Submitted for recognition as an American National Standard

FEDERAL SUPPLY CLASS 4720

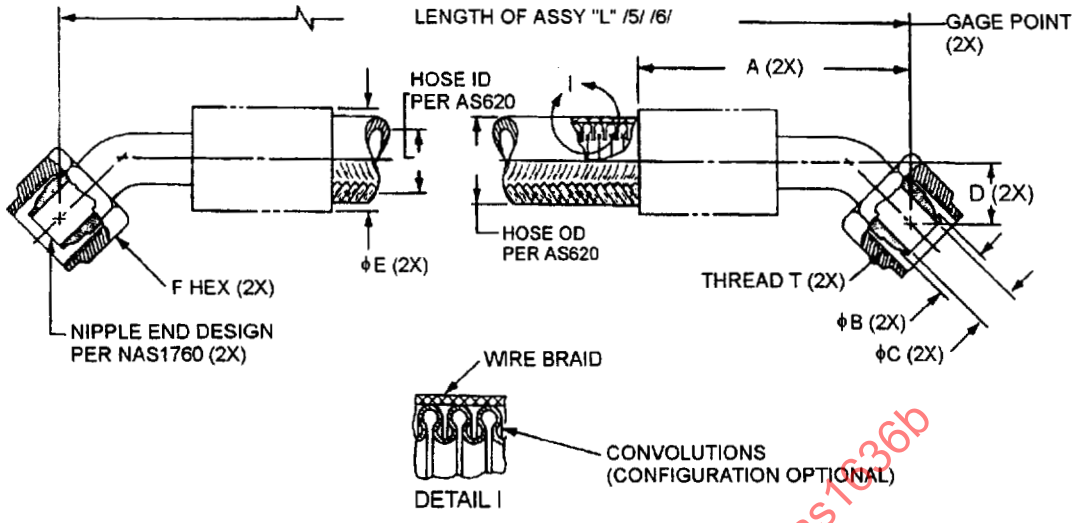

FIGURE 1 - HOSE ASSEMBLY

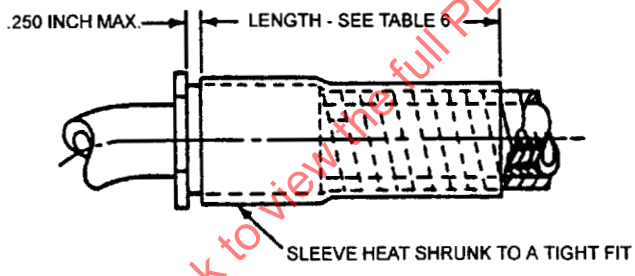

FIGURE 2 - SPIRAL ABRASION COVER /7/

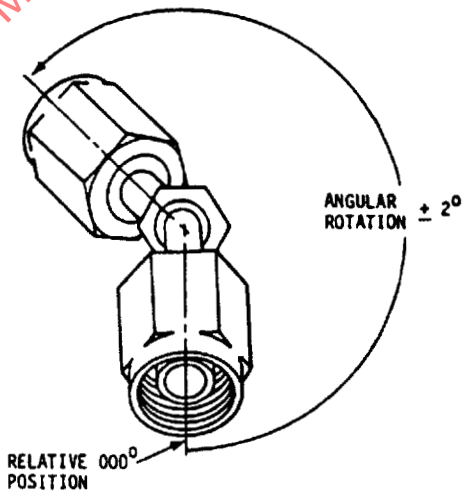

FIGURE 3 - FITTING ANGULAR ORIENTATION /17/

ISSUED 1980-01-15 REVISED 1998-03

CUSTODIAN: SAE G-3/G-3D

PROCUREMENT SPECIFICATION: AS620 /2/

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

AEROSPACE STANDARD

HOSE ASSEMBLY, CONVOLUTED, POLYTETRAFLUOROETHYLENE, METALLIC REINFORCED CONDUCTIVE, FLARELESS, 45° TO 45°

QUESTIONS REGARDING THIS DOCUMENT: (412) 772-8510 FAX: (412) 776-0243
TO PLACE A DOCUMENT ORDER: (412) 776-4970

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 /9/ MIN	D MIN	D MAX	E /10/ MAX WITHOUT SLEEVING	F HEX (REF)
AS1636E	.250	.4375-20 UNJF-3B	1.52	.2930	.132	.384	.454	.55	.56
AS1636G	.375	.5625-18 UNJF-3B	1.93	.4120	.256	.509	.579	.68	.69
AS1636H	.500	.7500-16 UNJF-3B	2.16	.5600	.345	.567	.637	.86	.88
AS1636J	.625	.8750-14 UNJF-3B	2.54	.6730	.430	.700	.770	.95	1.00
AS1636K	.750	1.0625-12 UNJ -3B	2.87	.8100	.635	.700	.770	1.28	1.25
AS1636M	1.00	1.3125-12 UNJ -3B	3.19	1.0620	.835	.901	.971	1.47	1.50
AS1636N	1.25	1.6250-12 UNJ -3B	4.02	1.3160	1.085	1.013	1.083	1.70	1.81
AS1636P	1.50	1.8750-12 UNJ -3B	4.57	1.5650	1.310	1.241	1.311	2.00	2.12

TABLE 2 - 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%

TABLE 3 - HOSE OR COVER OUTSIDE DIAMETER

HOSE OR COVER CODE	HOSE OR TYPE OF PROTECTIVE COVER	HOSE SIZE .250	HOSE SIZE .375	HOSE SIZE .500	HOSE SIZE .625	HOSE SIZE .750	HOSE SIZE 1.00	HOSE SIZE 1.25	HOSE SIZE 1.50	UPPER TEMP. LIMIT °F
