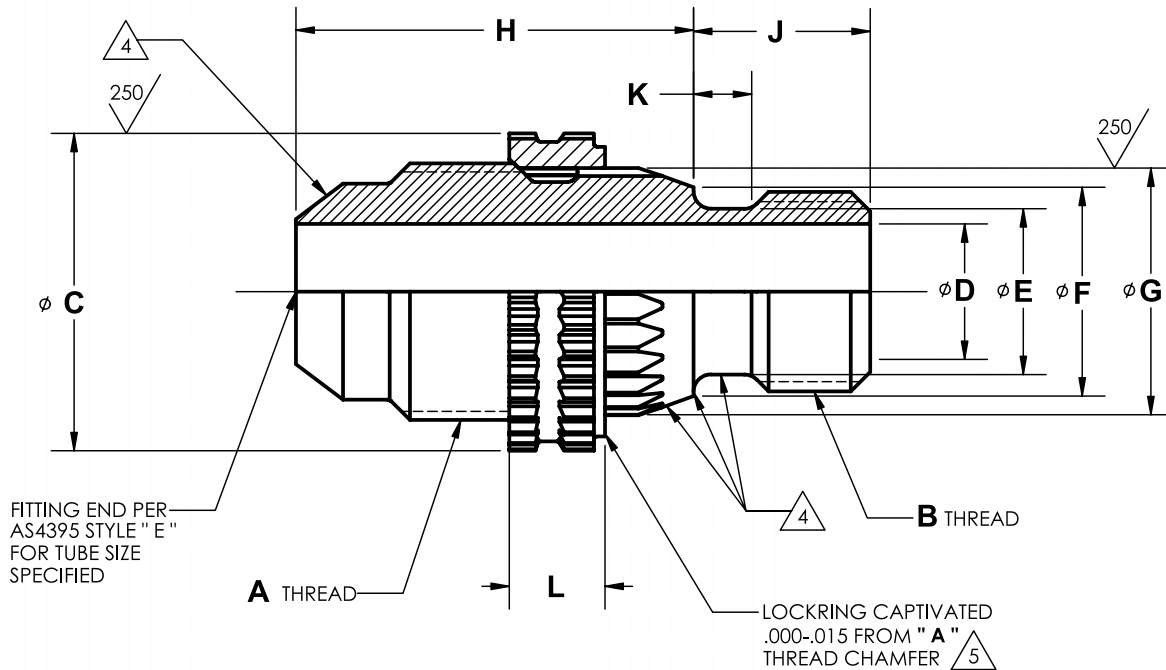


Sta-Lok® Fluid Fittings



NOTES:

1. MATERIAL :
 - a. FITTING: 6Al-4V TITANIUM ALLOY PER AMS4928, AMS4965, OR AMS4967.
 - b. LOCKRING: A286 CORROSION RESISTANT STEEL PER AMS5731 OR AMS5734.
2. HEAT TREATMENT:
 - a. FITTING: 130 ksi UTS MIN
 - b. LOCKRING: 34-40 HRC
3. FINISH:
 - a. FITTING: ANODIC TREATMENT PER AMS2488, TYPE 2.
 - b. LOCKRING: PASSIVATE PER AMS-QQ-P-35, TYPE II.
4. SEALING SURFACE : NO VISIBLE DEFECTS. TO BE PROTECTED FOR SHIPMENT.
5. LOCKRING RETAINED ON FITTING BY CONTROLLED INTERFERENCE FIT.
6. IDENTIFICATION PER AS478 CLASS 35D, NAME, TRADEMARK OR CAGE CODE AND PART NUMBER.
7. WORKING PRESSURE: THIS PART IS DESIGNED FOR USE IN 4000 psi WORKING PRESSURE SYSTEMS COMPATIBLE WITH TITANIUM.
8. FITTINGS TO BE INSTALLED PER TECHNICAL SALES BULLETIN No. TSB0022 (SLAS1301) INTO BOSS CAVITIES PER SLAS1300.
9. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36. REQUIREMENTS PER ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 MICROINCHES Ra AND SEALING SURFACE TO BE 63 MICROINCHES Ra.

