

AS1634

SAE Technical Board rules provide that: "All technical reports, including standards approved and practices recommended, are advisory only. Their use by anyone engaged in industry or trade is entirely voluntary. There is no agreement to adhere to any SAE standard or recommended practice, and no commitment to conform to or be guided by any technical report. In formulating and approving technical reports, the Board and its Committees will not investigate or consider patents which may apply to the subject matter. Prospective users of the report are responsible for protecting themselves against liability for infringement of patents."

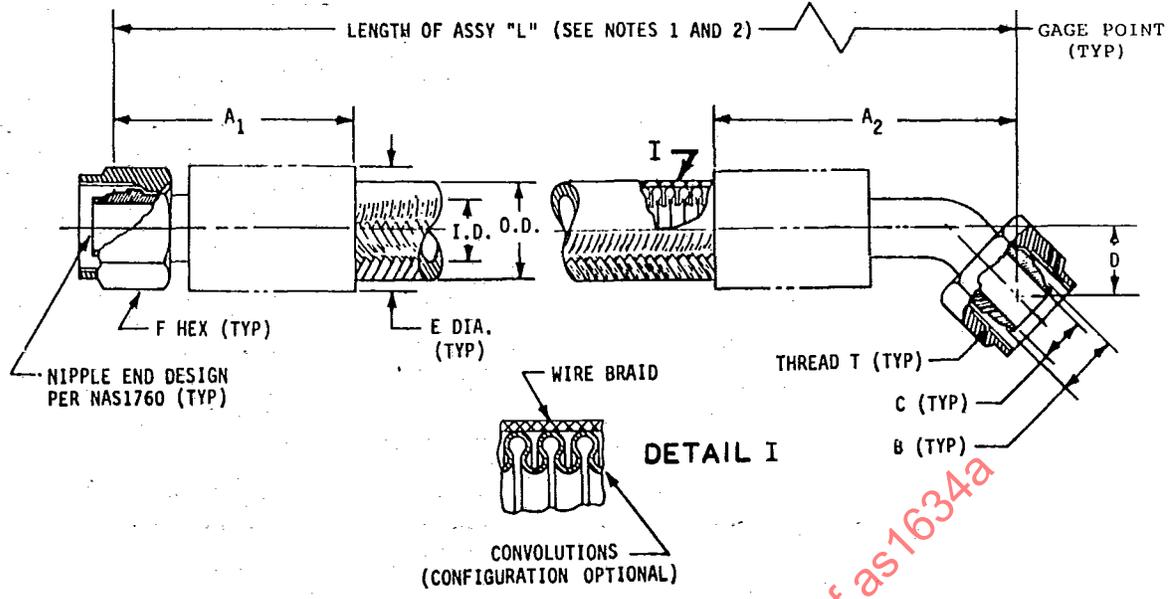


FIGURE 1

TABLE I

HOSE ASSEMBLY NO. AND SIZE CODE	HOSE ASSEMBLY SIZE (REF)	THREAD T PER MIL-S-8879 (REF)	I.D. MIN	A1 MAX	A2 MAX	B GAGE DIA BASIC	C <sup>5</sup> DRILL DIA MIN
AS1634-04	1/4	.4375-20 UNJF-3B	.270	1.11	1.52	.2930	.132
AS1634-06	3/8	.5625-18 UNJF-3B	.355	1.33	1.93	.4120	.256
AS1634-08	1/2	.7500-16 UNJF-3B	.510	1.52	2.16	.5600	.345
AS1634-10	5/8	.8750-14 UNJF-3B	.600	1.71	2.54	.6730	.430
AS1634-12	3/4	1.0625-12 UNJ -3B	.765	1.89	2.87	.8100	.635
AS1634-16	1	1.3125-12 UNJ -3B	.980	2.00	3.19	1.0620	.835
AS1634-20	1-1/4	1.6250-12 UNJ -3B	1.220	2.53	4.02	1.3160	1.085
AS1634-24	1-1/2	1.8750-12 UNJ -3B	1.480	2.69	4.57	1.5650	1.310

