

RATIONALE

MATERIAL RECOMMENDATION NOTE ADDED. FLAGNOTE /16/ ADDED TO MATERIAL NOTE FOR MATERIALS D AND S. UPDATED SPECIFICATION CALLOUTS TO CURRENT NOMENCLATURE. UPDATED PROCUREMENT SPECIFICATION NOTE. FLAGNOTE /16/ ADDED.

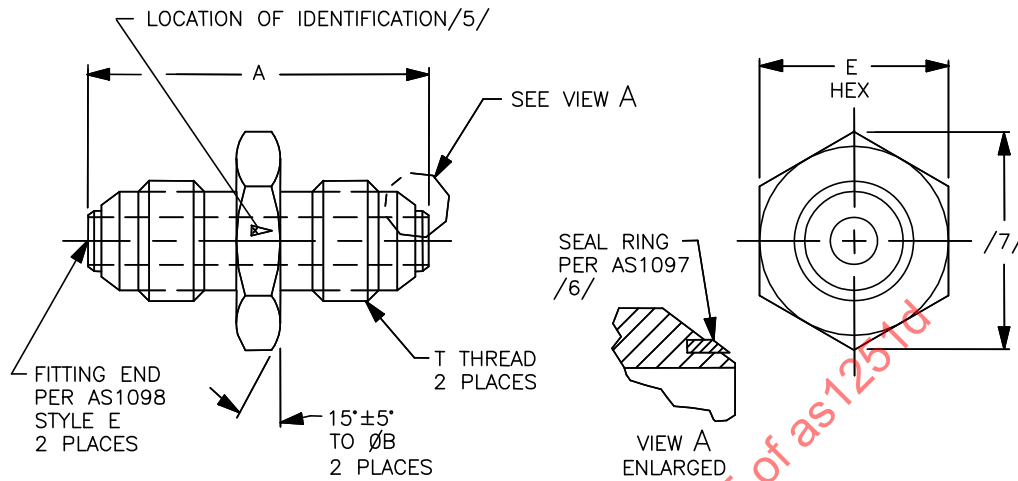


FIGURE 1 - FITTING, UNION, FLARED TUBE

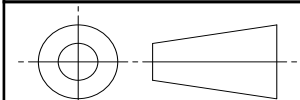
TABLE 1 - DIMENSIONS A-E AND WEIGHTS

BASIC NUMBER AS1251 /15/ SIZE CODE	(NOMINAL TUBE SIZE)	T THREAD PER AS8879 CLASS 3A	A + .000 - .090	B ± .010	E	LB/EA APPROX REF ALUM	LB/EA APPROX REF CRES
04	.250	.4375-20UNJF	1.266	.668	.678-.691	.0145	.042
06	.375	.5625-18UNJF	1.391	.792	.802-.815	.0248	.072
08	.500	.7500-16UNJF	1.578	.980	.990-1.003	.0462	.134
10	.625	.8750-14UNJF	1.844	1.103	1.113-1.128	.070	.204
12	.750	1.0625-12UNJ	2.125	1.353	1.363-1.380	.122	.355
16	1.000	1.3125-12UNJ	2.203	1.603	1.613-1.630	.173	.502
20	1.250	1.6250-12UNJ	2.297	1.853	1.863-1.880	.238	.690
24	1.500	1.8750-12UNJ	2.547	2.099	2.109-2.135	.360	1.044
28	1.750	2.2500-12UNJ	2.828	2.474	2.484-2.510	.538	1.562
32	2.000	2.5000-12UNJ	3.078	2.724	2.734-2.760	.669	1.943

NOT RECOMMENDED IN PART /16/

For more information on this standard, visit
<https://www.sae.org/standards/content/AS1251D>

THIRD ANGLE PROJECTION



CUSTODIAN: SAE G-3B

PROCUREMENT SPECIFICATION: KSC-F-124 /4/



AEROSPACE STANDARD

FITTING, UNION,
FLARED TUBE,
FOR SEAL RING

AS1251™
SHEET 1 OF 3

REV.
D

NOTES:

/1/ MATERIAL:

- a. CODE LETTER D: TYPE 2024-T6 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6 OR AMS4112, OR TYPE 2024-T851 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/6. /16/
- b. CODE LETTER J: 304 CORROSION-RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS5639.
- c. CODE LETTER K: 316 CORROSION-RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS5648.
- d. CODE LETTER R: 321 CORROSION-RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS5645.
- e. CODE LETTER S: 347 CORROSION-RESISTANT STEEL BAR PER AMS-QQ-S-763 OR AMS5646. /16/
- f. CODE LETTER W: TYPE 7075-T73 ALUMINUM ALLOY BAR PER AMS-QQ-A-225/9, OR TYPE 7075-T7351 ALUMINUM ALLOY BAR PER AMS4124.

2. HEAT TREAT PER PROCUREMENT SPECIFICATION

3. FINISH:

- a. MATERIAL CODE LETTER D: ANODIZE PER AMS2472 OR MIL-PRF-8625 TYPE II, CLASS 2, DYE BLUE, AND DUPLEX SEAL PER PROCUREMENT SPECIFICATION.
- b. MATERIAL CODE LETTERS J, K, R, AND S; PASSIVATE PER AMS2700, TYPE 6 OR TYPE 7.
- c. MATERIAL CODE LETTER W: ANODIZE PER AMS2472 OR MIL-PRF-8625, TYPE II, CLASS 2, DYE BROWN, DUPLEX SEAL PER PROCUREMENT SPECIFICATION.

/4/ PROCUREMENT SPECIFICATION: KSC-F-124 JOHN F KENNEDY SPACE CENTER, NASA, SPECIFICATION FOR FITTINGS (PRESSURE CONNECTIONS), FLARED TUBE. PRODUCT MANUFACTURED TO THIS STANDARD SHALL MEET THE REQUIREMENTS SPECIFIED HEREIN AND THE PROCUREMENT SPECIFICATION. ORIGINAL COMPONENT MANUFACTURERS (OCM) SHALL BE LISTED IN THE NADCAP QUALIFIED MANUFACTURER LIST (QML) AC7112, AC7112/2 FOR THIS PRODUCT TYPE. THE QML IS AVAILABLE AT www.eAuditNet.com.

/5/ IDENTIFICATION: MARK PER AS478 CLASS C OR CLASS D; METHOD 7A3, 15A3, OR 15B.

- a. FOR SIZES .06 (.375 OD TUBE SIZE) AND SMALLER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, LETTERS "AS," AND MATERIAL CODE LETTER.
- b. FOR SIZES .08 (.500 OD TUBE SIZE) AND LARGER: MANUFACTURER'S NAME, CAGE CODE OR TRADEMARK, BASIC PART NUMBER, AND MATERIAL CODE LETTER.

/6/ THE SEAL RING IS ORDERED SEPARATELY AS AN AS1097.

/7/ HEX CORNERS MAY BE ROUNDED PER ARP1942.

8. INTERPRETATION OF DRAWING PER AS4296.

9. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES ARE TO BE 125 MICROINCHES Ra.

10. BREAK EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.

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

12. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED. TOLERANCES: LINEAR DIMENSIONS ± 0.016 ; ANGULAR DIMENSIONS $\pm 0^{\circ}30'$.

13. REVISION INDICATOR: A CHANGE BAR (I) LOCATED IN THE LEFT MARGIN IS FOR THE CONVENIENCE OF THE USER IN LOCATING AREAS WHERE TECHNICAL REVISIONS, NOT EDITORIAL CHANGES, HAVE BEEN MADE TO THE PREVIOUS ISSUE OF THIS DOCUMENT. AN (R) SYMBOL TO THE LEFT OF THE DOCUMENT TITLE INDICATES A COMPLETE REVISION OF THE DOCUMENT, INCLUDING TECHNICAL REVISIONS. CHANGE BARS AND (R) ARE NOT USED IN ORIGINAL PUBLICATIONS, NOR IN DOCUMENTS THAT CONTAIN EDITORIAL CHANGES ONLY.

	AEROSPACE STANDARD	AS1251™ SHEET 2 OF 3	REV. D
	FITTING, UNION, FLARED TUBE, FOR SEAL RING		