

REV.  
D

SAE AS1581

FEDERAL SUPPLY CLASS  
4730

# RATIONALE

ADD NOTE TO INDICATE ACTIVATION DATES FOR PRI-QPL-AS1576.

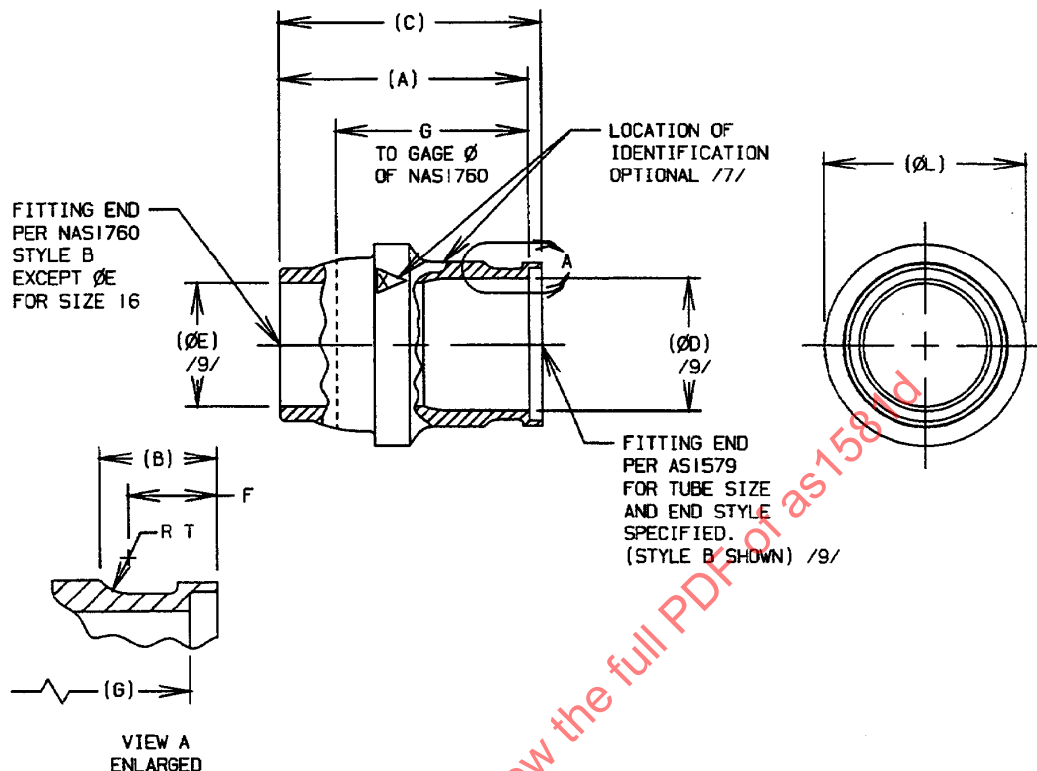


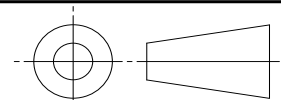
FIGURE 1 - FITTING, SLEEVE

TABLE 1 - DIMENSIONS

| BASIC NO.<br>AS1581<br>/17/<br>SIZE CODE | (NOMINAL<br>TUBE<br>SIZE) | (NOMINAL<br>TUBE<br>WALL) | PORT #2<br>STYLE | A<br>/10/ | B<br>/10/ | C     | D<br>/9/ | E<br>/9/ | F    |
|------------------------------------------|---------------------------|---------------------------|------------------|-----------|-----------|-------|----------|----------|------|
| 04                                       | .250                      | .016                      | B                | .759      | .152      | .789  | .212     | .176     | .111 |
| 05                                       | .312                      | .020                      | B                | .759      | .152      | .789  | .266     | .232     | .110 |
| 06                                       | .375                      | .020                      | B                | .759      | .152      | .789  | .329     | .294     | .111 |
| 08                                       | .500                      | .026                      | B                | .835      | .194      | .875  | .442     | .412     | .147 |
| 10                                       | .625                      | .033                      | B                | .971      | .226      | 1.011 | .553     | .498     | .175 |
| 12                                       | .750                      | .039                      | B                | 1.031     | .274      | 1.081 | .666     | .648     | .205 |
| 16                                       | 1.000                     | .052                      | A                | 1.205     | .343      | 1.265 | .890     | -        | .274 |
| 20                                       | 1.250                     | .065                      | B                | 1.375     | .343      | 1.435 | 1.114    | 1.090    | .273 |

