

SAE Executive Standards Committee Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

SAE reviews each technical report at least every five years at which time it may be revised, reaffirmed, stabilized, or cancelled. SAE invites your written comments and suggestions.

REV.
D

AS1895™/2

RATIONALE

FEDERAL SUPPLY CLASS
5340

GRAPHICS REDRAWN. .710 DIMENSION CHANGED FROM A REFERENCED TO A DEFINED DIMENSION. TABLE 1 REDRAWN TO REMOVE DIMENSIONS FOR DIM A FOR SIZES ABOVE -.325 AND TO ADD 'REF' TO DIM C AND D. NOTE 3 REVISED TO STATE CURRENT QML NOTE. GENERAL UPDATING OF SPECIFICATIONS BEING SPECIFIED HEREIN. CHANGE BAR NOTE REVISED. NOTE 18 ADDED.

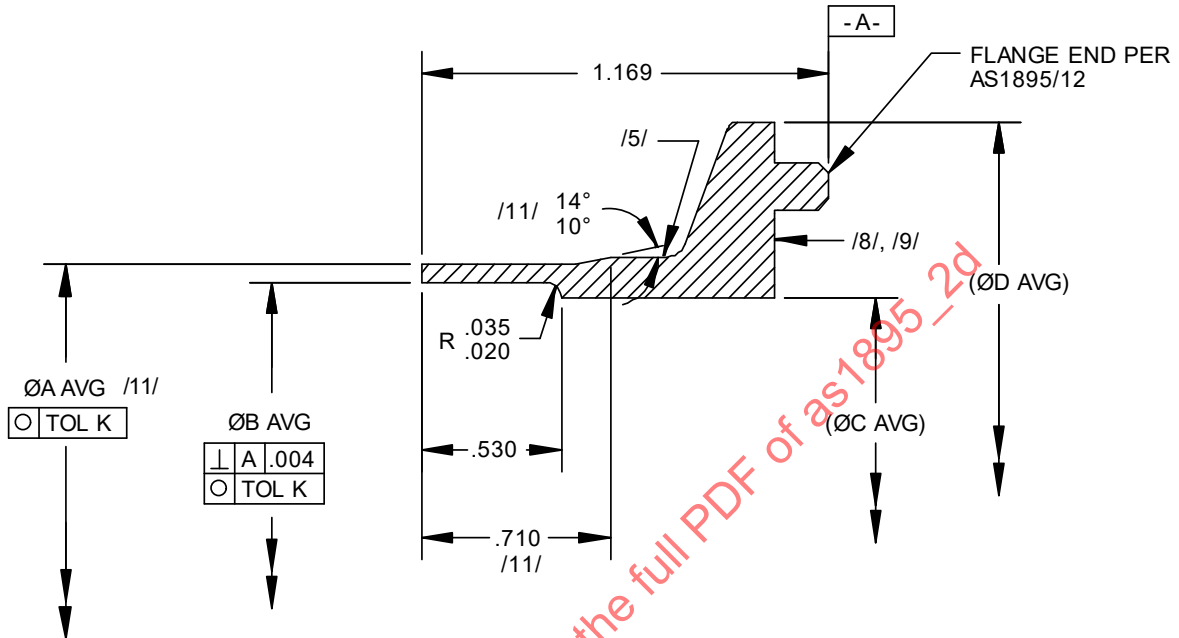
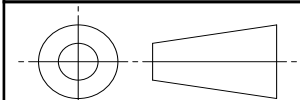


FIGURE 1 - TYPICAL SECTION

For more information on this standard, visit
<https://www.sae.org/standards/content/AS1895/2D/>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3A

