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**REV.
D**

AS14238™

FEDERAL SUPPLY CLASS
3120

RATIONALE

AS14238 REVISION D IS A FIVE-YEAR REVIEW. THIS DOCUMENT HAS BEEN REVISED TO BRING IT UP TO CURRENT SAE STANDARDS.

AS14238D HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

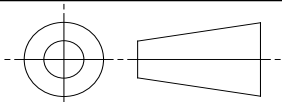
NOTICE

THE INITIAL SAE PUBLICATION OF THIS DOCUMENT WAS TAKEN DIRECTLY FROM U.S. MILITARY STANDARD MS14238. THIS SAE STANDARD MAY RETAIN THE SAME PART NUMBERS ESTABLISHED BY THE ORIGINAL MILITARY DOCUMENT.

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THIRD ANGLE PROJECTION



CUSTODIAN: ACBG

PROCUREMENT SPECIFICATION: NONE



AEROSPACE STANDARD

BUSHING, SLEEVE FLANGED, PRESS FIT,
REAM TYPE

AS14238™
SHEET 1 OF 4

**REV.
D**

ISSUED 1997-08 REVISED 2017-07 REAFFIRMED 2023-01



SIZE DASH NO.	NOM DIA	ØA	ØB	RECM'D HOUSING BORE	INTERFERENCE FIT (REF)	ØC	T ±.002	WEIGHT (REF) (POUND)
-03	.1900	.184 .177	.3142 .3137	.3133 .3125	.0017 .0004	.447 .427	.062	(.009 + .053L _(MAX)) X D
-04	.2500	.243 .235	.3767 .3762	.3758 .3750	.0017 .0004	.510 .490	.062	(.010 + .069L _(MAX)) X D
-05	.3125	.307 .299	.4393 .4388	.4383 .4375	.0018 .0005	.572 .552	.062	(.012 + .082L _(MAX)) X D
-06	.3750	.364 .356	.5020 .5013	.5008 .5000	.0020 .0005	.635 .615	.062	(.014 + .099L _(MAX)) X D
-07	.4375	.428 .421	.5646 .5639	.5634 .5625	.0021 .0005	.697 .677	.062	(.016 + .112L _(MAX)) X D
-08	.5000	.490 .483	.6272 .6264	.6259 .6250	.0022 .0006	.760 .740	.062	(.017 + .126L _(MAX)) X D
-10	.6250	.615 .608	.8150 .8140	.8134 .8125	.0025 .0006	1.010 .990	.094	(.049 + .232L _(MAX)) X D
-10A	.6250	.615 .608	.8150 .8140	.8134 .8125	.0025 .0006	1.010 .990	.062	(.033 + .232L _(MAX)) X D
-12	.7500	.742 .732	.9400 .9390	.9384 .9375	.0025 .0006	1.135 1.115	.094	(.057 + .274L _(MAX)) X D
-14	.8750	.867 .857	1.0651 1.0641	1.0635 1.0625	.0026 .0006	1.260 1.240	.094	(.064 + .315L _(MAX)) X D
-16	1.0000	.992 .982	1.1901 1.1891	1.1885 1.1875	.0026 .0006	1.385 1.365	.094	(.072 + .356L _(MAX)) X D
-18	1.1250	1.117 1.107	1.3151 1.3141	1.3135 1.3125	.0026 .0006	1.510 1.490	.125	(.105 + .396L _(MAX)) X D
-20	1.2500	1.242 1.232	1.4401 1.4391	1.4385 1.4375	.0026 .0006	1.635 1.615	.125	(.115 + .437L _(MAX)) X D

REQUIREMENTS

$$1. \text{ WEIGHT}_{(MAX)} = \pi/4 \times [(C_{MAX}^2 - A_{MIN}^2) \times T_{MAX} + (B_{MAX}^2 - A_{MIN}^2) \times L_{MAX}] \times \text{DENSITY}$$

TABLE 2

MATERIAL	DENSITY LB/IN ³ (REF)
4130 STEEL	.283
17-4PH	.283
ALUMINUM NICKEL BRONZE	.276
COPPER BERYLLIUM	.298

2. MATERIAL:

ALLOY STEEL: 4130 STEEL PER AMS-S-6758, AMS6360, AMS6361, OR AMS6362

CORROSION RESISTANT STEEL: 17-4PH PER AMS5643, PASSIVATE PER AMS2700 (TYPE 8 NOT ALLOWED) OR ASTM A967 CITRIC 1, CITRIC 2 OR CITRIC 3

ALUMINUM NICKEL BRONZE PER AMS4640

COPPER BERYLLIUM PER AMS4534 OR ASTM B196, CONDITION TH04

3. HEAT TREAT:

ALLOY STEEL: 125000 TO 145000 PSI UTS

CORROSION RESISTANT STEEL: 135000 TO 170000 PSI UTS

COPPER BERYLLIUM: 165000 PSI UTS (MINIMUM)

4. FINISH:

(P): CADMIUM PLATE OUTSIDE DIAMETER AND END SURFACES PER AMS-QQ-P-416 TYPE II, CLASS 2. FLASH PERMITTED IN BORE.

(E): ZINC NICKEL PLATE OUTSIDE DIAMETER AND END SURFACES PER AMS2417 TYPE 2, GRADE B. FLASH PERMITTED IN BORE.

(D): ALUMINUM COATING PER MIL-DTL-83488 TYPE II, CLASS 3.

5. PART MARKING:

BAG AND TAG WITH THE SUPPLIER'S NAME, TRADEMARK OR CAGE CODE, BASIC PART NUMBER (LESS MS PREFIX), MATERIAL CODE AND SIZE CODE. PACKAGES SHALL BE MARKED WITH THE SUPPLIER'S NAME, TRADEMARK OR CAGE CODE AND THE COMPLETE PART NUMBER FOR ALL BUSHING SIZES.



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