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Superseding AS1424C

(R) Hose Assemblies, Metal, Medium Pressure,
High Temperature

1. SCOPE:

This SAE Aerospace Standard (AS) covers medium-pressure, high-temperature, flexible, metal-hose assemblies suitable for continuous operation in pneumatic systems up to 850 °F with short duration excursion to 1200 °F and primarily for use on jet aircraft power plants.

1.1 Types:

Hose assemblies furnished under this document may be of two types:

- a. Type 1: Convolute annular or helical inner tube, welded, seamless, or butt-welded and redrawn, of moderate or light weight, and of moderate or high flexibility.
- b. Type 2: Convolute annular inner tube, seamless or butt-welded and redrawn, of light weight, and of high flexibility.

1.2 Classes:

Hose assemblies furnished under this document may be of the following classes. If no class is defined the class "S" shall be utilized.

- a. Class "A": Corrosion resistant Type 321 convolute inner tube and nickel alloy Type 625 or 718 fitting components.
- b. Class "B": Nickel alloy Type 625 convolute inner tube and nickel alloy Type 625 or 718 fitting components.
- c. Class "N": Nickel alloy Type 625 convolute inner liner and corrosion resistant Type 321 or 347 fitting components.
- d. Class "S": Corrosion resistant Type 321 convolute inner liner and corrosion resistant Type 321 or 347 fitting components.

NOTE: Refer to Table 1 for specific fitting material definition.

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SAE AS1424 Revision D

2. REFERENCES:

2.1 Applicable Documents:

The following publications form a part of this document to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order. In the event of conflict between this document and 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.

2.1.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AMS 5556	Steel, Corrosion and heat Resistant, Seamless or Welded Tubing, 18Cr 11Ni 0.70(Cb+Ta) (SAE 30347), Hydraulic, Solution Heat Treated
AMS 5557	Steel Tubing, Seamless and Welded, Corrosion and Heat Resistant, 18.5Cr 10.5Ni 0.40Ti (SAE 30321), Hydraulic, Solution Heat Treated
AMS 5570	Steel, Corrosion and Heat Resistant, Seamless Tubing, 18Cr 11Ni 0.40Ti (SAE 30321), Solution Heat Treated
AMS 5571	Steel, Corrosion and Heat Resistant, Seamless Tubing, 18Cr 10.5Ni 0.70(Cb+Ta) (SAE 30347), Solution Heat Treated
AMS 5581	Nickel Alloy, Corrosion and Heat Resistant, Seamless or Welded Tubing, 62Ni 21.5Cr 9.0Mo 3.7Cb, Annealed (SAE 06625)
AMS 5589	Nickel Alloy, Corrosion and Heat Resistant, Seamless Tubing 52.5Ni 19Cr 3.0Mo 5.1Cb 0.9Ti 0.5Al 18Fe Consumable Electrode or Vacuum Induction Melted, 1775°F (968°C), Solution Heat Treated (UNS N07718)
AMS 5645	Steel Bars, Forging, Tubing, and Rings, Corrosion Resistant, 18Cr-10Ni-0.40Ti, Solution Heat Treated (SAE 30321)
AMS 5646	Steel Bars, Forging, Tubing, and Rings, 18Cr-11Ni-0.60 (Cb+Ta), Solution Heat Treated (SAE 30347)
AMS 5662	Nickel Alloy, Corrosion and Heat Resistant, Bars, Forgings, and Rings 52.5Ni 19Cr 3.0Mo 5.1Cb 0.9Ti 0.5Al 18Fe Consumable Electrode or Vacuum Induction Melted, 1775°F (968°C), Solution Heat Treated, Precipitation Hardenable (UNS N07718)
AMS 5663	Nickel Alloy, Corrosion and Heat Resistant, Bars, Forgings, and Rings 52.5Ni 19Cr 3.0Mo 5.1Cb 0.9Ti 0.5Al 18Fe Consumable Electrode or Vacuum Induction Melted, 1775°F (968°C), Solution and Precipitation Heat Treated (UNS N07718)
AMS 5666	Nickel Alloy, Corrosion and heat Resistant, Bars, Forgings, Extrusions and Rings, 62Ni 21.5Cr 9.0Mo 3.65(Cb+Ta) (SAE 06625), Annealed
AMS 5680	Steel, Corrosion and Heat Resistant, Welding Wire, 18.5Cr-11Ni-0.40Cb (SAE 30347)
AMS 5689	Steel, Corrosion and Heat Resistant, Wire, 18Cr-10.5Ni-0.40Ti, Solution Heat Treated (SAE 30321)

