

REV.
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AS4099

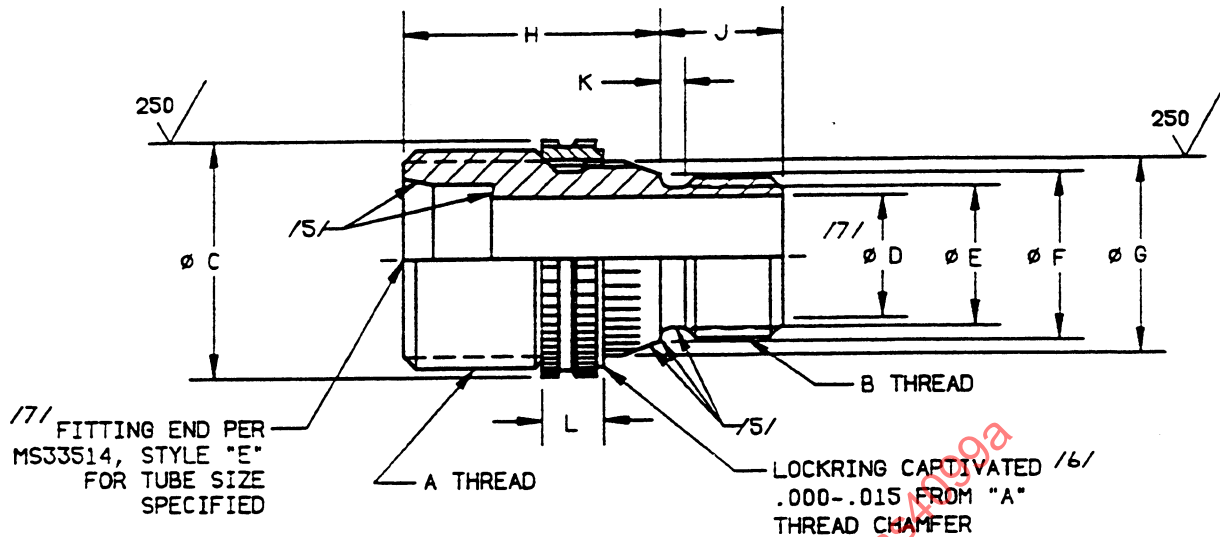
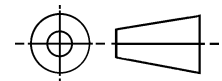


FIGURE 1 - ADAPTER, ASSEMBLY

TABLE 1A - DIMENSIONS

BASIC NO. AS4099	(NOMINAL TUBE SIZE)	A THREAD MIL-S-8879	B THREAD MIL-S-8879	C	D /7/	E +.005 -.002	F MIN	G
16/ SIZE CODE								(G)
02	.125	.3125-24UNJF-3A	.2160-28UNJF-3A	.400	.090-.096	.154	.246	.317
03	.188	.3750-24UNJF-3A	.2500-28UNJF-3A	.468	.122-.128	.186	.278	.349
04	.250	.4375-20UNJF-3A	.3125-24UNJF-3A	.514	.169-.175	.239	.331	.400
05	.312	.5000-20UNJF-3A	.3750-24UNJF-3A	.624	.231-.237	.301	.393	.491
06	.375	.5625-18UNJF-3A	.4375-20UNJF-3A	.700	.294-.300	.364	.456	.544
08	.500	.7500-16UNJF-3A	.5625-18UNJF-3A	.814	.419-.425	.482	.574	.670
10	.625	.8750-14UNJF-3A	.6875-24UNJEF-3A	1.040	.497-.503	.625	.717	.824
12	.750	1.0625-12UNJ-3A	.8125-20UNJEF-3A	1.170	.653-.659	.737	.891	.981
16	1.000	1.3125-12UNJ-3A	1.1250-18UNJEF-3A	1.456	.872-.878	1.000	1.154	1.251
20	1.250	1.6250-12UNJ-3A	1.3125-18UNJEF-3A	1.782	1.090-1.096	1.225	1.379	1.466
24	1.500	1.8750-12UNJ-3A	1.6250-18UNJEF-3A	2.031	1.341-1.347	1.502	1.656	1.768
32	2.000	2.5000-12UNJ-3A	2.1250-16UNJ-3A	2.548	1.810-1.816	2.040	2.194	2.311

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ MIL-F-18280

SAE The Engineering Society
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INTERNATIONAL
400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARD

ADAPTER, ASSEMBLY - PORT CONNECTION
RING LOCKED TO FLARELESS TUBE ENDAS4099
SHEET 1 OF 3REV.
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AS4099

TABLE 1B - DIMENSIONS AND WEIGHTS

BASIC NO. AS4099	H	J	K	L	WEIGHT LB/EA
/16/ SIZE CODE	+ .010 - .005	+ .000 - .015	+ .010 - .005	± .007	MAX
02	.674	.300	.125	.192	.009
03	.721	.355	.125	.192	.013
04	.752	.355	.125	.192	.015
05	.752	.381	.125	.192	.022
06	.789	.395	.125	.210	.026
08	.882	.430	.125	.210	.039
10	.945	.465	.125	.210	.064
12	1.018	.527	.157	.220	.084
16	1.018	.564	.157	.220	.129
20	1.045	.569	.157	.240	.189
24	1.045	.608	.157	.240	.248
32	1.086	.730	.157	.240	.411

NOTES:

1. MATERIAL:
 - a. FITTING: 6A1-4V TITANIUM ALLOY PER AMS 4928, AMS 4965, OR AMS 4967.
 - b. LOCKRING: A286 CORROSION RESISTANT STEEL PER AMS 5731 OR AMS 5734.
2. HEAT TREATMENT:
 - a. FITTING: 130 ksi UTS MIN
 - b. LOCKRING: 34 TO 40 HRC
3. FINISH:
 - a. FITTING: ANODIC TREATMENT PER AMS 2488, TYPE 2.
 - b. LOCKRING: PASSIVATE PER QQ-P-35, TY II.
- /4/ PROCUREMENT SPECIFICATION: MIL-F-18280 EXCEPT AS SPECIFIED ON THIS STANDARD. THIS PART SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION IN A COMPLETE ASSEMBLY. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENTS SHEET OR SIMILAR MEANS.
- /5/ SEALING SURFACE: NO VISIBLE DEFECTS. TO BE PROTECTED FOR SHIPMENT.
- /6/ LOCKRING RETAINED ON FITTING BY CONTROLLED INTERFERENCE FIT.
- /7/ "D" DIAMETER FOR DASH -04 IS .184-.190 ON MS33514 END AND REDUCED TO "D" DIAMETER PER THIS STANDARD ON OPPOSITE END.
8. IDENTIFICATION PER AS478 CLASS 35D, NAME, TRADEMARK OR CAGE CODE AND PART NUMBER.
9. WORKING PRESSURE: THIS PART IS DESIGNED FOR USE IN 4000 psi WORKING PRESSURE SYSTEMS COMPATIBLE WITH TITANIUM.
10. ADAPTERS TO BE INSTALLED PER AS1301 INTO BOSS CAVITIES PER AS1300.
11. INTERPRETATION OF DRAWING PER ARP4296.
12. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36; REQUIREMENTS PER ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 μ in Ra AND SEALING SURFACE TO BE 63 μ in Ra.
13. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.
14. DIMENSIONING AND TOLERANCING: ANSI Y14.5M.
15. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS $\pm$.005, ANGULAR DIMENSIONS $\pm$ 5°.

AEROSPACE STANDARD

ADAPTER, ASSEMBLY - PORT CONNECTION
RING LOCKED TO FLARELESS TUBE END

AS4099
SHEET 2 OF 3

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