

REV.
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AS624

Submitted for recognition as an American National Standard

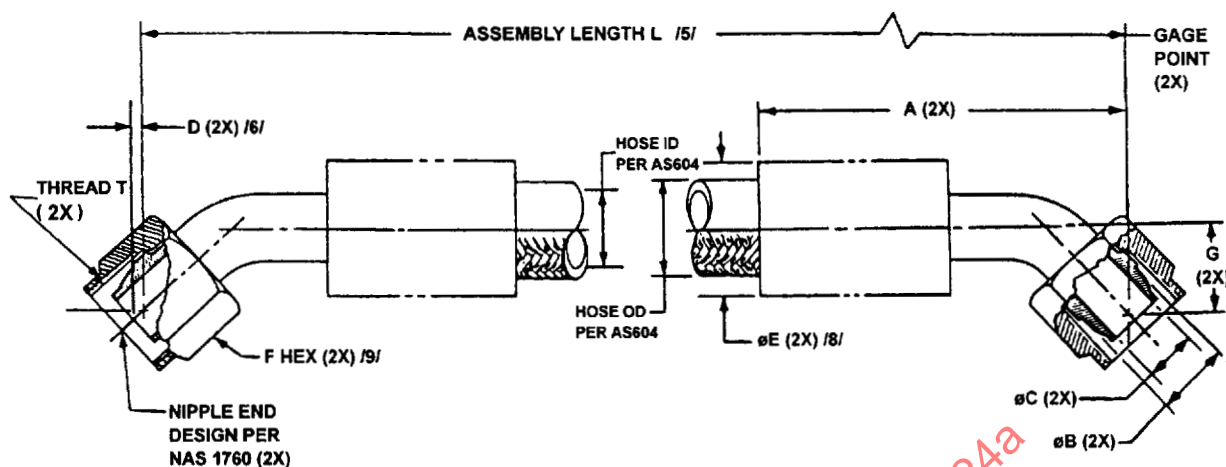
FEDERAL SUPPLY CLASS
4720

FIGURE 1 - HOSE AND FITTING DIMENSIONS

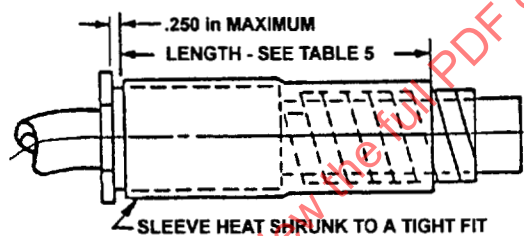


FIGURE 2 - TUBULAR/COIL ABRASION END /10/ /11/

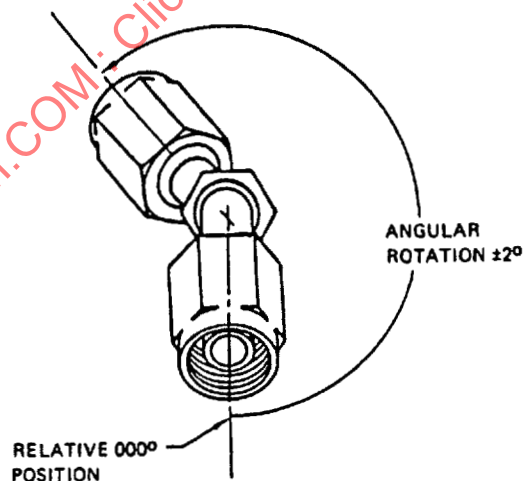


FIGURE 3 - FITTING ANGULAR ORIENTATION /19/

CUSTODIAN: SAE G-3/G-3D

PROCUREMENT SPECIFICATION: AS604 /2/

SAE The Engineering Society
For Advancing Mobility
Land Sea Air and Space
INTERNATIONAL
400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARD(R) HOSE ASSEMBLY, 3000 psi, TFE, FLARELESS,
45° TO 45°, HEAVYWEIGHT**AS624**
SHEET 1 OF 6**REV.**
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TABLE 1 - ASSEMBLY DIMENSIONS

HOSE ASSEMBLY NO. AND SIZE CODE	HOSE ASSEMBLY SIZE (REF)	THREAD T PER MIL-S-8879 (REF)	A MAX	B GAGE BASIC	C // MIN	D (REF)	E MAX WITHOUT SLEEVING	F HEX (REF)
AS624E	.250	.4375-20 UNJF-3B	2.17	.2930	.135	.11	.88	.56
AS624G	.375	.5625-18 UNJF-3B	2.68	.4120	.240	.12	1.00	.69
AS624H	.500	.7500-16 UNJF-3B	3.11	.5600	.340	.13	1.20	.88
AS624J	.625	.8750-14 UNJF-3B	3.59	.6730	.410	.14	1.41	1.00
AS624K	.750	1.0625-12 UNJ-3B	3.67	.8100	.510	.16	1.69	1.25
AS624M	1.00	1.3125-12 UNJ-3B	4.44	1.0620	.760	.21	2.00	1.50
AS624N	1.25	1.6250-12 UNJ-3B	4.65	1.3160	.925	.21	2.13	2.00

TABLE 1 (CONTINUED)

HOSE ASSEMBLY NO. AND SIZE CODE	HOSE ASSEMBLY SIZE (REF)	G MIN	G MAX	INSPECTION BALL SIZE // DIA IN
AS624E	.250	.31	.50	.115
AS624G	.375	.44	.62	.204
AS624H	.500	.50	.75	.289
AS624J	.625	.56	.81	.349
AS624K	.750	.62	.88	.434
AS624M	1.00	.81	1.09	.646
AS624N	1.25	1.24	1.31	.786