NONE	HOSE ONLY PER AS620									
B REF	SPIRAL ABRASION /7/	.505	.615	.825	.935	1.140	1.358	1.630	1.890	275
H ± .032	INTEGRAL FIRESLEEVE /11/	–	.830	1.010	1.170	1.360	1.510	1.750	2.000	400
N REF	FIRESLEEVE SIL/FG (AS1072) /11/ /12/ /13/	.760	.870	1.030	1.130	1.370	1.630	1.870	2.130	400
K ± .032	INTEGRAL ABRASION /8/ (BRAIDED) POLYESTER	.500	.630	.840	.920	1.135	1.373	1.600	1.870	300
J ± .032	INTEGRAL FIRESLEEVE /14/	.685	.795	.995	1.090	1.300	1.530	–	–	400

TABLE 4 - HOSE ASSEMBLIES PHYSICAL CHARACTERISTICS

HOSE SIZE (REF)	OPERATING PRESSURE MAX PSI	PROOF PRESSURE MIN PSI	BURST PRESSURES ROOM TEMP MIN PSI	BURST PRESSURES HIGH TEMP MIN PSI	BEND RADIUS AT INSIDE OF BEND INCHES (HOSE ONLY)
E	1000	2000	4000	2800	1.25
G	1000	2000	4000	2800	2.25
H	1000	2000	4000	2800	2.88
J	1000	1800	3600	2500	3.00
K	1000	1800	3600	2500	3.75
M	1000	1800	3600	2500	5.00
N	1000	1800	3600	2500	6.25
P	750	1500	3000	2100	7.50

TABLE 5 - WEIGHTS (NOM)

HOSE SIZE (REF)	HOSE ONLY LB/IN	HOSE WITH SPIRAL ABRASION COVER CODE B LB/IN	HOSE WITH INTEGRAL FIRESLEEVE COVER CODE H & J LB/IN	HOSE WITH TUBULAR FIRESLEEVE COVER CODE N LB/IN	HOSE WITH POLYESTER ABRASION COVER CODE K LB/IN	45° END FITTING LB EACH	HOSE LENGTH CORRECTION FACTOR-IN /16/ 45°
E	.008	.011	–	.018	.009	.07	.88
G	.010	.014	.028	.021	.012	.11	1.18
H	.015	.020	.032	.030	.018	.18	1.41
J	.020	.025	.042	.035	.022	.29	1.64
K	.027	.032	.050	.044	.028	.43	1.82
M	.033	.039	.055	.057	.038	.65	2.15
N	.050	.060	.070	.077	.045	1.09	2.32
P	.060	.071	.082	.107	.058	1.63	2.67

