



Fastener *Tool & Supply*

***Proud distributor for
Shur-Lok***





Shur-Lok

Sta-Lok[®] Fluid Fittings



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Please contact Shur-Lok Corporation at (949) 474-6000 for any special designs or other standards not listed above.



INTRODUCTION

The Shur-Lok Corporation ... fastening the future for over 50 years

Our proven performance record has been a result of a customer oriented approach to meeting the increasingly complex requirements of the industry for over 50 years. Our affiliate, Shur-Lok International was formed over 20 years ago to serve the European aerospace and related industries. Like its U.S. counterpart, this operation has the capacity to design, manufacture and support the sale of Shur-Lok products worldwide.

Shur-Lok offers customers with special design or application problems the chance to utilize the special expertise of engineers with years of concentrated experience in the design of specialty fasteners. As a pioneer in the development of fastener components, we have logged an impressive record of successful solutions to the most complex problems. In fact, many of our products have become industry standards.

Fabrication is done at one of the most progressive and continuously evolving manufacturing facilities, where research and development are encouraged. This modern manufacturing facility provides Shur-Lok with a high degree of production flexibility in meeting both large and small volume production. By maximizing our resources, Shur-Lok has been able to invest in new equipment while satisfying the just-in-time delivery requirements of industry. From the latest in computer numerically controlled (CNC) milling and turning machines to building our own semi-automated assembly machines, Shur-Lok strives to take full advantage of new advancements in manufacturing technology.

Extensive quality control is fundamental to Shur-Lok's design and manufacturing groups. As a result, our fasteners and components have adhered to the highest industry standards. By qualifying to MIL-Q-9858A, Shur-Lok continues to meet the requirements of the most comprehensive inspection system in use today.

Whatever your fastener or component requirements, you'll find that Shur-Lok Corporation offers superior products, engineered for superior performance. Standing behind the products and services we offer, our sales personnel retain an active role from design to after sales service. For more information contact your nearest Shur-Lok Representative.

Shur-Lok International, S.A.

Centrally located to serve the growing requirements of the European community, Shur-Lok International's facility in Belgium is fully staffed and equipped to manufacture and distribute a full line of Shur-Lok products. Originally established in 1965, our European operation has enjoyed continual growth in their large headquarters pictured below.

Shur-Lok International is supported by sales representatives throughout Europe and beyond; additionally it is uniquely qualified to provide expertise in the marketing of products to many different countries. Our multi-lingual sales engineering personnel are qualified to assist in the design of products for the aerospace industry both in Europe and elsewhere.

Our international operations also provide a full range of management services that are available to firms desiring to enter the European market. Included are manufacturing and sub-assembly capability, bonded warehousing for duty-free storage, registration of patents, brand names, and trademarks. Further we are able to offer such services as banking and auditing that can provide assistance to U.S. firms seeking to establish themselves on the continent with minimum difficulty and expense.

McKinnon Industries, Inc.

McKinnon Industries has over twenty-five years experience in tool design and machining in both the private and government sectors. McKinnon has also been the primary installation and removal tool source for the Rosán products. Shur-Lok Corporation acquired McKinnon Industries in 2001 to complement their Ring Locked product lines.

McKinnon has provided product components and/or tools for most aerospace programs, including: Boeing Co. F/A-18 Hornet fighter, F-15 Eagle fighter, B-1B Lance bomber, C-17A Globemaster3, Lockheed Martin F-16 Fighting Falcon, F22 Raptor, F-117 Nighthawk, Northrop Grumman B-2 bomber.

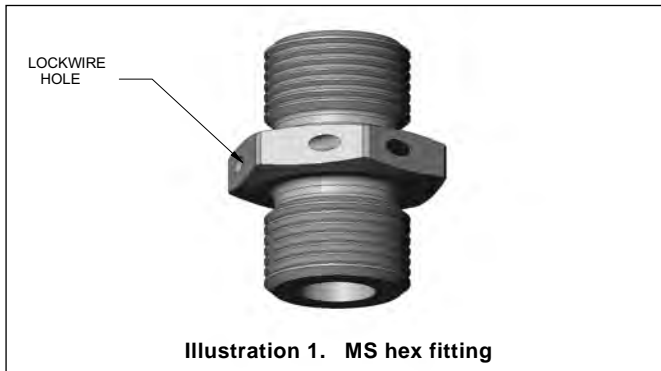
INTRODUCTION

Forward

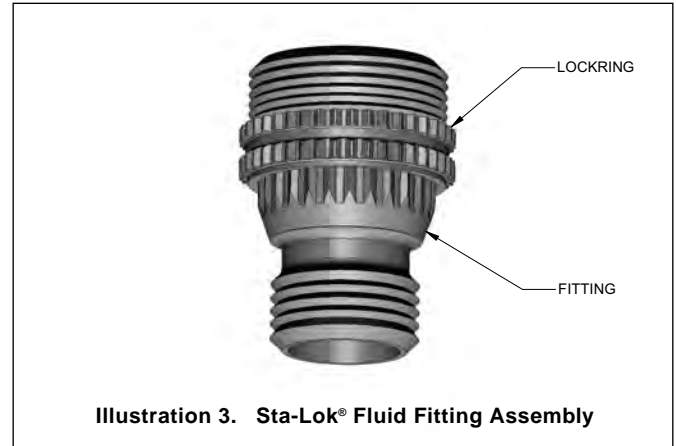
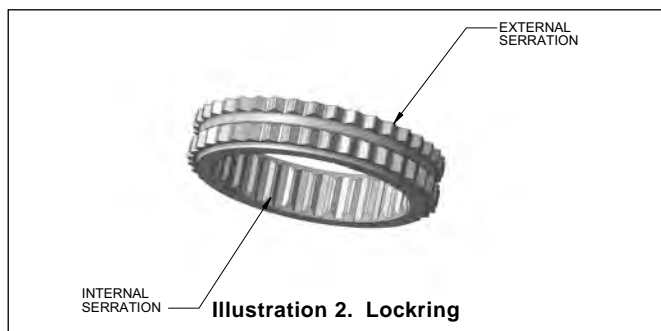
Shur-Lok has been a Leader in Fastener Solutions for over 50 years. This leadership position has been achieved not only by engineering unique problem-solving designs but also by manufacturing quality products on-time, backed by unsurpassed technical support. One of Shur-Lok's many successes has been the patented Sta-lok® system that provides positive locking without the use of pins or lockwires. The heart of the two piece Sta-Lok® locknut system is mating serrations that maintain precise preload. Few companies have the expertise and experience to manufacture serrated parts that mate and must be interchangeable with replacement hardware.

Sta-Lok® Fluid Fittings

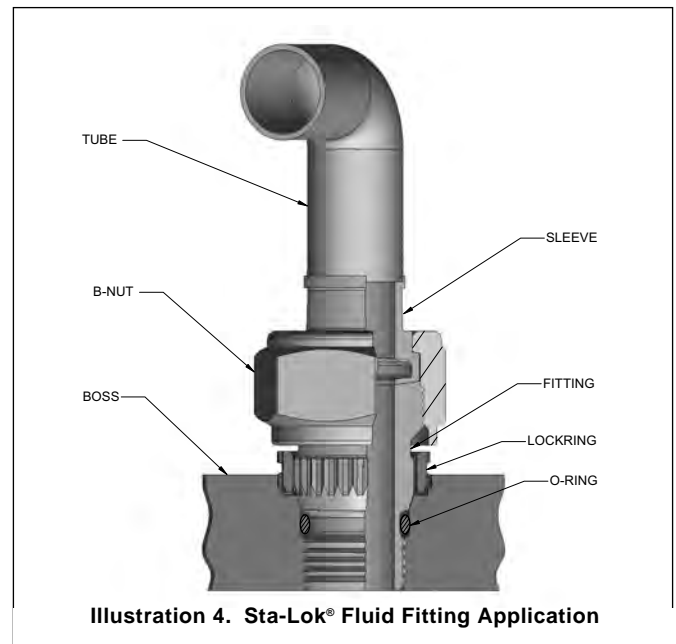
Now Shur-Lok is applying its talents and Sta-Lok® brand name to the design and manufacture of serrated Fluid Fittings that will not rotate in a port connection or boss, unlike standard MS fittings (Illustration 1) that requires a lockwire to prevent rotation.



The Sta-Lok® Fluid Fittings are held in place by a locking that is internally and externally serrated (Illustration 2). The locking is pressed onto an externally serrated fitting and supplied as an assembly (Illustration 3).



The fitting assembly is installed in the boss by first threading the fitting into a tapped port. Next the locking ring is pressed into the pre-broached boss to secure the fitting assembly. The external locking serrations prevent the fitting assembly from rotating in the boss and eliminate damage when applying torque to the B nut during installation (Illustration 4).



Sta-Lok® Fluid Fittings are designed for applications in hydraulic, pneumatic or fuel systems of aircraft, helicopter and engines. These fittings are certified to 3,000, 4,000, 5,000 or 8,000 psi systems.

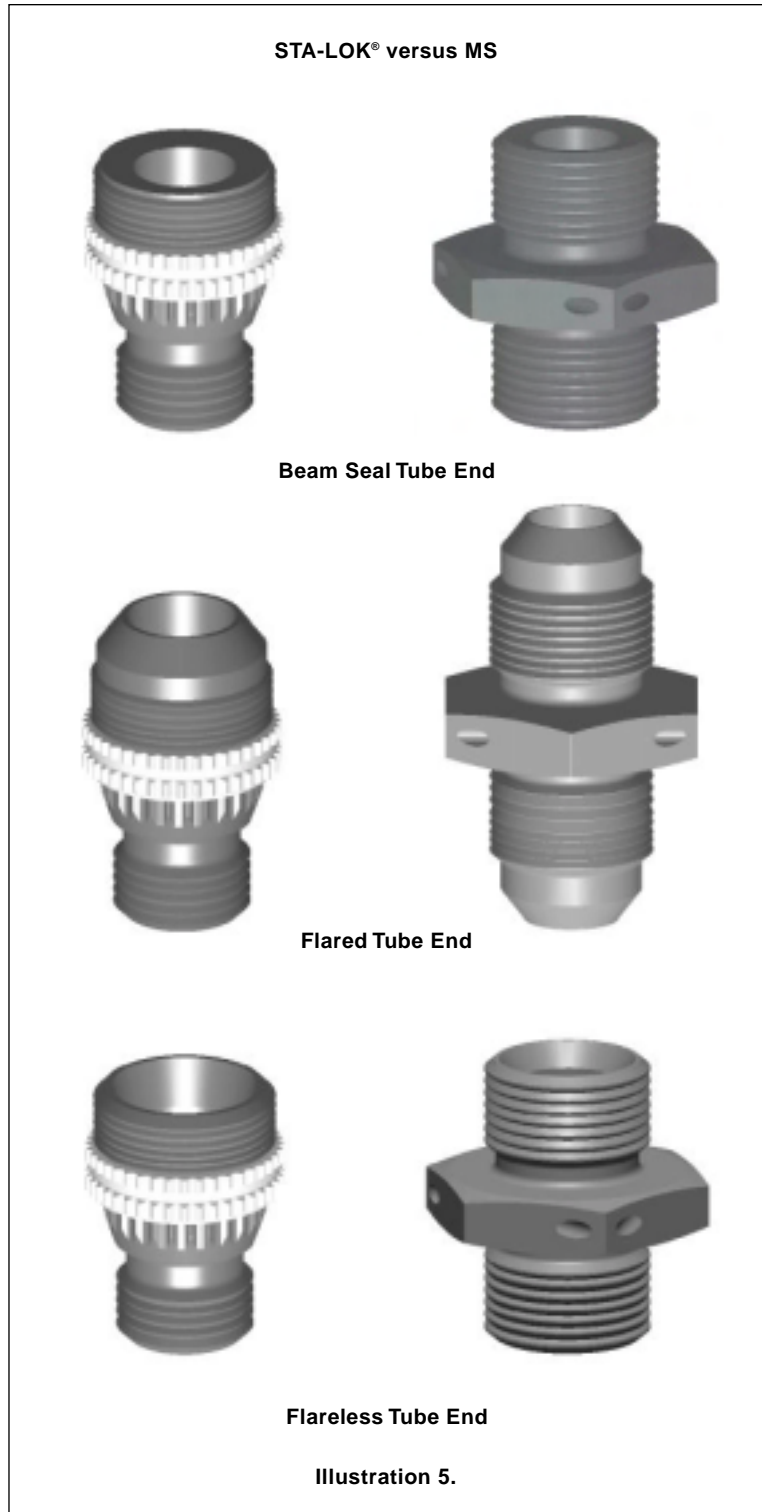
FEATURES AND BENEFITS

STA-LOK® FLUID FITTING versus MS HEX NUT FITTING

- Sta-Lok® Fluid Fittings offer tube end configurations in Beam Seal, Flared and Flareless in both inch and metric.
- Sta-Lok® Fluid Fittings are designed to fit standard B-nuts that are easily tightened or removed with only one wrench.
- The primary seal is metal to metal. A standard elastomeric O-ring, supplied by the user, provides a secondary seal.
- Sta-Lok® Fluid Fittings require no lockwires to prevent rotation under load.
- The serrated locking prevents the fitting assembly from rotation under vibration. The fitting assembly can be easily removed from the boss for system maintenance or repair with simple tooling.
- Sta-Lok® Fluid Fittings are lighter weight. The port side threaded end is smaller to allow the design of a smaller boss diameter.
- Lower stand-off from the boss and smaller profile promotes the design of compact fluid systems.
- Manufactured from strong lightweight titanium, Sta-Lok® Fluid Fittings offer the high strength necessary to withstand extreme operating pressures.

SPECIAL DESIGNS

When operating conditions demand deviation from standard sealing configurations, pressures, or temperatures, Shur-Lok will design and fabricate special Sta-Lok® Fluid Fittings to meet the requirements of these special applications.





TSB (TECHNICAL SALES BULLETIN)
References for port preparation, installation and removal of Sta-Lok® Fluid Fittings

Shur-Lok Part Number	TSB Title	TSB #
SLAS1986, SLAS4099, SLAS1985, SLAS5368	SLAS1301 — Port preparation, installation & removal instructions of adapter	TSB 0022
SLAS4383, SLF2002, SLF3004	SLAS1301R — Port preparation, installation & removal instructions of adapter reducer	TSB 0023
SLAS4200	SLAS4202 — Port preparation, installation & removal instructions of adapter	TSB 0024
SLAS5103	SLAS5104 — Port preparation, installation & removal instructions of plug	TSB 0025
SLAS3078	SLAS1959 — Port preparation, installation & removal instructions of fluid boss insert	TSB 0026
SLMA2111, SLMA2112, SLMA2113	SLMA2114 — Port preparation, installation & removal instructions of metric adapter	TSB 0027
SLMA2119	SLMA2114R — Port preparation, installation & removal instructions of metric adapter reducer	TSB 0028

NOTE:

1. TSBs listed above can be viewed and printed from the Shur-Lok website www.shur-lok.com or you may contact our engineering department at (949) 474-6000.
2. All port preparation, installation and removal tools are referenced within the relevant TSB and are available through McKinnon Industries Inc, a Shur-Lok Company (949) 655-9231 Fax (949) 655-9254.



STA-LOK® FLUID FITTING CROSS REFERENCES

Shur-Lok® Part Number Series	Rosán Part Number Series	SAE Standard Part Number Series
SLAS1986	RF5000-13	AS1986
SLAS4383	RF5000-00-13	AS4383-00-00
SLAS4200	RFH5000-13	AS4200
SLAS4099	RFK9900-13	AS4099
SLF2002	RF9900-00-13	N/A
SLAS1985	RFK9800-13	AS1985
SLF3004	RF9800-00-13	N/A
SLAS5368	RFGA9800-19	AS5368
SLAS5103	RF7500-13	AS5103
SLMA2111	7017-490000-00	MA2111
SLMA2112	6660-490000-00	MA2112
SLMA2113	6520-490000-00	MA2113
SLMA2119	7027-490000-00	MA2119
SLAS3077	RLT9500-24	AS3077
SLAS3078	RF9500-504	AS3078
MF5000C ⁽¹⁾	RF5000C ⁽¹⁾	AS4282
MF70CM ⁽¹⁾	RF70CM ⁽¹⁾	AS4300
MF9900C ⁽¹⁾	RF9900C ⁽¹⁾	MA4248

⁽¹⁾ Fluid Fitting Caps are available through McKinnon Industries, a Shur-Lok Company.
Rosán is a registered trademark of Alcoa.



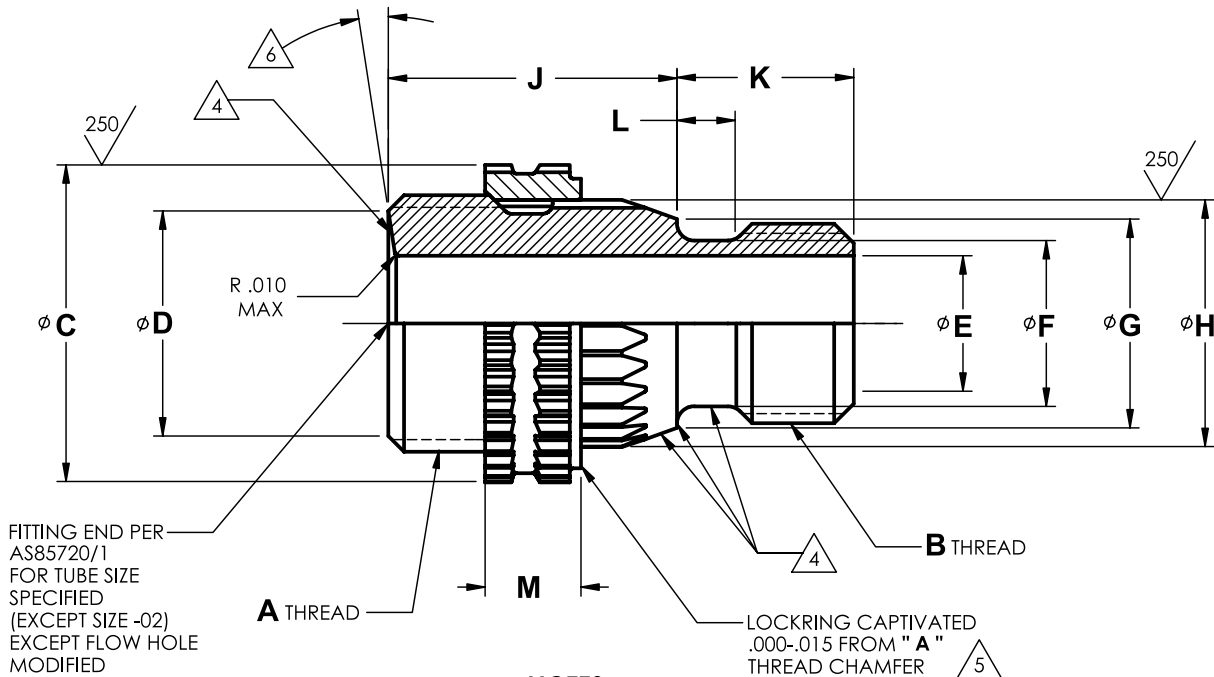
SYSTEM WORKING PRESSURE

INCH

Sta-Lok® Fluid Fitting Part				
Number Series	Product Description	Operating psi	Burst psi	Sizes
SLAS1986	Beam Seal Adapter	4,000	16,000	2, 3, 5, 14, 20 and 24
SLAS1986	Beam Seal Adapter	5,000	20,000	4, 6, 8, 10, 12 and 16
SLAS4383	Beam Seal Adapter Reducer	5,000	20,000	05-04, 06-04, 08-04, 08-06, 10-04, 10-06, 10-08, 12-06, 12-08, 12-10, 16-10, and 16-12
SLAS4383	Beam Seal Adapter Reducer	4,000	16,000	20-12, 20-16, 24-12, 24-16
SLAS4200	Beam Seal Adapter	8,000	24,000	All
SLAS4099	Flareless Adapter	4,000	16,000	All
SLF2002	Flareless Adapter Reducer	3,000	12,000	All
SLAS1985	Flared Adapter	4,000	16,000	All
SLF3004	Flared Adapter Reducer	3,000	12,000	All
SLAS5368	Spherical Flared Adapter	3,000	12,000	All
SLAS5103	Plug	4,000	16,000	2, 3, 5, 14, 20, 24 and 32
SLAS5103	Plug	5,000	20,000	4, 6, 8, 10, 12 and 16
SLAS3078	Fluid Boss Insert	3,000	12,000	All

METRIC

Sta-Lok® Fluid Fitting Part				
Number Series	Product Description	Operating kPa	Burst kPa	Sizes
SLMA2111	Beam Seal Adapter	28,000	112,000	All
SLMA2112	24° Flareless Adapter	28,000	112,000	All
SLMA2113	60° Flareless Reducer	28,000	112,000	All
SLMA2119	Beam Seal Adapter Reducer	28,000	112,000	All



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. SEALING ANGLES:
 - a. SIZES -02 AND -03 : 3°00' TO 3°30'
 - b. SIZES -04 AND LARGER : 8°30' TO 9°00'
7. IDENTIFICATION PER AS478 CLASS 35D. NAME, TRADEMARK OR CAGE CODE AND PART NUMBER.
8. WORKING PRESSURE: THIS PART IS DESIGNED FOR USE IN HYDRAULIC SYSTEMS COMPATIBLE WITH TITANIUM.
 - a. SIZE -04, -06, -08, -10, -12, AND -16: 5000 psi (20000 psi BURST PRESSURE) SYSTEMS.
 - b. ALL OTHER SIZES : 4000 psi (16000 psi BURST PRESSURE) SYSTEMS.
9. FITTINGS TO BE INSTALLED PER TECHNICAL SALES BULLETIN No. TS80022 (SLAS1301) INTO BOSS CAVITIES PER SLAS1300.

