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REV. D
AS1655™

FEDERAL SUPPLY CLASS
4730

RATIONALE

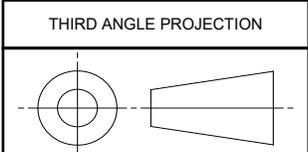
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CUSTODIAN: G-3/G-3A		PROCUREMENT SPECIFICATION: AS1650 /4/	
	AEROSPACE STANDARD		AS1655™
	COUPLING BODY, THREADLESS - FLEXIBLE, FIXED CAVITY, SELF-BONDING		

ISSUED 1992-03 REVISED 2007-07 REAFFIRMED 2013-01 STABILIZED 2024-06

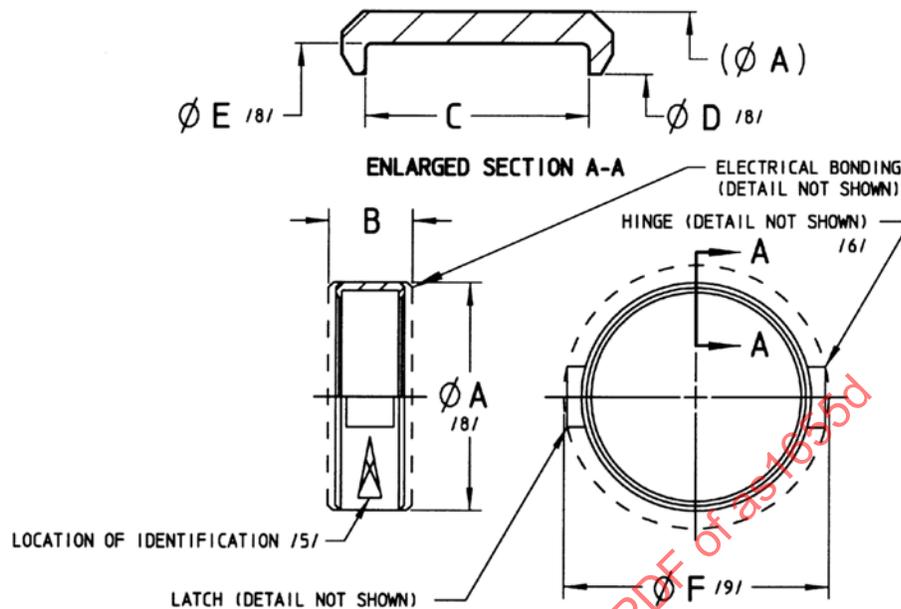


FIGURE 1 - COUPLING BODY

TABLE 1 - DIMENSIONS AND WEIGHTS /6/

BASIC NO. AS1655 /16/ SIZE CODE	NOM TUBE SIZE REF	A		C		D		E	F	LB/EA MAX ALUM	LB/EA MAX CRES	LB/EA MAX TI
		MAX /8/	B MAX	+0.003 -0.007	MAX /8/	MIN /8/	MAX /9/					
08	.500	1.120	.891	.609	.640	.766	1.600	.035	.096	TBD		
10	.625	1.200	.891	.609	.765	.891	1.720	.036	.102	TBD		
12	.750	1.320	.971	.689	.925	1.071	1.850	.044	.121	TBD		
16	1.000	1.540	1.051	.769	1.190	1.347	2.100	.054	.152	TBD		
20	1.250	1.800	1.051	.769	1.440	1.597	2.350	.059	.166	TBD		
24	1.500	2.080	1.051	.769	1.690	1.867	2.600	.066	.186	TBD		
28	1.750	2.300	1.051	.769	1.940	2.118	2.850	.072	.197	TBD		
32	2.000	2.580	1.091	.799	2.193	2.391	3.100	.084	.228	TBD		
36	2.250	2.920	1.091	.799	2.443	2.640	3.350	.097	.274	TBD		
40	2.500	3.080	1.091	.799	2.693	2.891	3.600	.107	.302	TBD		
48	3.000	3.740	1.131	.799	3.193	3.391	4.120	.156	.440	TBD		
56	3.500	4.240	1.131	.799	3.693	3.905	4.620	.188	.530	TBD		
64	4.000	4.840	1.131	.799	4.193	4.411	5.120	.257	.725	TBD		



AEROSPACE STANDARD

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AS1655™
SHEET 1 OF 3

**REV.
D**

NOTES:

/1/ MATERIAL:

- a. CODE LETTER A - TYPE 2024-T351, T6, T851, T8510 OR T8511 ALUMINUM ALLOY PER AMS-QQ-A-225/6, AMS 4120, AMS 4339, AMS-QQ-A-200/3, WW-T-700/3, ASTM B 211 OR ASTM B 241.
- b. CODE LETTER C -
 - 1. TYPE 17-4PH, CONDITION H1075 STA, CORROSION RESISTANT STEEL PER AMS 5643.
 - 2. TYPE 15-5PH, CONDITION H1150 STA, CORROSION RESISTANT STEEL PER AMS 5659.
 - 3. TYPE 303 SERIES, CONDITION A, CORROSION RESISTANT STEEL PER AMS 5638, AMS 5640 OR ASTM A 582.
 - 4. TYPE 304, CONDITION A, CORROSION RESISTANT STEEL PER AMS 5560, AMS 5639, AMS-QQ-S-763 OR ASTM A 376.
- c. CODE LETTER T -
 - 1. TYPE 6AL-4V, CONDITION A, TITANIUM ALLOY PER AMS 4928, AMS 4967 OR AMS-T-9047.
 - 2. TYPE CP-70, CONDITION A, COMMERCIAL PURE TITANIUM PER AMS 4921 OR AMS-T-9047.

2. HEAT TREATMENT:

- a. MATERIAL CODE LETTER A - IF THE RAW MATERIAL IS PROCURED IN THE SOLUTION TREATED CONDITION, AGE TO THE FINAL CONDITION PER AMS-H-6088 OR AMS 2770.
- b. MATERIAL CODE LETTER C -
 - 1. TYPE 17-4PH - AGE TO CONDITION H1075 PER MIL-H-6875 OR AMS 2759/3.
 - 2. TYPE 15-5PH - AGE TO CONDITION H1150 PER MIL-H-6875 OR AMS 2759/3.
 - 3. TYPE 303 SERIES OR 304 - NONE.
- c. MATERIAL CODE LETTER T - NONE.

3. FINISH:

- a. MATERIAL CODE LETTER A - ANODIZE PER AMS 2472, CLASS 2, DYE MAGENTA SIMILAR IN COLOR TO FED-STD-595 NO. 17142 OR MIL-A-8625, TYPE II, CLASS 2, DYE MAGENTA SIMILAR IN COLOR FED-STD-595 NO. 17142, EXCEPT NICKEL ACETATE OR DUPLEX SEALED ONLY.
- b. MATERIAL CODE LETTER C -
 - 1. TYPE 17-4PH OR 15-5PH - PASSIVATE PER AMS2700, METHOD 1, TYPE 2 OR TYPE 8.
 - 2. TYPE 303 SERIES - PASSIVATE PER AMS 2700, METHOD 1, TYPE 2.
 - 3. TYPE 304 - PASSIVATE PER AMS2700, METHOD 1, TYPE 6 OR TYPE 7.
- c. MATERIAL CODE LETTER T - NONE.

/4/ QUALIFICATION: PARTS SHALL BE QUALIFIED TO THE PROCUREMENT SPECIFICATION AS A COMPLETE ASSEMBLY. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEETS OR SIMILAR MEANS.

/5/ IDENTIFICATION: MARK PER AS478-30 USING .062 in OR LARGER CHARACTERS. MARK AS A MINIMUM THE MANUFACTURER'S NAME, TRADEMARK AND/OR CAGE CODE, COMPLETE "AS" NUMBER AND DATE OF MANUFACTURE IN QUARTERS (1Q98 = FIRST QUARTER 1998). SIZES 12 AND SMALLER MAY BE INDIVIDUALLY BAGGED WITH A TAG PER AS478-35D CONTAINING THE PREVIOUS INFORMATION.

	AEROSPACE STANDARD	AS1655™ SHEET 2 OF 3	REV. D
	COUPLING BODY, THREADLESS - FLEXIBLE, FIXED CAVITY, SELF-BONDING		