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REV.
D

AS85421™/15

FEDERAL SUPPLY CLASS
4730

RATIONALE

CUSTODIAN NOTE REVISED TO INCLUDE SUB-COMMITTEE GROUP. HEADINGS IN TABLE 1 REVISED. REFERENCE TO NOTE 6.4 OF THE PROCUREMENT SPECIFICATION MENTIONED BELOW TABLE 1 HAS BEEN REVISED TO POINT READER TO ACTUAL NAME OF PARAGRAPH (SAE PRACTICE IS TO NOT REFER TO PARAGRAPHS WITHIN ANOTHER DOCUMENT). FINISH FOR MATERIAL CODE LETTERS P AND V CHANGED FROM TYPE 6 OR 7 TO 2 OR 8. UPDATED PROCUREMENT SPECIFICATION NOTE TO CURRENT QPL VERBIAGE. TITANIUM USAGE NOTE 10 REMOVED. (THIS NOTE SHOULD NOT BE PART OF THE PART STANDARD). ADDED NEW NOTE 10: WHEN MACHINED FROM BAR STOCK OR OVERSIZED FORGING, THE CENTER BODY DIMENSIONS SHALL CONFORM TO AS1376, TABLE 4. REVISION INDICATOR NOTE REVISED TO CURRENT VERBIAGE.

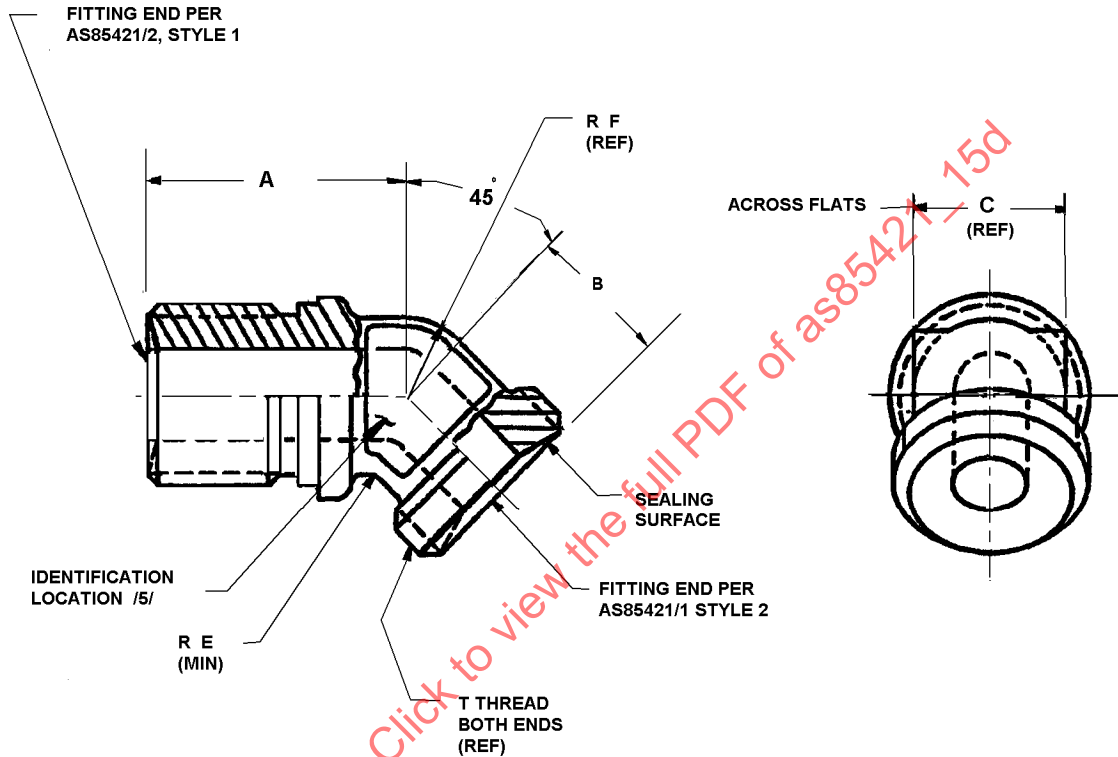
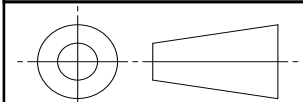


FIGURE 1

For more information on this standard, visit
<https://www.sae.org/standards/content/AS85421/15D/>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS85421 /4/