SAE AS1424 Revision D

2.1.1 (Continued):

AMS 5832	Nickel Alloy, Corrosion and Heat Resistant Welding Wire, 52.5Ni 19Cr 3.0Mo 5.1Cb 0.90Ti 0.50Al 18Fe Consumable Electrode or Vacuum Induction Melted
AMS 5837	Nickel Alloy, Corrosion and Heat Resistant, Welding Wire, 62Ni-21.5Cr-9.0Mo-3.7Cb (SAE 06625)
AMS-QQ-S-763	Steel Bars, Wire Shapes and Forgings, Corrosion Resisting
AMS-STD-2219	Fusion Welding for Aerospace Applications
AMS-H-6875	Heat Treatment of Steels (Aerospace Practice)
AS4395	Fitting End - Flared Tube Connection, Design Standard
ARP908	Hose Fitting - Installation and Qualification Test Torque Requirements
ARP1835	Preparation for Delivery, General Requirements for Hose Assemblies
AS7003	National Aerospace and Defense Contractors Accreditation Program (NADCAP)
AS7112	National Aerospace and Defense Contractors Accreditation Program Requirements for Fluid System Components
AS8879	Screw Threads, Controlled Radius Root with Increased Minor Diameter
AS21921	Nut-Sleeve Coupling, Flareless
AS33514	Fitting End, Standard Dimensions for Flareless Tube Connection and Gasket Seal
AS85421	Fittings, Tube, Fluid Systems, Separable, Beam Seal, 3000/4000 psi, General Specifications for

2.1.2 ASTM Publications: Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

ASTM A 262	Detecting Susceptibility to Intergranular Attack on Stainless Steel
ASTM A 580	Stainless and Heat-Resistant Steel Wire - Type 321 or 347, Condition A
ASTM B 444	Nickel-Chromium-Molybdenum-Columbium Alloys, Pipe and Tube (UNS 06625)

2.1.3 NAS Publications: Available from Aerospace Industries Association, 1250 Eye Street NW, Washington, DC 20005.

NAS 847	Caps and Plugs, Protective, Dust and Moisture Seal
NAS 1760	Fitting End, Flareless Acorn, Standard Dimensions for

2.1.4 U.S. Government Publications: Available from DODSSP, Subscription Services Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.

MIL-STD-810	Environmental Test Methods
MIL-HDBK-831	Preparation of Test Reports

SAE AS1424 Revision D

2.1.5 PRI Publications: Available from Performance Review Institute, 161 Thornhill Road, Warrendale, PA 15086-7527 (www.pri.sae.org).

PD2001	Qualified Product Management Council Procedures for Qualified Products Group
PD2101	Aerospace Quality Assurance, Product Standard, Qualification Procedures, Fluid Systems

2.1.6 AWS Publications: Available from American Welding Society, 550 N.W. LeJeune Road, Miami, FL 33126.

AWS A5.9	Corrosion-resisting chromium & chromium-nickel steel bare & composite metal cored & standard arc welding electrodes & rods
AWS A5.14	Nickel & nickel alloy bare welding rods and electrodes

2.1.7 ASME Publications: Available from ASME, 22 Law Drive, Box 2900, Fairfield, NJ 07007-2900.

ASME Y14.100	Engineering Drawing Practices
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2.2 Hose Assembly Procurement Documents:

Refer to AS1424SUP1 for a listing of applicable hose assembly procurement standards applicable to this document.

3. TECHNICAL REQUIREMENTS:

3.1 Qualification:

Hose assemblies supplied in accordance with this document shall be representative of products which have been subjected to and which have successfully passed the qualification tests specified in this standard.

3.1.1 Manufacturer Qualification: A manufacturer producing a product in conformance to this procurement specification shall be accredited in accordance with the requirements of PD2101, AS7003 and AS7112, and shall be listed in a Performance Review Institute (PRI) Qualified Manufacturers List (QML).

3.1.2 Product Qualification: All products defined in SUP1 shall conform to the requirements of this procurement specification and shall be approved in accordance with the requirements of PD2001, and PD2101, for listing in a Performance Review Institute (PRI) Qualified Parts List (QPL). When this procurement specification is specified on design activity controlled drawings, the approved sources of supply shall be defined by the design activity.

