

DETAIL SPECIFICATION SHEET

VALVE, HYDRAULIC BLEEDER

This specification is approved for use by all Departments and Agencies of the Department of Defense.

The requirements for acquiring the product described herein shall consist of this specification sheet.

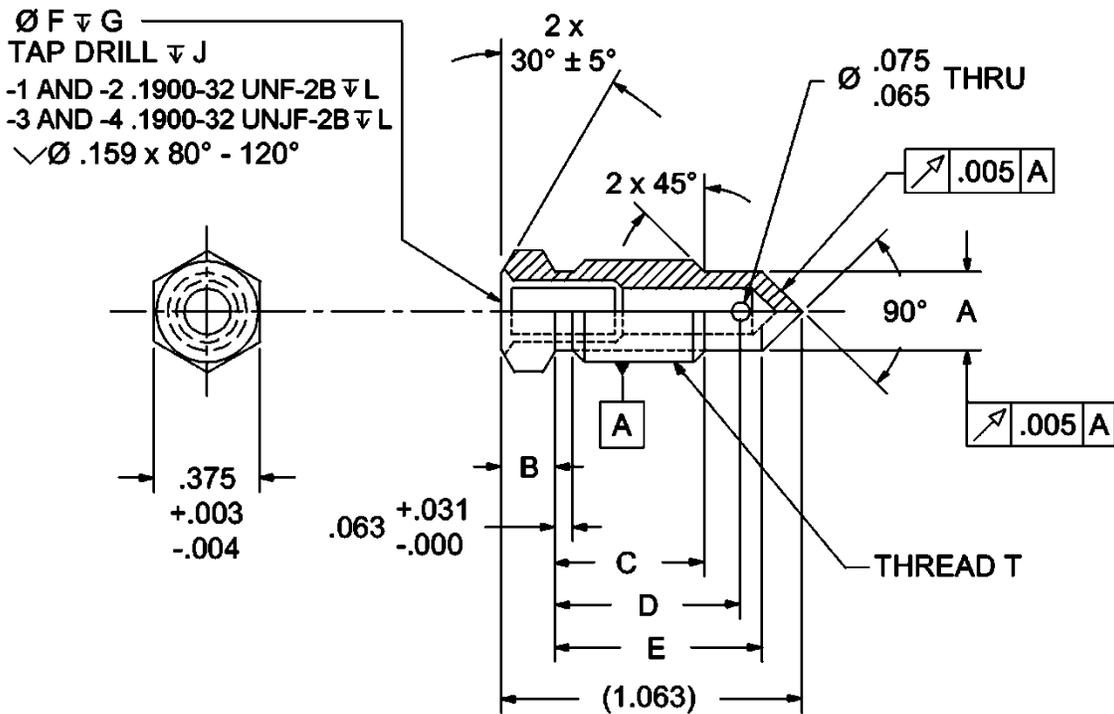


FIGURE 1. Valve dimensions and configuration.

AN6204L

AN6204 Dash number	Thread T	A Dia	B ±.016	C ±.016	D ±.016	E ±.016	F ±.005	G	J ±.016	L ±.016
1 (see note 7)	.3750-24 UNF-2A (see note 8)	.278 ±.005	.188	.563	.656	.734	.159	.906 ±.016	---	---
2 (see note 7)	.2500-28 UNF-2A (see note 8)	+ .000 .190 - .005	.430	.406	.453	.531	.0781	+ .000 .922 - .010	.344	.313
3 (see note 9)	.3750-24 UNJF-3A (see note 10)	.278 ±.005	.188	.563	.656	.734	.159	.906 ±.016	---	---
4 (see note 9)	.2500-28 UNJF-3A (see note 10)	+ .000 .190 - .005	.430	.406	.453	.531	.0781	+ .000 .922 - .010	.344	.313

Inches	mm	Inches	mm
.003	0.08	.2500	6.350
.004	0.10	.278	7.06
.005	0.13	.313	7.95
.010	0.25	.344	8.74
.016	0.41	.375	9.53
.031	0.79	.3750	9.525
.063	1.60	.406	10.31
.065	1.65	.430	10.92
.075	1.91	.531	13.49
.0781	1.984	.563	14.30
.159	4.04	.734	18.64
.188	4.78	.906	23.01
.190	4.83	.922	23.42
		1.063	27.00

NOTES:

1. Dimensions are in inches.
2. Metric equivalents are given for information only.
3. Unless otherwise specified, tolerances $\pm .005$ (0.13 mm), angles $\pm .5^\circ$.
4. Dimensioning and tolerancing in accordance with ASME Y14.5.
5. Break edges .003 to .015 inch (0.08 to 0.38 mm) unless otherwise specified. Remove all hanging burrs and slivers.
6. Surface texture shall be 250 μin R_a for unmachined surfaces, except forging parting lines and 500 μin R_a for forging parting planes in accordance with ASME B46.1.
- 7 Inactive for new design.
- 8 Thread right hand in accordance with ASME B1.1.
- 9 Recommended for new design.
- 10 Threads shall be in accordance with SAE-AS8879.