SAE values your input. To provide feedback  
on this Technical Report, please visit  
<http://www.sae.org/technical/standards/AS1581D>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: /6/ AS1576

**SAE Aerospace**  
An SAE International Group

## AEROSPACE STANDARD

FITTING, SLEEVE, FLARELESS ACORN  
TO INTEGRAL WELD RING, 3000 PSI

**SAE AS1581**  
SHEET 1 OF 3

REV.  
D

TABLE 1A - DIMENSIONS AND WEIGHTS

| BASIC NO.<br>AS1581<br>/17/<br>SIZE CODE | G     | L     | T    | LB/100<br>APPROX<br>REF<br>CRES | LB/100<br>APPROX<br>REF<br>TI |
|------------------------------------------|-------|-------|------|---------------------------------|-------------------------------|
| 04                                       | .600  | .371  | .050 | 1.15                            | .635                          |
| 05                                       | .598  | .434  | .050 | 1.56                            | .863                          |
| 06                                       | .592  | .490  | .050 | 1.84                            | 1.02                          |
| 08                                       | .642  | .670  | .060 | 3.03                            | 1.67                          |
| 10                                       | .766  | .786  | .060 | 5.24                            | 2.89                          |
| 12                                       | .800  | .960  | .090 | 6.42                            | 3.54                          |
| 16                                       | .904  | 1.210 | .090 | 10.1                            | 5.57                          |
| 20                                       | 1.072 | 1.470 | .090 | 18.0                            | 9.93                          |

## NOTES:

## /1/ MATERIAL:

- a. CODE LETTER T - TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS4928.
- b. CODE LETTER V - TYPE 15-5PH CORROSION RESISTANT STEEL BAR PER AMS5659

## 2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER T - NONE
- b. MATERIAL CODE LETTER V - HEAT TREAT TO CONDITION H 1075 PER AMS2759/3.

## 3. FINISH: NONE.

## /4/ CLEANING:

- a. NO SUFFIX CODE LETTER IN PART NUMBER - CLEAN BY ANY SUITABLE METHOD PER PROCUREMENT SPECIFICATION.
- b. SUFFIX CODE LETTER "C" IN PART NUMBER - HOT ALKALINE CLEAN PER PROCUREMENT SPECIFICATION.
- c. SUFFIX CODE LETTER "E" IN PART NUMBER FOR TITANIUM ALLOY PARTS ONLY - NITRIC-HYDROFLUORIC ACID ETCH PER PROCUREMENT SPECIFICATION.

## 5. PACKAGING: PER PROCUREMENT SPECIFICATION.

/6/ PROCUREMENT SPECIFICATION: AS1576 UNLESS OTHERWISE SPECIFIED ON THIS STANDARD. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER AS LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST PRI-QPL-AS1576 FOR THIS STANDARD. SEE <http://www.eauditnet.com> FOR CURRENT QPL ONLINE.

THIS QPL REQUIREMENT SHALL BE IN EFFECT FOR PURCHASE ORDERS PLACED ON OR AFTER JULY 1, 2013. SUPPLIERS SEEKING LISTING ON THE INITIAL QPL MUST APPLY TO PRI FOR APPROVAL NO LATER THAN JANUARY 1, 2013. UNTIL THE QPL IS IN EFFECT, USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVALS. TRANSITION TO PRI-QPL SHALL BE COMPLETED BY JULY 1, 2013.

/7/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3, OR 15B MANUFACTURER'S IDENTIFICATION, CAGE CODE NUMBER OR TRADEMARK, BASIC PART NUMBER FOR SIZE 08 AND LARGER, LETTERS "AS" FOR SIZE 06 AND SMALLER AND MATERIAL CODE LETTER.

|                                                                                                                   |                                                                     |                                   |                         |
|-------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------|-----------------------------------|-------------------------|
| <br>An SAE International Group | <b>AEROSPACE STANDARD</b>                                           | <b>SAE AS1581</b><br>SHEET 2 OF 3 | <b>REV.</b><br><b>D</b> |
|                                                                                                                   | FITTING, SLEEVE, FLARELESS ACORN<br>TO INTEGRAL WELD RING, 3000 PSI |                                   |                         |