SAE AS1424 Revision D

3.2 Material:

The hose assembly materials shall be uniform in quality, free from defects, suitable for use in continuous ambient and/or fluid temperatures up to 850 °F with short fluid temperature excursions up to 1200 °F, consistent with good manufacturing practices, and in conformance with the applicable specifications and the requirements specified herein. Materials used in these hose assemblies shall be selected from those listed in Table 1. Inner tube physical properties may vary from the requirements of Table 1 as required to achieve a convoluting grade of material.

TABLE 1 - Hose Assembly Materials

Component	Material Description	Specification
Flexible metal hose inner tube	Class "A" or "S" - 321 corrosion resistant steel	AMS 5557 or AMS-QQ-S-763
	Class "B" or "N" - nickel alloy Type 625	AMS 5581 or ASTM B 444
Hose reinforcement wire	321 corrosion resistant steel	ASTM A 580 or AMS 5689
Braid retainers	321 or 347 corrosion resistant steel	AMS 5556, AMS 5557, AMS 5570, AMS 5571, AMS 5645, AMS 5646, or AMS-QQ-S-763
All fitting components	Class "A" or "S" - corrosion resistant steel Type 321 or 347	AMS 5556, AMS 5557, AMS 5570, AMS 5571, AMS 5645, AMS 5646, or AMS-QQ-S-763
	Class "B" or "N" - nickel alloy Type 625 or 718	AMS 5581, AMS 5589, AMS 5662, AMS 5663, or AMS 5666
Nut retaining wire	321 or 347 corrosion resistant steel	ASTM A 580 or AMS-QQ-S-763
Identification bands	300 series corrosion resistant steel	AMS-QQ-S-763

NOTE: Other fitting materials may be qualified providing they meet all of the applicable performance requirements of this specification.

3.3 Design and Construction:

The hose assembly shall consist of a seamless, welded, or welded and redrawn convoluted, stabilized, corrosion-resistant alloy, pressure-carrying tube, uniform in size and wall thickness; reinforced with stabilized, corrosion-resistant steel, braided wire and having stabilized, corrosion-resistant alloy end fittings and nuts. End fittings shall be attached to the hose by welding.

SAE AS1424 Revision D

3.3.1 End Fitting: All standard end fittings shall be a single piece construction from the mating surface to the convoluted tube attachment fitting. If welding is required in construction, welded butt joints shall be used. Fittings shall conform to applicable requirements in Tables 1 and 2. Standard hose assemblies shall have flared end fitting outlet design to mate with AS4395, flareless end fitting outlet dimensional design per NAS 1760 to mate with AS33514 or AS4375, or beam seal end fitting outlet design to mate with AS85421, as applicable.

3.3.1.1 Coupling Nuts: When required, AN818 or AS21921 type coupling nuts or functional equivalents shall be used. Wire retained coupling nuts shall be used to the minimum extent possible, and when used, shall have the retaining wire inserted in a clockwise direction when viewed from the open end of the nut.

3.3.1.2 Screw Threads: All fitting threads shall be Class 3 in accordance with AS8879 (ISO 3161). A thread tolerance increase of 10% after assembly or testing shall not be a cause for rejection.

3.3.2 Hose:

3.3.2.1 Inner Tube Construction: For Type 1 hoses, the inner tube shall be an annular or helical, convoluted flexible tube, made from welded, seamless, or butt-welded and redrawn tubing.

For Type 2 hoses, the inner tube shall be an annular, convoluted flexible tube, made from seamless or butt-welded and redrawn tubing.

Tubing shall be uniform in size and quality and free from pitting, excessive die marks, and other defects. There shall be no inner tube splices on hose assemblies 3 ft in length or less. One splice is allowed for each additional 3 ft increment of hose assembly length. Splices are undesirable but if required, shall be low profile welds in accordance with 3.3.3 and Figure 1. After welding, the convolutes shall be closed as shown in Figure 1.