PROCUREMENT SPECIFICATION: AS1895 /3/



AEROSPACE STANDARD

FLANGE, MALE, SEAM WELD
TYPE I STANDARD PROFILE

AS1895™/2
SHEET 1 OF 3

REV.
D

TABLE 1 - DIMENSIONS A-K AND WEIGHTS

PART NUMBER	(TUBE SIZE) DIA	A +.000/- .005	B +.005/- .000	C REF	D REF	K	LB/EA MAX
AS1895/2-150	1.50	1.600	1.505	1.450	2.250	.002	.28
AS1895/2-175	1.75	1.850	1.755	1.700	2.500	.002	.32
AS1895/2-200	2.00	2.100	2.005	1.950	2.750	.002	.36
AS1895/2-225	2.25	2.350	2.255	2.200	3.000	.002	.40
AS1895/2-250	2.50	2.600	2.505	2.440	3.250	.003	.45
AS1895/2-275	2.75	2.850	2.755	2.680	3.500	.003	.48
AS1895/2-300	3.00	3.100	3.005	2.920	3.750	.003	.52
AS1895/2-325	3.25	3.350	3.255	3.170	4.000	.003	.57
AS1895/2-350	3.50	/11/	3.505	3.410	4.250	.004	.72
AS1895/2-400	4.00	/11/	4.005	3.900	4.750	.004	.80
AS1895/2-450	4.50	/11/	4.505	4.380	5.250	.005	.92
AS1895/2-500	5.00	/11/	5.005	4.870	5.750	.005	1.03
AS1895/2-550	5.50	/11/	5.505	5.360	6.250	.006	1.14
AS1895/2-600	6.00	/11/	6.005	5.850	6.750	.006	1.25
AS1895/2-650	6.50	/11/	6.505	6.340	7.250	.007	1.37
AS1895/2-700	7.00	/11/	7.005	6.830	7.750	.007	1.49
AS1895/2-750	7.50	/11/	7.505	7.320	8.250	.008	1.61

NOTES:

1. MATERIAL:

- a) DASH NUMBERS 150 THROUGH 350 - NICKEL ALLOY 625 IN ACCORDANCE WITH AMS5666, AMS5599, OR AMS5581.
- b) DASH NUMBERS 400 AND LARGER - NICKEL ALLOY 718 IN ACCORDANCE WITH AMS5596, AMS5662, OR AMS5589 IN THE PRECIPITATE HARDENED CONDITION.

2. FINISH: DESCALED AND FREE OF SURFACE CONTAMINATION.

/3/ PROCUREMENT SPECIFICATION: AS1895 EXCEPT AS SPECIFIED ON THIS STANDARD. PRODUCT MANUFACTURED TO THIS STANDARD SHALL MEET THE REQUIREMENTS SPECIFIED HEREIN AND THE PROCUREMENT SPECIFICATION. ORIGINAL COMPONENT MANUFACTURERS (OCM) AND VALUE ADDED DISTRIBUTORS (VAD) SHALL BE LISTED IN THE NADCAP QUALIFIED MANUFACTURER LIST (QML) FOR THIS PRODUCT TYPE. THE QML IS AVAILABLE AT www.eAuditNet.com.

4. THIS FLANGE, WHEN MATED WITH FLANGE P/N AS1895/3-XXX, FLANGE P/N AS1895/11-XXX OR AS1895/19-XXX, FLANGE END PER AS1895/13-XXX, SEALS P/N AS1895/7-XXX OR AS1895/23-XXX, COUPLING P/N AS1895/1-XXX OR AS1895/22-XXX SHALL MEET ALL THE REQUIREMENTS OF SPECIFICATION AS1895.

/5/ MARKING: MARK FLANGE WITH SUPPLIER IDENTIFICATION AND AS1895/2-XXX PART NUMBER PER AS1895.

6. MAXIMUM VARIATION OF WALL (RADIAL) THICKNESS IN ANY DIAMETRAL PLANE TO BE WITHIN .004 TOTAL.

7. FLANGES ARE DESIGNED FOR SEAM RESISTANCE WELDING TO TUBING IN ACCORDANCE WITH AWS D17.2/D17.2M.

/8/ INTENDED USE: FLATNESS LIMIT AFTER WELDING PER AS1895.

/9/ WORKMANSHIP: THE FLANGES SHALL BE FREE OF SHARP EDGES AND BURRS AND SHALL BE CAPABLE OF MATING UNDER ALL TOLERANCE CONDITIONS OF THE COMPONENT PARTS.

FLANGES SHALL BE FREE OF STREAKS, STAINS, DISCOLORATION, OR DEPOSITS.

SEALING SURFACE SHALL BE FREE OF SCRATCHES AND SURFACE FINISH SHALL BE CIRCULAR AND CONCENTRIC TO BORE DIAMETER.

10. INSPECTION REQUIREMENT - MANUFACTURER: PENETRANT INSPECT ALL FLANGES IN ACCORDANCE WITH ASTM E1417. ACCEPTANCE CRITERIA: .015 DIA MAXIMUM ROUNDED INDICATIONS, NO LINEAR OR CRACK INDICATIONS.

/11/ THIS DIMENSION REQUIRED ONLY FOR SIZES UP TO -325 INCLUSIVE. FOR SIZES OVER -325, DIA A IS STRAIGHT TO THE BACK RADIUS PER AS1895/12 AND DOES NOT REQUIRE ANGLED SURFACE TRANSITION.



AEROSPACE STANDARD

FLANGE, MALE, SEAM WELD
TYPE I STANDARD PROFILE

AS1895™/2
SHEET 2 OF 3

REV.
D