

TABLE 1A - DIMENSIONS

BASIC NO. AS5235 /13/ SIZE CODE	(NOMINAL TUBE SIZE)	A ±.020	B ±.003	C +.005/- .000	D	E +.003/- .000	F ±.003
02	.125	.410	.316	.098	.164- .168	.129	.157
03	.188	.450	.278	.060	.226- .230	.193	.230
04	.250	.520	.336	.060	.294- .298	.255	.289
05	.312	.590	.336	.060	.360- .364	.318	.353
06	.375	.660	.375	.060	.419- .423	.380	.411
08	.500	.750	.375	.060	.546- .550	.506	.559
10	.625	.800	.415	.090	.682- .686	.633	.672
12	.750	.750	.415	.120	.817- .821	.758	.810
16	1.000	.800	.415	.120	1.065-1.069	1.008	1.060
20	1.250	.800	.415	.120	1.320-1.325	1.258	1.313
24	1.500	.800	.415	.120	1.570-1.575	1.511	1.563
32	2.000	.800	.415	.150	2.070-2.075	2.011	2.066

TABLE 1B - DIMENSIONS AND WEIGHTS

BASIC NO. AS5235 /13/ SIZE CODE	G ±.002	H	J ±.004	K ±.004	RR +.005/- .000	RS +.005/- .000	LB/100 APPROX REF
02	.177	.256	.152	.028	.003-.006	.010	.145
03	.254	.299	.225	.024	.003-.006	.007	.242
04	.311	.359	.284	.028	.003-.006	.007	.485
05	.375	.422	.348	.028	.003-.006	.007	.660
06	.437	.484	.406	.028	.003-.006	.007	.770
08	.587	.619	.554	.028	.003-.006	.007	1.21
10	.709	.750	.667	.028	.008-.014	.010	1.65
12	.838	.938	.805	.028	.008-.014	.010	2.20
16	1.088	1.156	1.055	.028	.008-.014	.010	3.16
20	1.341	1.437	1.308	.028	.008-.014	.010	4.07
24	1.591	1.687	1.558	.028	.008-.014	.010	4.73
32	2.094	2.218	2.061	.028	.008-.014	.010	6.09

NOTES:

NOTICE

THIS DOCUMENT REFERENCES A PART WHICH CONTAINS CADMIUM AS A PLATING MATERIAL. CONSULT LOCAL OFFICIALS IF YOU HAVE QUESTIONS CONCERNING CADMIUM'S USE.

/1/ MATERIAL:

- DASH AS CODE LETTER - TYPE 1213, 12L14 OR 1215 CARBON STEEL BAR PER ASTM A 108 OR TYPE 1213 CARBON STEEL BAR PER ASTM A 576.
- CODE LETTER K - TYPE 316 CORROSION RESISTANT STEEL BAR PER AMS5648.
- CODE LETTER C - TYPE 17-4PH CORROSION RESISTANT STEEL BAR PER AMS5643 /6/.

 An SAE International Group	AEROSPACE STANDARD		 AS5235 SHEET 2 OF 4	REV. B
	FITTING, SLEEVE, COUPLING, FLARELESS			

2. HEAT TREATMENT:

- a. DASH AS MATERIAL CODE LETTER - SEE FUNCTIONAL TEST REQUIREMENT PER PROCUREMENT SPECIFICATION.
- b. MATERIAL CODE LETTER K - SEE FUNCTIONAL TEST REQUIREMENT PER PROCUREMENT SPECIFICATION.

NOTE: NO TENSILE TEST REQUIRED FOR USE OF 304 ANNEALED TUBING

- c. MATERIAL CODE LETTER C - MINIMUM THROUGH-HARDNESS 414 KHN.

NOTE: NO TENSILE TEST REQUIRED FOR USE OF 304 ANNEALED TUBING

3. FINISH:

- a. DASH AS MATERIAL CODE LETTER - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 AND PER PROCUREMENT SPECIFICATION.
- b. MATERIAL CODE LETTER K - NONE
- c. MATERIAL CODE LETTER C - PASSIVATE PER AMS2700, TYPE 2 OR 8

/4/ PROCUREMENT SPECIFICATION: AS18280 EXCEPT AS 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-AS18280 FOR THIS STANDARD. SEE <http://www.eauditnet.com> FOR CURRENT QPL ONLINE.

NOTE: PRI-QPL LIMITATION - WITH REVISION B OF THIS STANDARD THE PROCUREMENT SPECIFICATION HAS BEEN CHANGED FROM AS4444 FOR 5000 psi TO AS18280 FOR 3000 psi. USERS OF THIS FITTING FOR 5000 psi APPLICATIONS PER AS4444 ARE ADVISED TO CONTROL SOURCE APPROVAL BY STANDARD PAGE SUPPLEMENT OR SIMILAR MEANS.

/5/ IDENTIFICATION AT LOCATION SHOWN: MARK PER AS478 CLASS C OR D OR METHOD 7A3, 15A3 OR 15B. MARK MANUFACTURER'S NAME, TRADEMARK OR CAGE CODE AND MATERIAL CODE LETTER ON ϕ D.

/6/ INTENDED USE: THIS PART IS DESIGNED FOR USE IN SYSTEMS WITH MAXIMUM OPERATING PRESSURES AS FOLLOWS:

- a. DASH AS MATERIAL CODE LETTER "-" SIZES 02 THROUGH 16 AT 3000 psi; SIZES 20 THROUGH 32 AT 1500 psi.
- b. MATERIAL CODE LETTER K SIZES 02 THROUGH 16 AT 3000 psi, SIZES 20 THROUGH 24 AT 1500 psi, TESTED WITH 304 ANNEALED TUBING PER AMS5567.
- c. MATERIAL CODE LETTER C SIZES 02 THROUGH 16 AT 3000 psi, SIZES 20 THROUGH 24 AT 1500 psi, TESTED WITH 304 ANNEALED TUBING PER AMS5567.

7. F DIAMETER, K LENGTH, R RADIUS, S RADIUS AND 2°30' EDGE ANGLE ARE NON-INSPECTABLE AFTER PRODUCTION OF 12°0' PILOT ANGLE.

8. OVALITY: THE INCREASE OR DECREASE OF ALL DIAMETERS (D, E, F, G, H AND J) DUE TO WARPAGE CAUSED BY HEAT TREATMENT SHALL NOT EXCEED THE SPECIFIED DIMENSIONS, INCLUDING TOLERANCES, BY MORE THAN .004 FOR SIZES 02 THROUGH 12, NOR MORE THAN .006 FOR SIZES 16 THROUGH 32 WHEN MEASURED AFTER HEAT TREATMENT.

9. INTERPRETATION OF DRAWING PER AS4296.

10. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M; REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 μ in Ra.

11. DIMENSIONING AND TOLERANCING: ASME Y14.5M-1994.

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