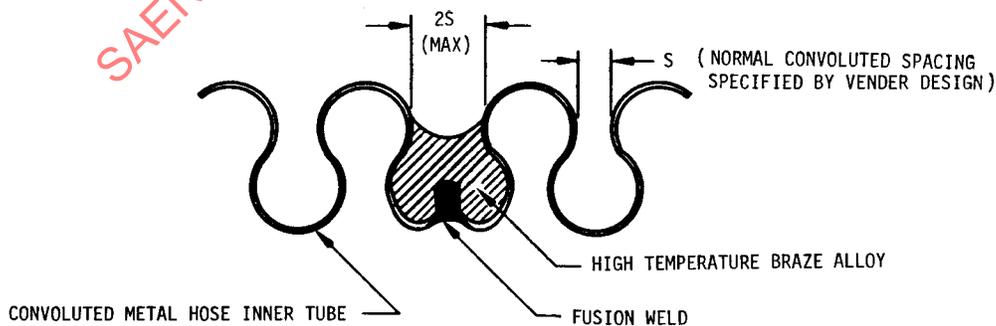


FIGURE 1 - Inner Tube Splice Configuration

SAE AS1424 Revision D

- 3.3.2.2 Braid: Braid shall be of corrosion-resistant steel wire braided in such a manner as to meet the requirements of this document. There shall be no splices allowed in the braid wire.
- 3.3.3 Welding: All pressure welds shall be fusion welds per AMS-STD-2219 Class B and braid attachment weld shall be per Class C. Equivalent or other comparable welding specifications may be substituted on prior approval by the purchaser. Filler wire, if used, shall be per AMS 5680 (Type 347) or AWS 5.9 Class ER347, for welding stainless steel components, and AMS 5837 (nickel alloy), or AWS A5.14 Class ERNiCrMo-3, for welding nickel alloy to nickel alloy, or nickel alloy to stainless steel components. If welding nickel alloy 718 to nickel alloy 718, AMS 5832 nickel alloy filler wire shall be used.

NOTE: When welding CRES 347 material to any other stainless steel, or nickel alloy, material component, appropriate filler wire material shall be used. Any exception to this requirement shall require prior approval from the approval activity based on submittal of appropriate design and process documentation.

- 3.3.4 Heat Treatment: If stress relieving of stainless steel alloy is required to meet the corrosion and Strauss test requirements, the weld joints shall be stress relieved at 1650 °F ± 25 °F for 2 h ± 15 min per AMS-H-6875.

3.4 Dimensions and Weights:

- 3.4.1 Dimensions: Hose assembly dimensions, except for length, shall be as specified in Table 2.

TABLE 2 - Hose and Fitting Dimensions

Hose Size	Rigid Tube OD (Ref)	Hose ID Min	Hose OD Max	Straight Fitting Bore Min	Spherical Ball Size for Determining Minimum Hose Assembly ID ¹ Straight Fitting	Spherical Ball Size for Determining Minimum Hose Assembly ID ¹ Elbow Fitting
04	.250	.23	.56	.141	.127	.120
05	.312	.28	.63	.197	.177	.167
06	.375	.34	.70	.250	.225	.212
08	.500	.45	.86	.360	.324	.306
10	.625	.57	1.00	.455	.410	.387
12	.750	.70	1.15	.568	.511	.483
16	1.000	.95	1.45	.760	.684	.646
20	1.250	1.20	1.75	.920	.828	.782

1. Minimum specified inside diameter through the hose assembly shall be verified by passing the applicable, or larger spherical ball through the assembly.

SAE AS1424 Revision D

3.4.2 Assembly Length and Tolerance: Hose assembly length shall be as specified on the applicable procurement standards or drawing. Flareless hose assemblies with NAS 1760 end terminations shall be measured from gage point to gage point.

Assembly length tolerance shall be as follows:

- a. ± 0.062 in for lengths under 10 in
- b. ± 0.125 in for lengths from 10 to 36 in exclusive
- c. ± 0.250 in for lengths from 36 to 50 in exclusive
- d. $\pm 1\%$ for lengths of 50 in and over

3.4.3 Hose Weight: Hose consisting of inner tube and reinforcement shall not exceed the maximum weight noted in Table 3.

TABLE 3 - Hose Weight, Bend Radius, and Pressures Requirement

Hose Size	Tube Size (Ref)	Hose Weight Max lb/in	Minimum Centerline Bend Radius Static	Minimum Centerline Bend Radius Flexing	Operating Pressure psig Nom Room Temp	Operating Pressure psig Nom 850 °F	Proof Pressure psig Nom Room Temp	Burst Pressure psig Min Room Temp	Burst Pressure psig Min 850 °F
04	.250	.016	2.00	4.00	2000	1320	3000	8000	5280
05	.312	.018	2.50	5.00	1800	1190	2700	7200	4750
06	.375	.020	3.00	6.00	1600	1060	2400	6400	4220
08	.500	.028	4.00	8.00	1400	920	2100	5600	3690
10	.625	.038	4.50	9.00	1200	790	1800	4800	3170
12	.750	.042	5.00	10.00	1050	690	1575	4200	2770
16	1.000	.058	6.00	12.00	800	530	1200	3200	2120
20	1.250	.072	7.00	14.00	550	360	825	2200	1450

NOTES:

1. For pressure rating at other elevated temperatures, multiply data in table by percentage factor from Figure 2 (expressed in decimal equivalent) for desired temperature level.
2. Unless otherwise specified, pressure values shall have a tolerance of $\pm 5\%$.

