

FED. SUP. CL.
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AS631

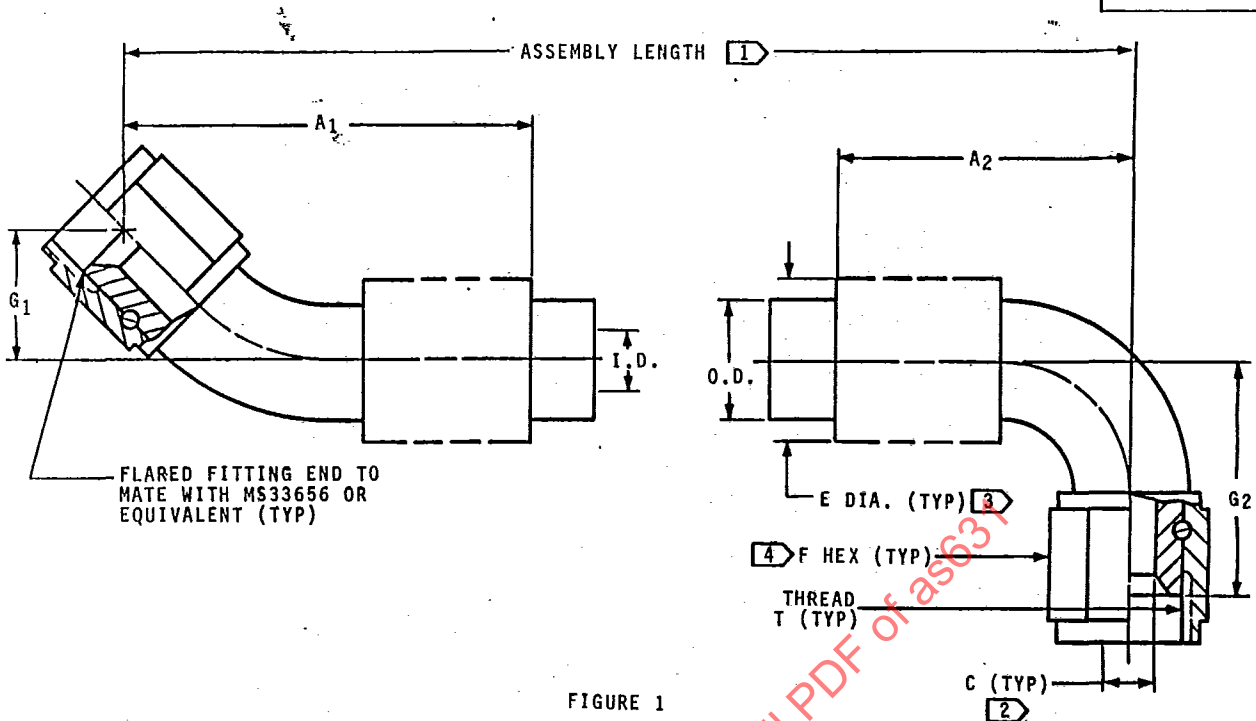


FIGURE 1

DIMENSIONS IN INCHES

TABLE I

HOSE ASSEMBLY NO. AND SIZE CODE	SIZE REF	THREAD T PER MIL-S-8879 REF	I.D. MIN	A ₁ MAX	A ₂ MAX	C ② DRILL DIA MIN	E ③ DIA MAX WITHOUT SLEEVING	F HEX REF	BALL SIZE MIN THRU DIA ②	
									MS19059 DASH NO.	DIA IN.
AS631E	1/4	.4375-20 UNJF-3B	.212	1.79	1.44	.135	.88	.56	4807	.109
AS631G	3/8	.5625-18 UNJF-3B	.298	2.22	1.76	.240	1.00	.69	4812	.188
AS631H	1/2	.7500-16 UNJF-3B	.391	2.49	1.93	.340	1.20	.88	4816	.313
AS631J	5/8	.8750-14 UNJF-3B	.485	2.96	2.29	.410	1.41	1.00	4818	.375
AS631K	3/4	1.0625-12 UNJ -3B	.602	2.99	2.77	.510	1.69	1.25	4821	.469
AS631M	1	1.3125-12 UNJ -3B	.852	3.38	3.28	.760	2.00	1.50	4829	.719
AS631N	1-1/4	1.6250-12 UNJ -3B	1.101	4.50	4.10	.925	2.13	2.00	4834	.875