EXAMPLE OF PART CODING

SLAS1986 - 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] ✓ ALL SURFACES
TOLERANCES
 .XX .XXX ANGLES [X.X] [X.XX]
 ±.03 ±.010 ±2° ±[0.8] ±[0.25]
 DIMENSION IN [] ARE MILLIMETERS

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SLAS1986

FITTING ASSEMBLY – PORT CONNECTION RING LOCKED TO BEAM SEAL TUBE END, 4000psi AND 5000psi



SHEET 1 OF 2

Sta-Lok® Fluid Fittings



NOTES: CONTINUED

- 10. 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.
- 11. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.
- 12. DIMENSIONS IN INCHES.

TABLE I

SIZE CODE	AS1986 PART NUMBER	NOMINAL TUBE SIZE REF	A THREAD PER AS8879	B THREAD PER AS8879	φ C ±.005	φ D REF	φ E	φ F + .005 - .002
02	AS1986-02	.125	.3125-32UNJEF-3A	.2160-28UNJF-3A	.400	.265-.271	.090-.096	.154
03	AS1986-03	.188	.3750-28UNJS-3A	.2500-28UNJF-3A	.468	.323-.329	.122-.128	.186
04	AS1986-04	.250	.4375-24UNJS-3A	.3125-24UNJF-3A	.514	.377-.383	.169-.175	.239
05	AS1986-05	.312	.5000-24UNJS-3A	.3750-24UNJF-3A	.624	.440-.446	.231-.237	.301
06	AS1986-06	.375	.5625-20UNJS-3A	.4375-20UNJF-3A	.700	.490-.497	.294-.300	.364
08	AS1986-08	.500	.7188-20UNJS-3A	.5625-18UNJF-3A	.814	.646-.654	.398-.408	.482
10	AS1986-10	.625	.8438-18UNJS-3A	.6875-24UNJEF-3A	1.040	.763-.772	.493-.503	.625
12	AS1986-12	.750	1.0000-16UNJ-3A	.8125-20UNJEF-3A	1.170	.910-.919	.604-.614	.737
14	AS1986-14	.875	1.1250-16UNJ-3A	.9375-20UNJEF-3A	1.341	1.034-1.044	.729-.739	.868
16	AS1986-16	1.000	1.2500-14UNJS-3A	1.1250-18UNJEF-3A	1.456	1.148-1.158	.839-.851	1.000
20	AS1986-20	1.250	1.5781-14UNJS-3A	1.3125-18UNJEF-3A	1.782	1.476-1.486	1.073-1.086	1.225
24	AS1986-24	1.500	1.8438-14UNJS-3A	1.6250-18UNJEF-3A	2.031	1.741-1.751	1.307-1.320	1.502

TABLE I CONT'D

SIZE CODE	φ G MIN	φ H REF	J +.010 - .005	K +.000 - .015	L +.010 - .005	M ± .007	WEIGHT LB/EA APPROX
02	.246	.317	.519	.300	.125	.192	.008
03	.278	.349	.550	.355	.125	.192	.012
04	.331	.400	.592	.355	.125	.192	.014
05	.393	.491	.592	.381	.125	.192	.020
06	.456	.544	.633	.395	.125	.210	.025
08	.574	.670	.646	.430	.125	.210	.035
10	.717	.824	.710	.465	.125	.210	.059
12	.891	.981	.760	.527	.157	.220	.079
14	1.022	1.118	.778	.572	.157	.220	.101
16	1.154	1.251	.808	.564	.157	.220	.125
20	1.379	1.466	.832	.569	.157	.240	.179
24	1.656	1.768	.917	.608	.157	.240	.257

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] ALL SURFACES
 TOLERANCES
 .XX .XXX ANGLES [X.X] [X.XX]
 ±.03 ±.010 ±2° ±[0.8] ±[0.25]
 DIMENSION IN [] ARE MILLIMETERS

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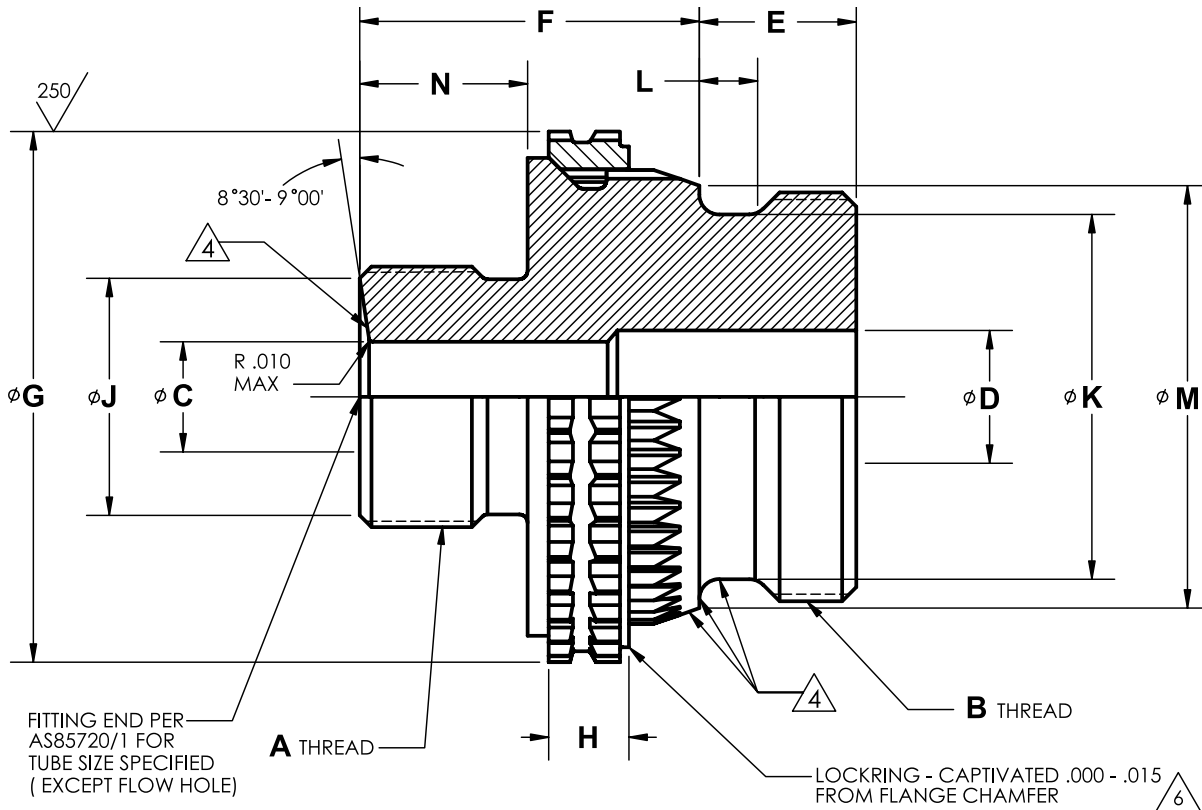
SLAS1986

**FITTING ASSEMBLY – PORT CONNECTION RING LOCKED
 TO BEAM SEAL TUBE END, 4000psi AND 5000psi**



SHEET 2 OF 2

Sta-Lok® Fluid Fittings



FITTING END PER AS85720/1 FOR TUBE SIZE SPECIFIED (EXCEPT FLOW HOLE)

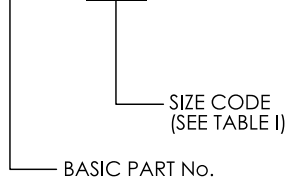
A THREAD

B THREAD

LOCKRING - CAPTIVED .000 - .015 FROM FLANGE CHAMFER

EXAMPLE OF PART CODING:

SLAS4383 - 16-10



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. IDENTIFICATION PER AS478 CLASS 35D, NAME, TRADEMARK OR CAGE CODE AND PART NUMBER.
6. LOCKRING RETAINED ON FITTING BY CONTROLLED INTERFERENCE FIT.
7. FITTINGS TO BE INSTALLED PER TECHNICAL SALES BULLETIN No. TSB0023 (SLAS1301R) INTO BOSS CAVITIES PER SLAS1300.
8. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36. REQUIREMENTS PER ANSI / ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 MICROINCHES R_a AND SEALING SURFACE TO BE 63 MICROINCHES R_a .
9. WORKING PRESSURE: THIS PART IS DESIGNED FOR USE IN 5000 psi (20000 psi BURST PRESSURE) HYDRAULIC WORKING PRESSURE SYSTEMS COMPATIBLE WITH TITANIUM, EXCEPT PORT END SIZES -20 AND -24 ARE FOR 4000 psi (16000 psi BURST PRESSURE).

NOTES: CONTINUED ON SHEET 2 OF 2

REVISION NC 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

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FITTING ASSEMBLY-REDUCER, PORT CONNECTION
RING LOCKED TO BEAM SEAL TUBE END, 4000psi & 5000psi

SLAS4383

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	AS4383 PART NUMBER	PORT END SIZE	TUBE END SIZE	A THREAD PER AS8879	B THREAD PER AS8879	φ C	φ D	E + .000 - .015
05-04	AS4383-05-04	05	04	.4375-24UNJS-3A	.3750-24UNJF-3A	.184-.190	.232	.381
06-04	AS4383-06-04	06	04	.4375-24UNJS-3A	.4375-20UNJF-3A	.184-.190	.295	.395
08-04	AS4383-08-04	08	04	.4375-24UNJS-3A	.5625-18UNJF-3A	.184-.190	.412	.430
08-06	AS4383-08-06		06	.5625-20UNJS-3A		.294-.300		
10-04	AS4383-10-04	10	04	.4375-24UNJS-3A	.6875-24UNJEF-3A	.184-.190	.498	.465
10-06	AS4383-10-06		06	.5625-20UNJS-3A		.294-.300		
10-08	AS4383-10-08		08	.7188-20UNJS-3A		.398-.408		
12-06	AS4383-12-06	12	06	.5625-20UNJS-3A	.8125-20UNJEF-3A	.294-.300	.633	.527
12-08	AS4383-12-08		08	.7188-20UNJS-3A		.398-.408		
12-10	AS4383-12-10		10	.8438-18UNJS-3A		.493-.503		
16-10	AS4383-16-10	16	10	.8438-18UNJS-3A	1.1250-18UNJEF-3A	.493-.503	.861	.564
16-12	AS4383-16-12		12	1.0000-16UNJ-3A		.604-.614		
20-12	AS4383-20-12	20	12	1.0000-16UNJ-3A	1.3125-18UNJEF-3A	.604-.614	1.057	.569
20-16	AS4383-20-16		16	1.2500-14UNJS-3A		.839-.851		
24-12	AS4383-24-12	24	12	1.0000-16UNJ-3A	1.6250-18UNJEF-3A	.604-.614	1.297	.608
24-16	AS4383-24-16		16	1.2500-14UNJS-3A		.839-.851		

TABLE I CONT'D

SIZE CODE	F + .010 - .005	φ G ± .005	H ± .007	φ J	φ K + .005 - .002	L + .010 - .005	φ M MIN	N ± .015
05-04	.701	.624	.192	.377-.383	.299	.125	.393	.275
06-04	.733	.700	.210	.377-.383	.362	.125	.456	.275
08-04	.734	.814	.210	.377-.383	.480	.125	.574	.275
08-06	.754			.490-.497				.295
10-04	.758	1.040	.210	.377-.383	.623	.125	.717	.275
10-06				.490-.497				.295
10-08				.646-.654				.308
12-06	.751	1.170	.220	.490-.497	.735	.157	.891	.295
12-08	.764			.646-.654				.308
12-10	.828			.763-.772				.372
16-10	.841	1.456	.220	.763-.772	.998	.157	1.154	.372
16-12	.881			.910-.919				.412
20-12	.888	1.782	.240	.910-.919	1.223	.157	1.379	.412
20-16	.936			1.148-1.158				.460
24-12	.909	2.031	.240	.910-.919	1.500	.157	1.656	.412
24-16	.957			1.148-1.158				.460

REVISION **NC** 20 MAY 2003

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 INTERPRET DIMENSION & TOLERANCES PER
 ANSI Y14.5M. ALL DIMENSIONS APPLY AFTER
 PLATING AND PRIOR TO THE ADDITION OF SOLID
 FILM LUBRICANT. 125 [3,2] ✓ ALL SURFACES
TOLERANCES
 .XX .XXX ANGLES [X.X] [X.XX]
 ±.03 ±.010 ±2° ±[0.8] ±[0.25]
 DIMENSION IN [] ARE MILLIMETERS

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SHUR-LOK

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

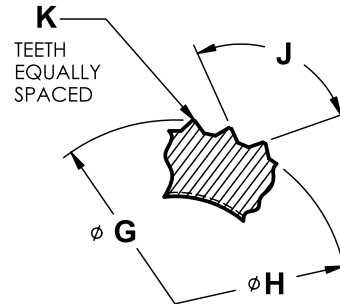
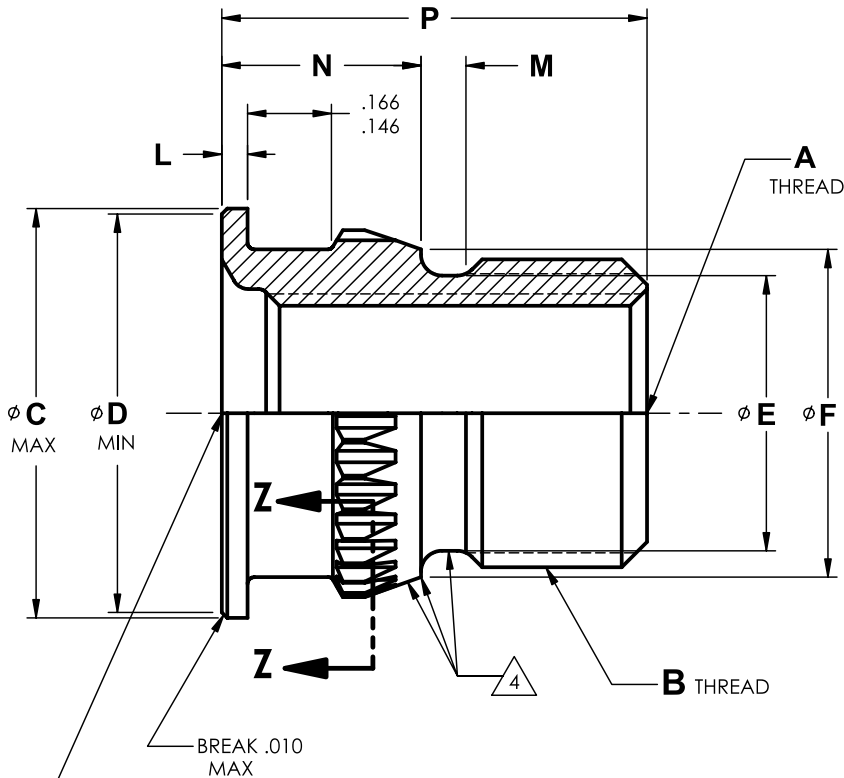
SLAS4383

**FITTING ASSEMBLY-REDUCER, PORT CONNECTION
 RING LOCKED TO BEAM SEAL TUBE END, 4000psi & 5000psi**



SHEET 2 OF 2

Sta-Lok® Fluid Fittings



SECTION Z - Z

INTERNAL CONFIGURATION PER AS33649, EXCEPT AS SHOWN, FOR SIZE SPECIFIED

EXAMPLE OF PART CODING:

SLAS3078 - 06
 BASIC PART NUMBER SIZE CODE (SEE TABLE I)



NOTES:

1. MATERIAL : A286 CORROSION RESISTANT STEEL PER AMS5731, AMS5732, AMS5734 OR AMS5737.
2. HEAT TREATMENT: AMS5731 AND AMS5734 PARTS SHALL BE AGED IN ACCORDANCE WITH SAE AMS-H-6875. HARDNESS 29 HRC MIN.
3. FINISH: PASSIVATE PER AMS-QQ-P-35, TYPE II OR TYPE VII.
4. SEALING SURFACE : NO VISIBLE DEFECTS. TO BE PROTECTED FOR SHIPMENT.
5. FLUORESCENT PENETRANT INSPECTION PER ASTM E1417. CRITERIA IN ACCORDANCE WITH AS3071.
6. IDENTIFICATION PER AS478, CLASS 35D, NAME, TRADEMARK OR CAGE CODE AND PART NUMBER.
7. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36. REQUIREMENTS PER ANSI / ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 MICROINCHES Ra EXCEPT SEALING SURFACE TO BE 63 MICROINCHES Ra AND SERRATIONS TO BE 250 MICROINCHES Ra.
8. INSERT TO BE USED IN CONJUNCTION WITH SLAS3077 LOCKRING AND TO BE INSTALLED PER TECHNICAL SALES BULLETIN No. TSB0026 (SLAS1959) INTO BOSS CAVITIES PER SLAS1958.
9. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.
10. DIMENSIONS IN INCHES.

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 [5.2] ALL SURFACES
TOLERANCES
 .XX .XXX ANGLES ±2° [X.X] [X.XX]
 ±.03 ±.010 ±[0.8] ±[0.25]
 DIMENSION IN [] ARE MILLIMETERS

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 TELEPHONE: (32) 87-32.07.11

SLAS4200

**FITTING ASSEMBLY – PORT CONNECTION
 RING LOCKED TO BEAM SEAL TUBE END, 8000psi**

SHEET 1 OF 2



NOTES: CONTINUED

9. FITTINGS TO BE INSTALLED PER TECHNICAL SALES BULLETIN No. TSB0024 (SLAS4202) INTO BOSS CAVITIES PER SLAS4201.
10. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36. REQUIREMENTS PER ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 MICROINCHES R_a AND SEALING SURFACE TO BE 63 MICROINCHES R_a.
11. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.
12. DIMENSIONS IN INCHES.

TABLE I

SIZE CODE	AS4200 PART NUMBER	NOMINAL TUBE SIZE REF	A THREAD PER AS8879	B THREAD PER AS8879	Ø C ±.005	Ø D REF	Ø E	Ø F +.005 - .002
02	AS4200-02	.125	.3125-32UNJEF-3A	.2160-28UNJF-3A	.400	.076-.083	.058	.154
03	AS4200-03	.188	.3750-28UNJS-3A	.2500-28UNJF-3A	.468	.154-.164	.092	.186
04	AS4200-04	.250	.4375-24UNJS-3A	.3125-24UNJF-3A	.514	.184-.194	.143	.239
05	AS4200-05	.312	.5000-24UNJS-3A	.3750-24UNJF-3A	.624	.232-.242	.199	.301
06	AS4200-06	.375	.5625-20UNJS-3A	.4375-20UNJF-3A	.700	.297-.307	.254	.364
07	AS4200-07	.438	.6562-20UNJS-3A	.5000-20UNJF-3A	.767	.360-.370	.304	.423
08	AS4200-08	.500	.7188-20UNJS-3A	.5625-18UNJF-3A	.814	.398-.408	.355	.482
09	AS4200-09	.562	.7812-18UNJS-3A	.6250-24UNJEF-3A	.890	.450-.460	.421	.560
10	AS4200-10	.625	.8438-18UNJS-3A	.6875-24UNJEF-3A	1.040	.512-.523	.476	.625
11	AS4200-11	.688	.9375-16UNJ-3A	.7500-20UNJEF-3A	1.102	.591-.602	.517	.673

TABLE I CONT'D

SIZE CODE	Ø G MIN	Ø H REF	J +.010 - .005	K +.000 - .015	L +.010 - .005	M ±.007	WEIGHT LB/EA APPROX
02	.246	.317	.496	.339	.125	.192	.008
03	.278	.349	.527	.350	.125	.192	.011
04	.331	.400	.569	.378	.125	.192	.015
05	.393	.491	.569	.404	.125	.192	.020
06	.456	.544	.610	.434	.125	.210	.027
07	.515	.605	.623	.458	.125	.210	.035
08	.574	.670	.623	.485	.125	.210	.038
09	.652	.739	.687	.513	.125	.210	.049
10	.717	.824	.687	.538	.125	.210	.062
11	.765	.891	.737	.561	.125	.220	.074

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] ALL SURFACES
 TOLERANCES
 .XX .XXX ANGLES [X.X] [X.XX]
 ±.03 ±.010 ±2° ±[0.8] ±[0.25]
 DIMENSION IN [] ARE MILLIMETERS

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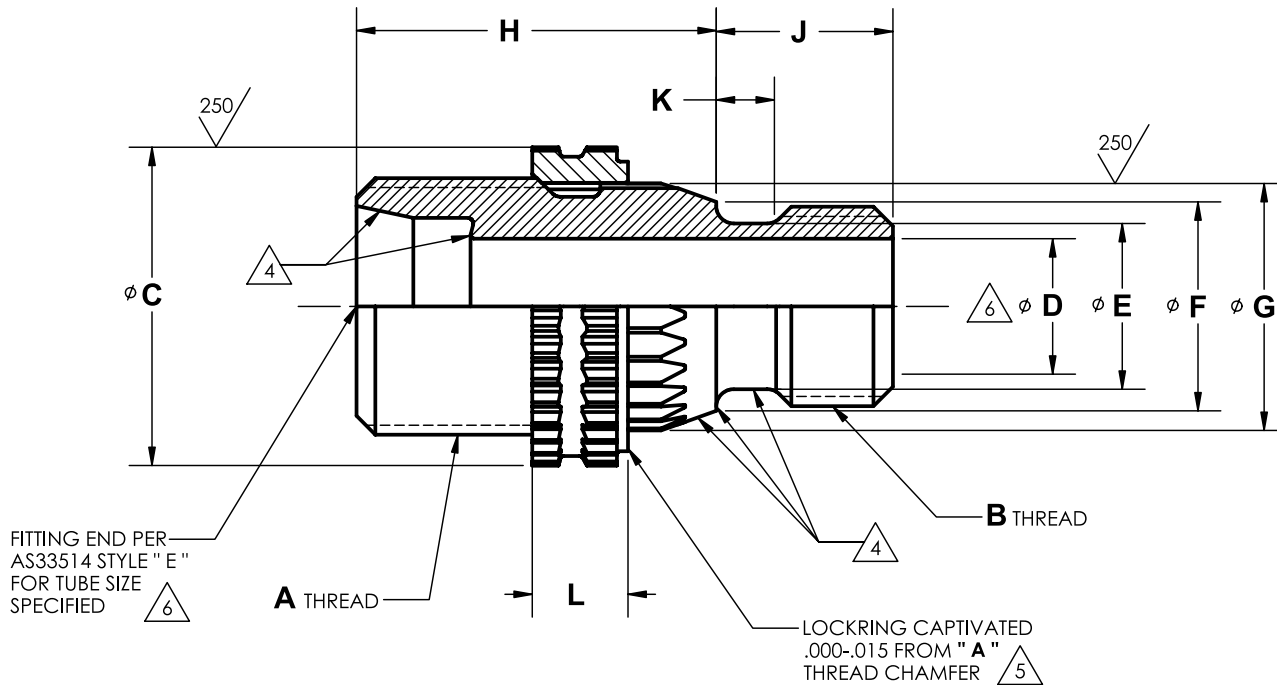
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SLAS4200

**FITTING ASSEMBLY – PORT CONNECTION
 RING LOCKED TO BEAM SEAL TUBE END, 8000psi**

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

Sta-Lok® Fluid Fittings



EXAMPLE OF PART CODING

SLAS4099 - 06

SIZE CODE
(SEE TABLE I)

BASIC PART NUMBER



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. "D" DIAMETER FOR DASH 04 IS .184 - .190 ON AS33514 END AND REDUCED TO "D" DIAMETER PER THIS DRAWING ON OPPOSITE END.
7. IDENTIFICATION PER AS478 CLASS 35D, NAME, TRADEMARK OR CAGE CODE AND PART NUMBER.
8. WORKING PRESSURE: THIS PART IS DESIGNED FOR USE IN 4000 psi WORKING PRESSURE SYSTEMS COMPATIBLE WITH TITANIUM.
9. FITTINGS TO BE INSTALLED PER TECHNICAL SALES BULLETIN No. TSB0022 (SLAS1301) INTO BOSS CAVITIES PER SLAS1300.

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

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SLAS4099

**FITTING ASSEMBLY - PORT CONNECTION
RING LOCKED TO FLARELESS TUBE END, 4000psi**

SHEET 1 OF 2

Sta-Lok® Fluid Fittings



NOTES: CONTINUED

10. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36. REQUIREMENTS PER ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 MICROINCHES R_a AND SEALING SURFACE TO BE 63 MICROINCHES R_a.
11. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.
12. DIMENSIONS IN INCHES.

TABLE I

SIZE CODE	AS4099 PART NUMBER	NOMINAL TUBE SIZE REF	A THREAD PER AS8879	B THREAD PER AS8879	φC ±.005	φD 	φE + .005 - .002	φF MIN
02	AS4099-02	.125	.3125-24UNJF-3A	.2160-28UNJF-3A	.400	.090-.096	.154	.246
03	AS4099-03	.188	.3750-24UNJF-3A	.2500-28UNJF-3A	.468	.122-.128	.186	.278
04	AS4099-04	.250	.4375-20UNJF-3A	.3125-24UNJF-3A	.514	.169-.175	.239	.331
05	AS4099-05	.312	.5000-20UNJF-3A	.3750-24UNJF-3A	.624	.231-.237	.301	.393
06	AS4099-06	.375	.5625-18UNJF-3A	.4375-20UNJF-3A	.700	.294-.300	.364	.456
08	AS4099-08	.500	.7500-16UNJF-3A	.5625-18UNJF-3A	.814	.419-.425	.482	.574
10	AS4099-10	.625	.8750-14UNJF-3A	.6875-24UNJEF-3A	1.040	.497-.503	.625	.717
12	AS4099-12	.750	1.0625-12UNJ-3A	.8125-20UNJEF-3A	1.170	.653-.659	.737	.891
16	AS4099-16	1.000	1.3125-12UNJ-3A	1.1250-18UNJEF-3A	1.456	.872-.878	1.000	1.154
20	AS4099-20	1.250	1.6250-12UNJ-3A	1.3125-18UNJEF-3A	1.782	1.090-1.096	1.225	1.379
24	AS4099-24	1.500	1.8750-12UNJ-3A	1.6250-18UNJEF-3A	2.031	1.341-1.347	1.502	1.656
32	AS4099-32	2.000	2.5000-12UNJ-3A	2.1250-16UNJ-3A	2.548	1.810-1.816	2.040	2.194

TABLE I CONT 'D

SIZE CODE	φG REF	H + .010 - .005	J + .000 - .015	K + .010 - .005	L ± .007	WEIGHT LB/EA APPROX
02	.317	.674	.300	.125	.192	.009
03	.349	.721	.355	.125	.192	.013
04	.400	.752	.355	.125	.192	.015
05	.491	.752	.381	.125	.192	.022
06	.544	.789	.395	.125	.210	.026
08	.670	.882	.430	.125	.210	.039
10	.824	.945	.465	.125	.210	.064
12	.981	1.018	.527	.157	.220	.084
16	1.251	1.018	.564	.157	.220	.129
20	1.466	1.045	.569	.157	.240	.189
24	1.768	1.045	.608	.157	.240	.248
32	2.311	1.086	.730	.157	.240	.411

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 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

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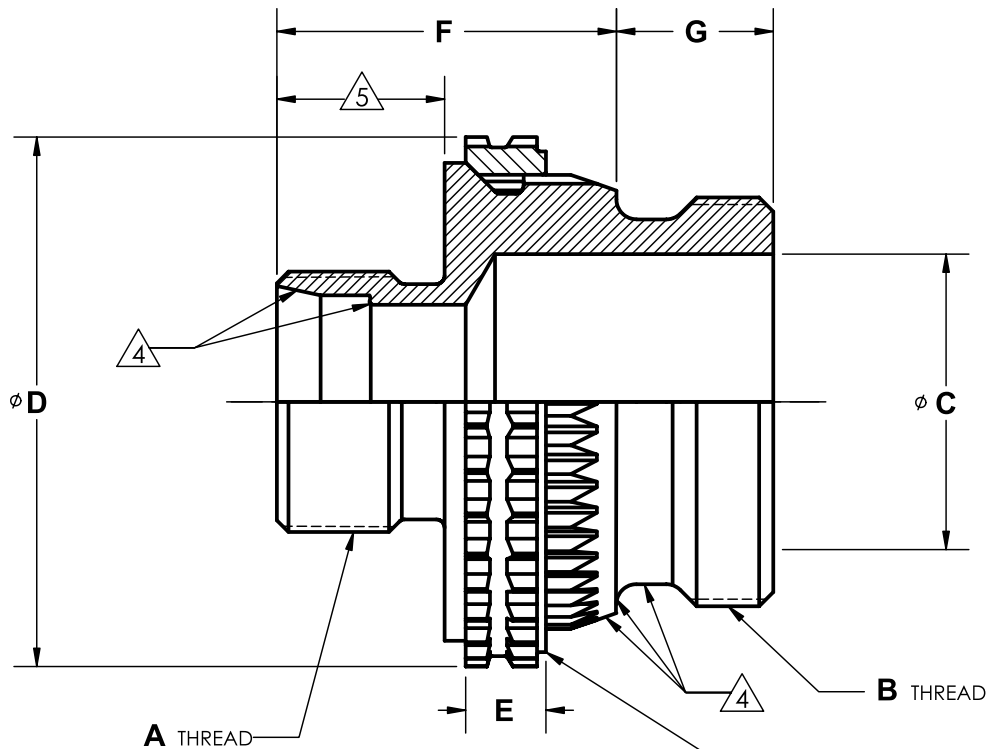
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SLAS4099

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

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



EXAMPLE OF PART CODING

SLF2002 - 08-06

SIZE CODE
(SEE TABLE I)

BASIC PART NUMBER



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. THIS END PER AS33514, STYLE " E " FOR TUBE SIZE SPECIFIED.
6. LOCKRING RETAINED ON FITTING BY CONTROLLED INTERFERENCE FIT.
7. IDENTIFICATION PER AS478 CLASS 35D, NAME, TRADEMARK OR CAGE CODE AND PART NUMBER.
8. FITTINGS TO BE INSTALLED PER TECHNICAL SALES BULLETIN No. TSB0023 (SLAS1301R) 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 R_a AND SEALING SURFACE TO BE 63 MICROINCHES R_a .

NOTES: CONTINUED ON SHEET 2 OF 2

REVISION (NC) 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

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TELEPHONE: (32) 87-32.07.11

SLF2002

**FITTING ASSEMBLY - REDUCER, PORT CONNECTION
RING LOCKED TO FLARELESS TUBE END**

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	PORT END SIZE	TUBE END SIZE	A THREAD PER AS8879	B THREAD PER AS8879	øC ± .005	øD ± .005	E ± .007	F + .010 - .005	G + .000 - .015
04-02	04	02	.3125-24UNJF-3A	.3125-24UNJF-3A	.185	.514	.192	.793	.355
04-03		03	.3750-24UNJF-3A					.840	
05-04	05	04	.4375-20UNJF-3A	.3750-24UNJF-3A	.232	.624	.192	.882	.381
06-03	06	03	.3750-24UNJF-3A	.4375-20UNJF-3A	.295	.700	.210	.884	.395
06-04		04	.4375-20UNJF-3A					.915	
06-05		05	.5000-20UNJF-3A					.915	
08-03	08	03	.3750-24UNJF-3A	.5625-18UNJF-3A	.412	.814	.210	.884	.430
08-04		04	.4375-20UNJF-3A					.915	
08-05		05	.5000-20UNJF-3A					.915	
08-06		06	.5625-18UNJF-3A					.931	
10-04	10	04	.4375-20UNJF-3A	.6875-24UNJEF-3A	.498	1.040	.210	.915	.465
10-06		06	.5625-18UNJF-3A					.931	
10-08		08	.7500-16UNJF-3A					1.025	
12-04	12	04	.4375-20UNJF-3A	.8125-20UNJEF-3A	.633	1.170	.220	.915	.527
12-05		05	.5000-20UNJF-3A					.915	
12-06		06	.5625-18UNJF-3A					.931	
12-08		08	.7500-16UNJF-3A					1.025	
12-10		10	.8750-14UNJF-3A					1.084	
16-04	16	04	.4375-20UNJF-3A	1.1250-18UNJEF-3A	.861	1.456	.220	.924	.564
16-10		10	.8750-14UNJF-3A					1.096	
16-12		12	1.0625-12UNJ-3A					1.159	
16-14		14	1.1875-12UNJ-3A					1.159	
20-04	20	04	.4375-20UNJF-3A	1.3125-18UNJEF-3A	1.057	1.782	.240	.931	.569
20-12		12	1.0625-12UNJ-3A					1.166	
20-16		16	1.3125-2UNJ-3A					1.166	
24-16	24	16	1.3125-12UNJ-3A	1.6250-18UNJEF-3A	1.297	2.031	.240	1.187	.608
24-20		20	1.6250-12UNJ-3A					1.187	

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 ANSI Y14.5M. ALL DIMENSIONS APPLY AFTER
 PLATING AND PRIOR TO THE ADDITION OF SOLID
 FILM LUBRICANT. 125 [3,2] ✓ ALL SURFACES
TOLERANCES
 .XX .XXX ANGLES [X.X] [X.XX]
 ±.03 ±.010 ±2° ±[0.8] ±[0.25]
 DIMENSION IN [] ARE MILLIMETERS

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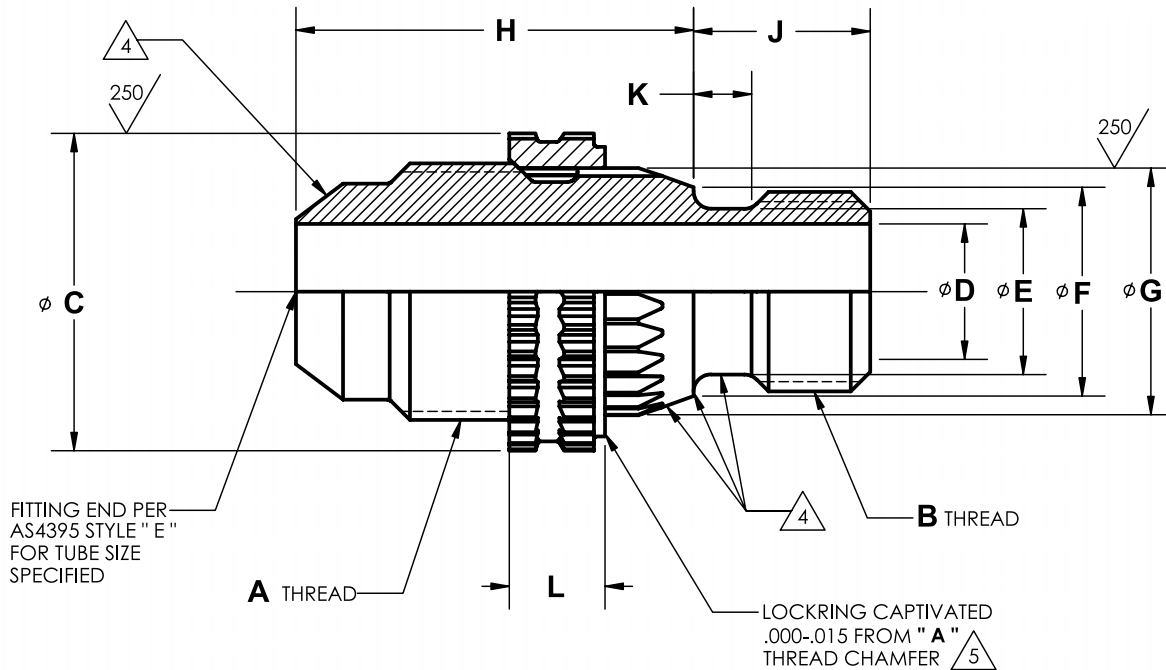
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SLF2002

**FITTING ASSEMBLY – REDUCER, PORT CONNECTION
 RING LOCKED TO FLARELESS TUBE END**

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

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 R_a AND SEALING SURFACE TO BE 63 MICROINCHES R_a.

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] ✓ ALL SURFACES
TOLERANCES

.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	φ C ±.005	φ D REF	φ E + .005 - .002	φ 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	φ 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

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

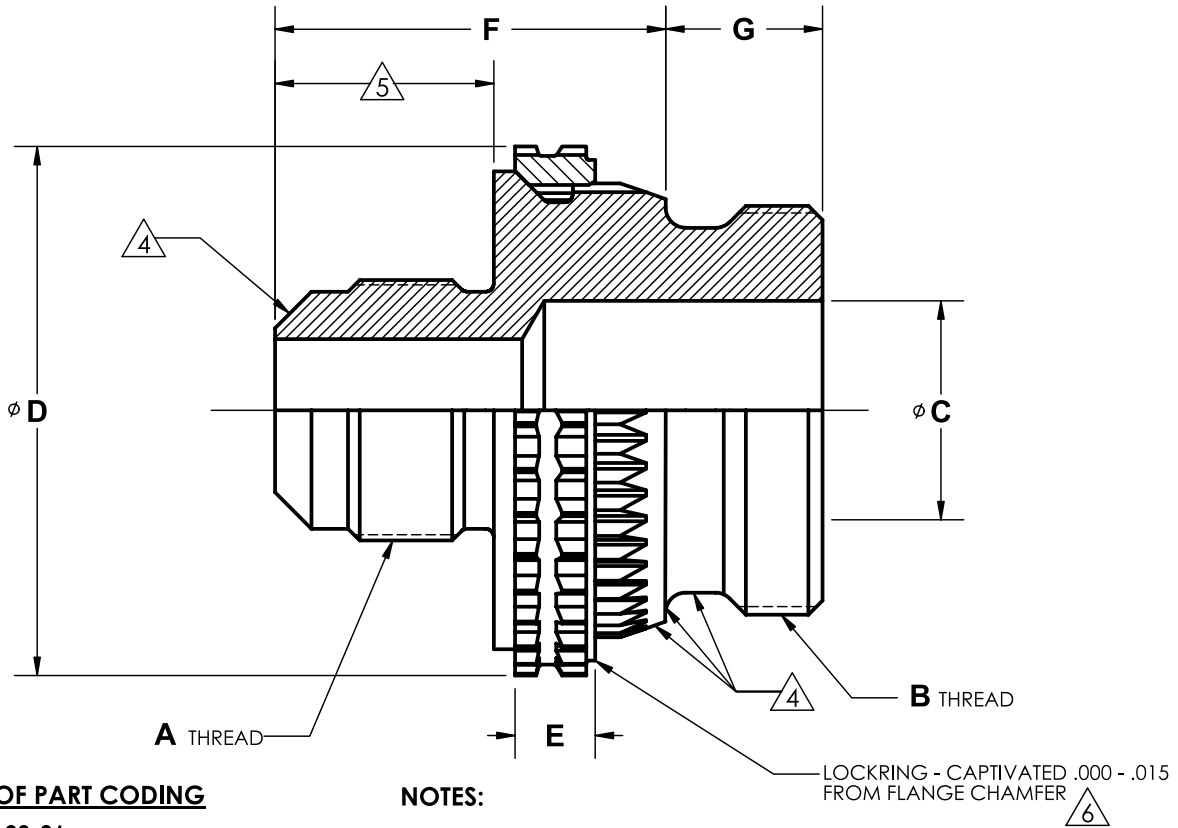
SHUR-LOK INTERNATIONAL, S.A.
 PETIT-RECHAIN, BELGIUM
 TELEPHONE: (32) 87-32.07.11

SLAS1985

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

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

Sta-Lok® Fluid Fittings



EXAMPLE OF PART CODING

SLF3004 - 08-06

SIZE CODE
(SEE TABLE I)

BASIC PART NUMBER



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. THIS END PER AS4395, STYLE " E " FOR TUBE SIZE SPECIFIED.
6. LOCKRING RETAINED ON FITTING BY CONTROLLED INTERFERENCE FIT.
7. IDENTIFICATION PER AS478 CLASS 35D, NAME, TRADEMARK OR CAGE CODE AND PART NUMBER.
8. FITTINGS TO BE INSTALLED PER TECHNICAL SALES BULLETIN No. TSB0023 (SLAS1301R) 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 R_a AND SEALING SURFACE TO BE 63 MICROINCHES R_a.

NOTES: CONTINUED ON SHEET 2 OF 2

REVISION (NC) 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] ALL SURFACES

TOLERANCES

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

DIMENSION IN [] ARE MILLIMETERS

SHUR-LOK CORPORATION
IRVINE, CALIFORNIA 92614
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SHUR-LOK

SHUR-LOK INTERNATIONAL, S.A.
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SLF3004

**FITTING ASSEMBLY - REDUCER, PORT CONNECTION
RING LOCKED TO FLARED TUBE END**

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	PORT END SIZE	TUBE END SIZE	A THREAD PER AS8879	B THREAD PER AS8879	φ C ± .005	φ D ± .005	E ± .007	F + .010 - .005	G + .000 - .015
04-02	04	02	.3125-24UNJF-3A	.3125-24UNJF-3A	.185	.514	.192	.866	.355
04-03		03	.3750-24UNJF-3A					.897	
05-04	05	04	.4375-20UNJF-3A	.3750-24UNJF-3A	.232	.624	.192	.979	.381
06-03	06	03	.3750-24UNJF-3A	.4375-20UNJF-3A	.295	.700	.210	.941	.395
06-04		04	.4375-20UNJF-3A					1.010	
06-05		05	.5000-20UNJF-3A					1.010	
08-03	08	03	.3750-24UNJF-3A	.5625-18UNJF-3A	.412	.814	.210	.941	.430
08-04		04	.4375-20UNJF-3A					1.010	
08-05		05	.5000-20UNJF-3A					1.010	
08-06		06	.5625-18UNJF-3A					1.018	
10-04	10	04	.4375-20UNJF-3A	.6875-24UNJEF-3A	.498	1.040	.210	1.010	.465
10-06		06	.5625-18UNJF-3A					1.018	
10-08		08	.7500-16UNJF-3A					1.120	
12-04	12	04	.4375-20UNJF-3A	.8125-20UNJEF-3A	.633	1.170	.220	1.010	.527
12-05		05	.5000-20UNJF-3A					1.010	
12-06		06	.5625-18UNJF-3A					1.018	
12-08		08	.7500-16UNJF-3A					1.120	
12-10		10	.8750-14UNJF-3A					1.217	
14-10	14	10	.8750-14UNJF-3A	.9375-20UNJEF-3A	.730	1.341	.220	1.200	.572
16-04	16	04	.4375-20UNJF-3A	1.1250-18UNJEF-3A	.861	1.456	.220	1.021	.564
16-10		10	.8750-14UNJF-3A					1.229	
16-12		12	1.0625-12UNJ-3A					1.335	
20-04	20	04	.4375-20UNJF-3A	1.3125-18UNJEF-3A	1.057	1.782	.240	1.028	.569
20-12		12	1.0625-12UNJ-3A					1.342	
20-16		16	1.3125-12UNJ-3A					1.389	
24-16	24	16	1.3125-12UNJ-3A	1.6250-18UNJEF-3A	1.297	2.031	.240	1.410	.608
24-20		20	1.6250-12UNJ-3A					1.457	

REVISION NC 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] / ALL SURFACES

TOLERANCES
 .XX .XXX ANGLES [X.X] [X.XX]
 ±.03 ±.010 ±.2* ±[0.8] ±[0.25]
 DIMENSION IN [] ARE MILLIMETERS

SHUR-LOK CORPORATION
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 TELEPHONE: (949) 474-6000

SHUR-LOK

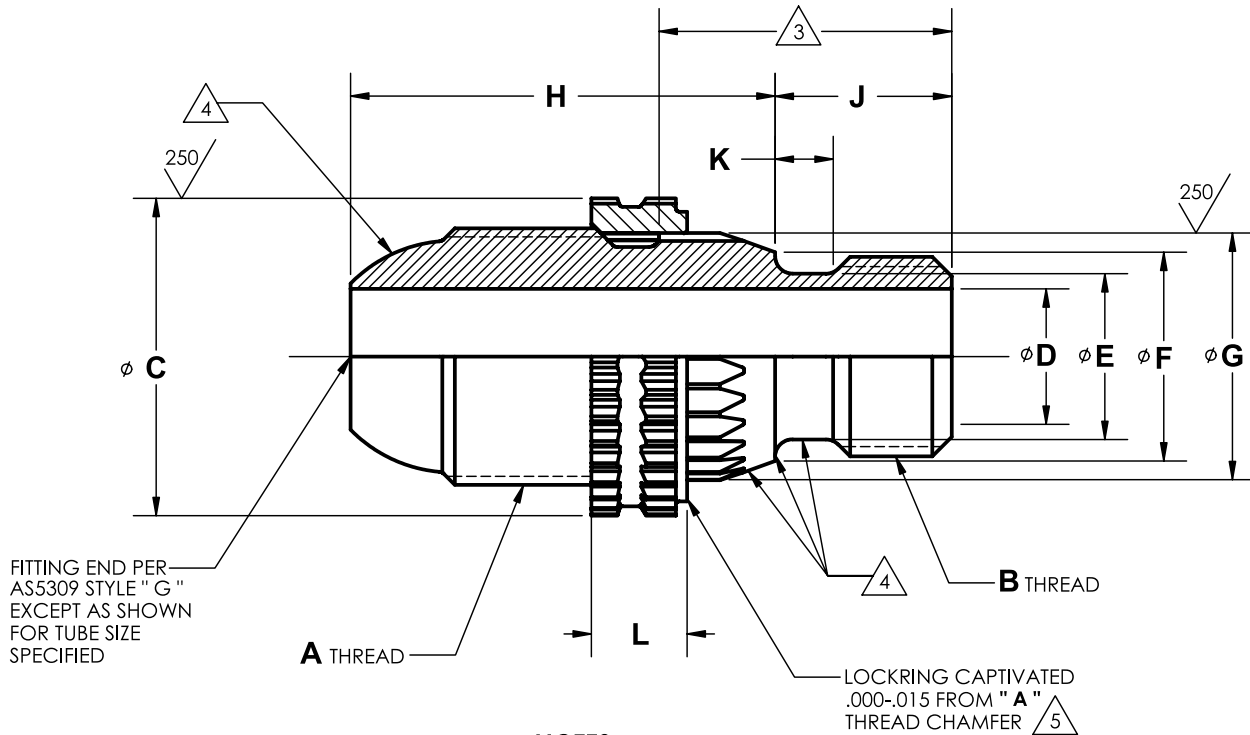
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 PETIT-RECHAIN, BELGIUM
 TELEPHONE: (32) 87-32.07.11

SLF3004

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

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

Sta-Lok® Fluid Fittings



NOTES:

1. MATERIAL :
 - a. FITTING: CRES A286 CORROSION RESISTANT STEEL PER AMS5731, AMS5732, AMS5734 OR AMS5737.
 - b. LOCKRING: A286 CORROSION RESISTANT STEEL PER AMS5731 OR AMS5734.
2. HEAT TREATMENT:
 - a. FITTING: 130 ksi UTS MIN PER AMS2759/3
 - b. LOCKRING: 34-40 HRC
3. FINISH:
 - a. FITTING: DRY FILM LUBE PER AS5272, TYPE 1 ON NOTED SURFACES EXCEPT NONE IN FLOW HOLE, OVERSPRAY PERMISSIBLE ON ADJACENT GROOVE.
 - 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 3000 psi WORKING PRESSURE SYSTEMS COMPATIBLE WITH CRES A286.
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 R_a AND SEALING SURFACE TO BE 63 MICROINCHES R_a .

EXAMPLE OF PART CODING

SLAS5368 - 06

SIZE CODE
(SEE TABLE I)

BASIC PART NUMBER



NOTES: CONTINUED ON SHEET 2 OF 2

REVISION NC 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

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

SHUR-LOK

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

SLAS5368

FITTING ASSEMBLY – PORT CONNECTION
RING LOCKED TO SPHERICAL FLARED TUBE END, 3000psi

SHEET 1 OF 2



NOTES: CONTINUED

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

11. DIMENSIONS IN INCHES.

TABLE I

SIZE CODE	AS5368 PART NUMBER	NOMINAL TUBE SIZE REF	A THREAD PER AS8879	B THREAD PER AS8879	φC ±.005	φD REF	φE +.005 -.002	φF MIN
04	AS5368-04	.250	.4375-20UNJF-3A	.3125-24UNJF-3A	.514	.168-.175	.239	.331
05	AS5368-05	.312	.5000-20UNJF-3A	.3750-24UNJF-3A	.624	.230-.237	.301	.393
06	AS5368-06	.375	.5625-18UNJF-3A	.4375-20UNJF-3A	.700	.293-.301	.364	.456
08	AS5368-08	.500	.7500-16UNJF-3A	.5625-18UNJF-3A	.814	.387-.395	.482	.574
10	AS5368-10	.625	.8750-14UNJF-3A	.6875-24UNJEF-3A	1.040	.480-.488	.625	.717
12	AS5368-12	.750	1.0625-12UNJ-3A	.8125-20UNJEF-3A	1.170	.604-.614	.737	.891
16	AS5368-16	1.000	1.3125-12UNJ-3A	1.1250-18UNJEF-3A	1.456	.839-.851	1.000	1.154

TABLE I CONT'D

SIZE CODE	φG REF	H +.010 -.005	J +.000 -.015	K +.010 -.005	L ±.007	WEIGHT LB/EA APPROX
04	.400	.856	.355	.125	.192	.0262
05	.491	.856	.381	.125	.192	.0363
06	.544	.931	.395	.125	.210	.0426
08	.670	1.091	.430	.125	.210	.0810
10	.824	1.191	.465	.125	.210	.1321
12	.981	1.301	.527	.157	.220	.1991
16	1.251	1.341	.564	.157	.220	.2953

REVISION NC 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] ✓ ALL SURFACES

TOLERANCES
 .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

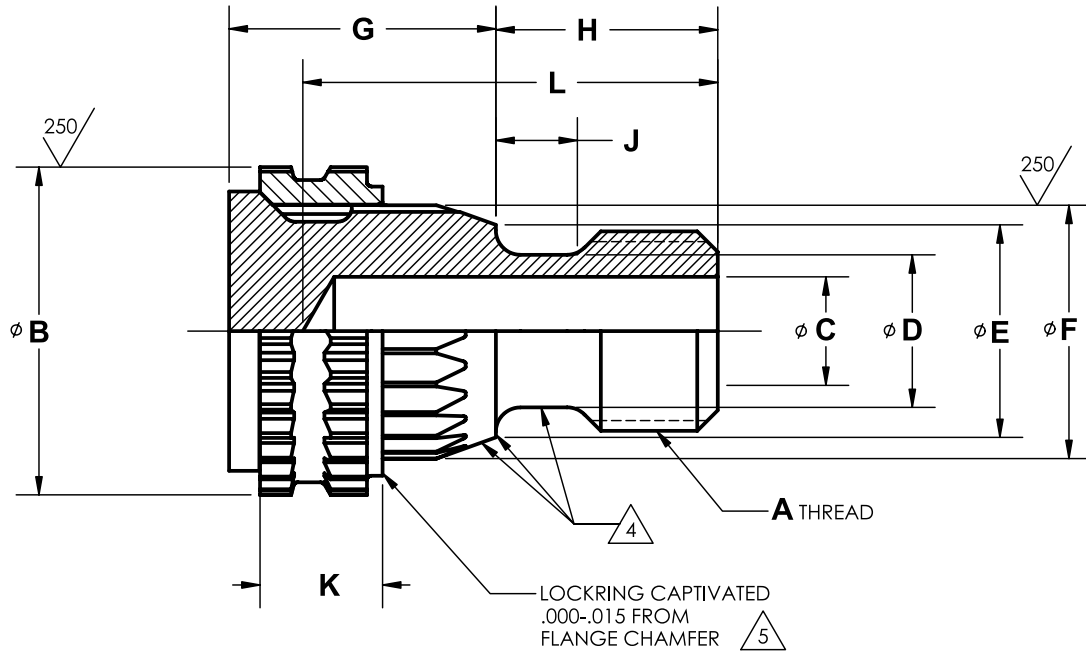
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 PETIT-RECHAIN, BELGIUM
 TELEPHONE: (32) 87-32.07.11

SLAS5368

**FITTING ASSEMBLY – PORT CONNECTION
 RING LOCKED TO SPHERICAL FLARED TUBE END, 3000psi**

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

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, AMS5732, AMS5734 OR AMS5737.
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 PERAS478 CLASS 35D, NAME, TRADEMARK OR CAGE CODE AND PART NUMBER.
7. WORKING PRESSURE: THIS PART IS DESIGNED FOR USE IN HYDRAULIC SYSTEMS COMPATIBLE WITH TITANIUM.
 - a. SIZE: -04, -06, -08, -10, -12 AND -16: 5000 psi (20000 psi BURST PRESSURE) SYSTEMS
 - b. ALL OTHER SIZE: 4000 psi (16000 psi BURST PRESSURE) SYSTEMS
8. FITTINGS TO BE INSTALLED PER TECHNICAL SALES BULLETIN No. TSB0025 (SLAS5104) 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 R_a AND SEALING SURFACE TO BE 63 MICROINCHES R_a.

EXAMPLE OF PART CODING

SLAS5103 - 06

SIZE CODE
(SEE TABLE I)

BASIC PART NUMBER



NOTES: CONTINUED ON SHEET 2 OF 2

REVISION **NC** 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] ALL SURFACES
TOLERANCES

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

 DIMENSION IN [] ARE MILLIMETERS

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TELEPHONE: (949) 474-6000

SHUR-LOK

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

SLAS5103

**FITTING ASSEMBLY, PLUG, RING LOCKED
PORT CONNECTION, 4000psi AND 5000psi**



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	AS5103 PART NUMBER	A THREAD PER AS8879	ØB ±.005	ØC	ØD +.005 -.002	ØE MIN	ØF REF
02	AS5103-02	.2160-28UNJF-3A	.400	.071-.096	.154	.246	.317
03	AS5103-03	.2500-28UNJF-3A	.468	.103-.128	.186	.278	.394
04	AS5103-04	.3125-24UNJF-3A	.514	.165-.175	.239	.331	.400
05	AS5103-05	.3750-24UNJF-3A	.624	.212-.237	.301	.393	.491
06	AS5103-06	.4375-20UNJF-3A	.700	.275-.300	.364	.456	.544
08	AS5103-08	.5625-18UNJF-3A	.814	.392-.408	.482	.574	.670
10	AS5103-10	.6875-24UNJEF-3A	1.040	.478-.503	.625	.717	.824
12	AS5103-12	.8125-20UNJEF-3A	1.170	.604-.614	.737	.891	.981
14	AS5103-14	.9375-20UNJEF-3A	1.341	.714-.739	.868	1.022	1.118
16	AS5103-16	1.1250-18UNJEF-3A	1.456	.841-.851	1.000	1.154	1.251
20	AS5103-20	1.3125-18UNJEF-3A	1.782	1.037-1.062	1.225	1.379	1.466
24	AS5103-24	1.6250-18UNJEF-3A	2.031	1.277-1.302	1.502	1.656	1.768
32	AS5103-32	2.1250-16UNJ-3A	2.548	1.746-1.771	2.040	2.194	2.311

TABLE I CONT'D

SIZE CODE	G +.010 -.005	H +.000 -.015	J +.010 -.005	K ±.007	L MAX	WEIGHT LB/EA APPROX
02	.418	.300	.125	.192	.61	.007
03	.418	.355	.125	.192	.67	.010
04	.418	.355	.125	.192	.67	.012
05	.426	.381	.125	.192	.70	.017
06	.459	.395	.125	.210	.75	.024
08	.459	.430	.125	.210	.78	.032
10	.459	.465	.125	.210	.82	.056
12	.459	.527	.157	.220	.88	.072
14	.469	.572	.157	.220	.88	.095
16	.469	.564	.157	.220	.87	.118
20	.476	.569	.157	.240	.85	.179
24	.497	.608	.157	.240	.90	.261
32	.637	.730	.157	.240	.90	.637

REVISION **NC** 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
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 TELEPHONE: (949) 474-6000

SHUR-LOK

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 PETIT-RECHAIN, BELGIUM
 TELEPHONE: (32) 87-32.07.11

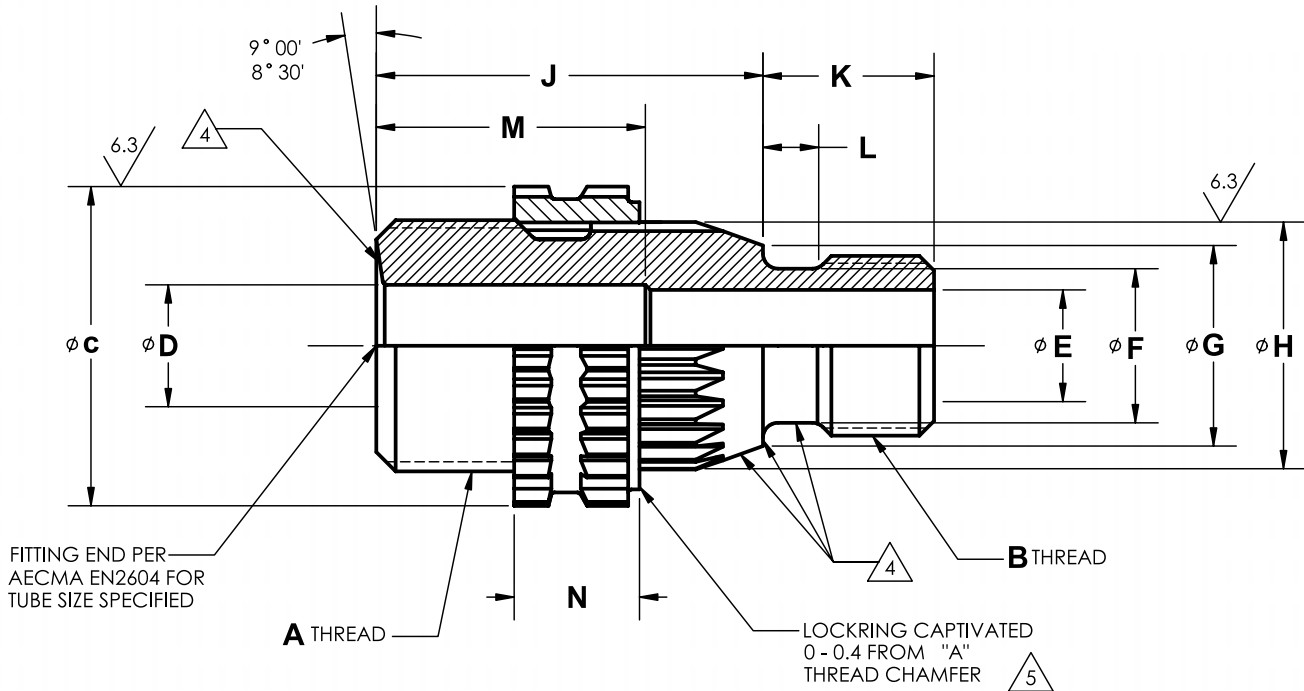
SLAS5103

**FITTING ASSEMBLY, PLUG, RING LOCKED
 PORT CONNECTION, 4000psi AND 5000psi**



SHEET 2 OF 2

Sta-Lok® Fluid Fittings



FITTING END PER AECMA EN2604 FOR TUBE SIZE SPECIFIED

A THREAD
B THREAD
LOCKRING CAPTIVATED 0 - 0.4 FROM "A" THREAD CHAMFER

NOTES:

- MATERIAL :
 - FITTING: 6Al-4V TITANIUM ALLOY PER AMS4928, AMS4965, OR AMS4967.
 - LOCKRING: A286 CORROSION RESISTANT STEEL PER AMS5731 OR AMS5734.
- HEAT TREATMENT:
 - FITTING: 900 MPa UTS MIN
 - LOCKRING: 34-40 HRC
- FINISH:
 - FITTING: ANODIC TREATMENT PER AMS2488, TYPE 2.
 - LOCKRING: PASSIVATE PER AMS-QQ-P-35, TYPE II
- SEALING SURFACE : NO VISIBLE DEFECTS. TO BE PROTECTED FOR SHIPMENT.
- LOCKRING RETAINED ON FITTING BY CONTROLLED INTERFERENCE FIT. LOCKRING EXTERNAL SERRATION: ONE TOOTH DELETED FOR METRIC IDENTIFICATION PURPOSE.
- IDENTIFICATION PER AS478 CLASS 35D. NAME, TRADEMARK OR CAGE CODE AND PART NUMBER.
- WORKING PRESSURE: THIS PART IS DESIGNED FOR USE IN 28000 kPa WORKING PRESSURE SYSTEMS COMPATIBLE WITH TITANIUM.
- FITTINGS TO BE INSTALLED PER TECHNICAL SALES BULLETIN No. TSB0027 (SLMA2114) INTO BOSS CAVITIES PER SLMA2110.
- SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36. REQUIREMENTS PER ANSI/ ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 3.2 MICROMILLIMETER R_a AND SEALING SURFACE TO BE 1.6 MICROMILLIMETER R_a .

EXAMPLE OF PART CODING

SLMA2111 - 06

SIZE CODE
(SEE TABLE I)

BASIC PART NUMBER



NOTES: CONTINUED ON SHEET 2 OF 2

REVISION (B) 20 MAY 2003

UNLESS OTHERWISE SPECIFIED
INTERPRET DIMENSION & TOLERANCES PER ANSI Y14.5-1994. ALL DIMENSIONS APPLY AFTER PLATING AND PRIOR TO THE ADDITION OF SOLID FILM LUBRICANT. 3.2 [125]

TOLERANCES ALL SURFACES

.XX	.XXX	ANGLES	[X.X]	[X.XX]
± 0.8	± 0.25	$\pm 2^{\circ}$	$\pm [0.03]$	$\pm [0.10]$

 DIMENSION IN [] ARE INCHES

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

FITTING ASSEMBLY - PORT CONNECTION
RING LOCKED TO BEAM SEAL TUBE END, 28000 kPa, METRIC

SLMA2111

SHEET 1 OF 2

Sta-Lok® Fluid Fittings



NOTES: CONTINUED

10. BREAK EDGES 0.08 TO 0.38 UNLESS OTHERWISE SPECIFIED.

11. DIMENSIONS IN MILLIMETERS.

TABLE I

SIZE CODE	MA2111 PART NUMBER	AECMA PART NUMBER	NOMINAL TUBE SIZE REF	A THREAD PER MA1370	B THREAD PER MA1370	φC ±0.09	φD REF
05	MA2111-05	EN3566-0605	5.0	MJ10 X 1-4g6g	MJ6 X 1-4h6h	12.90	4.20-4.40
06	MA2111-06	EN3566-0806	6.0	MJ12 X 1.25-4g6g	MJ8 X 1-4h6h	14.75	5.00-5.20
08	MA2111-08	EN3566-1008	8.0	MJ14 X 1.5-4g6g	MJ10 X 1-4h6h	17.80	6.70-6.90
10	MA2111-10	EN3566-1210	10.0	MJ16 X 1.5-4g6g	MJ12 X 1.25-4h6h	19.50	8.70-8.90
12	MA2111-12	EN3566-1412	12.0	MJ18 X 1.5-4g6g	MJ14 X 1.5-4h6h	21.00	10.60-10.80
14	MA2111-14	EN3566-1614	14.0	MJ20 X 1.5-4g6g	MJ16 X 1.5-4h6h	22.60	11.45-11.65
16	MA2111-16	EN3566-1816	16.0	MJ22 X 1.5-4g6g	MJ18 X 1.5-4h6h	26.40	13.30-13.60
18	MA2111-18	EN3566-2018	18.0	MJ24 X 1.5-4g6g	MJ20 X 1.5-4h6h	28.00	15.30-15.60
20	MA2111-20	EN3566-2220	20.0	MJ27 X 1.5-4g6g	MJ22 X 1.5-4h6h	30.20	18.00-18.30
22	MA2111-22	EN3566-2422	22.0	MJ30 X 1.5-4g6g	MJ24 X 1.5-4h6h	33.70	20.80-21.10
25	MA2111-25	EN3566-2725	25.0	MJ33 X 1.5-4g6g	MJ27 X 1.5-4h6h	37.00	22.40-22.70
28	MA2111-28	EN3566-3028	28.0	MJ36 X 1.5-4g6g	MJ30 X 1.5-4h6h	40.95	25.60-25.90
32	MA2111-32	EN3566-3332	32.0	MJ39 X 1.5-4g6g	MJ33 X 1.5-4h6h	43.00	28.30-28.60

TABLE I CONT'D

SIZE CODE	φE + 0.20 - 0	φF + 0.15 - 0.05	φG MIN	φH REF	J ±0.20	K + 0.50 - 0	L + 0.15 - 0.10	M ±0.4	N ± 0.2	WEIGHT KG/EA APPROX
05	2.50	4.50	7.10	9.37	16.35	7.95	3.00	11.0	5.3	0.007
06	4.40	6.50	9.05	11.53	18.85	8.60	3.00	13.0	6.1	0.009
08	6.10	8.50	11.06	13.87	21.60	9.30	3.00	15.0	7.0	0.015
10	7.70	10.20	12.78	15.37	21.60	10.00	3.00	15.0	7.0	0.018
12	9.00	11.90	14.38	17.12	21.65	10.65	3.00	15.0	7.0	0.022
14	10.70	13.90	16.36	18.77	21.85	11.30	3.00	15.0	7.0	0.026
16	12.50	15.90	18.37	20.93	21.85	12.00	3.00	15.0	7.0	0.033
18	14.20	17.90	20.37	23.85	22.65	12.70	3.00	15.0	7.0	0.038
20	15.90	19.90	22.38	24.92	23.25	13.35	3.00	15.5	7.0	0.044
22	17.65	21.90	24.35	27.41	23.25	14.00	3.00	15.5	7.0	0.050
25	20.20	24.90	27.35	31.47	23.65	15.05	3.00	15.5	7.0	0.065
28	22.80	27.90	30.37	33.60	23.65	16.05	3.00	15.5	7.0	0.077
32	25.40	30.90	33.37	37.57	23.65	17.05	3.00	15.5	7.0	0.086

REVISION **B** 20 MAY 2003

UNLESS OTHERWISE SPECIFIED
 INTERPRET DIMENSION & TOLERANCES PER
 ANSI Y14.5-1994. ALL DIMENSIONS APPLY AFTER
 PLATING AND PRIOR TO THE ADDITION OF SOLID
 FILM LUBRICANT. 3.2 [125] ✓ ALL SURFACES
 TOLERANCES
 .XX .XXX ANGLES [X.X] [X.XX]
 ±0.8 ±0.25 ±2° ±[.03] ±[.010]
 DIMENSION IN [] ARE INCHES

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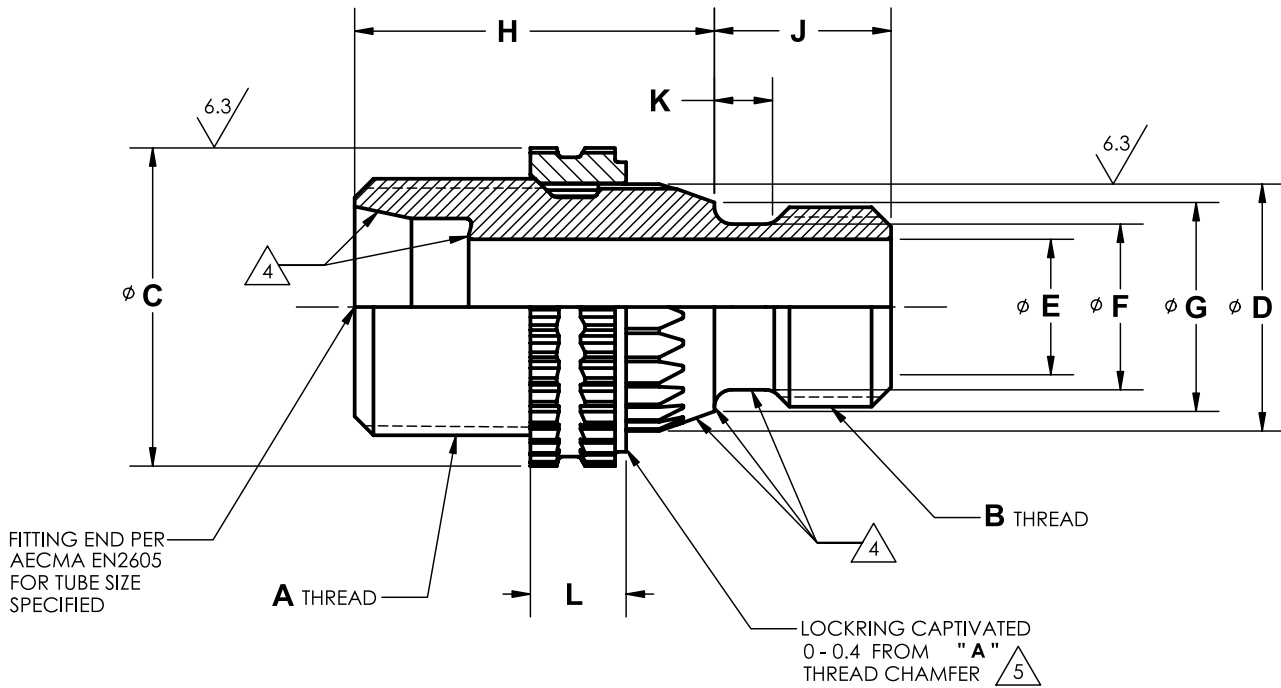
SHUR-LOK

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

SLMA2111

**FITTING ASSEMBLY – PORT CONNECTION
 RING LOCKED TO BEAM SEAL TUBE END, 28000 kPa, METRIC**

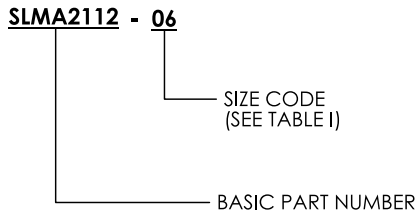
SHEET **2** OF **2**



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: 900 MP_a 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. LOCKRING EXTERNAL SERRATION: ONE TOOTH DELETED FOR METRIC IDENTIFICATION PURPOSE.
6. IDENTIFICATION PER AS478 CLASS 35D. NAME, TRADEMARK OR CAGE CODE AND PART NUMBER.
7. WORKING PRESSURE: THIS PART IS DESIGNED FOR USE IN 28000 kPa WORKING PRESSURE SYSTEMS COMPATIBLE WITH TITANIUM.
8. FITTINGS TO BE INSTALLED PER TECHNICAL SALES BULLETIN No. TSB0027 (SLMA2114) INTO BOSS CAVITIES PER SLMA2110.
9. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36. REQUIREMENTS PER ANSI/ ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 3.2 MICROMILLIMETER R_a AND SEALING SURFACE TO BE 1.6 MICROMILLIMETER R_a.

EXAMPLE OF PART CODING



NOTES: CONTINUED ON SHEET 2 OF 2

REVISION **NC** 20 MAY 2003

UNLESS OTHERWISE SPECIFIED
 INTERPRET DIMENSION & TOLERANCES PER
 ANSI Y14.5-1994. ALL DIMENSIONS APPLY AFTER
 PLATING AND PRIOR TO THE ADDITION OF SOLID
 FILM LUBRICANT. 3.2 [125] ✓ ALL SURFACES
TOLERANCES
 .XX .XXX ANGLES [X.X] [X.XX]
 ±0.8 ±0.25 ±2° ±[.03] ±[.010]
 DIMENSION IN [] ARE INCHES

SHUR-LOK CORPORATION
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 PETIT-RECHAIN, BELGIUM
 TELEPHONE: (32) 87-32.07.11

SLMA2112

FITTING ASSEMBLY – PORT CONNECTION
RING LOCKED TO 24° FLARELESS TUBE END, 28000 kPa, METRIC

SHEET **1** OF **2**



NOTES: CONTINUED

10. BREAK EDGES 0.08 TO 0.38 UNLESS OTHERWISE SPECIFIED.

11. DIMENSIONS IN MILLIMETERS.

TABLE I

SIZE CODE	MA2112 PART NUMBER	NOMINAL TUBE SIZE REF	A THREAD PER MA1370	B THREAD PER MA1370	φ C ±0.09	φ D REF
05	MA2112-05	5.0	MJ10 X 1-4g6g	MJ6 X 1-4h6h	12.90	9.37
06	MA2112-06	6.0	MJ12 X 1.25-4g6g	MJ8 X 1-4h6h	14.75	11.53
08	MA2112-08	8.0	MJ14 X 1.5-4g6g	MJ10 X 1-4h6h	17.80	13.87
10	MA2112-10	10.0	MJ16 X 1.5-4g6g	MJ12 X 1.25-4h6h	19.50	15.37
12	MA2112-12	12.0	MJ18 X 1.5-4g6g	MJ14 X 1.5-4h6h	21.00	17.12
14	MA2112-14	14.0	MJ20 X 1.5-4g6g	MJ16 X 1.5-4h6h	22.60	18.77
16	MA2112-16	16.0	MJ22 X 1.5-4g6g	MJ18 X 1.5-4h6h	26.40	20.93
20	MA2112-20	20.0	MJ27 X 1.5-4g6g	MJ22 X 1.5-4h6h	30.20	24.92
25	MA2112-25	25.0	MJ33 X 1.5-4g6g	MJ27 X 1.5-4h6h	37.00	31.47
32	MA2112-32	32.0	MJ42 X 2-4g6g	MJ36 X 1.5-4h6h	50.45	41.10
40	MA2112-40	40.0	MJ50 X 2-4g6g	MJ42 X 2-4h6h	59.05	49.45

TABLE I CONT'D

SIZE CODE	φ E + 0.20 - 0	φ F + 0.15 - 0.05	φ G MIN	H ±.20	J + 0.50 - 0	K + 0.15 - 0.10	L ±0.2	WEIGHT KG/EA APPROX
05	2.50	4.50	7.10	18.15	7.95	3.00	5.3	.007
06	4.40	6.50	9.05	19.95	8.60	3.00	6.1	.010
08	6.10	8.50	11.06	21.95	9.30	3.00	7.0	.015
10	7.70	10.20	12.78	22.95	10.00	3.00	7.0	.018
12	9.00	11.90	14.38	22.95	10.65	3.00	7.0	.021
14	10.70	13.90	16.36	22.95	11.30	3.00	7.0	.025
16	12.50	15.90	18.37	22.95	12.00	3.00	7.0	.033
20	15.90	19.90	22.38	24.55	13.35	3.00	7.0	.045
25	20.20	24.90	27.35	25.65	15.05	3.00	7.0	.070
32	27.95	33.90	36.35	29.15	18.10	3.00	7.7	.145
40	32.55	39.25	41.73	32.05	20.00	3.00	7.7	.210

REVISION **NC** 20 MAY 2003

UNLESS OTHERWISE SPECIFIED
 INTERPRET DIMENSION & TOLERANCES PER
 ANSI Y14.5-1994. ALL DIMENSIONS APPLY AFTER
 PLATING AND PRIOR TO THE ADDITION OF SOLID
 FILM LUBRICANT. 3.2 [125] ✓ ALL SURFACES

TOLERANCES
 .XX .XXX ANGLES [X.X] [X.XX]
 ±0.8 ±0.25 ±2° ±[.03] ±[.010]
 DIMENSION IN [] ARE INCHES

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

SHUR-LOK

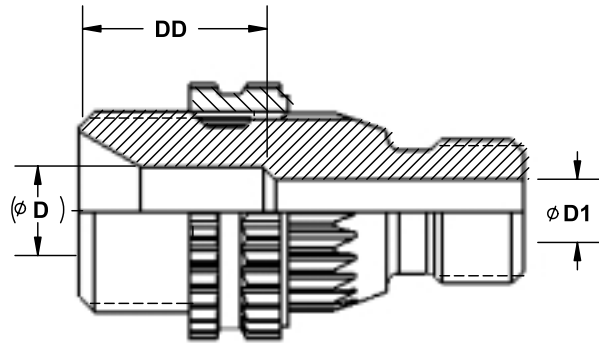
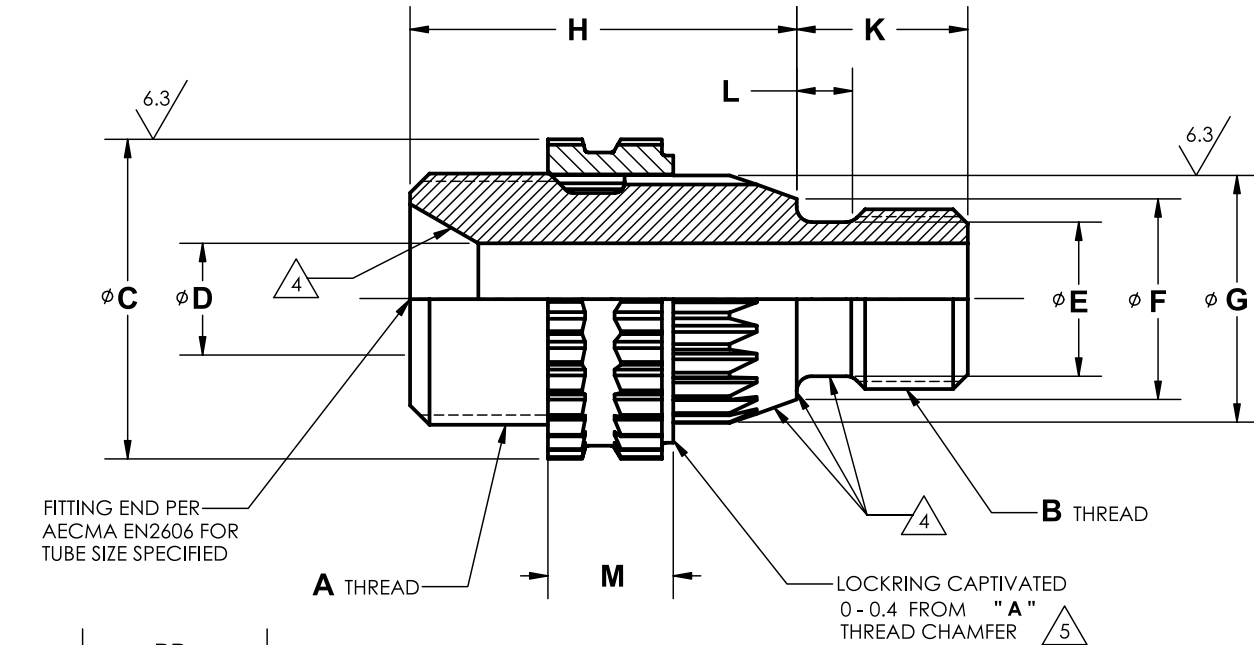
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 PETIT-RECHAIN, BELGIUM
 TELEPHONE: (32) 87-32.07.11

SLMA2112

**FITTING ASSEMBLY – PORT CONNECTION
 RING LOCKED TO 24' FLARELESS TUBE END, 28000 kPa, METRIC**

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

Sta-Lok® Fluid Fittings



CONFIGURATION FOR SIZES: -06, -16, -18 AND -20

EXAMPLE OF PART CODING

SLMA2113 - 06

SIZE CODE (SEE TABLE I)

BASIC PART NUMBER



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: 900 MPa 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. LOCKRING EXTERNAL SERRATION: ONE TOOTH DELETED FOR METRIC IDENTIFICATION PURPOSE.
6. IDENTIFICATION PER AS478 CLASS 35D. NAME, TRADEMARK OR CAGE CODE AND PART NUMBER.
7. WORKING PRESSURE: THIS PART IS DESIGNED FOR USE IN 28000 kPa WORKING PRESSURE SYSTEMS COMPATIBLE WITH TITANIUM.
8. FITTINGS TO BE INSTALLED PER TECHNICAL SALES BULLETIN No. TSB0027 (SLMA2114) INTO BOSS CAVITIES PER SLMA2110.
9. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36. REQUIREMENTS PER ANSI/ ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED TO BE 3.2 MICROMILLIMETER R_a AND SEALING SURFACE TO BE SURFACES 1.6 MICROMILLIMETER R_a.