EXAMPLE OF PART CODING

SLAS1985 - 06

SIZE CODE
(SEE TABLE I)

BASIC PART NUMBER



NOTES: CONTINUED ON SHEET 2 OF 2

REVISION (A) 20 MAY 2003

UNLESS OTHERWISE SPECIFIED
INTERPRET DIMENSION & TOLERANCES PER
ANSI Y14.5M. ALL DIMENSIONS APPLY AFTER
PLATING AND PRIOR TO THE ADDITION OF SOLID
FILM LUBRICANT. 125 [3.2]

TOLERANCES ALL SURFACES

.XX	.XXX	ANGLES	[X.X]	[X.XX]
±.03	±.010	±2°	±[0.8]	±[0.25]

 DIMENSION IN [] ARE MILLIMETERS

SHUR-LOK CORPORATION
IRVINE, CALIFORNIA 92614
TELEPHONE: (949) 474-6000

SHUR-LOK

SHUR-LOK INTERNATIONAL, S.A.
PETIT-RECHAIN, BELGIUM
TELEPHONE: (32) 87-32.07.11

SLAS1985

**FITTING ASSEMBLY – PORT CONNECTION
RING LOCKED TO FLARED TUBE END, 4000psi**

SHEET 1 OF 2

Sta-Lok® Fluid Fittings



NOTES: CONTINUED

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

11. DIMENSIONS IN INCHES.

TABLE I

SIZE CODE	AS1985 PART NUMBER	NOMINAL TUBE SIZE REF	A THREAD PER AS8879	B THREAD PER AS8879	Ø C ±.005	Ø D REF	Ø E +.005 -.002	Ø F MIN
02	AS1985-02	.125	.3125-24UNJF-3A	.2160-28UNJF-3A	.400	.058-.065	.154	.246
03	AS1985-03	.188	.3750-24UNJF-3A	.2500-28UNJF-3A	.468	.121-.128	.186	.278
04	AS1985-04	.250	.4375-20UNJF-3A	.3125-24UNJF-3A	.514	.168-.175	.239	.331
05	AS1985-05	.312	.5000-20UNJF-3A	.3750-24UNJF-3A	.624	.230-.237	.301	.393
06	AS1985-06	.375	.5625-18UNJF-3A	.4375-20UNJF-3A	.700	.293-.301	.364	.456
08	AS1985-08	.500	.7500-16UNJF-3A	.5625-18UNJF-3A	.814	.387-.395	.482	.574
10	AS1985-10	.625	.8750-14UNJF-3A	.6875-24UNJEF-3A	1.040	.480-.488	.625	.717
12	AS1985-12	.750	1.0625-12UNJ-3A	.8125-20UNJEF-3A	1.170	.604-.614	.737	.891
16	AS1985-16	1.000	1.3125-12UNJ-3A	1.1250-18UNJEF-3A	1.456	.839-.851	1.000	1.154
20	AS1985-20	1.250	1.6250-12UNJ-3A	1.3125-18UNJEF-3A	1.782	1.073-1.086	1.225	1.379
24	AS1985-24	1.500	1.8750-12UNJ-3A	1.6250-18UNJEF-3A	2.031	1.307-1.320	1.502	1.656
32	AS1985-32	2.000	2.5000-12UNJ-3A	2.1250-16UNJ-3A	2.548	1.776-1.791	2.040	2.194

TABLE I CONT'D

SIZE CODE	Ø G REF	H +.010 -.005	J +.000 -.015	K +.010 -.005	L ±.007	WEIGHT LB/EA APPROX
02	.317	.743	.300	.125	.192	.010
03	.349	.774	.355	.125	.192	.014
04	.400	.845	.355	.125	.192	.017
05	.491	.845	.381	.125	.192	.023
06	.544	.872	.395	.125	.210	.028
08	.670	.973	.430	.125	.210	.047
10	.824	1.074	.465	.125	.210	.077
12	.981	1.190	.527	.157	.220	.110
16	1.251	1.237	.564	.157	.220	.163
20	1.466	1.311	.569	.157	.240	.245
24	1.768	1.435	.608	.157	.240	.282
32	2.311	1.726	.730	.157	.240	.612

REVISION **A** 20 MAY 2003

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SLAS1985

**FITTING ASSEMBLY – PORT CONNECTION
 RING LOCKED TO FLARED TUBE END, 4000psi**

SHEET **2** OF **2**