FIGURE 1. Valve dimensions and configuration - Continued.

AN6204L

REQUIREMENTS:

Materials:

Steel alloy 4140 in accordance with SAE-AMS6349 or SAE-AMS6382.

Corrosion resistant steel (CRES) in accordance with one of the following:

- 321 CRES in accordance with SAE-AMS5645.
- 15-5 PH CRES (UNS 15500) in accordance with SAE-AMS5862, SAE-AMS5659, or ASTM A693.

Age hardening CRES in accordance with ASTM A705/A705M

Heat treat to 155,000 psi (1069 MPa) tensile strength.

Finish: See table I.

TABLE I. Material and plating designators.

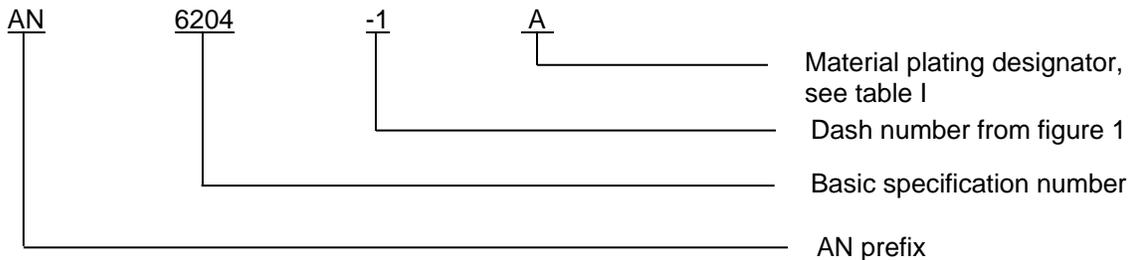
Material and plating designator	Material alloy and plating finish
A	Steel alloy 4140 with cadmium finish in accordance with SAE-AMS-QQ-P-416, type II, class 2, dyed black.
B	CRES no finish.
R	Steel alloy 4140 with zinc plate in accordance with ASTM B633; type VI, Fe/Zn 5.

Finish. Finishes shall be as specified in table I. All plating's shall be capable of meeting a minimum of 96 hours salt spray test in accordance with ASTM B117. The valve shall show no evidence of corrosion after 96 hours of salt spray. Fluid passages, other openings, and internal threads shall not be subject to the plating thickness requirement and may have bare areas provided they are protected with a light film of oil.

OPERATING CHARACTERISTICS

The valve shall be able to function at operating pressure at 3,000 PSI and shall withstand and seal 2,250 psi (16 Mpa) minimum pressure.

Part or Identifying Number (PIN):



PIN example: AN6204-1A is for a hydraulic bleeder valve steel alloy 4140 with cadmium finish for a .3750-24UNF-2A taped hole.

AN6204L

Guidance on use of alternative parts with less hazardous or non-hazardous materials. This specification provides for a number of alternative plating materials via the PIN. Users should select the PIN with the least hazardous material that meets the form, fit, and function requirements of their application.

Order of precedence. Unless otherwise noted herein or in the contract, in the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

Referenced documents shall be of the issue in effect on date of invitations for bid.

Changes from previous issues. Marginal notations are not used in this revision to identify changes with respect to the previous issue due to the extent of the changes.

Referenced document. This document references the following:

ASME B1.1	SAE-AMS-QQ-P-416
ASME B46.1	SAE-AMS5645
ASME Y14.5	SAE-AMS5659
ASTM A693	SAE-AMS5862
ASTM A705/A705M	SAE-AMS6349
ASTM B633	SAE-AMS6382
ASTM B117	SAE-AS8879

CONCLUDING MATERIAL

Custodians:

Army - AV
Navy - AS
Air Force - 99
DLA - CC

Preparing activity:

DLA - CC

(Project 4820-2013-011)

Review activities:

Army - MI
Navy - CG, MC, SA, SH
Air Force - 11, 70, 71

NOTE: The activities listed above were interested in this document as of the date of this document. Since organizations and responsibilities can change, you should verify the currency of the information above using the ASSIST Online database at <https://assist.dla.mil>.