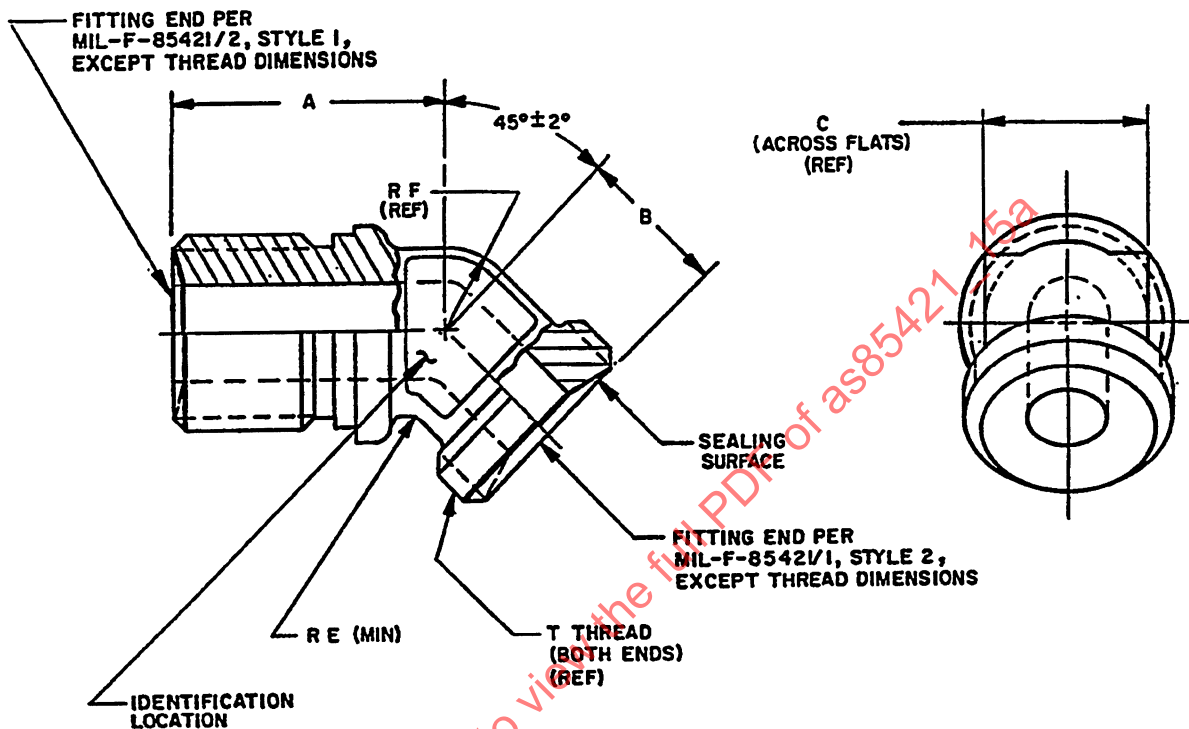
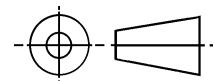


THE REQUIREMENTS FOR ACQUIRING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION: MIL-R-85421.



THIRD ANGLE PROJECTION



PREPARED BY SAE COMMITTEE G-3

PROCUREMENT SPECIFICATION: AS85421

SAE The Engineering Society
For Advancing Mobility
Land Sea Air and Space
INTERNATIONAL
400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARD

FITTING, ELBOW, 45°, BEAM SEAL,
3000/4000 PSI, BULKHEAD, MALE ENDS

AS85421/15
SHEET 1 OF 3

REV. A

ISSUED 2001-05 REVISED 2002-03

REV.
A

AS85421/15

TABLE I. DIMENSIONAL DATA.

| Dash No. | Tube O.D. | T Thread MIL-S-8879 (Ref) | A | B | C (Ref) | E Rad (Min) | F Rad (Ref) | Wt Lbs (Max) | |
|----------|-----------|---------------------------|-------|-------|---------|-------------|-------------|--------------|------|
| | | | | | | | | Ti | Cres |
| -03 | .188 | .3750-28UNJS-3A | .987 | .378 | .375 | .084 | .188 | .022 | .039 |
| -04 | .250 | .4375-24UNJS-3A | 1.028 | .420 | .375 | .084 | .188 | .026 | .046 |
| -05 | .312 | .5000-24UNJS-3A | 1.046 | .438 | .438 | .084 | .219 | .030 | .053 |
| -06 | .375 | .5625-20UNJS-3A | 1.120 | .471 | .500 | .084 | .250 | .046 | .081 |
| -08 | .500 | .7188-20UNJS-3A | 1.246 | .528 | .562 | .140 | .281 | .076 | .134 |
| -10 | .625 | .8438-18UNJS-3A | 1.433 | .619 | .688 | .140 | .344 | .098 | .173 |
| -12 | .750 | 1.0000-16UNJ-3A | 1.576 | .685 | .875 | .196 | .438 | .148 | .262 |
| -14 | .875 | 1.1250-16UNJ-3A | 1.723 | .753 | 1.125 | .196 | .563 | .206 | .364 |
| -16 | 1.000 | 1.2500-14UNJS-3A | 1.725 | .783 | 1.125 | .196 | .563 | .204 | .361 |
| -20 | 1.250 | 1.5781-14UNJS-3A | 1.775 | .836 | 1.375 | .196 | .688 | .281 | .497 |
| -24 | 1.500 | 1.8438-14UNJS-3A | 2.027 | 1.003 | 1.625 | .196 | .813 | .516 | .912 |

SIZES -20 AND -24 WERE ORIGINALLY DESIGNATED AS SIZES -21 AND -25 ON SOME MANUFACTURER'S DRAWINGS. THESE SIZES WILL NOT CONNECT WITH THE ORIGINAL -20 AND -24 FITTINGS. SEE PARAGRAPH 6.9 IN THE PROCUREMENT SPECIFICATION FOR ADDITIONAL INFORMATION.

REQUIREMENTS:

- MATERIALS: TITANIUM ALLOY
CORROSION RESISTANT STEEL } SEE PROCUREMENT SPECIFICATION
- FINISH: TITANIUM: FLUORIDE PHOSPHATE COAT PER AMS 2486.
CORROSION RESISTANT STEEL: SURFACE SHALL BE TREATED AND PASSIVATED PER QQ-P-35.

NOTES:

- DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS $\pm .015$.
- REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
- ALL MACHINED SURFACES SHALL BE SMOOTH TO 125 MICROINCHES Ra PER ANSI/ASME B46.1 UNLESS OTHERWISE SPECIFIED.
- PART NUMBERS:
ADD "T" AFTER SLASH NUMBER FOR 6AL-4V TITANIUM ALLOY PER AMS 4965.
ADD "P" AFTER SLASH NUMBER FOR 17-4PH CORROSION RESISTANT STEEL PER AMS 5643.
ADD "V" AFTER SLASH NUMBER FOR 15-5PH CORROSION RESISTANT STEEL PER AMS 5659.
- EXAMPLE OF PART NUMBERS:

