

REV.
A

AS5802™

FEDERAL SUPPLY CLASS
4730

RATIONALE

REVISED NOTE 13 FOR DEFINITION CORRECTION OF DIMENSION "A1" (FITTING BODY LENGTH). ADDED SUFFIX CODE "B" FOR FITTING ASSEMBLIES WITH BLUE ANODIZED RINGS AND NOTE 15 AS AN OPTION FOR FUTURE REPLACEMENT OF "NO CODE" BLUE COATING OR PAINT. UPDATED FIGURE AND WEIGHTS. REVISED NOTES 3, 7, AND 14. ADDED NOTES 12, 16, AND AS6449 AS A NEW LUBRICANT TYPE.

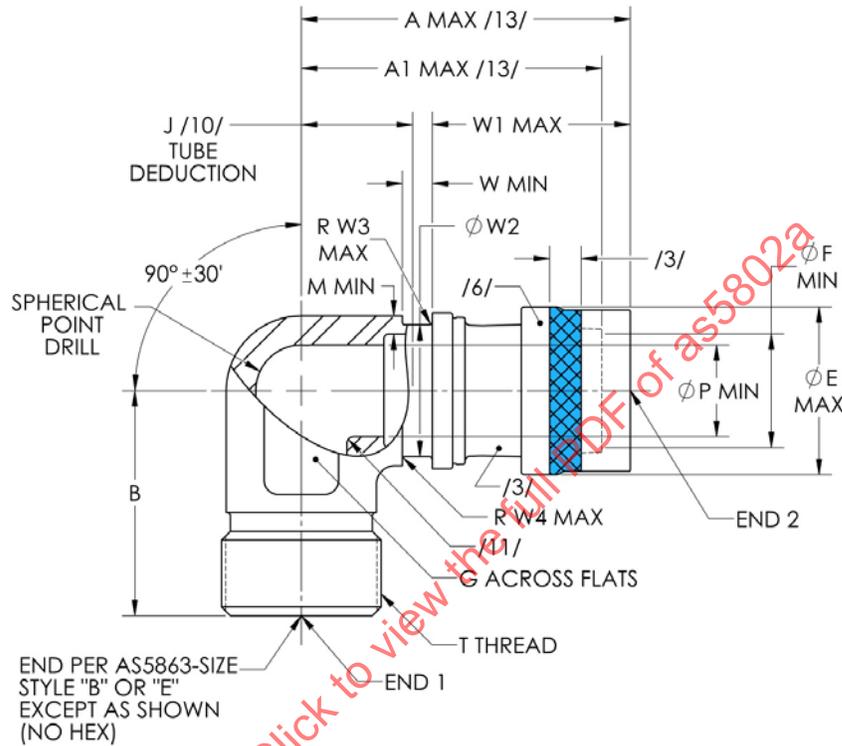
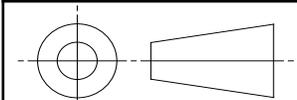


FIGURE 1 - ELBOW, 90°, MALE FLARELESS, AXIAL SWAGED

(SEE TABLES 1A AND 1B FOR DIMENSIONS AND WEIGHTS)

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THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3B

PROCUREMENT SPECIFICATION: AS5958 /4/



AEROSPACE STANDARD

(R) FITTING ASSEMBLY, ELBOW, 90°, MALE FLARELESS, AXIALLY SWAGED, HYDRAULIC, 3000 PSI

AS5802™
SHEET 1 OF 4

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ISSUED 2008-06 REAFFIRMED 2015-04 REVISED 2015-08

TABLE 1A - DIMENSIONS A THROUGH J

BASIC NO. AS5802 /14/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	A MAX.	A1 MAX.	B ±.015	E MAX.	F MIN.	G		J /10/ TUBE DEDUCT	
0404	.2500	.2500	.935	.848	.767	.466	.253	.348	.380	.353	±.150
0604	.3750	.2500	.998	.911	.846	.466	.253	.477	.509	.416	±.150
0406	.2500	.3750	1.215	1.099	.830	.609	.378	.477	.509	.416	±.150
0606	.3750	.3750	1.215	1.099	.846	.609	.378	.477	.509	.416	±.150
0806	.5000	.3750	1.308	1.192	1.032	.609	.378	.615	.647	.509	±.150
0608	.3750	.5000	1.516	1.370	.939	.783	.504	.615	.647	.517	±.175
0808	.5000	.5000	1.516	1.370	1.032	.783	.504	.615	.647	.517	±.175
1008	.6250	.5000	1.579	1.433	1.158	.783	.504	.751	.783	.580	±.175
0810	.5000	.6250	1.873	1.669	1.095	.939	.629	.751	.783	.580	±.175
1010	.6250	.6250	1.873	1.669	1.158	.939	.629	.751	.783	.580	±.175
1210	.7500	.6250	1.998	1.794	1.346	.939	.629	.893	.925	.705	±.175
1012	.6250	.7500	2.149	1.944	1.283	1.122	.754	.893	.925	.712	±.175
1212	.7500	.7500	2.149	1.944	1.346	1.122	.754	.893	.925	.712	±.175
1612	1.0000	.7500	2.308	2.103	1.505	1.122	.754	1.181	1.213	.871	±.175
1216	.7500	1.0000	2.606	2.392	1.505	1.495	1.004	1.181	1.213	.878	±.200
1616	1.0000	1.0000	2.606	2.392	1.505	1.495	1.004	1.181	1.213	.878	±.200
2016	1.2500	1.0000	2.728	2.514	1.627	1.495	1.004	1.609	1.641	1.000	±.200
1620	1.0000	1.2500	3.020	2.796	1.627	1.758	1.255	1.609	1.641	1.009	±.200
2020	1.2500	1.2500	3.020	2.796	1.627	1.758	1.255	1.609	1.641	1.009	±.200

TABLE 1B - DIMENSIONS M THROUGH W4 AND WEIGHTS

BASIC NO. AS5802 /14/ SIZE CODE	NOMINAL TUBE SIZE END 1	NOMINAL TUBE SIZE END 2	M MIN.	P MIN.	T THREAD PER AS8879	W MIN.	W1 MAX.	W2 ±.0015	W3 MAX.	W4 MAX.	WEIGHT
											APPROX. REF.
0404	.2500	.2500	.043	.198	.4375-20 UNJF-3A	.123	.488	.3005	.018	.065	.019
0604	.3750	.2500	.045	.198	.5625-18 UNJF-3A	.123	.488	.3005	.018	.065	.035
0406	.2500	.3750	.045	.302	.4375-20 UNJF-3A	.153	.675	.4475	.033	.065	.039
0606	.3750	.3750	.045	.302	.5625-18 UNJF-3A	.153	.675	.4475	.033	.065	.038
0806	.5000	.3750	.052	.302	.7500-16 UNJF-3A	.153	.675	.4475	.033	.065	.060
0608	.3750	.5000	.052	.401	.5625-18 UNJF-3A	.165	.871	.5945	.033	.129	.070
0808	.5000	.5000	.052	.401	.7500-16 UNJF-3A	.165	.871	.5945	.033	.129	.076
1008	.6250	.5000	.057	.401	.8750-14 UNJF-3A	.165	.871	.5945	.033	.129	.112
0810	.5000	.6250	.057	.507	.7500-16 UNJF-3A	.140	1.190	.7365	.021	.078	.122
1010	.6250	.6250	.057	.507	.8750-14 UNJF-3A	.140	1.190	.7365	.021	.078	.121
1210	.7500	.6250	.065	.507	1.0625-12 UNJ-3A	.140	1.190	.7365	.021	.078	.195
1012	.6250	.7500	.065	.604	.8750-14 UNJF-3A	.154	1.327	.8805	.024	.089	.195
1212	.7500	.7500	.065	.604	1.0625-12 UNJ-3A	.154	1.327	.8805	.024	.089	.195
1612	1.0000	.7500	.084	.604	1.3125-12 UNJ-3A	.154	1.327	.8805	.024	.089	.326
1216	.7500	1.0000	.084	.802	1.0625-12 UNJ-3A	.167	1.612	1.1725	.027	.099	.405
1616	1.0000	1.0000	.084	.802	1.3125-12 UNJ-3A	.167	1.612	1.1725	.027	.099	.386
2016	1.2500	1.0000	.174	.802	1.6250-12 UNJ-3A	.167	1.612	1.1725	.027	.099	.665
1620	1.0000	1.2500	.174	1.011	1.3125-12 UNJ-3A	.185	1.886	1.4345	.030	.113	.705
2020	1.2500	1.2500	.174	1.011	1.6250-12 UNJ-3A	.185	1.886	1.4345	.030	.113	.700