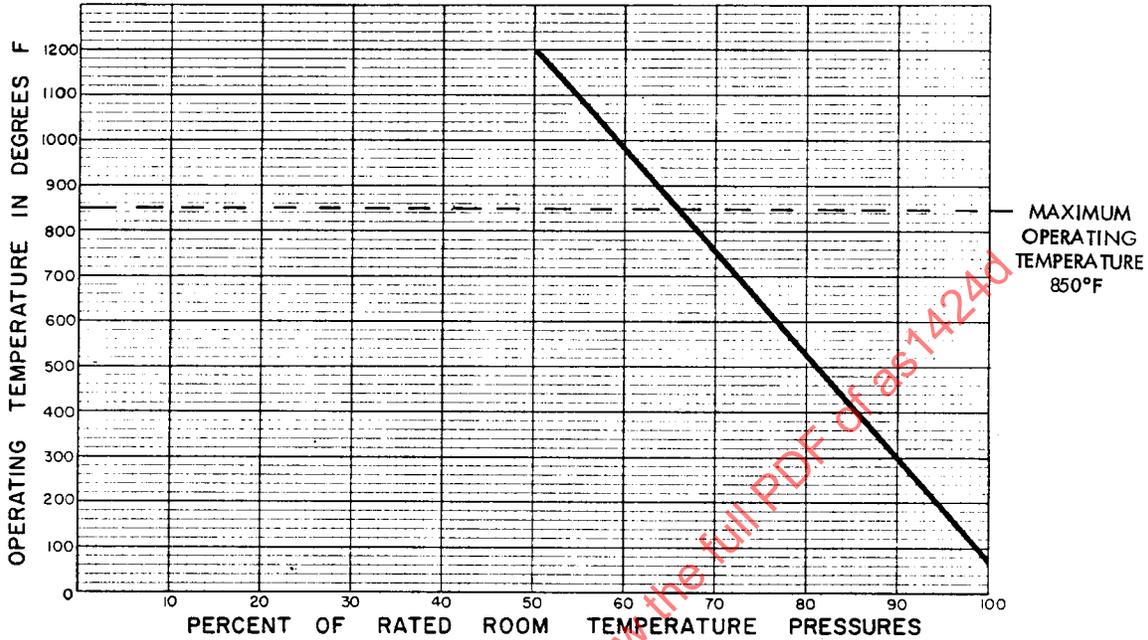


FIGURE 2 - Pressure Correction at Elevated Temperatures

3.5 Performance:

The hose assembly minimum bend radius and operating, proof, and burst pressure ratings, as shown in Table 3, shall be verified by demonstration of meeting or exceeding the following performance requirements through qualification testing as specified herein. Compliance with performance requirements shall be maintained by adherence to the quality assurance provisions as specified herein.

- 3.5.1 Examination of Product: Each assembly must conform dimensionally and materially to the applicable standard or drawing and to all requirements of this document, when examined in accordance with 4.6.1.
- 3.5.2 Proof Pressure: The hose assembly shall withstand the applicable room temperature proof pressure specified in Table 3, without leakage or evidence of permanent deformation or malfunction that would affect hose assembly installation or removal, when assembled with torque values per ARP908 or AS85421, as applicable, and tested in accordance with 4.6.2.
- 3.5.3 Corrosion Test: The hose assembly shall be capable of withstanding the proof pressure requirements of 3.5.2 after 50 immersion cycles in a 3.5% NaCl solution in accordance with 4.6.3.

SAE AS1424 Revision D

- 3.5.4 Vibration: The hose assembly shall have no broken braid wire and shall be capable of withstanding, without leakage, the proof pressure requirements of 3.5.2 after vibration testing in accordance with 4.6.4.
- 3.5.5 Flexure and Pressure Cycling Endurance: The hose assembly shall have no broken braid wire and shall be capable of maintaining operating pressure after 50,000 combination flexure and pressure cycles in accordance with 4.6.5
- 3.5.6 Repetitive Assembly Torque: The fitting shall withstand repetitive assembly tightening torque when tested in accordance with 4.6.6. There shall be no leakage, galling, or other malfunction of the fitting nut and sealing interface connection.
- 3.5.7 Burst Pressure: The hose assembly shall not rupture and shall show no evidence of leakage at any pressure up to the burst pressure specified in Table 3, when tested in accordance with 4.6.7.
- 3.5.8 Strauss Test: There shall be no evidence of fissures or intergranular or transgranular corrosion of the weld specimen when tested in accordance with 4.6.8.
- 3.5.9 High Temperature Torque Test: Solid film lubricated, or silver plated, fitting ends shall not exhibit galling when tested in accordance with 4.6.9.