TABLE I (Continued)

HOSE ASSEMBLY NO. AND SIZE CODE	HOSE ASSEMBLY SIZE (REF)	D		E <sup>6</sup> DIA MAX WITHOUT SLEEVING	F HEX (REF)
		MIN	MAX		
AS1634-04	1/4	.384	.454	.55	.56
AS1634-06	3/8	.509	.579	.65	.69
AS1634-08	1/2	.567	.637	.86	.88
AS1634-10	5/8	.700	.770	.95	1.00
AS1634-12	3/4	.700	.770	1.28	1.25
AS1634-16	1	.901	.971	1.47	1.50
AS1634-20	1-1/4	1.013	1.083	1.70	2.00
AS1634-24	1-1/2	1.241	1.311	2.00	2.25

TABLE II

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

SHEET	1	2	3	4
REV.	A	A	A	A

CUSTODIAN: SAE G-3/G-3D      PROCUREMENT SPECIFICATION: AS 620

**SAE** The Engineering Resource For Advancing Mobility®

**AEROSPACE STANDARD**  
HOSE ASSEMBLY, CONVOLUTED, TETRAFLUOROETHYLENE, FLARE

**AS1634**  
SHEET 1 OF 4

400 COMMONWEALTH DRIVE, WARRENDALE, PA 15096      Distributed under license from the IHS Archive

Issued 1-15-80      Revised (A) 2-86

AS1634

TABLE III

HOSE OR COVER CODE	HOSE OR TYPE OF PROTECTIVE COVER	HOSE OR COVER O.D. ± .320								UPPER TEMP. LIMIT °F
		HOSE SIZE								
		1/4	3/8	1/2	5/8	3/4	1	1-1/4	1-1/2	
HOSE ONLY		.445	.555	.755	.850	1.060	1.270	1.526	1.790	400
D	SPIRAL ABRASION	.505	.615	.825	.935	1.140	1.330	1.630	1.890	275
D	INTEGRAL ABRASION	.562	.688	.906	1.000	1.203	1.438	1.688	1.937	325
H	INTEGRAL FIRESLEEVE	--	.830	1.010	1.170	1.360	1.510	1.750	2.000	400
H	FIRESLEEVE SIL/FG (AS 1072)	.760	.870	1.030	1.130	1.370	1.630	1.870	2.130	400
K	INTEGRAL ABRASION (BRAIDED) POLYESTER	.500	.630	.840	.920	1.135	1.345	1.600	1.870	300

TABLE IV PHYSICAL REQUIREMENTS OF HOSE ASSEMBLIES

HOSE SIZE (REF)	OPERATING PRESSURE MAX. PSI	PROOF PRESSURE MIN. PSI	BURST PRESSURES		BEND RADIUS AT INSIDE OF BEND INCHES (HOSE ONLY)
			ROOM TEMP MIN. PSI	HIGH TEMP MIN. PSI	
-04	1000	2000	4000	2800	1.25
-06	1000	2000	4000	2800	2.25
-08	1000	2000	4000	2800	2.88
-10	1000	1800	3600	2500	3.00
-12	1000	1800	3600	2500	3.75
-16	1000	1800	3600	2500	5.00
-20	1000	1800	3600	2500	6.25
-24	750	1500	3000	2100	7.50