TABLE 6 - SLEEVE LENGTH

HOSE SIZE	LENGTH (INCHES)
E G	2.00 ± .25
H J	2.50 ± .25
K M	3.00 ± .25
N P	3.50 ± .25

TABLE 7 - MINIMUM INSPECTION BALL SIZE FOR VERIFYING HOSE ASSEMBLY ID /9/

HOSE SIZE	DIA IN
E	.112
G	.218
H	.293
J	.366
K	.540
M	.710
N	.922
P	1.114

TABLE 8 - LENGTH CORRECTION FACTORS

HOSE SIZE (REF)	45° END FITTING
E	.11
G	.12
H	.13
J	.14
K	.16
M	.21
N	.21
P	.26

NOTES:

1. MATERIALS: HOSE AND FITTINGS PER AS620, TYPE II, CLASS 1 OR 2, AS SPECIFIED BY PART NUMBER.
   CODE B, SPIRAL ABRASION COVER, BLACK NYLON COIL PER AS1294
   CODE H AND J, INTEGRAL FIRESLEEVE, RED OR BROWN SILICONE
   CODE N, TUBULAR FIRESLEEVE, FIBERGLASS SILICONE PER AS1072
   CODE K, INTEGRAL ABRASION SLEEVE, BRAIDED POLYESTER

/2/ THIS HOSE ASSEMBLY STANDARD SHALL BE QUALIFIED IN ACCORDANCE WITH PROCUREMENT SPECIFICATION AS620. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.

3. MARKING SHALL BE PER AS620 ON A STAINLESS STEEL BAND NOT OVER 1.0 in WIDE OR ON THE END FITTING COLLAR. THE CHARACTERS SHALL BE A MINIMUM OF .06 in HIGH. THE BAND SHALL BE SO DESIGNED AS TO REMAIN TIGHT ON THE HOSE TO PREVENT RELATIVE MOTION AND CHAFING. IT SHALL BE OF SUFFICIENT STRENGTH TO PREVENT REMOVAL BY HAND.

4. CONSTRUCTION AND PERFORMANCE PER AS620. FITTINGS SHALL BE PERMANENTLY ATTACHED TO HOSE.

/5/ LENGTH "L" IS A THREE DIGIT NUMBER OF WHICH THE FIRST TWO 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 "GAGE POINT" TO "GAGE POINT." SEE TABLE 2 FOR LENGTH TOLERANCES.

/6/ TO CONVERT "GAGE POINT" TO "GAGE POINT" TO "END" TO "END" MEASUREMENT, ADD TO "L" THE APPROPRIATE TABLE 8 CORRECTION FACTOR FOR EACH END FITTING.

/7/ SPIRAL ABRASION COVER WHEN ASSEMBLED IN THE STRAIGHT CONDITION ON THE HOSE, SHALL HAVE AN AVERAGE GAP BETWEEN SPIRALS NOT EXCEEDING .05 in. 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 6 AND FIGURE 2.

/8/ BRAIDED POLYESTER ABRASION COVER SHALL FORM AN INTEGRAL, PERMANENT PART OF THE HOSE AND SHALL TERMINATE A MAXIMUM OF .625 in FROM THE END OF THE END FITTING COLLAR.

/9/ HOSE ASSEMBLY INSIDE DIAMETER SHALL BE VERIFIED BY PASSING THE DESIGNATED, OR LARGER, SPHERICAL BALL PER TABLE 7 THROUGH THE ASSEMBLY.

/10/ DISTANCE ACROSS CORNERS OF COUPLING NUTS MAY EXCEED THIS DIMENSION.

/11/ ADD "AS1055 TYPE IIb CLASS B-S/P" OR "AS150 TYPE IIIbB" TO IDENTIFICATION MARKING TO SHOW LEVEL OF COMPLIANCE, "FIRE-PROOF" (15 min), WITH AS1055 OR AS150.

/12/ THE CUT ENDS OF THE FIRESLEEVE SHALL BE COATED WITH RTV SILICONE RUBBER, OR EQUIVALENT, 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 FIRESLEEVE, WHICH EXPOSE THE FIBERGLASS, SHALL BE COATED WITH RTV SILICONE RUBBER.