3.6 Part Numbering of Interchangeable Parts:

All parts having the same manufacturer's part number shall be functionally and dimensionally interchangeable. The item identification and part number requirements of ASME Y14.100 shall govern the manufacturer's part number and changes thereto.

3.7 Identification of Product:

The hose assemblies shall be marked for identification in accordance with the following:

- 3.7.1 Fittings: The manufacturer's name or trademark shall be permanently marked on end-fittings.
- 3.7.2 Assemblies: The hose assemblies shall have all identification marking permanently marked on one end fitting or on a permanently attached corrosion-resistant steel band not more than 1.00 in wide. The marking shall include, but is not limited to, the following:
- Manufacturer's name or trademark and "CAGE" code
 - Complete hose assembly part number
 - Complete "AS" standard number or specification control number
 - "PSI OPR at 850 °F"
 - "PSI OPR at 70 °F"
 - Pressure test symbol "PT"
 - Date of hose assembly manufacture expressed in terms of month and year

SAE AS1424 Revision D

3.8 Workmanship:

The hose assembly, including all parts, shall be constructed and finished in a thoroughly workmanlike manner. All surfaces shall be free from burrs.

3.8.1 Dimensions and Tolerances: All pertinent dimensions and tolerances, where interchangeability, operation or performance of the hose assembly may be affected, shall be specified on the applicable "AS" standard or drawing.

3.8.2 Cleaning: The hose assemblies shall be cleaned according to the general commercial practice of the manufacturer to remove oil, grease, dirt or any other foreign material, both internally or externally to the hose unless otherwise specified on standard or drawing.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Supplier's Responsibility:

The supplier is responsible for the performance of all quality assurance provisions as specified herein. Accurate records of the testing shall be kept by the supplier and shall be available to the purchaser for inspection, on request.

4.1.1 Rejection and Retest: Rejected hose or hose assemblies shall not be submitted for reinspection without furnishing full particulars concerning previous rejection and measures taken to overcome the defects.

4.1.1.1 Defects on Items Already Accepted: If the investigation of the rejection indicates that the defect or defects causing the rejection may exist in hose assemblies previously supplied to the purchaser, the contractor shall advise the purchaser of this condition, the method for identifying these parts and the corrective action or disposition of the defective parts.

4.2 User's Responsibility:

The user shall establish adequate inspection procedures to ensure that all requirements of this document are met. Emphasis shall be placed on the following aspects:

- a. Configuration and end fitting conformance
- b. Length
- c. Marking
- d. Pressure test

SAE AS1424 Revision D

4.3 Classification of Inspections:

The examining and testing of these hose assemblies shall be classified as:

- a. Qualification inspections
- b. Quality conformance inspections

4.4 Qualification Inspections:

The qualification inspections outlined herein are intended to qualify a manufacturer's hose type and class, fitting attachment method, and end fitting construction and outlet design. The hose construction and attachment method used for qualification shall be fully described by the hose assembly manufacturer design standard drawing number and be included in the test report.

All test specimens for each hose size are required for qualifying each of the fitting attachment methods and for each type of end fitting construction and outlet design. Satisfactory completion of qualification on these hose assemblies shall also constitute qualification approval on other hose assemblies that have an identical hose construction, fitting attachment method, and end fitting outlet design.

4.4.1 Test Specimens: Seven flexible metal hose assemblies of each size shall be used for qualifying performance of the manufacturer's product. They shall be standard "AS" series hose assemblies, as defined in Table 4, fabricated according to the manufacturer's assembly drawing(s).

If a supplier qualifies one end fitting outlet design and at a later date desires to qualify another end fitting outlet design, qualification testing to the requirements of 4.4.1.1 shall be performed.