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TABLE 2 - HOSE OR SLEEVE OUTSIDE DIAMETER /14/

SLEEVE CODE	SLEEVE MATERIAL	TEMP. LIMIT °F	HOSE SIZE .250	HOSE SIZE .375	HOSE SIZE .500	HOSE SIZE .625	HOSE SIZE .750	HOSE SIZE 1.00	HOSE SIZE 1.25
NONE	(-) INDICATES HOSE ONLY, NO SLEEVE	400	.455 .395	.595 .535	.735 .675	.935 .875	1.090 1.030	1.410 1.350	1.650 1.590
A	ABRASION SLEEVE TUBULAR (TFE-AS1291-CODE B) /10/	400	.540 .468	.715 .635	.855 .770	1.025 .960	1.195 1.125	1.515 1.445	1.825 1.755
B	ABRASION SLEEVE COIL (NYLON AS1294) /11/	275	.509 .413	.684 .584	.809 .733	1.005 .923	1.170 1.088	1.492 1.408	1.750 1.690
C	FIRE SLEEVE (AS1072 SIL-FG) (15 min) /12/ /13/ /18/	400	.688 .562	.875 .750	1.000 .875	1.250 1.125	1.375 1.250	1.750 1.625	2.000 1.875
E	ABRASION SLEEVE SHRINK-ON (FEP) /16/	350	.458 .417	.638 .592	.773 .727	.973 .927	1.148 1.102	1.438 1.392	1.688 1.632
F	ABRASION SLEEVE SHRINK-ON (POLYOLEFIN AS1073 - CODE B) /16/	275	.490 .440	.670 .610	.795 .745	.997 .937	1.174 1.112	1.482 1.428	1.740 1.680
G	FIRE SLEEVE (AS1072 SIL-FG) (5 min) /12/ /13/ /17/	400	.688 .562	.875 .750	1.000 .875	1.250 1.125	1.375 1.250	1.750 1.625	2.000 1.875
H	FIRE SLEEVE INTEGRAL SILICONE (15 min) /18/	400	.700 .640	.880 .820	1.000 .940	1.203 1.143	1.343 1.283	1.656 1.596	1.906 1.846
J	FIRE SLEEVE INTEGRAL SILICONE (5 min) /17/	400	.705 .645	.880 .820	1.005 .945	1.217 1.143	1.382 1.280	1.748 1.593	1.906 1.846
K	INTEGRAL ABRASION SLEEVE (BRAIDED) POLYESTER /15/	300	.505 .480	.675 .645	.795 .765	.985 .955	1.150 1.120	1.470 1.440	1.720 1.680
L	ABRASION SLEEVE COIL (PTFE-AS1293) /11/	400	.522 .449	.692 .622	.817 .747	1.007 .937	1.172 1.102	1.492 1.422	1.750 1.690

TABLE 3 - ASSEMBLY LENGTH TOLERANCE

HOSE ASSEMBLY LENGTH	TOLERANCE
UNDER 18 in	±.125 in
18 TO 36 in, EXCLUSIVE	±.250 in
36 TO 50 in, EXCLUSIVE	±.500 in
50 in AND OVER	±1%

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TABLE 4 - WEIGHTS (NOMINAL)

HOSE OR SLEEVE CODE	HOSE OR TYPE SLEEVE	UNITS	HOSE SIZE .250	HOSE SIZE .375	HOSE SIZE .500	HOSE SIZE .625	HOSE SIZE .750	HOSE SIZE 1.00	HOSE SIZE 1.25
NONE	HOSE ONLY	LB/IN	.012	.028	.040	.062	.086	.140	.154
A	ABRASION SLEEVE (TFE-AS1291-B)	LB/IN	.003	.004	.004	.005	.007	.009	.011
B	ABRASION SLEEVE (NYLON AS1294)	LB/IN	.001	.002	.003	.003	.004	.005	.007
C	FIRESLLEEVE (15 min) AS1072	LB/IN	.007	.010	.011	.015	.017	.021	.025
E	ABRASION SLEEVE (FEP)	LB/IN	.002	.003	.003	.005	.006	.007	.009
F	ABRASION SLEEVE (AS1073B)	LB/IN	.002	.003	.003	.004	.005	.006	.008
G	FIRESLLEEVE (5 min) AS1072	LB/IN	.007	.010	.011	.015	.017	.021	.025
H	FIRESLLEEVE INTEGRAL (15 min) ON HOSE	LB/IN	.022	.042	.056	.081	.102	.154	.190
J	FIRESLLEEVE INTEGRAL (5 min) ON HOSE	LB/IN	.022	.042	.056	.081	.102	.154	.190
K	ABRASION SLEEVE POLYESTER WITH HOSE	LB/IN	.013	.028	.039	.060	.082	.130	.160
L	ABRASION SLEEVE (PTFE-AS1293)	LB/IN	.003	.004	.005	.005	.006	.007	.009
NONE	FIRESLLEEVE CLAMP (*)	LB/EA	.020	.020	.025	.026	.026	.033	.038
NONE	FITTING END (45°) (*)	LB/EA	.078	.130	.221	.327	.597	.860	1.58

(*) NOTE: FIRESLLEEVE CLAMP AND FITTING END ARE IN POUNDS EACH.

TABLE 5 - SLEEVE LENGTH

HOSE SIZE	LENGTH (INCHES)
.250	2.00 ± .25
.375	
.500	2.50 ± .25
.625	
.750	3.00 ± .25
1.00	
1.25	3.50 ± .25