NOTES: CONTINUED ON SHEET 2 OF 2

REVISION (NC) 20 MAY 2003

UNLESS OTHERWISE SPECIFIED
 INTERPRET DIMENSION & TOLERANCES PER ANSI Y14.5-1994. ALL DIMENSIONS APPLY AFTER PLATING AND PRIOR TO THE ADDITION OF SOLID FILM LUBRICANT. 3.2 [125]

TOLERANCES ALL SURFACES
 .XX .XXX ANGLES [X.X] [X.XX]
 ±0.8 ±0.25 ±2° ±[.03] ±[.010]
 DIMENSION IN [] ARE INCHES

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SHUR-LOK

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

FITTING ASSEMBLY - PORT CONNECTION
RING LOCKED TO 60° FLARELESS TUBE END, 28000 kPa, METRIC

SLMA2113

SHEET 1 OF 2



NOTES: CONTINUED

10. BREAK EDGES 0.08 TO 0.38 UNLESS OTHERWISE SPECIFIED.

11. DIMENSIONS IN MILLIMETERS.

TABLE I

SIZE CODE	MA2113 PART NUMBER	NOMINAL TUBE SIZE REF	A THREAD PER MA1370	B THREAD PER MA1370	ø C ±0.09	ø D +0.20 -0	ø D1 +0.20 -0	DD ±0.20
04	MA2113-04	4.0	MJ10 X 1-4g6g	MJ6 X 1-4h6h	12.90	2.50	-	-
06	MA2113-06	6.0	MJ12 X 1.25-4g6g	MJ8 X 1-4h6h	14.75	4.50	4.40	12.85
08	MA2113-08	8.0	MJ16 X 1.5-4g6g	MJ12 X 1.25-4h6h	19.50	7.70	-	-
10	MA2113-10	10.0	MJ18 X 1.5-4g6g	MJ14 X 1.5-4h6h	21.00	9.00	-	-
12	MA2113-12	12.0	MJ20 X 1.5-4g6g	MJ16 X 1.5-4h6h	22.60	10.70	-	-
14	MA2113-14	14.0	MJ22 X 1.5-4g6g	MJ18 X 1.5-4h6h	26.40	12.50	-	-
16	MA2113-16	16.0	MJ24 X 1.5-4g6g	MJ20 X 1.5-4h6h	28.00	14.50	14.20	15.05
18	MA2113-18	18.0	MJ27 X 1.5-4g6g	MJ22 X 1.5-4h6h	30.20	16.50	15.90	16.00
20	MA2113-20	20.0	MJ30 X 1.5-4g6g	MJ24 X 1.5-4h6h	33.70	18.50	17.65	16.00

TABLE I CONT'D

SIZE CODE	ø E + 0.15 - 0.05	ø F MIN	ø G REF	H ±0.20	K + 0.50 - 0	L + 0.15 - 0.10	M ± 0.2	WEIGHT KG/EA APPROX
04	4.50	7.10	9.37	16.35	7.95	3.00	5.3	.007
06	6.50	9.05	11.53	18.85	8.60	3.00	6.1	.010
08	10.20	12.78	15.37	21.60	10.00	3.00	7.0	.019
10	11.90	14.38	17.12	21.65	10.65	3.00	7.0	.022
12	13.90	16.36	18.77	21.85	11.30	3.00	7.0	.029
14	15.90	18.37	20.93	21.85	12.00	3.00	7.0	.033
16	17.90	20.37	23.85	22.65	12.70	3.00	7.0	.037
18	19.90	22.38	24.92	23.25	13.35	3.00	7.0	.044
20	21.90	24.35	27.41	23.25	14.00	3.00	7.0	.050

REVISION **NC** 20 MAY 2003

UNLESS OTHERWISE SPECIFIED
 INTERPRET DIMENSION & TOLERANCES PER
 ANSI Y14.5-1994. ALL DIMENSIONS APPLY AFTER
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 FILM LUBRICANT. 3.2 [125] ✓ ALL SURFACES
TOLERANCES
 .XX .XXX ANGLES [X.X] [X.XX]
 ±0.8 ±0.25 ±2° ±[.03] ±[.010]
 DIMENSION IN [] ARE INCHES

SHUR-LOK CORPORATION
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 TELEPHONE: (949) 474-6000

SHUR-LOK

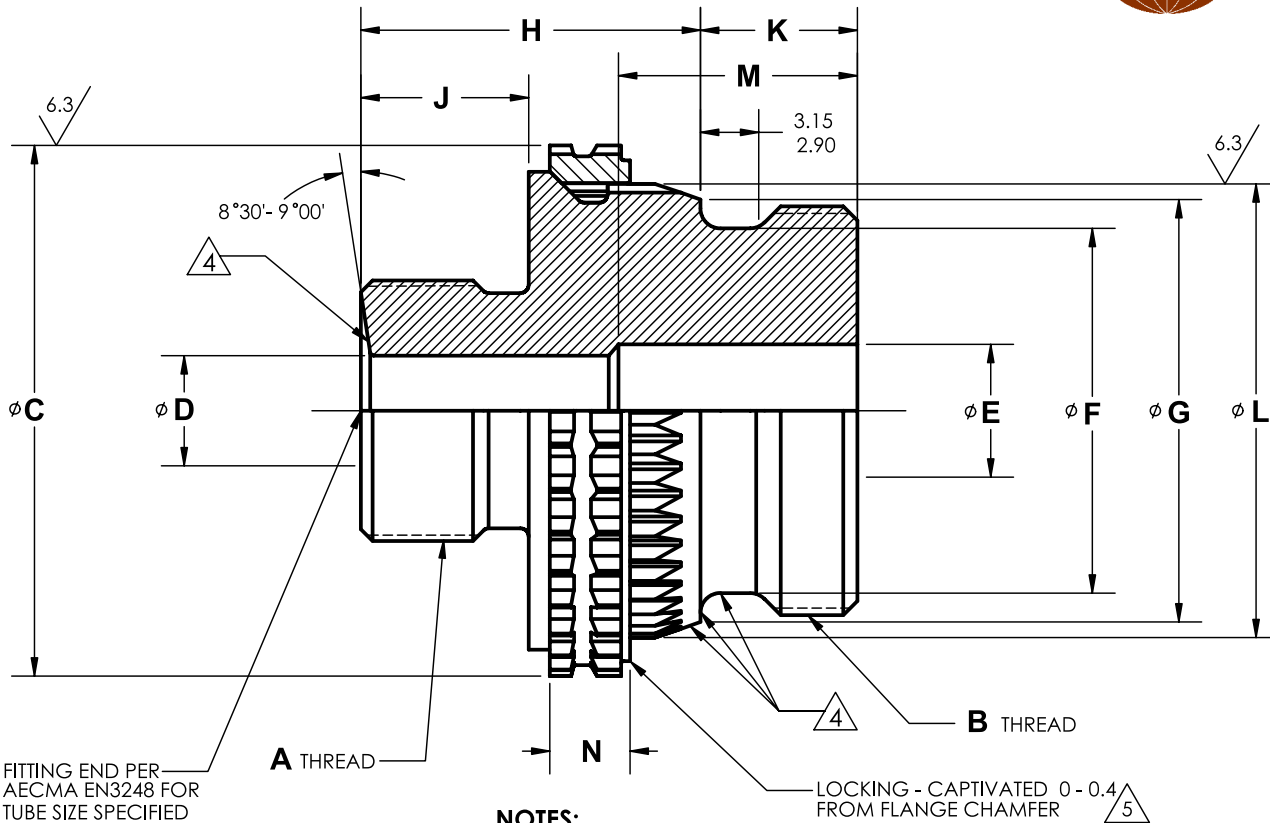
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 PETIT-RECHAIN, BELGIUM
 TELEPHONE: (32) 87-32.07.11

SLMA2113

**FITTING ASSEMBLY – PORT CONNECTION
 RING LOCKED TO 60° FLARELESS TUBE END, 28000 kPa, METRIC**

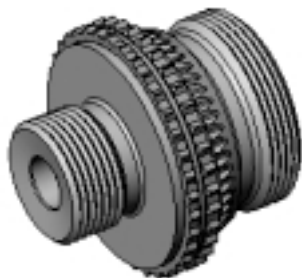
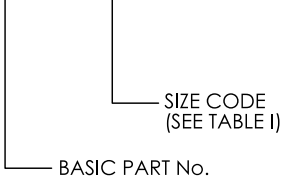
SHEET **2** OF **2**

Sta-Lok® Fluid Fittings



EXAMPLE OF PART CODING:

SLMA2119 - 10-06



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: 900 MP_a 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. LOCKRING EXTERNAL SERRATION: ONE TOOTH DELETED FOR METRIC IDENTIFICATION PURPOSE.
6. IDENTIFICATION PER AS478 CLASS 35D. NAME, TRADEMARK OR CAGE CODE AND PART NUMBER.
7. WORKING PRESSURE: THIS PART IS DESIGNED FOR USE IN 28000 kPa WORKING PRESSURE SYSTEMS COMPATIBLE WITH TITANIUM.
8. FITTINGS TO BE INSTALLED PER TECHNICAL SALES BULLETIN No. TSB0028 (SLMA2114R) INTO BOSS CAVITIES PER SLMA2110.
9. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36. REQUIREMENTS PER ANSI/ ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 3.2 MICROMILLIMETER R_a AND SEALING SURFACE TO BE 1.6 MICROMILLIMETER R_a.

NOTES: CONTINUED ON SHEET 2 OF 2

REVISION **NC** 20 MAY 2003

UNLESS OTHERWISE SPECIFIED
 INTERPRET DIMENSION & TOLERANCES PER
 ANSI Y14.5-1994. ALL DIMENSIONS APPLY AFTER
 PLATING AND PRIOR TO THE ADDITION OF SOLID
 FILM LUBRICANT. 3.2 [125]

TOLERANCES ALL SURFACES
 .XX .XXX ANGLES [X.X] [X.XX]
 ±0.8 ±0.25 ±2° ±[.03] ±[.010]
 DIMENSION IN [] ARE INCHES

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SHUR-LOK

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 PETIT-RECHAIN, BELGIUM
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SLMA2119

**FITTING ASSEMBLY – REDUCER PORT CONNECTION
 RING LOCKED TO BEAM SEAL TUBE END, 28000 kPa, METRIC**

SHEET 1 OF 2



NOTES: CONTINUED

10. BREAK EDGES 0.08 TO 0.38 UNLESS OTHERWISE SPECIFIED.

11. DIMENSIONS IN MILLIMETERS.

TABLE I

SIZE CODE	PORT SIZE END	TUBE SIZE END	MA2119 PART NUMBER	AECMA PART NUMBER	A THREAD PER MA1370 (ISO5855)	B THREAD PER MA1370 (ISO5855)	φ C ±0.09	φ D REF
08-06	08	06	MA2119-08-06	EN3248-1006	MJ12 X 1.25-4g6g	MJ10 X 1-4h6h	17.80	5.00-5.20
10-06	10	06	MA2119-10-06	EN3248-1206	MJ12 X 1.25-4g6g	MJ12 X 1.25-4h6h	19.50	5.00-5.20
10-08		08	MA2119-10-08	EN3248-1208	MJ14 X 1.5-4g6g			6.70-6.90
12-06	12	06	MA2119-12-06	EN3248-1406	MJ12 X 1.25-4g6g	MJ14 X 1.5-4h6h	21.00	5.00-5.20
12-08		08	MA2119-12-08	EN3248-1408	MJ14 X 1.5-4g6g			6.70-6.90
12-10		10	MA2119-12-10	EN3248-1410	MJ16 X 1.5-4g6g			8.70-8.90
14-06	14	06	MA2119-14-06	EN3248-1606	MJ12 X 1.25-4g6g	MJ16 X 1.5-4h6h	22.60	5.00-5.20
14-08		08	MA2119-14-08	EN3248-1608	MJ14 X 1.5-4g6g			6.70-6.90
14-10		10	MA2119-14-10	EN3248-1610	MJ16 X 1.5-4g6g			8.70-8.90
14-12		12	MA2119-14-12	EN3248-1612	MJ18 X 1.5-4g6g			10.60-10.80

TABLE I CONT'D

SIZE CODE	φ E + 0.20 - 0	φ F + 0.15 - 0.05	φ G MIN	H ± 0.2	J ± 0.15	K + 0.50 - 0	φ L REF	M ±0.40	N ±0.20
08-06	6.10	8.50	11.06	25.2	8.75	9.30	13.87	16.15	7.00
10-06	7.70	10.20	12.78	25.2	8.75	10.00	15.37	16.70	7.00
10-08				27.0	10.55				
12-06	9.00	11.90	14.38	25.2	8.75	10.65	17.12	17.45	7.00
12-08				27.0	10.55				
12-10				27.0	10.55				
14-06	10.70	13.90	16.36	25.2	8.75	11.30	18.77	17.90	7.00
14-08				27.0	10.55				
14-10				27.0	10.55				
14-12				27.0	10.55				

REVISION NC 20 MAY 2003

UNLESS OTHERWISE SPECIFIED
 INTERPRET DIMENSION & TOLERANCES PER
 ANSI Y14.5-1994. ALL DIMENSIONS APPLY AFTER
 PLATING AND PRIOR TO THE ADDITION OF SOLID
 FILM LUBRICANT. 3.2 [125] ✓ ALL SURFACES
TOLERANCES
 .XX .XXX ANGLES [X.X] [X.XX]
 ±0.8 ±0.25 ±2° ±[.03] ±[0.10]
 DIMENSION IN [] ARE INCHES

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

SLMA2119

**FITTING ASSEMBLY – REDUCER PORT CONNECTION
 RING LOCKED TO BEAM SEAL TUBE END, 28000 kPa, METRIC**

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



TABLE I

SIZE CODE	AS3077 PART NUMBER	φ A MAX	φ B	φ C	φ D	E °	φ F	φ G
02	AS3077-02	.630	.755 - .775	.509 - .516	.549 - .559	95 - 98	.697 - .706	.649 - .658
03	AS3077-03	.693	.820 - .840	.576 - .583	.616 - .626	94 - 97	.760 - .769	.712 - .721
04	AS3077-04	.755	.880 - .900	.639 - .646	.677 - .687	93.5 - 96.5	.822 - .831	.774 - .783
05	AS3077-05	.818	.940 - .960	.702 - .709	.742 - .752	93 - 96	.885 - .894	.837 - .846
06	AS3077-06	.865	.990 - 1.010	.764 - .771	.806 - .816	93 - 96	.932 - .941	.884 - .893
08	AS3077-08	1.113	1.240 - 1.260	.994 - 1.001	1.034 - 1.044	92 - 95	1.183 - 1.192	1.134 - 1.143
10	AS3077-10	1.238	1.370 - 1.390	1.129 - 1.136	1.177 - 1.187	92 - 95	1.308 - 1.317	1.259 - 1.268
12	AS3077-12	1.455	1.590 - 1.610	1.317 - 1.324	1.367 - 1.377	91.5 - 94.5	1.527 - 1.536	1.478 - 1.487
16	AS3077-16	1.716	1.850 - 1.870	1.567 - 1.574	1.617 - 1.627	91 - 94	1.793 - 1.802	1.744 - 1.753
20	AS3077-20	2.111	2.240 - 2.260	1.973 - 1.980	2.022 - 2.032	90.5 - 93.5	2.183 - 2.192	2.134 - 2.143

TABLE I CONT'D

H °	WEIGHT LB/100 PIECES APPROX	INSERT SLAS3078 SIZE CODE
92 - 96	.69	02
92.5 - 96.5	.72	03
92 - 96	.77	04
92 - 96	.87	05
92 - 96	.78	06
91.5 - 95.5	1.12	08
91 - 95	1.17	10
90.5 - 94.5	1.61	12
90 - 94	2.10	16
90 - 94	2.39	20

REVISION NC 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

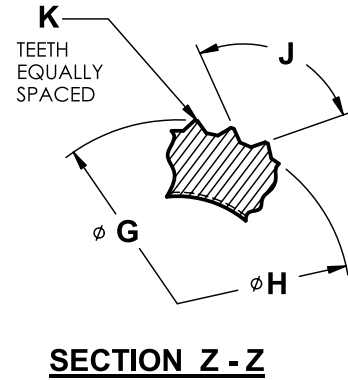
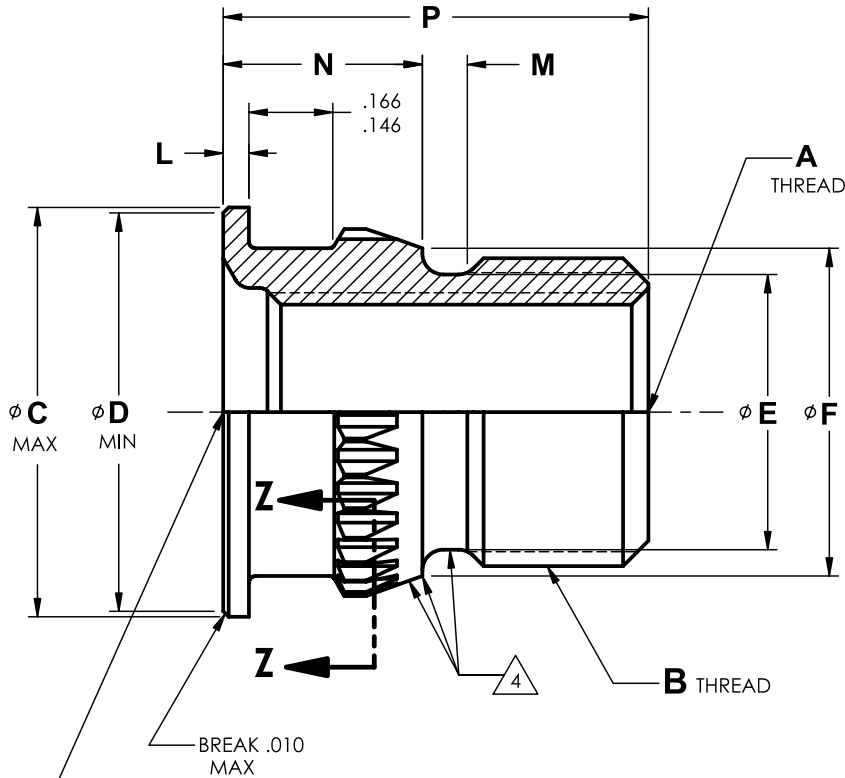
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 PETIT-RECHAIN, BELGIUM
 TELEPHONE: (32) 87-32.07.11

SLAS3077

**LOCKRING - FLUID CONNECTION BOSS INSERT
 INTERNAL STRAIGHT THREAD**

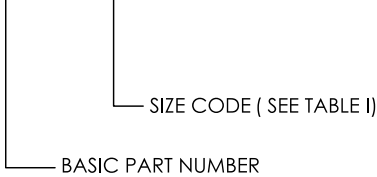
SHEET 2 OF 2

Sta-Lok® Fluid Fittings



EXAMPLE OF PART CODING:

SLAS3078 - 06



NOTES:

1. MATERIAL : A286 CORROSION RESISTANT STEEL PER AMS5731, AMS5732, AMS5734 OR AMS5737.
2. HEAT TREATMENT: AMS5731 AND AMS5734 PARTS SHALL BE AGED IN ACCORDANCE WITH SAE AMS-H-6875. HARDNESS 29 HRC MIN.
3. FINISH: PASSIVATE PER AMS-QQ-P-35, TYPE II OR TYPE VII.
4. SEALING SURFACE : NO VISIBLE DEFECTS. TO BE PROTECTED FOR SHIPMENT.
5. FLUORESCENT PENETRANT INSPECTION PER ASTM E1417. CRITERIA IN ACCORDANCE WITH AS3071.
6. IDENTIFICATION PER AS478, CLASS 35D, NAME, TRADEMARK OR CAGE CODE AND PART NUMBER.
7. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36. REQUIREMENTS PER ANSI / ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 MICROINCHES R_a EXCEPT SEALING SURFACE TO BE 63 MICROINCHES R_a AND SERRATIONS TO BE 250 MICROINCHES R_a.
8. INSERT TO BE USED IN CONJUNCTION WITH SLAS3077 LOCKRING AND TO BE INSTALLED PER TECHNICAL SALES BULLETIN No. TSB0026 (SLAS1959) INTO BOSS CAVITIES PER SLAS1958.
9. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.
10. DIMENSIONS IN INCHES.

REVISION **NC** 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] ALL SURFACES
TOLERANCES
 .XX .XXX ANGLES [X.X] [X.XX]
 ±.03 ±.010 ±2° ±[0.8] ±[0.25]
 DIMENSION [] ARE MILLIMETERS

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SLAS3078

**FITTING, AS33649 BOSS INSERT, FLUID CONNECTION
 TO RING LOCKED BOSS**


SHEET **1** OF **2**




TABLE I

SIZE CODE	AS3078 PART NUMBER	A THREAD PER AS8879	B THREAD PER AS8879	φC MAX	φD MIN	φE + .005 - .002	φF ±.003	φG + .005 - .004
02	AS3078-02	.3125-24UNJF-3B	.4375-28UNJEF-3A	.622	.602	.375	.469	.544
03	AS3078-03	.3750-24UNJF-3B	.5000-28UNJEF-3A	.685	.665	.440	.536	.611
04	AS3078-04	.4375-20UNJF-3B	.5625-24UNJEF-3A	.748	.728	.503	.599	.672
05	AS3078-05	.5000-20UNJF-3B	.6250-24UNJEF-3A	.810	.790	.566	.662	.737
06	AS3078-06	.5625-18UNJF-3B	.6875-24UNJEF-3A	.867	.852	.628	.724	.801
08	AS3078-08	.7500-16UNJF-3B	.9375-20UNJEF-3A	1.060	1.040	.858	.954	1.029
10	AS3078-10	.8750-14UNJF-3B	1.0625-18UNJEF-3A	1.185	1.165	.983	1.079	1.172
12	AS3078-12	1.0625-12UNJ-3B	1.2500-18UNJEF-3A	1.435	1.415	1.171	1.267	1.362
16	AS3078-16	1.3125-12UNJ-3B	1.5000-18UNJEF-3A	1.685	1.665	1.421	1.517	1.612
20	AS3078-20	1.6250-12UNJ-3B	1.8750-16UNJ-3A	2.020	1.978	1.760	1.918	2.012

TABLE I CONT'D

SIZE CODE	φH + .005 - .004	J ± 1.5°	K	L + .010 - .004	M + .010 - .005	N ±.015	P	WEIGHT LB/EA APPROX	LOCKRING SLAS3077 SIZE CODE 
02	.502	96.5	24	.047	.082	.364	.761	.0219	02
03	.569	95.5	28	.047	.082	.364	.729	.0286	03
04	.632	95.0	31	.047	.082	.364	.777	.0285	04
05	.695	94.5	34	.047	.082	.364	.802	.0358	05
06	.758	94.5	36	.047	.082	.364	.830	.0359	06
08	.988	93.5	48	.047	.082	.364	.955	.0757	08
10	1.122	93.5	46	.057	.082	.374	1.051	.0979	10
12	1.310	93.0	54	.072	.082	.389	1.185	.1219	12
16	1.560	92.5	64	.072	.082	.389	1.185	.1836	16
20	1.961	92.0	80	.072	.122	.389	1.237	.2796	20