TABLE 4 - Test Specimen Configurations

Specimen No.	Hose Assembly Type	Hose Nominal Tube Size .250	Hose Nominal Tube Size .312	Hose Nominal Tube Size .375	Hose Nominal Tube Size .500	Hose Nominal Tube Size .625	Hose Nominal Tube Size .750	Hose Nominal Tube Size 1.00	Hose Nominal Tube Size 1.25
1	Str.-Str.	L ₁ ¹							
2	Str.-Str.	L ₁ ¹							
3	Str.-90°	12 in							
4	Str.-90°	12 in							
5	Str.-Str.	L ₂ ²							
6	Str.-Str.	L ₂ ²							
7	Str.-Str.	L ₂ ²							

1. Hose assembly length equal to dimension "L₁" of Table 6.
2. Hose assembly length equal to dimension "L₂" of Table 6.

SAE AS1424 Revision D

4.4.1.1 Additional Fitting Outlet Designs: If qualification approval is desired for other type end fitting outlet designs, two additional hose assemblies, utilizing the same hose construction design and fitting attachment method previously qualified, shall be subjected to the following tests in the sequence a through d as indicated. The hose assemblies shall be 12 in length from fitting end to fitting end and incorporate straight to straight fitting construction. If high temperature torque testing is also required, three additional fittings of any size shall be subjected to the testing as noted in e.

- a. Examination of product (see 4.6.1)
- b. Proof pressure test (see 4.6.2)
- c. Repetitive assembly torque test (see 4.6.6)
- d. Room temperature burst test (see 4.6.7)
- e. High temperature torque test (see 4.6.9)

4.4.2 Test Schedule and Sequence: The test specimens shall be subjected to qualification tests in the order indicated in Table 5 (from left to right):

TABLE 5 - Test Schedule and Sequence for Qualification Testing

Specimen No.	Examination of Product 4.6.1	Proof Pressure 4.6.2	Corrosion Test 4.6.3	Proof Pressure 4.6.2	Vibration 4.6.4	Proof Pressure 4.6.2	Flexure Pressure Cycling Endurance 4.6.5	Repeated Torque 4.6.6	Proof Pressure 4.6.2	Burst Pressure 4.6.7	Strauss Test 4.6.8
1	x	x			x	x		x	x	x ¹	
2	x	x			x	x				x ¹	
3	x	x						x	x	x	x
4	x	x						x	x	x	x
5	x	x	x	x	x	x	x ¹				
6	x	x	x	x			x				
7	x	x					x				

1. The assemblies need not meet minimum requirements but all data should be accurately recorded and included in the report.

SAE AS1424 Revision D

4.4.3 Test Report, Test Samples, and Data for the Procuring Activity: When the tests are conducted at a location other than the laboratory of the procuring activity, the following shall be furnished to that activity:

- a. Test Report: The test report shall be written using MIL-HDBK-831 as a guideline and shall include a report of all tests and outline description of the tests and conditions.
- b. Test Samples: Test samples when requested by the procuring activity. Samples subjected to qualification testing shall not be shipped as part of the contract.
- c. Drawings: Three sets of assembly drawings. The assembly drawings may have a cut-away section showing all details in their normal assembly position and shall define all details and subassemblies.
- d. Sources: List of sources of hose, or hose components, including source's name and product identification for the inner tube, braid, and assembly.

NOTE: Log sheets and recorded test data shall remain on file at the source test facility and are not to be sent to the qualifying activity unless specifically requested.

4.5 Quality Conformance Inspections:

Quality conformance inspections shall consist of the following:

- a. Individual tests (100% inspection)
- b. Sampling tests
- c. Periodic control tests

4.5.1 Individual Tests (Functional Tests): Each hose assembly shall be subjected to the following:

- a. Examination of product
- b. Proof pressure test

4.5.2 Sampling Tests: The following tests shall be performed on one straight to straight, 12 inch length, hose assembly, fabricated from bulk inner liner, and braid, selected at random from a production run, when the supplier has manufactured an accumulated total of approximately, but no more than, 3000 hose assemblies all of one dash number size manufactured under essentially the same condition, but not necessarily during one continuous run.

- a. Proof pressure test per 4.6.2
- b. Burst test per 4.6.7
- c. Strauss test per 4.6.8

SAE AS1424 Revision D

4.5.3 Periodic Control Tests: The flexure test in Table 5 shall be performed according to 4.6.5 except the test may be conducted at room temperature on two straight to straight hose assemblies, fabricated from bulk inner liner, and braid, selected at random from a production run, when a supplier has manufactured an accumulated total of approximately, but no more than, 5000 hose assemblies all of one dash number size manufactured under essentially the same condition, but not necessarily during one continuous run.

4.6 Test Methods:

4.6.1 Examination of Product: Hose assemblies shall be visually and dimensionally inspected to determine compliance with the applicable hose assembly standard and examined for compliance with requirements of 4.3.

