	1.0625-12UNJ-3B	1.592	2.149	1.944	2.149	1.944	1.122	1.122	.754	.754
161616	1.0000	1.0000	1.0000	1.3125-12UNJ-3B	1.862	2.606	2.392	2.606	2.392	1.495	1.495	1.004	1.004
202020	1.2500	1.2500	1.2500	1.6250-12UNJ-3B	2.024	3.020	2.796	3.020	2.796	1.758	1.758	1.255	1.255

TABLE 1B - DIMENSIONS G THROUGH PB

BASIC NO. AS5804 /13/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	NOMINAL TUBE SIZE END 3	G	(H)	JA /10/ TUBE DEDUCT	JB /10/ TUBE DEDUCT	K MAX.	M MIN.	N GAGE	PA MIN.	PB MIN.
040404	.2500	.2500	.2500	.348- .380	.563	.353 ± .150	.353 ± .150	.325	.043	.2930	.198	.198
060606	.3750	.3750	.3750	.477- .509	.688	.416 ± .150	.416 ± .150	.337	.045	.4160	.302	.302
080606	.5000	.3750	.3750	.615- .647	.875	.509 ± .150	.509 ± .150	.380	.052	.5600	.302	.302
080808	.5000	.5000	.5000	.615- .647	.875	.517 ± .175	.517 ± .175	.380	.052	.5600	.401	.401
101004	.6250	.6250	.2500	.751- .783	1.000	.580 ± .175	.572 ± .175	.407	.057	.6860	.507	.198
101006	.6250	.6250	.3750	.751- .783	1.000	.580 ± .175	.572 ± .175	.407	.057	.6860	.507	.302
101010	.6250	.6250	.6250	.751- .783	1.000	.580 ± .175	.580 ± .175	.407	.057	.6860	.507	.507
121212	.7500	.7500	.7500	.893- .925	1.250	.712 ± .175	.712 ± .175	.433	.065	.8100	.604	.604
161616	1.0000	1.0000	1.0000	1.181-1.213	1.500	.878 ± .200	.878 ± .200	.437	.084	1.0620	.802	.802
202020	1.2500	1.2500	1.2500	1.609-1.641	2.000	1.009 ± .200	1.009 ± .200	.450	.174	1.3160	1.011	1.011

TABLE 1C - DIMENSIONS WA THROUGH W4B AND WEIGHTS

BASIC NO. AS5804/13/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	NOMINAL TUBE SIZE END 3	WA MIN.	WB MIN.	W1A MAX.	W1B MAX.	W2A ±.0015	W2B ±.0015	W3A MAX.	W3B MAX.	W4A MAX.	W4B MAX.	WEIGHT LB/EA APPROX. REF.
040404	.2500	.2500	.2500	.123	.123	.488	.488	.3005	.3005	.018	.018	.065	.065	.039
060606	.3750	.3750	.3750	.153	.153	.675	.675	.4475	.4475	.033	.033	.065	.065	.051
080606	.5000	.3750	.3750	.153	.153	.675	.675	.4475	.4475	.033	.033	.065	.065	.116
080808	.5000	.5000	.5000	.165	.165	.871	.871	.5945	.5945	.033	.033	.129	.129	.135
101004	.6250	.6250	.2500	.140	.123	1.190	.488	.7365	.3005	.021	.018	.078	.065	.191
101006	.6250	.6250	.3750	.140	.153	1.190	.675	.7365	.4475	.021	.033	.078	.065	.190
101010	.6250	.6250	.6250	.140	.140	1.190	1.190	.7365	.7365	.021	.021	.078	.078	.218
121212	.7500	.7500	.7500	.154	.154	1.327	1.327	.8805	.8805	.024	.024	.089	.089	.343
161616	1.0000	1.0000	1.0000	.167	.167	1.612	1.612	1.1725	1.1725	.027	.027	.099	.099	.668
202020	1.2500	1.2500	1.2500	.185	.185	1.886	1.886	1.4345	1.4345	.030	.030	.113	.113	1.171

NOTES:

/1/ MATERIALS:

CODE LETTER "T"

RING - AMS4965 TITANIUM ALLOY 6.0AL 4.0V SOLUTION HEAT TREATED AND AGED OR AMS4928 TITANIUM ALLOY 6.0AL 4.0V ANNEALED WITH HIGH STRENGTH CARBON FIBER/EPOXY RESIN COMPOSITE REINFORCEMENT.