TABLE I (Cont'd)

HOSE ASSEMBLY NO. AND SIZE CODE	SIZE REF	G ₁		G ₂	
		MIN	MAX	MIN	MAX
AS631E	1/4	.280	.450	.615	.740
AS631G	3/8	.370	.565	.830	.920
AS631H	1/2	.430	.645	.910	1.140
AS631J	5/8	.510	.675	1.110	1.310
AS631K	3/4	.590	.720	1.340	1.500
AS631M	1	.760	.820	1.805	1.865
AS631N	1-1/4	1.120	1.180	2.34	2.400

UPON ADOPTION OF THIS DOCUMENT BY THE MILITARY SERVICES FOR LISTING IN THE DODISS, THE DOCUMENT WILL NOT BE REVISED WITHOUT COORDINATION WITH THE ADOPTING MILITARY AGENCY.

1	---	2	---	3	---	4	---
LIST OF ACTIVE SHEETS							

CUSTODIAN: SAE G-3/G-3D

PROCUREMENT: AS 604

SAE The Engineering Resource For Advancing Mobility
400 COMMONWEALTH DRIVE, WARRENDALE, PA 15096

AEROSPACE STANDARD
HOSE ASSEMBLY, 3000 PSI, TFE, FLARED,
45° TO 90°, HEAVYWEIGHT

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TABLE II

SLEEVE CODE	SLEEVE MATERIAL	TEMP. LIMIT OF	HOSE OR SLEEVE OUTSIDE DIAMETER (MAX-MIN) 5						
			HOSE SIZE						
			1/4	3/8	1/2	5/8	3/4	1	1-1/4
-	(-) 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) 6	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) 7	275	.509 .413	.684 .584	.809 .733	1.005 .923	1.170 1.088	1.492 1.408	1.750 1.690
C	FIRESLEEVE (AS1072 SIL-FG) (15 MIN) 8 9 13	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) 11	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) 11	275	.490 .443	.670 .618	.795 .745	.997 .937	1.174 1.112	1.482 1.428	1.740 1.680
G	FIRESLEEVE (AS1072 SIL FG) (5 MIN) 8 9 12	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	FIRESLEEVE INTEGRAL SILICONE (15 MIN) 13	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	FIRESLEEVE INTEGRAL SILICONE (5 MIN) 12	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 10	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) 7	400	.522 .449	.692 .622	.817 .747	1.007 .937	1.172 1.102	1.492 1.422	1.750 1.690

TABLE III

HOSE ASSEMBLY LENGTH	AVAILABLE INCREMENTS	TOLERANCE
UNDER 18 INCHES	(NOT LESS THAN) .125 INCH	(PLUS OR MINUS) .125 INCH
18 TO 36 INCHES	(NOT LESS THAN) .250 INCH	(PLUS OR MINUS) .250 INCH
36 TO 50 INCHES	(NOT LESS THAN) .500 INCH	(PLUS OR MINUS) .500 INCH
OVER 50 INCHES	(NOT LESS THAN) 1.000 INCH	(PLUS OR MINUS) 1 PERCENT