TABLE V NOMINAL WEIGHT

HOSE SIZE (REF)	HOSE ONLY LBS/IN.	HOSE WITH SLEEVING LBS/IN.					STRAIGHT END FITTING LBS EACH	45° END FITTING LBS EACH	HOSE LENGTH CORRECTION FACTOR-IN. [B]	
		SPIRAL ABRASION CODE B	INTEGRAL ABRASION CODE D	INTEGRAL FIRE-SLEEVE CODE H	TUBULAR FIRE-SLEEVE CODE N	POLYEST. ABRASION CODE K			STR	45°
-06	.010	.014	.017	--	.021	.012	.11	.11	.61	1.18
-08	.015	.020	.025	.032	.030	.018	.18	.18	.80	1.41
-10	.020	.025	.030	.042	.035	.022	.27	.29	.84	1.64
-12	.025	.030	.036	.050	.042	.026	.37	.43	.86	1.82
-16	.030	.036	.050	.055	.054	.035	.56	.65	.99	2.15
-20	.050	.060	.061	.070	.077	.045	.98	1.09	1.11	2.32
-24	.060	.071	.075	.082	.107	.058	1.48	1.63	1.26	2.67

TABLE VI

HOSE SIZE	LENGTH (INCHES)
04	2.00 ±.25
06	
08	2.50 ±.25
10	
12	3.00 ±.25
16	
20	3.50 ±.25
24	

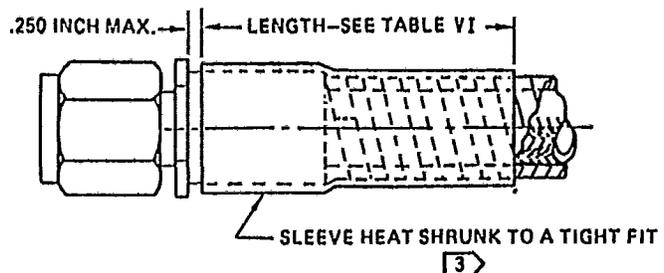


FIGURE 2

(A)

Issued 1-15-80 Revised (A) 2-86

AEROSPACE STANDARD

HOSE ASSEMBLY, CONVOLUTED, TETRAFLUOROETHYLENE, FLARELESS, STRAIGHT TO 45°

AS1634

SH 2

Distributed under license from the IHS Archive

AS1634

CONSTRUCTION AND PERFORMANCE: THESE HOSE ASSEMBLIES SHALL MEET THE CONSTRUCTION AND PERFORMANCE REQUIREMENTS OF AS 620. FITTINGS SHALL BE PERMANENTLY ATTACHED TO THE HOSE.

RATED OPERATING CHARACTERISTICS: SEE AS 620

MATERIALS: HOSE AND FITTINGS - PER AS 620, TYPE II, CLASS 1 OR CLASS 2 AS SPECIFIED BY PART NUMBER.

SPIRAL ABRASION COVER - BLACK, NYLON COIL PER AS 1294.

INTEGRAL FIRESLEEVE COVER - RED OR BROWN, SILICONE.

INTEGRAL ABRASION COVER - BLACK, INTEGRALLY BONDED SILICONE COMPOSITE.

FIRE SLEEVE, TUBULAR - FIBERGLASS SILICONE PER AS 1072.

INTEGRAL ABRASION SLEEVE BRAIDED POLYESTER

MARKING: THE HOSE ASSEMBLIES SHALL HAVE ALL IDENTIFICATION MARKING AS REQUIRED BY AS 620, ELECTRO-ETCHED ON A STAINLESS STEEL BAND NOT MORE THAN 1.0 INCH WIDE. THE CHARACTERS SHALL BE A MINIMUM OF 1/16 INCHES HIGH. THE BAND SHALL BE TIGHT ON THE HOSE BUT WITHOUT PINCHING, AND SHALL BE PERMANENTLY ATTACHED. VARIABLE DATA, SUCH AS MANUFACTURING DATE AND "PT" SYMBOL MAY BE ELECTRO-ETCHED ON ONE END FITTING.