AEROSPACE STANDARD

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

AS85421™/15
SHEET 1 OF 3

REV.
D

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ISSUED 2001-05 REAFFIRMED 2015-04 REVISED 2022-10

TABLE 1 - DIMENSIONS A TO F

AS85421/15 SIZE CODE /15/	TUBE OD	T THREAD AS8879	A	B	C (REF)	E RAD (MIN)	F RAD (REF)	MASS LB/EA APPROX (REF)	
								TI	CRES
03	.188	.3750-28UNJS-3A	.987	.378	.375	.084	.188	.025	.044
04	.250	.4375-24UNJS-3A	1.028	.420	.375	.084	.188	.029	.051
05	.312	.5000-24UNJS-3A	1.046	.438	.438	.084	.219	.037	.066
06	.375	.5625-20UNJS-3A	1.120	.471	.500	.084	.250	.046	.081
08	.500	.7188-20UNJS-3A	1.246	.528	.562	.140	.281	.078	.138
10	.625	.8438-18UNJS-3A	1.433	.619	.688	.140	.344	.113	.201
12	.750	1.0000-16UNJ-3A	1.576	.685	.875	.196	.438	.154	.273
14	.875	1.1250-16UNJ-3A	1.723	.753	1.125	.196	.563	.240	.424
16	1.000	1.2500-14UNJS-3A	1.725	.783	1.125	.196	.563	.243	.430
20	1.250	1.5781-14UNJS-3A	1.775	.836	1.375	.196	.688	.375	.662
24	1.500	1.8438-14UNJS-3A	2.027	1.003	1.625	.196	.813	.583	1.031

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 "DELETION OF SIZES 21 AND 25" NOTE IN THE PROCUREMENT SPECIFICATION FOR ADDITIONAL INFORMATION.

NOTES:

/1/ MATERIAL:

- a. CODE LETTER P: TYPE 17-4PH CORROSION RESISTANT STEEL PER AMS5643.
- b. CODE LETTER T: TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS4928 OR AMS4965.
- c. CODE LETTER V: TYPE 15-5PH, CORROSION RESISTANT STEEL PER AMS5659.

2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER P: CONDITION H1075 PER AMS2759/3.
- b. MATERIAL CODE LETTER T: NONE.
- c. MATERIAL CODE LETTER V: AGE TO CONDITION H 1075 PER AMS-H-6875 OR AMS2759/3.

3. FINISH:


- a. MATERIAL CODE LETTER P: PASSIVATE PER AMS2700, TYPE 2 OR 8.
- b. MATERIAL CODE LETTER T: NONE.
- c. MATERIAL CODE LETTER V: PASSIVATE PER AMS2700, TYPE 2 OR 8.

/4/ PROCUREMENT SPECIFICATION: AS85421 EXCEPT AS SPECIFIED ON THIS STANDARD. PRODUCT MANUFACTURED TO THIS STANDARD SHALL MEET THE REQUIREMENTS SPECIFIED HEREIN AND THE PROCUREMENT SPECIFICATION. ORIGINAL COMPONENT MANUFACTURERS (OCM) AND VALUE ADDED DISTRIBUTORS (VAD) SHALL BE LISTED IN THE PRI QUALIFIED PRODUCTS LIST (QPL) PRI-QPL-AS85421 FOR THIS STANDARD. SEE www.eAuditNet.com FOR CURRENT QPL ONLINE.

/5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D, OR METHOD 7A3, 15A3, OR 15B.

- a. FOR SIZES 06 AND SMALLER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, LETTERS "AS" AND MATERIAL CODE LETTER, AND FORGING MANUFACTURER'S IDENTIFICATION WHEN MADE FROM FORGING.
- b. FOR SIZES 08 AND LARGER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, BASIC PART NUMBER AND MATERIAL CODE LETTER, AND FORGING MANUFACTURER'S IDENTIFICATION WHEN MADE FROM FORGING.

6. INVENTORIED PARTS CONFORMING TO THE PREVIOUS "LETTER CHANGE" MAY BE USED TO DEPLETION.

	AEROSPACE STANDARD	AS85421™/15 SHEET 2 OF 3	REV. D
	FITTING, ELBOW, 45°, BEAM SEAL, 3000/4000 PSI, BULKHEAD, MALE ENDS		