TABLE IV

HOSE OR SLEEVE CODE	HOSE OR TYPE SLEEVE	UNITS	MAXIMUM WEIGHT LBS/INCH (*)						
			HOSE SIZE						
			1/4	3/8	1/2	5/8	3/4	1	1-1/4
-	HOSE ONLY	LBS/IN	.012	.028	.040	.062	.086	.140	.154
A	ABRASION SLEEVE (TFE-AS1291-B)	LBS/IN	.003	.004	.004	.005	.007	.009	.011
B	ABRASION SLEEVE (NYLON AS1294)	LBS/IN	.001	.002	.003	.003	.004	.005	.007
C	FIRESLEEVE (15 MIN) AS1072	LBS/IN	.007	.010	.011	.015	.017	.021	.025
E	ABRASION SLEEVE (FEP)	LBS/IN	.002	.003	.003	.005	.006	.007	.009
F	ABRASION SLEEVE (AS1073B)	LBS/IN	.002	.003	.003	.004	.005	.006	.008
G	FIRESLEEVE (5 MIN) AS1072	LBS/IN	.007	.010	.011	.015	.017	.021	.025
H	FIRESLEEVE INTEGRAL (15 MIN) ON HOSE	LBS/IN	.022	.042	.056	.081	.102	.154	.190
J	FIRESLEEVE INTEGRAL (5 MIN) ON HOSE	LBS/IN	.022	.042	.056	.081	.102	.154	.190
K	ABRASION SLEEVE POLYESTER WITH HOSE	LBS/IN	.013	.028	.039	.060	.082	.130	.160
L	ABRASION SLEEVE (PTFE-AS1293)	LBS/IN	.003	.004	.005	.005	.006	.007	.009
NONE	FIRE SLEEVE CLAMP (*)	LBS/EA	.020	.020	.025	.026	.026	.033	.038
NONE	FITTING END (45°) (*)	LBS/EA	.075	.135	.220	.306	.584	.820	1.510
NONE	FITTING END (90°) (*)	LBS/EA	.075	.140	.230	.315	.584	.840	1.630

(*) NOTE: FIRESLEEVE CLAMP AND FITTING END ARE IN LBS. EACH

AEROSPACE STANDARD

HOSE ASSEMBLY, 3000 PSI, TFE, FLARED,
45° TO 90°, HEAVYWEIGHT

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CONSTRUCTION AND PERFORMANCE: AS 604. FITTINGS SHALL BE PERMANENTLY ATTACHED TO THE HOSE.

OPERATING CHARACTERISTICS: SEE AS 604.

MATERIALS: HOSE AND FITTINGS - PER AS 604.
SLEEVES - SEE APPLICABLE STANDARD, TABLE II

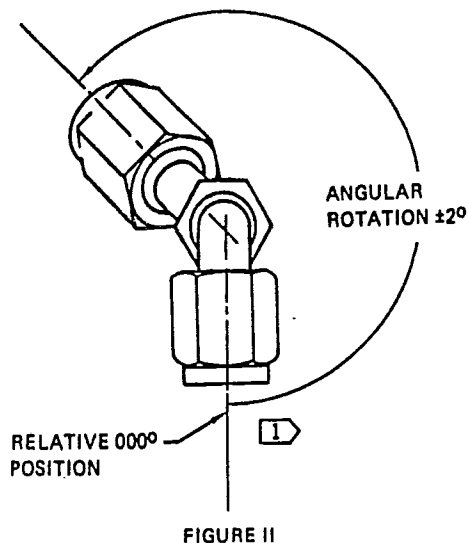
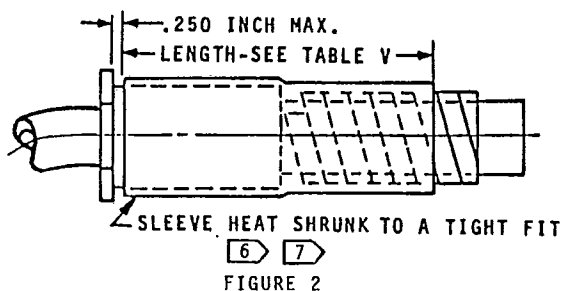
MARKING: MARKING SHALL BE PER AS 604 ON A STAINLESS STEEL BAND NOT OVER 1.0 INCH WIDE, OR ON THE COLLAR. THE CHARACTERS SHALL BE A MINIMUM OF 1/16 INCH HIGH. THE BAND SHALL BE SO DESIGNED AS TO REMAIN TIGHT ON THE HOSE TO PREVENT RELATIVE MOVEMENT AND RESULTANT CHAFING. IT SHALL BE OF SUFFICIENT STRENGTH TO PREVENT REMOVAL BY HAND. HOSE ASSEMBLY DATE AND "PT" SYMBOL SHALL BE ELECTROETCHED OR STAMPED ON THE BAND OR ON AN END FITTING OR A FIRESLEEVE CLAMP.