NOTES:

1. LENGTH "L" IS A FOUR DIGIT NUMBER OF WHICH THE FIRST THREE DIGITS DESCRIBE THE HOSE ASSEMBLY LENGTH IN WHOLE INCHES, AND THE FOURTH DIGIT, THE FRACTION OF AN INCH IN EIGHTS. LENGTH "L" IS MEASURED FROM "GAGE POINT" TO "GAGE POINT." SEE TABLE II FOR AVAILABLE LENGTH INCREMENTS AND TOLERANCES.
2. TO CONVERT "GAGE POINT" TO "GAGE POINT" TO "END" TO "END" MEASUREMENT, ADD TO "L" THE APPROPRIATE TABLE VIII CORRECTION FACTOR FOR EACH END FITTING.
3. SPIRAL ABRASION COVER WHEN ASSEMBLED IN THE STRAIGHT CONDITION ON THE HOSE, SHALL HAVE AN AVERAGE GAP BETWEEN SPIRALS NOT EXCEEDING .05 INCH. DISPLACEMENT OF THE SPIRAL COVER, CAUSING A GREATER GAP, SHALL NOT BE CAUSE FOR REJECTION IF THE SPIRALS CAN BE REPOSITIONED TO MEET THE GAP REQUIREMENT. ENDS OF THE SPIRAL COVER SHALL BE TERMINATED WITH A LENGTH OF MIL-I-23053/5 BLACK POLYOLEFIN TUBING PER TABLE VI AND FIGURE 2.
4. INTEGRAL AND POLYESTER ABRASION COVER SHALL FORM AN INTEGRAL, PERMANENT PART OF THE HOSE AND SHALL TERMINATE A MAXIMUM OF .625 INCH FROM THE END OF THE END FITTING COLLAR.
5. A TRUE CIRCULAR CROSS SECTION IS NOT REQUIRED THROUGH THE END FITTING. HOWEVER, THE APPLICABLE BALL DIAMETER LISTED IN TABLE VII SHALL PASS THROUGH THE END FITTING AFTER END FITTING IS ATTACHED TO HOSE ASSEMBLY.
6. DISTANCE ACROSS CORNERS OF COUPLINGS NUT MAY EXCEED THIS DIMENSION.
7. ADD "AS 1055 TYPE IIB CLASS B-S/P" TO IDENTIFICATION MARKING TO SHOW LEVEL OF COMPLIANCE, "FIRE-PROOF" (15 MINTUES), WITH AS 1055.
8. FOR EACH END FITTING, DEDUCT APPROPRIATE LENGTH FACTOR FROM HOSE LENGTH TO DETERMINE ASSEMBLY WEIGHT.
9. STANDARD COUPLING NUTS SHALL BE IN ACCORDANCE WITH MS21921 OR MS27073. NONSTANDARD COUPLING NUTS MAY BE USED BUT SHALL COMPLY WITH THE REQUIREMENT (b) OF NAS1760 FOR NON-STANDARD NUTS AND SHALL BE RETAINED BY THE END FITTING.
10. DO NOT USE UNASSIGNED SIZE CODES OR COVER CODES.
11. THE CODE "D" BLACK SILICONE COMPOSITE ABRASION SLEEVE IS SUPERCEDED FOR NEW DESIGN BY THE IMPROVED CODE "K" POLYESTER ABRASION SLEEVE
12. THE CUT ENDS OF THE FIRESLEEVE SHALL BE COATED WITH RTV SILICONE RUBBER, PRIOR TO INSTALLATION, TO PREVENT WICKING OF FLUIDS. THE FIRESLEEVE ENDS SHALL BE SECURED TO THE HOSE ASSEMBLY END FITTINGS WITH CORROSION RESISTANT STEEL BANDS. AFTER INSTALLATION, CRACKS OR VOIDS IN THE FIRE SLEEVE, WHICH EXPOSE THE FIBERGLASS, SHALL BE COATED WITH RTV SILICONE RUBBER.

(A)

## AEROSPACE STANDARD

HOSE ASSEMBLY, CONVOLUTED,  
TETRAFLUOROETHYLENE  
FLARELESS, STRAIGHT TO 40

AS1634

SH 3