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REV.
A

AS5865

FEDERAL SUPPLY CLASS
4730

RATIONALE

HARMONIZE AS5865 AND EN4836. ADD AMS5853 OPTION FOR A286 LOCKRING MATERIAL.

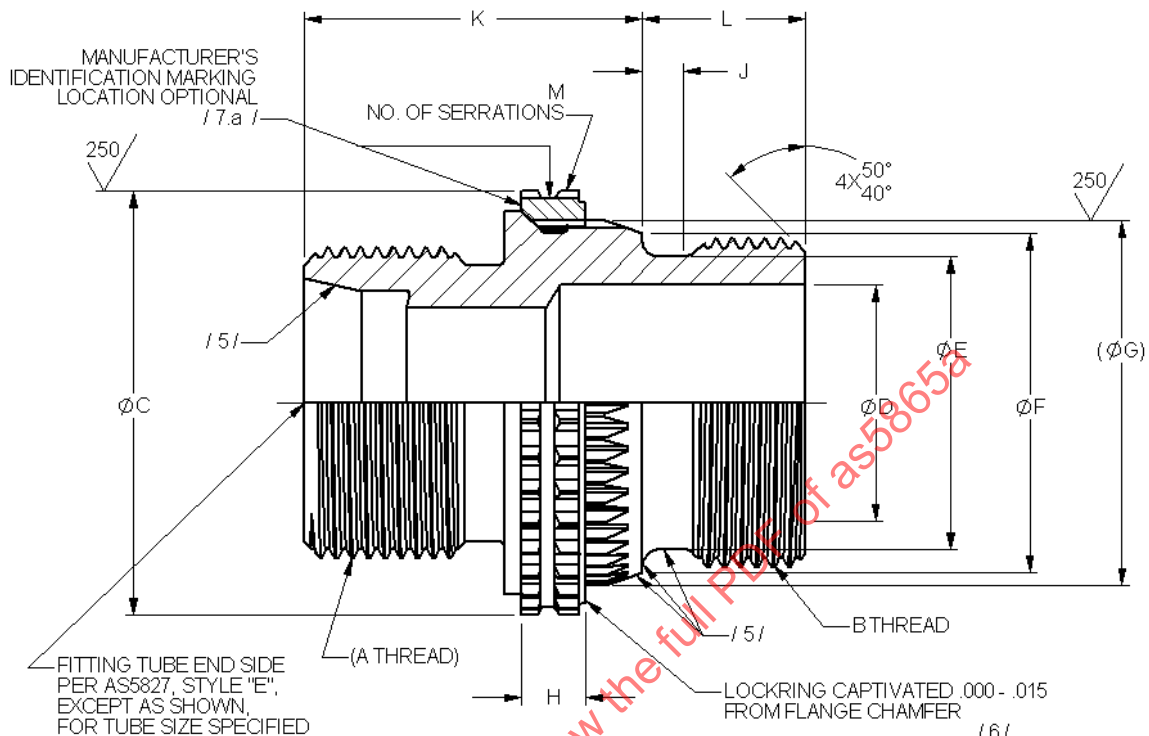


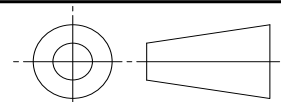
FIGURE 1 - FITTING REDUCER ASSEMBLY

TABLE 1A - DIMENSIONS A - F

BASIC NO. AS5865 /15/ SIZE CODE	(NOMINAL TUBE SIZE)	A THREAD AS8879	B THREAD AS8879	C	D	E +.005/- .002	F MIN
06-04	.250	.4375-28UNJEF-3A	.4375-20UNJF-3A	.700	.273- .300	.364	.456
08-06	.375	.5625-24UNJEF-3A	.5625-18UNJF-3A	.814	.377- .408	.482	.574
10-08	.500	.7500-20UNJEF-3A	.6875-24UNJEF-3A	1.040	.477- .503	.625	.717
12-10	.625	.8750-20UNJEF-3A	.8125-20UNJEF-3A	1.170	.576- .614	.737	.891
16-12	.750	1.0625-18UNJEF-3A	1.1250-18UNJEF-3A	1.456	.804- .851	1.000	1.154
20-16	1.000	1.3125-16UNJ-3A	1.3125-18UNJEF-3A	1.782	1.001-1.039	1.225	1.379
24-20	1.250	1.6250-16UNJ-3A	1.6250-18UNJEF-3A	2.031	1.244-1.250	1.502	1.656

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on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS5865A>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ AS5000



AEROSPACE STANDARD

(R) FITTING REDUCER ASSEMBLY, RING LOCKED,
ADAPTER, FLARELESS TO PORT,
EXTRA FINE THREADS, 5080 PSI

AS5865
SHEET 1 OF 3

REV.
A

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ISSUED 2005-10 REVISED 2015-01

TABLE 1B - DIMENSIONS G - M AND WEIGHTS

BASIC NO. AS5865 /15/ SIZE CODE	(G)	H ±.007	J +.010/-.005	K	L +.000/-.015	M TEETH	LB/EA MAX
06-04	.544	.210	.125	.915	.395	36	.0334
08-06	.670	.210	.125	.931	.430	40	.0441
10-08	.824	.210	.125	1.025	.465	38	.0792
12-10	.981	.220	.157	1.084	.527	40	.1023
16-12	1.251	.220	.157	1.159	.564	36	.1652
20-16	1.466	.240	.157	1.166	.569	56	.2222
24-20	1.768	.240	.157	1.187	.608	81	.3168

NOTES:

1. MATERIAL:

- a. FITTING REDUCER: 6Al-4V TITANIUM ALLOY PER AMS4928, AMS4965, OR AMS4967.
- b. LOCKRING: A286 CORROSION RESISTANT STEEL PER AMS5731, AMS5732, AMS5734, AMS5737, OR AMS-5853.

2. HEAT TREATMENT:

- a. FITTING REDUCER: 130 KSI UTS MIN.
- b. LOCKRING: 34-40 HRC.

3. FINISH:

- a. FITTING REDUCER: ANODIC TREATMENT PER AMS2488, TYPE 2 OR FLUORIDE PHOSPHATE CONVERSION PER AMS2486.
- b. LOCKRING: PASSIVATE PER AMS2700, TYPE 2 OR 8, AND PTFE COATING (WHITE COLOR).

/4/ PROCUREMENT SPECIFICATION: PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER AS LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCT LIST (QPL) PRI-QPL-AS5000 FOR THIS STANDARD. SEE www.eAuditNet.com FOR CURRENT QPL ONLINE.

/5/ SEALING SURFACE: NO VISIBLE DEFECTS. TO BE PROTECTED FOR SHIPMENT.

/6/ LOCKRING RETAINED ON FITTING REDUCER BY CONTROLLED INTERFERENCE FIT.

/7/ IDENTIFICATION:

- a. MARK AT LOCATION(S) SHOWN PER AS478 METHOD 2 OR 15, MANUFACTURER'S NAME, TRADEMARK, OR CAGE CODE.
- b. BAG AND TAG PER AS478, METHOD 35D, MANUFACTURER'S NAME, TRADEMARK, OR CAGE CODE AND PART NUMBER.

	AEROSPACE STANDARD	AS5865 SHEET 2 OF 3	REV. A
	(R) FITTING REDUCER ASSEMBLY, RING LOCKED, ADAPTER, FLARELESS TO PORT, EXTRA FINE THREADS, 5080 PSI		