FLAG NOTES:

- 1 LENGTH "L" IS A THREE DIGIT NUMBER OF WHICH THE FIRST THREE DIGITS DESCRIBE THE HOSE ASSEMBLY LENGTH IN WHOLE INCHES, AND THE THIRD DIGIT, THE FRACTION OF AN INCH IN EIGHTHS. LENGTH "L" IS MEASURED FROM "FACE OF SEAT" TO "FACE OF SEAT." FOR LENGTH INCREMENTS AND TOLERANCES SEE TABLE III.
- 2 A TRUE CIRCULAR CROSS SECTION IS NOT REQUIRED THROUGH THE FITTING I.D. HOWEVER, THE APPLICABLE BALL DIAMETER LISTED IN TABLE I SHALL PASS THROUGH THE END FITTING AFTER IT IS ASSEMBLED TO THE HOSE.
- 3 DISTANCE ACROSS CORNERS OF THE COUPLING NUT MAY EXCEED THIS DIMENSION.
- 4 STANDARD COUPLING NUTS SHALL BE IN ACCORDANCE WITH MS21921 OR MS27073 AND MATE WITH MS33514 FITTING ENDS. NONSTANDARD COUPLING NUTS MAY BE USED, PROVIDED THEY ARE DIMENSIONALLY AND FUNCTIONALLY EQUIVALENT, AND PROVIDED THEY CANNOT BE REMOVED FROM THE FITTING. NUTS SHALL MEET TORQUE TEST REQUIREMENTS PER AS 604.
- 5 DIAMETERS ARE LISTED FOR CLAMP SELECTION. TUBULAR SLEEVES MAY NOT BE A PERFECT ROUND AND SHALL BE MEASURED WITH A DIAMETER TAPE RULER (OFTEN REFERRED TO AS PI-TAPE).
- 6 TUBULAR ABRASION (TFE) SLEEVES SHALL HAVE AN I.D. NO GREATER THAN HOSE O.D. + .05 INCH. AXIAL MOVEMENT OF THE SLEEVE INSTALLED ON THE HOSE SHALL NOT EXCEED .05 INCH. ENDS OF THE TUBULAR SLEEVE SHALL BE TERMINATED WITH A LENGTH OF MIL-I-23053/11 (FEP) CLASS 1 OR 2, COLOR CLEAR, PER TABLE V FIGURE 2.
- 7 COIL ABRASION SLEEVES, WHEN ASSEMBLED ON A STRAIGHT HOSE, SHALL HAVE AN AVERAGE GAP BETWEEN COILS NOT EXCEEDING .05 INCH. DISPLACEMENT OF THE COILS OF THE SLEEVE, CAUSING A GREATER GAP, SHALL NOT BE CAUSE FOR REJECTION IF THE COILS CAN BE REPOSITIONED TO MEET THE GAP REQUIREMENTS. ENDS OF THE COIL SLEEVE SHALL BE TERMINATED WITH A LENGTH OF HEAT SHRINKABLE SLEEVING IN ACCORDANCE WITH TABLE V AND FIGURE 2. CODE "B" (NYLON COIL) ABRASION SLEEVES SHALL BE TERMINATED WITH MIL-I-23053/5, CLASS 1 OR 3, COLOR BLACK. CODE "L" (COIL ABRASION) SLEEVES SHALL BE TERMINATED WITH MIL-I-23053/12A, CLASS 1, COLOR TRANSPARENT, PTFE. (OPTIONAL MIL-I-23053/11 (FEP) CLASS 1 OR 2, COLOR CLEAR).

TABLE V

HOSE SIZE	LENGTH (INCHES)
1/4 3/8	2.00 ± .25
1/2 5/8	2.50 ± .25
3/4 1	3.00 ± .25
1-1/4	3.50 ± .25



AEROSPACE STANDARD

HOSE ASSEMBLY, 3000 PSI, TFE, FLARED,
45° TO 90°, HEAVYWEIGHT

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