4.6.2 Proof Pressure Test: Hose assemblies shall be proof pressure tested under water at room temperature to the applicable pressures of Table 3 using air or nitrogen as test medium. Pressure shall be held 5 min minimum. All hose assemblies shall be thoroughly dried after testing. For individual tests (functional tests) only, the pressure shall be held 1 min minimum.

4.6.3 Corrosion Test: Test specimens 5 and 6, as shown in Table 5 shall be subjected to a corrosion test as follows:

- a. Pressurize the hose assembly to the room temperature operating pressure listed in Table 3 and maintain the pressure for steps b through d.
- b. Immerse in 3.5% NaCl solution for 8 to 10 min.
- c. Air dry for remainder of 1 h at room temperature.
- d. Repeat b and c for a total of 50 times.
- e. Proof test assemblies according to 4.6.2.
- f. Without removing salt or cleaning hose, continue testing according to Table 5 sequence.

4.6.4 Vibration Test: Test specimens 1, 2, and 5, as shown in Table 5, shall be subjected to the vibration test. The test specimens shall be mounted as shown in Figures 3 and 3A and pressurized with air or nitrogen to maximum operating pressure at a temperature of 850 °F. Hose temperature must be stabilized at 850 °F ± 25 °F. One end of the specimen shall be fixed and the other end vibrated. Vibration shall be induced in three mutually perpendicular axes, one axis at a time, as follows:

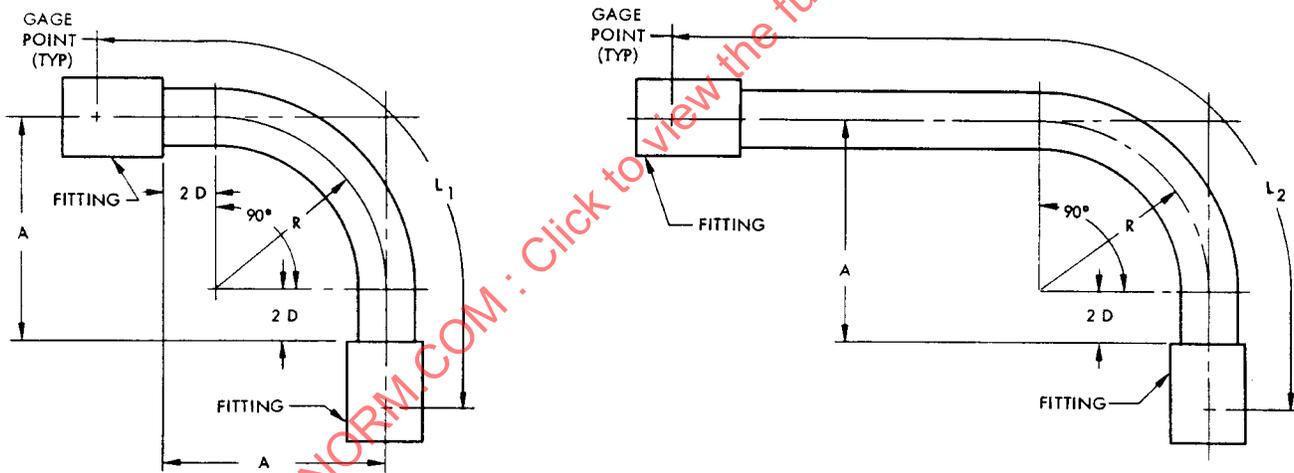
- a. One axis parallel to the plane of the specimen and the centerline of the free end fitting.
- b. One axis parallel to the plane of the specimen and the centerline of the fixed end fitting.
- c. One axis perpendicular to the plane of the specimen.

SAE AS1424 Revision D

TABLE 6 - Specimen Lengths

Hose Size	Tube Size	"L ₁ "	"L ₂ "
04	.250	8.0	21.0
05	.312	9.3	24.5
06	.375	10.5	28.0
08	.500	13.0	35.5
10	.625	15.0	39.5
12	.750	16.5	43.5
16	1.000	19.5	51.5
20	1.250	23.0	59.5

NOTE: Hose assemblies with straight "NAS" type flareless end fittings shall measure from gage point to gage point.



$A = R + 2D$
 $D = \text{Hose OD Max}$
 $R = \text{Static Bend Radius (Table 3)}$

Refer to Table 6 for Dimensions

FIGURE 3 - Vibration Test (4.6.4)
(Test Specimens No. 1 & 2)

FIGURE 3A - Vibration Test (4.6.4)
(Test Specimens No. 5, 6 & 7)