REVISION  20 MAY 2003

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

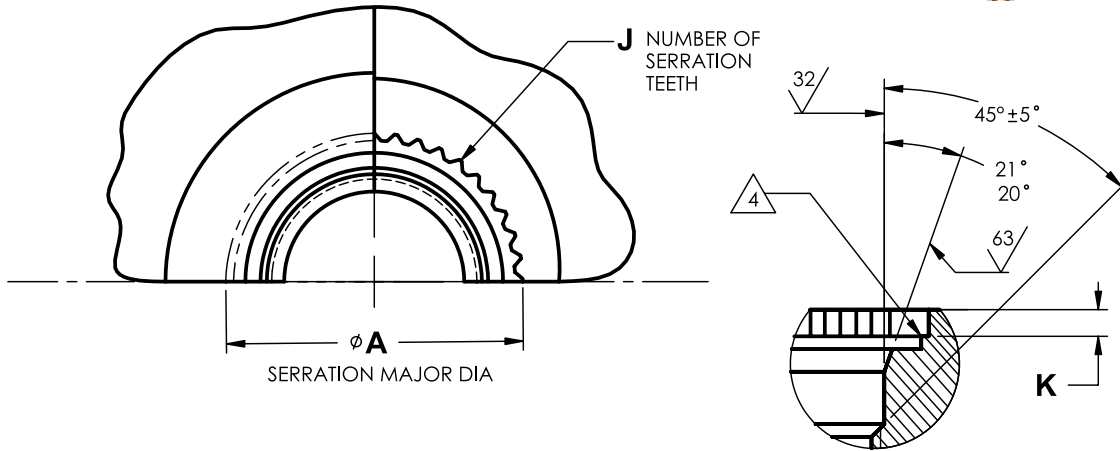
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 PETIT-RECHAIN, BELGIUM
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SLAS3078

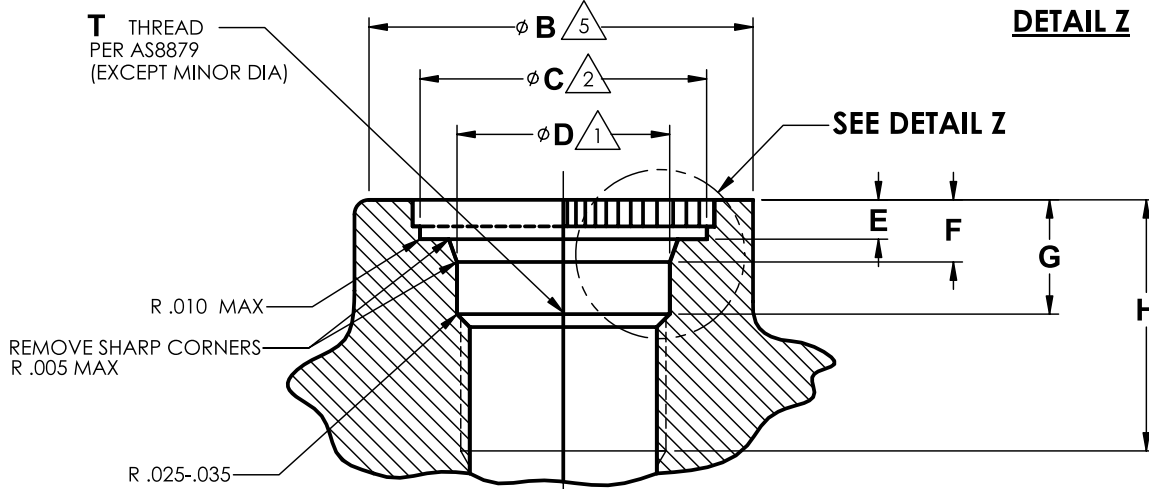
**FITTING, AS33649 BOSS INSERT, FLUID CONNECTION
 TO RING LOCKED BOSS**

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

Sta-Lok® Fluid Fittings



DETAIL Z

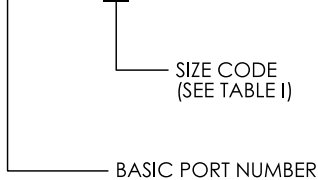


NOTES:

- 1. THREAD PITCH DIA AND " D " DIA MUST BE CONCENTRIC WITHIN .003 FIM.
- 2. THREAD PITCH DIA MUST BE CONCENTRIC WITHIN .003 FIM TO " C " DIA
- 3. THE DRILL AND PORTING TOOL METHOD OF PREPARING THE MACHINED CAVITY IS MANDATORY. DRILL .015 - .030 SMALLER THAN CONTROLLED MINOR DIA SPECIFIED. THE PORTING TOOL WILL SIZE THE MINOR DIA AND PROVIDE BALANCE OF CAVITY CONFIGURATION READY FOR BROACHING SERRATION.
- 4. AFTER SERRATIONS ARE BROACHED, CHIP REMOVAL IS REQUIRED.
- 5. THE MINIMUM BOSS DIAMETER " B " SHOWN IS TO RESIST FITTING INSTALLATION TORQUE AND COUPLING NUT TORQUE. THEY ARE SATISFACTORY FOR USE IN MATERIALS THAT EXHIBIT MINIMUM SHEAR STRENGTHS OF 26 ksi. A 10% INCREASE IN DIAMETERS SHOWN IS REQUIRED FOR SIZES -05 THROUGH -08, AND A 15% INCREASE IN DIAMETERS SHOWN FOR SIZES -10 AND ABOVE WHEN DESIGNING IN MATERIALS WHOSE SHEAR STRENGTH IS LESS THAN 26 ksi. INCREASE NOT REQUIRED FOR -02 THROUGH -04. USING DESIGN ACTIVITY MAY REDUCE MIN " B " IN STEEL BOSSES.
- 6. USE OF PORTING TOOL AND BROACH TOOL SPECIFIED IS MANDATORY TO PROVIDE REQUIRED PORT CONFIGURATION. THIS TOOLING IS AVAILABLE FROM MCKINNON INDUSTRIES INC., A SHUR-LOK COMPANY, IRVINE, CA-CAGE CODE: 65085.
- 7. DIMENSIONS IN INCHES.

EXAMPLE OF PORT CODING

SLAS1300 - 06



REVISION **NC** 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
 .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

SLAS1300

**PORT - RING LOCKED FLUID CONNECTION TYPE,
 STANDARD DIMENSIONS FOR**

SHEET **1** OF **2**



TABLE I

SIZE CODE	AS1300 PORT NUMBER	NOMINAL TUBE SIZE REF	T THREAD		φ A MIN	φ B MIN	φ C	φ D
			PER AS8879	CONTROLLED MINOR DIA				
02	AS1300-02	.125	.2160-28UNJF-3B	.1827-.1857	.408	.50	.381-.384	.254-.256
03	AS1300-03	.188	.2500-28UNJF-3B	.2167-.2197	.478	.62	.448-.451	.286-.288
04	AS1300-04	.250	.3125-24UNJF-3B	.2734-.2764	.524	.68	.495-.498	.339-.341
05	AS1300-05	.312	.3750-24UNJF-3B	.3359-.3389	.635	.79	.601-.604	.401-.403
06	AS1300-06	.375	.4375-20UNJF-3B	.3903-.3933	.710	.85	.675-.678	.464-.466
08	AS1300-08	.500	.5625-18UNJF-3B	.5099-.5129	.826	1.04	.784-.787	.582-.584
10	AS1300-10	.625	.6875-24UNJEF-3B	.6484-.6514	1.052	1.17	1.015-1.018	.725-.727
12	AS1300-12	.750	.8125-20UNJEF-3B	.7653-.7683	1.182	1.42	1.139-1.142	.899-.901
14	AS1300-14	.875	.9375-20UNJEF-3B	.8903-.8933	1.354	1.54	1.311-1.314	1.030-1.032
16	AS1300-16	1.000	1.1250-18UNJEF-3B	1.0714-1.0744	1.471	1.67	1.427-1.430	1.162-1.164
20	AS1300-20	1.250	1.3125-18UNJEF-3B	1.2599-1.2629	1.795	1.98	1.750-1.753	1.387-1.389
24	AS1300-24	1.500	1.6250-18UNJEF-3B	1.5724-1.5754	2.045	2.23	2.000-2.005	1.664-1.666
32	AS1300-32	2.000	2.1250-16UNJ-3B	2.0627-2.0657	2.561	2.86	2.516-2.521	2.202-2.204

TABLE I CONT'D

SIZE CODE	E	F	G	H MIN FULL THREAD DEPTH	J No. OF TEETH	K MIN	TOOLING	
							PORTING TOOL No. REF	BASIC BROACH TOOL No. REF
02	.088-.098	.153-.158	.296-.301	.507	24	.061	MPT02	MFOPB5002
03	.088-.098	.153-.158	.296-.301	.568	26	.061	MPT03	MFOPB5003
04	.088-.098	.153-.158	.296-.301	.568	30	.061	MPT04	MFOPB5004
05	.088-.098	.153-.158	.296-.301	.594	36	.061	MPT05	MFOPB5005
06	.103-.113	.168-.173	.311-.316	.631	36	.073	MPT06	MFOPB5006
08	.103-.113	.168-.173	.311-.316	.672	40	.073	MPT08	MFOPB5008
10	.103-.113	.168-.173	.311-.316	.693	38	.073	MPT10	MFOPB5010
12	.103-.113	.168-.173	.343-.348	.763	40	.073	MPT12	MFOPB5012
14	.103-.113	.168-.173	.343-.348	.800	50	.073	MPT14	MFOPB5014
16	.103-.113	.168-.173	.343-.348	.806	36	.073	MPT16	MFOPB5016
20	.130-.140	.195-.200	.375-.380	.838	56	.093	MPT20	MFOPB5020
24	.130-.140	.195-.200	.375-.380	.877	81	.093	MPT24	MFOPB5024
32	.130-.140	.236-.241	.416-.421	1.050	102	.093	MPT32	MFOPB5032

REVISION 20 MAY 2003

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

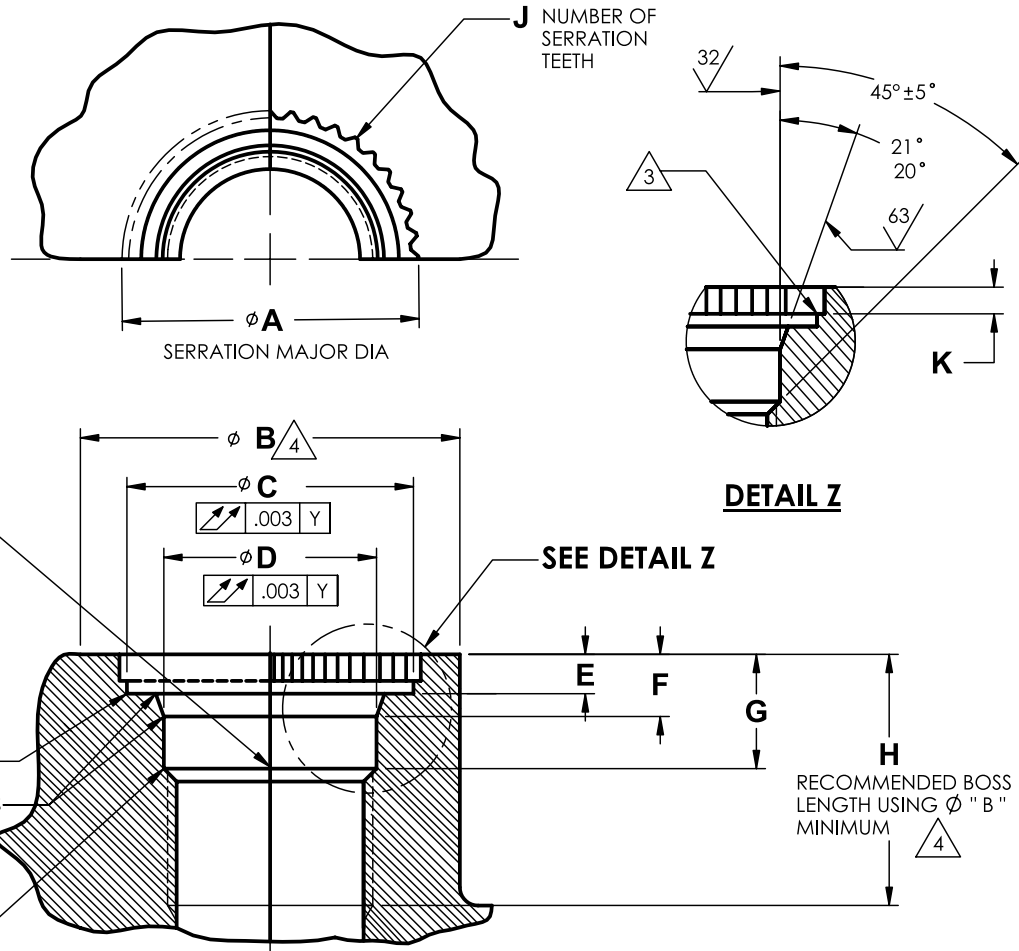
SHUR-LOK INTERNATIONAL, S.A.
 PETIT-RECHAIN, BELGIUM
 TELEPHONE: (32) 87-32.07.11

SLAS1300

**PORT - RING LOCKED FLUID CONNECTION TYPE,
 STANDARD DIMENSIONS FOR**

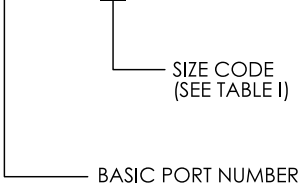
SHEET 2 OF 2

Sta-Lok® Fluid Fittings



EXAMPLE OF PORT CODING

SLAS4201 - 06



NOTES:

1. THIS PORT IS DESIGNED FOR USE WITH FITTINGS PER AS85720.
2. THE DRILL AND PORTING TOOL METHOD OF PREPARING THE MACHINED CAVITY IS MANDATORY. DRILL .015 -.030 SMALLER THAN CONTROLLED MINOR DIA SPECIFIED. THE PORTING TOOL WILL SIZE THE MINOR DIA AND PROVIDE BALANCE OF CAVITY CONFIGURATION READY FOR BROACHING SERRATION.
- 3 AFTER SERRATIONS ARE BROACHED, CHIP REMOVAL IS REQUIRED.
- 4 THE MINIMUM BOSS DIAMETER " B " AND BOSS DEPTH " H " SHOWN ARE SATISFACTORY FOR USE IN MATERIALS THAT EXHIBIT A MINIMUM SHEAR STRENGTHS OF 20 ksi.
- 5 USE OF PORTING TOOL AND BROACH TOOL SPECIFIED IS MANDATORY TO PROVIDE REQUIRED PORT CONFIGURATION. THIS TOOLING IS AVAILABLE FROM MCKINNON INDUSTRIES INC., A SHUR-LOK COMPANY, CAGE CODE No: 65085, IRVINE CA.
6. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36. REQUIREMENTS PER ANSI/ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 MICRINCHES Ra .

NOTES: CONTINUED ON SHEET 2 OF 2

REVISION **NC** 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] ✓ ALL SURFACES
TOLERANCES

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

 DIMENSION IN [] ARE MILLIMETERS

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SHUR-LOK

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 PETIT-RECHAIN, BELGIUM
 TELEPHONE: (32) 87-32.07.11

SLAS4201

**PORT - RING LOCKED FLUID CONNECTION TYPE,
 STANDARD DIMENSIONS FOR, 8000psi**

SHEET **1** OF **2**



NOTES: CONTINUED

7. DIMENSIONING AND TORANCING: ASME Y14.5M-1994.
8. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.
9. DIMENSIONS IN INCHES.

TABLE I




SIZE CODE	AS4201 PORT NUMBER	NOMINAL TUBE SIZE REF	T THREAD		φ A MIN	φ B MIN 	φ C	φ D
			PER AS8879	CONTROLLED MINOR DIA				
02	AS4201-02	.125	.2160-28UNJF-3B	.1827-.1857	.408	.650	.381-.384	.254-.256
03	AS4201-03	.188	.2500-28UNJF-3B	.2167-.2197	.478	.800	.448-.451	.286-.288
04	AS4201-04	.250	.3125-24UNJF-3B	.2734-.2764	.524	.880	.495-.498	.339-.341
05	AS4201-05	.312	.3750-24UNJF-3B	.3359-.3389	.635	1.030	.601-.604	.401-.403
06	AS4201-06	.375	.4375-20UNJF-3B	.3903-.3933	.710	1.100	.675-.678	.464-.466
07	AS4201-07	.438	.5000-20UNJF-3B	.4528-.4558	.778	1.250	.747-.750	.523-.525
08	AS4201-08	.500	.5625-18UNJF-3B	.5099-.5129	.826	1.350	.784-.787	.582-.584
09	AS4201-09	.562	.6250-24UNJEF-3B	.5859-.5889	.902	1.400	.860-.863	.660-.662
10	AS4201-10	.625	.6875-24UNJEF-3B	.6484-.6514	1.052	1.520	1.015-1.018	.725-.727
11	AS4201-11	.688	.7500-20UNJEF-3B	.7028-.7058	1.116	1.680	1.073-1.076	.773-.775

TABLE I CONT'D

SIZE CODE	E	F	G	H MIN FULL THREAD DEPTH	J No. OF TEETH	K MIN	TOOLING 	
							PORTING TOOL No. REF	BASIC BROACH TOOL No. REF
02	.088-.098	.153-.158	.296-.301	.514	24	.061	MPT02	MFOPB5002
03	.088-.098	.153-.158	.296-.301	.525	26	.061	MPT03	MFOPB5003
04	.088-.098	.153-.158	.296-.301	.553	30	.061	MPT04	MFOPB5004
05	.088-.098	.153-.158	.296-.301	.579	36	.061	MPT05	MFOPB5005
06	.103-.113	.168-.173	.311-.316	.624	36	.073	MPT06	MFOPB5006
07	.103-.113	.168-.173	.311-.316	.648	40	.073	MPT07	MFOPB5007
08	.103-.113	.168-.173	.311-.316	.675	40	.073	MPT08	MFOPB5008
09	.103-.113	.168-.173	.311-.316	.703	40	.073	MPT09	MFOPB5009
10	.103-.113	.168-.173	.311-.316	.728	38	.073	MPT10	MFOPB5010
11	.103-.113	.168-.173	.311-.316	.751	43	.073	MPT11	MFOPB5011

REVISION  20 MAY 2003

UNLESS OTHERWISE SPECIFIED
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 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

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 TELEPHONE: (949) 474-6000

SHUR-LOK

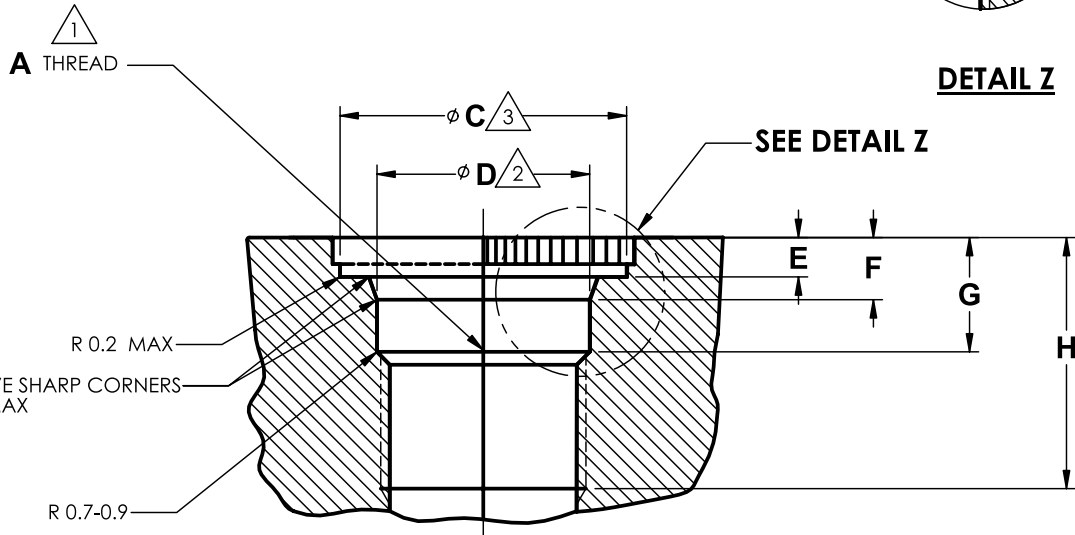
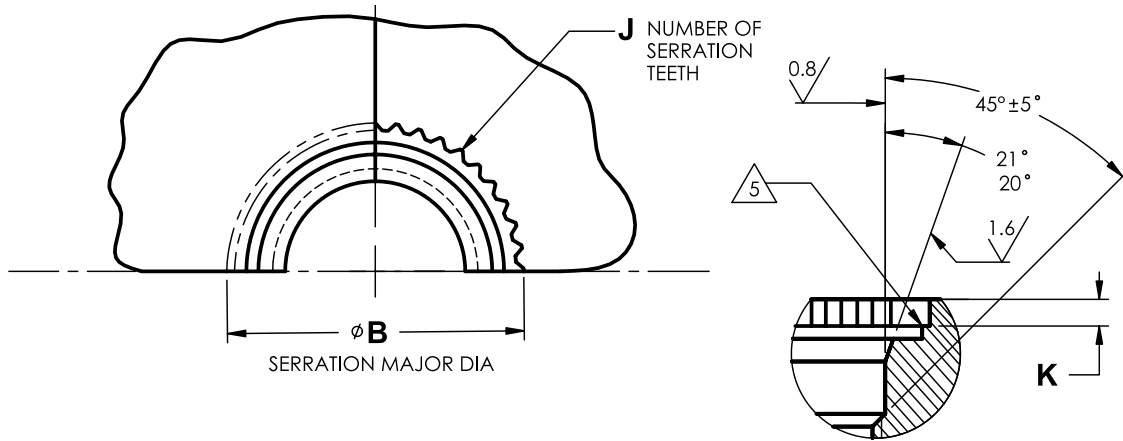
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 PETIT-RECHAIN, BELGIUM
 TELEPHONE: (32) 87-32.07.11

SLAS4201

**PORT – RING LOCKED FLUID CONNECTION TYPE,
 STANDARD DIMENSIONS FOR, 8000psi**

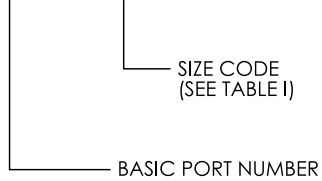
SHEET 2 OF 2

Sta-Lok® Fluid Fittings



EXAMPLE OF PORT CODING

SLMA2110 - 098



NOTES:

1. THREAD IN ACCORDANCE WITH MA1370 (ISO 5855).
2. THREAD PITCH DIA AND "D" DIA MUST BE CONCENTRIC WITHIN 0.08 FIM.
3. THREAD PITCH DIA MUST BE CONCENTRIC WITHIN 0.08 FIM TO "C" DIA
4. THE DRILL AND PORTING TOOL METHOD OF PREPARING THE MACHINED CAVITY IS MANDATORY. DRILL 0.4-0.7 SMALLER THAN CONTROLLED MINOR DIA SPECIFIED. THE PORTING TOOL WILL SIZE THE MINOR DIA AND PROVIDE BALANCE OF CAVITY CONFIGURATION READY FOR BROACHING SERRATION. USE OF PREBROACH TOOL SPECIFIED IS MANDATORY TO PROVIDE PROPER SERRATIONS.
5. AFTER SERRATIONS ARE BROACHED, CHIP REMOVAL IS REQUIRED.
6. THIS PORT REQUIRES SPECIAL TOOLING FOR PROPER INSTALLATION. THIS TOOLING IS AVAILABLE FROM MCKINNON INDUSTRIES INC., A SHUR-LOK COMPANY, IRVINE, CA-CAGE CODE: 65085.
7. DIMENSIONS IN MILLIMETERS.

