

REV.
A

AS4661

FEDERAL SUPPLY CLASS
4730

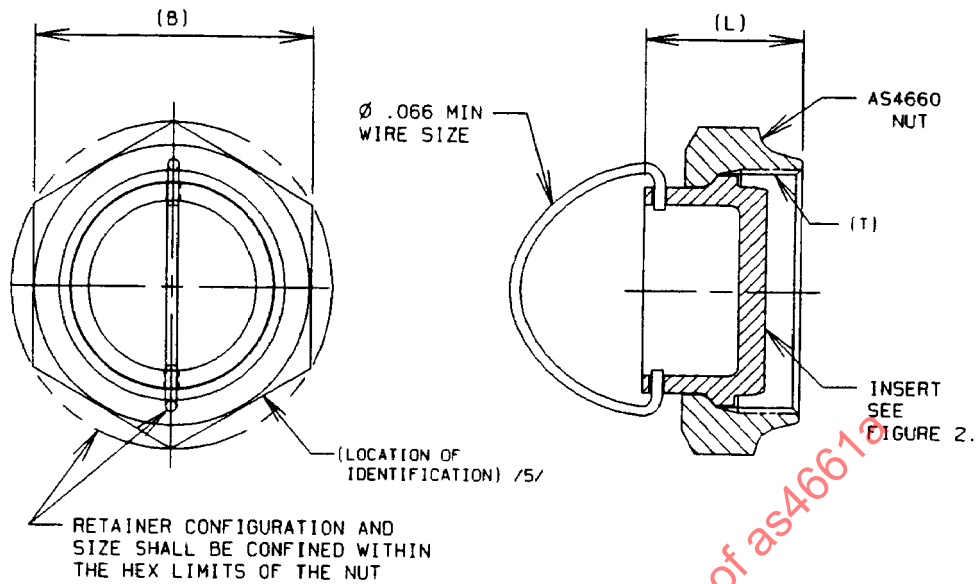


FIGURE 1 - FITTING ASSEMBLY, CAP

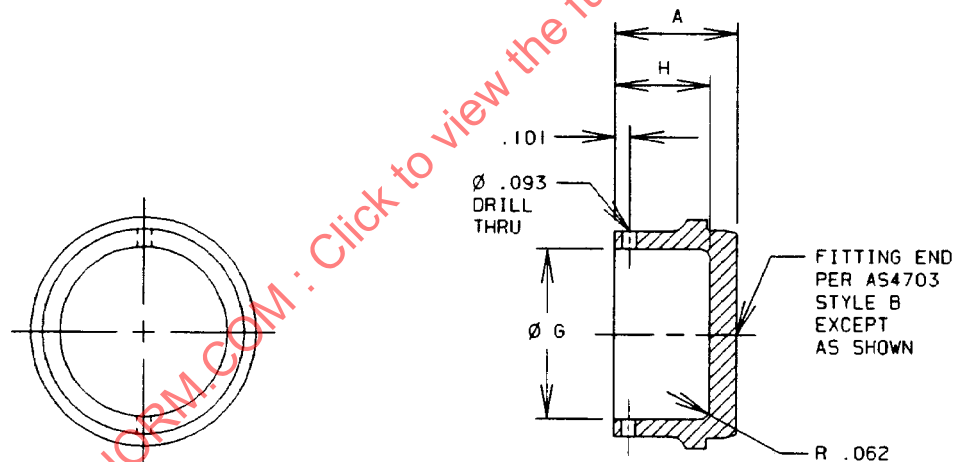
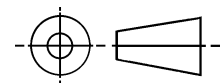


FIGURE 2 - CAP INSERT

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3/G-3B

PROCUREMENT SPECIFICATION: /4/ MIL-F-18280

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

FITTING ASSEMBLY, CAP, SHORT FLARELESS

AS4661
SHEET 1 OF 3

**REV.
A**

REV.
A

AS4661

TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NO. AS4661	(NOMINAL TUBE SIZE)	T THREAD PER MIL-S-8879	A	B	G	H	L	LB/EA MAX ALUM	LB/EA MAX CRES	LB/EA MAX TI
20	1.250	1.5625-12 UNJ	.800	1.812	1.093	.590	1.035	.118	.321	.185
24	1.500	1.8125-12 UNJ	.800	2.062	1.343	.525	1.035	.171	.473	.258
28	1.750	2.1250-12 UNJ	.820	2.375	1.585	.520	1.065	.325	.892	.512

NOTES:

/1/ MATERIAL:

a. CODE LETTER T:

- (1) INSERT: TYPE 6AL-4V TITANIUM ALLOY BAR PER AMS 4928
- (2) NUT: CODE LETTER T OF AS4660 REFERENCE (TYPE 6AL-4V TITANIUM ALLOY)
- (3) WIRE: CORROSION RESISTANT STEEL TYPE 302 PER ASTM A 493 OR CLASS 305 PER AMS 5685

b. CODE LETTER V:

- (1) INSERT: TYPE 15-5PH CORROSION RESISTANT STEEL PER AMS 5659
- (2) NUT: CODE LETTER V OF AS4660 REFERENCE (TYPE 15-5PH CORROSION RESISTANT STEEL)
- (3) WIRE: CORROSION RESISTANT STEEL TYPE 302 PER ASTM A 493 OR CLASS 305 PER AMS 5685

c. CODE LETTER W:

- (1) INSERT: TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS 4124
- (2) NUT: CODE LETTER W OF AS4660 REFERENCE (TYPE 7075T73 ALUMINUM ALLOY)
- (3) WIRE: CORROSION RESISTANT STEEL TYPE 302 PER ASTM A 493 OR CLASS 305 PER AMS 5685

/2/ HEAT TREATMENT:

a. MATERIAL CODE LETTER T:

- (1) INSERT, NUT, AND WIRE: NONE

b. MATERIAL CODE LETTER V:

- (1) INSERT: HEAT TREAT TO CONDITION H1075 PER AMS 2759/3
- (2) NUT: MATERIAL CODE LETTER V OF AS4660 REFERENCE (HEAT TREAT TO CONDITION H1075)
- (3) WIRE: NONE

c. MATERIAL CODE LETTER W:

- (1) INSERT, NUT, AND WIRE: NONE

/3/ FINISH:

a. MATERIAL CODE LETTER T:

- (1) INSERT: FLUORIDE PHOSPHATE CONVERSION COAT PER AMS 2486
- (2) NUT: CODE LETTER T OF AS4660 REFERENCE (FLUORIDE PHOSPHATE COAT AND COAT WITH DRY LUBRICANT ON ID)
- (3) WIRE: PASSIVATE PER QQ-P-35 TYPE VI OR VII