BODY - AMS4928 TITANIUM ALLOY 6.0AL 4.0V ANNEALED

NUT - AMS4965 TITANIUM ALLOY 6.0AL 4.0V SOLUTION HEAT TREATED AND AGED OR AMS4928 TITANIUM ALLOY 6.0AL 4.0V ANNEALED.

WIRE - AMS5637 STEEL, CORROSION RESISTANT, 18CR - 9.0 NI (UNS30302) SOLUTION TREATED AND COLD DRAWN 125 KSI TENSILE STRENGTH.

- AMS5685 STEEL, CORROSION RESISTANT, SAFETY WIRE 18CR-11.5 NI, 305 WIRE, SOLUTION TREATED AND COLD FINISHED

- ASTM A 580 STEEL, CORROSION RESISTANT, WIRE, 302 OR 305 CONDITION A

2. FINISH:

TITANIUM - NONE REQUIRED

CRES - PASSIVATION PER AMS2700 TYPE 6 OR 7

/3/ COATINGS/LUBRICANTS:

RING - THE OUTER SURFACE SHALL HAVE A .125 INCH MINIMUM WIDTH BLUE COLORED RING OR COMPLETELY COLORED BLUE TO MATCH THE ASSEMBLY TOOLING COLOR CODE SPECIFIED IN AS5959 ASSEMBLY PROCEDURE. AN AS1241 FLUID RESISTANT PTFE COATING OR PAINT SHALL BE USED. THE SWAGE RING IS COLOR CODED BLUE TO INDICATE THE SWAGE END IS QUALIFIED TO 5080 PSI AND IS INSTALLED WITH THE SAME TOOLING AS THE 5080 PSI RATED FITTING.

BODY - SOLID FILM LUBRICANT PER AS5272, TYPE I OR II, OR PTFE BASE LUBRICANT MAY BE APPLIED TO PORTIONS OF THE ID AND OD. THE AS5272 OR PTFE LUBRICANT SHALL NOT BE IN CONTACT WITH THE SYSTEM FLUID.

NUT - LUBRICATE ID THREADS AND WIRE GROOVE LOAD BEARING SHOULDER OR MATING WIRE GROOVE LOAD BEARING SHOULDER WITH SOLID FILM LUBRICANT PER AS5272, TYPE I OR TYPE II.

WIRE - LUBRICATE THE WIRE WITH SOLID FILM LUBRICANT PER AS5272, TYPE I OR TYPE II.

/4/ PROCUREMENT SPECIFICATION: AS5958 EXCEPT AS SPECIFIED ON THIS STANDARD. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED AND ASSEMBLED BY AN ACCREDITED MANUFACTURER OR ASSEMBLED BY AN ACCREDITED ASSEMBLING DISTRIBUTOR LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST FOR PRI-QPL-AS5958 FOR THIS STANDARD. SEE www.eauditnet.com FOR CURRENT QPL ON-LINE.

5. DIMENSIONS AND TOLERANCES NOT DEFINED ON THIS STANDARD SHALL BE SPECIFIED AND CONTROLLED BY THE MANUFACTURER. THE MANUFACTURER IS RESPONSIBLE TO INSURE COMPLIANCE WITH THE PROCUREMENT SPECIFICATION.

/6/ IDENTIFICATION SHALL BE IN ACCORDANCE WITH AS5958 AND SHALL BE IDENTIFIED ON ONE OF THE TWO RINGS.

7. FITTINGS SHALL BE INSTALLED IN ACCORDANCE WITH AS5959.