REVISION NC 20 MAY 2003

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 ANSI Y14.5-1994. ALL DIMENSIONS APPLY AFTER
 PLATING AND PRIOR TO THE ADDITION OF SOLID
 FILM LUBRICANT. 3.2 [125] ✓ ALL SURFACES
TOLERANCES
 .XX .XXX ANGLES [X.X] [X.XX]
 ±0.8 ±0.25 ±2° ±[.03] ±[.010]
 DIMENSION IN IT ARE INCHES

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SLMA2110

**PORT - RING LOCKED FLUID CONNECTION TYPE,
 STANDARD DIMENSIONS FOR, METRIC**

SHEET 1 OF 2



TABLE I





SIZE CODE	MA2110 PORT NUMBER	NOMINAL TUBE SIZE REF	ATHREAD		øB SERRATION MAJOR DIA MIN	øC 	øD 
			PER MA1370	CONTROLLED MINOR DIA			
077	MA2110-077	5.0	MJ6 X1-4H5H	5.065-5.141	13.13	12.01-12.09	7.37-7.42
098	MA2110-098	6.0	MJ8 X1-4H5H	7.065-7.141	15.01	14.02-14.10	9.33-9.38
125	MA2110-125	8.0	MJ10 X1-4H5H	9.065-9.141	18.08	17.04-17.12	11.34-11.39
136	MA2110-136	10.0	MJ12 X1.25-4H5H	10.821-10.898	19.76	18.64-18.72	13.06-13.11
153	MA2110-153	12.0	MJ14 X1.5-4H5H	12.576-12.652	21.29	20.22-20.30	14.66-14.71
170	MA2110-170	14.0	MJ16 X1.5-4H5H	14.576-14.652	22.89	21.82-21.90	16.64-16.69
192	MA2110-192	16.0	MJ18 X1.5-4H5H	16.576-16.652	26.72	25.40-25.48	18.65-18.70
214	MA2110-214	18.0	MJ20 X1.5-4H5H	18.576-18.652	28.30	27.05-27.13	20.66-20.71
231	MA2110-231	20.0	MJ22 X1.5-4H5H	20.576-20.652	30.45	29.36-29.44	22.68-22.73
253	MA2110-253	22.0	MJ24 X1.5-4H5H	22.576-22.652	34.01	32.54-32.62	24.66-24.71
295	MA2110-295	25.0	MJ27 X1.5-4H5H	25.576-25.652	37.34	36.04-36.12	27.66-27.71
320	MA2110-320	28.0	MJ30 X1.5-4H5H	28.576-28.652	41.25	39.67-39.75	30.68-30.73
350	MA2110-350	32.0	MJ33 X1.5-4H5H	31.576-31.652	43.33	42.06-42.14	33.68-33.73
381	MA2110-381	TBD	MJ36 X1.5-4H5H	34.576-34.652	50.82	49.20-49.28	36.66-36.71
452	MA2110-452	40.0	MJ42 X2-4H5H	40.088-40.164	59.44	57.93-58.01	42.04-42.09

TABLE I CONT'D

SIZE CODE	E	F	G	H MIN FULL THREAD DEPTH	J No. OF TEETH	K MIN	TOOLING 	
							PORTING TOOL No. REF	PREBROACH TOOL No. REF
077	2.90-3.15	5.26-5.39	8.40-8.53	14.20	23	1.9	MPTM077	MFMOPB077
098	3.30-3.55	5.82-5.95	9.00-9.13	15.40	27	2.3	MPTM098	MFMOPB098
125	3.80-4.05	6.36-6.49	9.50-9.63	16.65	31	2.7	MPTM125	MFMOPB125
136	3.80-4.05	6.36-6.49	9.50-9.63	17.35	40	2.7	MPTM136	MFMOPB136
153	3.80-4.05	6.36-6.49	9.50-9.63	18.00	38	2.7	MPTM153	MFMOPB153
170	3.80-4.05	6.36-6.49	9.50-9.63	18.65	40	2.7	MPTM170	MFMOPB170
192	3.80-4.05	6.36-6.49	9.50-9.63	19.30	38	2.7	MPTM192	MFMOPB192
214	3.80-4.05	7.36-7.49	10.50-10.63	21.00	43	2.7	MPTM214	MFMOPB214
231	3.80-4.05	7.36-7.49	10.50-10.63	21.70	46	2.7	MPTM231	MFMOPB231
253	3.80-4.05	7.36-7.49	10.50-10.63	22.35	36	2.7	MPTM253	MFMOPB253
295	3.80-4.05	7.36-7.49	10.50-10.63	23.40	47	2.7	MPTM295	MFMOPB295
320	3.80-4.05	7.36-7.49	10.50-10.63	24.40	32	2.7	MPTM320	MFMOPB320
350	3.80-4.05	7.36-7.49	10.50-10.63	25.40	53	2.7	MPTM350	MFMOPB350
381	4.10-4.35	9.76-9.89	13.10-13.23	28.90	40	3.9	MPTM381	MFMOPB381
452	4.10-4.35	12.66-12.79	16.00-16.13	33.70	40	3.9	MPTM452	MFMOPB452

REVISION  20 MAY 2003

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 FILM LUBRICANT. 3.2 [125]
 TOLERANCES  ALL SURFACES
 .XX .XXX ANGLES [X.X] [X.XX]
 ±0.8 ±0.25 ±2° ±[.03] ±[.010]
 DIMENSION IN IT ARE INCHES

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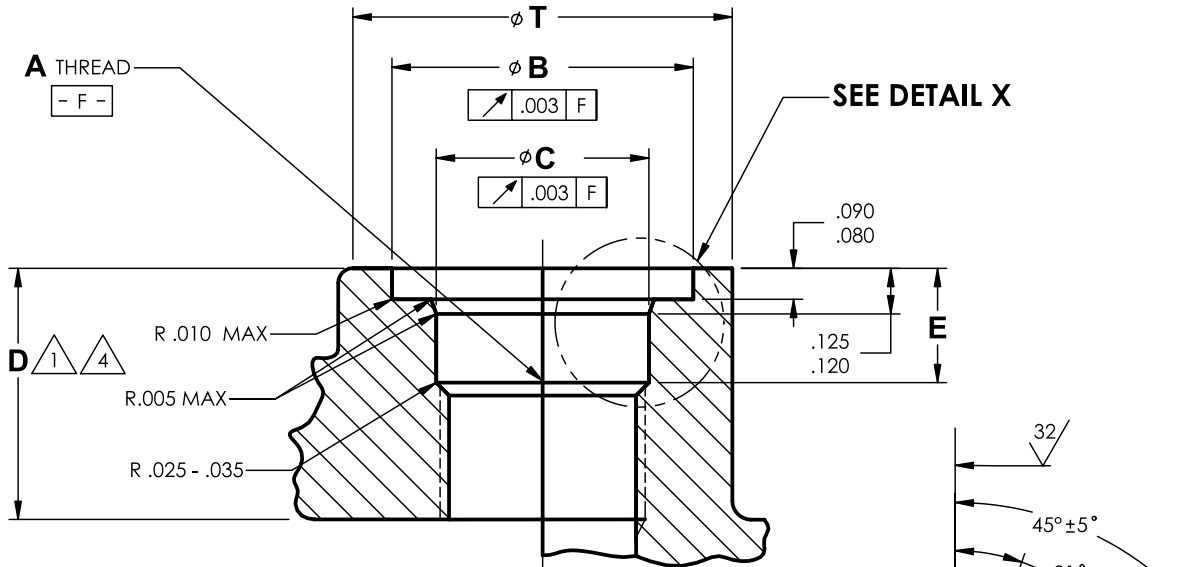
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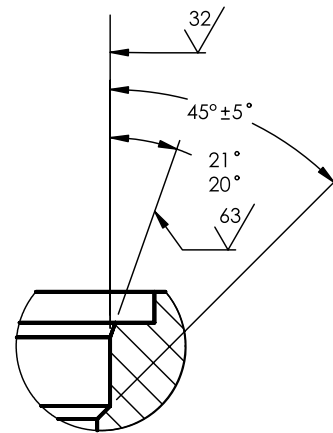
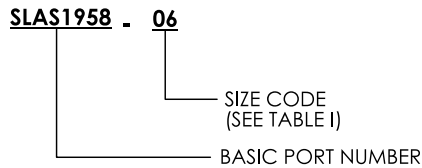
SLMA2110

**PORT - RING LOCKED FLUID CONNECTION TYPE,
 STANDARD DIMENSIONS FOR, METRIC**

SHEET 2 OF 2



EXAMPLE OF PORT CODING



DETAIL X

NOTES:

1. RECOMMENDED MIN FULL THREAD DEPTH.
2. DIMENSIONS IN INCHES. DIMENSIONING AND TOLERANCING: ANSI Y14.5M-1982
3. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36 -1978, REQUIREMENTS PER ANSI/ASME B46.1-1985, UNLESS OTHERWISE SPECIFIED. MACHINED SURFACES TO BE 125 MICROINCHES R_a .
4. THE MINIMUM BOSS DIAMETER " T " AND BOSS DEPTH SHOWN ARE SATISFACTORY FOR USE IN MATERIALS THAT EXHIBIT A MINIMUM SHEAR STRENGTH OF 14 ksi AT MAXIMUM TEMPERATURE.

REVISION **NC** 20 MAY 2003

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 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

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SLAS1958

**PORT - FLUID CONNECTION, RING LOCKED
 INSERT, STANDARD DIMENSIONS FOR**


SHEET **1** OF **2**



TABLE I

SIZE CODE	AS1958 PORT NUMBER	NOMINAL TUBE SIZE REF	A THREAD PER AS8879	φ B +.005 -.000	φ C +.002 -.000	D MIN	E ±.005	φ T BOSS DIA MIN 
02	AS1958-02	.125	.4375-28UNJEF-3B	.670	.473	.550	.225	.80
03	AS1958-03	.188	.5000-28UNJEF-3B	.733	.540	.520	.225	.84
04	AS1958-04	.250	.5625-24UNJEF-3B	.795	.603	.565	.225	.92
05	AS1958-05	.312	.6250-24UNJEF-3B	.858	.666	.590	.225	.98
06	AS1958-06	.375	.6875-24UNJEF-3B	.905	.728	.620	.225	1.03
08	AS1958-08	.500	.9375-20UNJEF-3B	1.155	.958	.745	.225	1.40
10	AS1958-10	.625	1.0625-18UNJEF-3B	1.280	1.083	.830	.225	1.60
12	AS1958-12	.750	1.2500-18UNJEF-3B	1.499	1.271	.950	.225	1.83
16	AS1958-16	1.000	1.5000-18UNJEF-3B	1.765	1.521	.950	.225	2.20
20	AS1958-20	1.250	1.8750-16UNJ-3B	2.155	1.922	1.000	.265	2.80

REVISION  20 MAY 2003

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

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

 DIMENSION IN [] ARE MILLIMETERS

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SLAS1958

**PORT – FLUID CONNECTION, RING LOCKED
 INSERT, STANDARD DIMENSIONS FOR**

SHEET 2 OF 2



APPENDIX A INTERNATIONAL SPECIFICATIONS FOR STEELS

STAINLESS STEELS						
USA	France	Europe		Germany	Great Britain	Commercial Specification
		AECMA	EN			
303	Z10CNF18.09			1.4305		
304	Z6CN18.09			1.4301		
(AISI 431) MIL-S-18732	Z15CND17-04 AIR9160	FE-PM 42	2136	1.4044	5S80	A.P.X.
Z8CND17-04 AIR 9160						A.P.X.4
15-5 PH AMS5659		FE-PM 64		1.4546		
17-4 PH AMS 5643	Z6CNU17-04 AIR 9160			1.4548		X 17 U 4
17-7 PH MIL-S-25043						
13-8 Mo AMS5629			1.4534			
		FE-PM 66	prEN 2506		2 S 145	
A 286 AMS5737 (Bars) AMS 5525 (Tubes)	E-Z6NCT25 AIR 9165	FE-PA 92 HT	prEN 2303 pr EN 2304	1.4944 (Bars)	BS HR 51 DTD 5076	
INCONEL 718	NC19FeNb	NI-P 100 HT	prEN 2404	2.4668		
AMS 5662	AIR 9165		prEN 2405			



APPENDIX A INTERNATIONAL SPECIFICATIONS FOR STEELS

STRUCTURAL STEELS						
	30NCD16 AIR 9160					
	E30NCD16 AIR 9160					
(SAE 4135)	35CD4 AIR 9160	FE-PL 45		1.7220	708H37*	
	35NCD16 AIR 9160					
	E35NCD16 AIR 9160					
SAE 4140 MIL-S-5626	40CD4 AIR 9160					
SAE 4130 MIL-S-6758 (Bars) MIL-S-1872 9 (Tubes)	25CD4S AIR 9160	FE-PL 43S	2206	1.7214	S-142 (Bars) S-534 (Tubes)	
SAE 4340 MIL-S-8844 AMS 6414	(40NCD7) AIR 9160			1.6944	817M40* 3S99*	

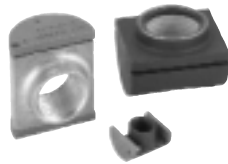
MACHINING STEELS						
12L14 FED-STD66 ASTM-A-108				1.0737		9SMnPb36
1117						
1137						
1140				1.0726		35S20

* For more information, please contact Shur-Lok Corporation at (949) 474-6000.

OTHER SHUR-LOK PRODUCT GROUPS



SANDWICH FASTENERS allow fabrication with sandwich structure material; types include threaded or non-threaded, through or blind, locking or non-locking. Blind inserts for sheet metal applications include: flush or plus flush heads, locking or non-locking. Thermally bonded studs and inserts, with adhesive disk, provide for attachment to composite materials.



BARREL NUTS minimize drilling and eliminate the need for long expensive bolts when attaching heavy structural members in high-tensile applications. This product family includes floating or non-floating, metallic lock or non-metallic lock ring, special designs such as tandem nuts.



BEARING LOCKNUTS are designed for shaft or spindle applications in aircraft engines, gearboxes, and transmissions. Types include the Sta-Lok® positive locking system that minimizes keyway stress and the loss of torque preload, and prevailing torque locknuts with either internal or external threads, metallic or non-metallic lock.



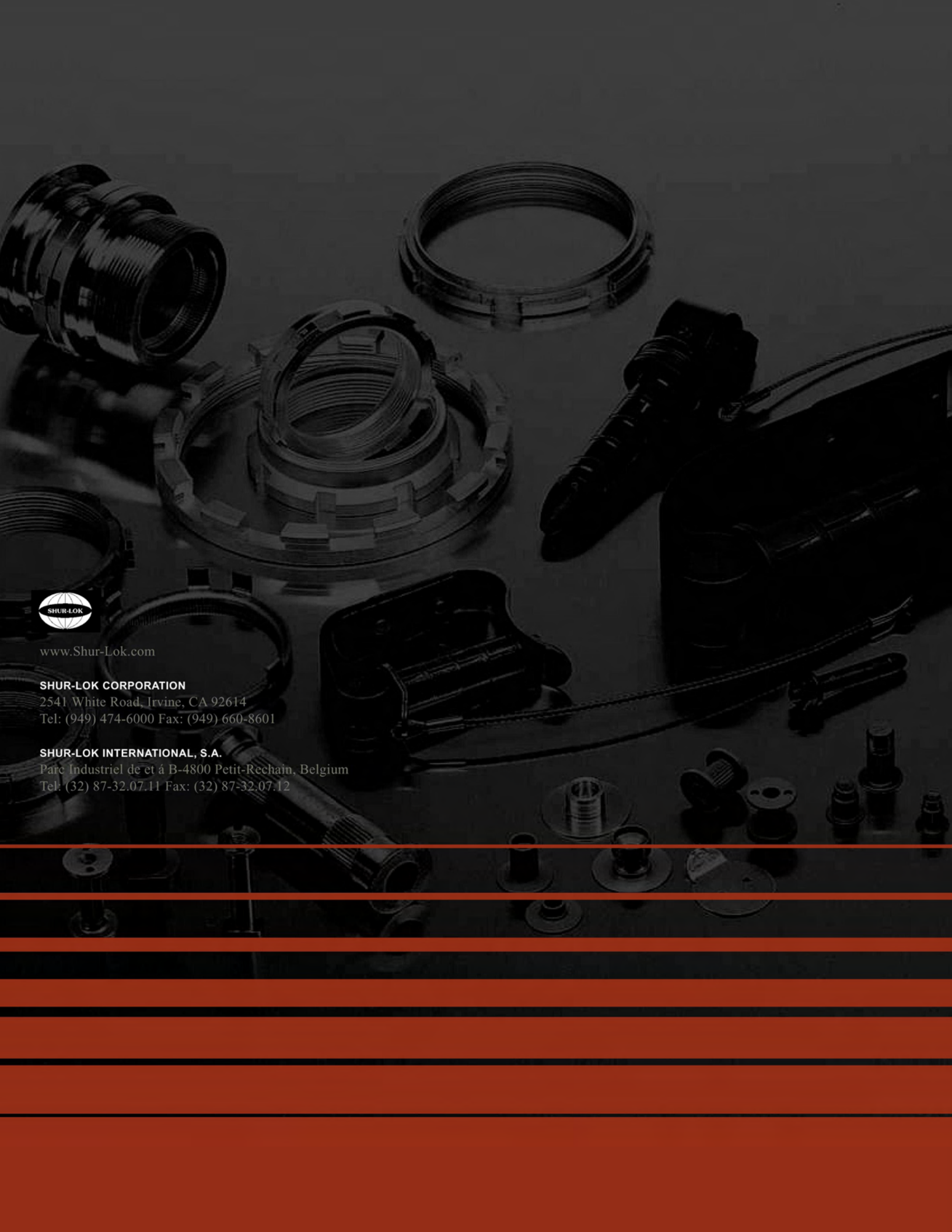
EXPANDABLE DIAMETER FASTENERS are quick-operating and reusable fasteners engineered to expand in the hole to prevent fretting. Typically these fasteners are custom designed for critical applications. Types include cam actuated pins, bolts, blind bolts, and shafts.



RING LOCKED INSERTS & STUDS were designed for resistance to high torque-out and pullout loads. These products utilize a locking that prevents the stud or insert from backing out. These products are ideal for high fatigue and vibration environments found in gearboxes, engines and vehicles.



ISOLATOR MOUNTS are designed to reduce vibration, noise and heat transfer. These neoprene or silicone rubber mount fasteners are available with thread lock or non-thread lock inserts. Special designs offer a quick-release turn receptacle when frequent removal is required.



www.Shur-Lok.com

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