	AEROSPACE STANDARD	AS5802™ SHEET 2 OF 4	REV. A
	(R) FITTING ASSEMBLY, ELBOW, 90°, MALE FLARELESS, AXIALLY SWAGED, HYDRAULIC, 3000 PSI		

NOTES:

/1/ MATERIALS:

CODE LETTER "T"

RING - AMS4965 TITANIUM ALLOY, 6.0AI - 4.0V SOLUTION HEAT TREATED AND AGED OR AMS4928 TITANIUM ALLOY 6.0AI - 4.0V ANNEALED WITH HIGH STRENGTH CARBON FIBER/EPOXY RESIN COMPOSITE REINFORCEMENT.

BODY - AMS4928 TITANIUM ALLOY, 6.0AI - 4.0V ANNEALED

2. FINISH:

TITANIUM - NONE REQUIRED

/3/ COATINGS/LUBRICANTS /15/:

a. NO SUFFIX CODE LETTER

- (1) RING - THE OUTER SURFACE SHALL HAVE A .125 INCH MINIMUM WIDTH BLUE COLORED RING OR SHALL BE COMPLETELY COLORED BLUE TO MATCH THE SWAGE TOOL COLOR CODE SPECIFIED IN THE AS5959 INSTALLATION PROCEDURE. BLUE PTFE COATING OR PAINT SHALL BE RESISTANT TO AS1241 FLUID WHEN USED. MARKING METHODS SHALL BE IN ACCORDANCE WITH AS5958.
- (2) BODY - LEAD FREE SOLID FILM LUBRICANT PER AS5272 TYPE I OR II, OR PER AS6449 TYPE III OR IV, PTFE OR PETROLEUM-BASED LUBRICANT SHALL BE APPLIED TO PORTIONS OF THE ID AND OD. THE PETROLEUM-BASED LUBRICANT AND/OR AS5272 LUBRICANT SHALL NOT BE IN CONTACT WITH THE SYSTEM FLUID.

b. SUFFIX CODE LETTER "B"

- (1) RING - THE OUTER SURFACE SHALL HAVE A .125 INCH MINIMUM WIDTH BLUE ANODIZED RING OR SHALL BE COMPLETELY ANODIZED BLUE TO MATCH THE SWAGE TOOL COLOR CODE SPECIFIED IN THE AS5959 INSTALLATION PROCEDURE. MARKING METHODS SHALL BE IN ACCORDANCE WITH AS5958.
- (2) BODY - LEAD FREE SOLID FILM LUBRICANT PER AS5272 TYPE I OR II, OR PER AS6449 TYPE III OR IV, PTFE OR PETROLEUM-BASED LUBRICANT SHALL BE APPLIED TO PORTIONS OF THE ID AND OD. THE PETROLEUM-BASED LUBRICANT AND/OR AS5272 LUBRICANT SHALL NOT BE IN CONTACT WITH THE SYSTEM FLUID.

/4/ PROCUREMENT SPECIFICATION: AS5958 EXCEPT AS SPECIFIED ON THIS STANDARD. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED AND ASSEMBLED BY AN ACCREDITED MANUFACTURER OR ASSEMBLED BY AN ACCREDITED DISTRIBUTOR LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST (QPL) PRI-QPL-AS5958 FOR THIS STANDARD. SEE www.eAuditNet.com FOR THE CURRENT QPL ON-LINE.

5. DIMENSIONS AND TOLERANCES NOT DEFINED ON THIS STANDARD SHALL BE SPECIFIED AND CONTROLLED BY THE MANUFACTURER. THE MANUFACTURER IS RESPONSIBLE TO ENSURE COMPLIANCE WITH THE PROCUREMENT SPECIFICATION.

/6/ IDENTIFICATION SHALL BE IN ACCORDANCE WITH AS5958 AND SHALL BE LOCATED ON THE RING IN THE AREA SHOWN.

7. FITTINGS SHALL BE INSTALLED IN ACCORDANCE WITH AS5959. THE AFTER SWAGE ACCEPTABILITY LIMIT DIMENSION "Z" FOR EACH PORT SIZE IS DEFINED IN AS5959.

8. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES SHALL BE 125 MICROINCHES Ra AND THE FORGED SURFACES SHALL BE 250 MICROINCHES Ra.

	AEROSPACE STANDARD	AS5802™ SHEET 3 OF 4	REV. A
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