

RATIONALE

GRAPHICS REDRAWN. CIRCULARITY REQUIREMENT REMOVED FROM REFERENCE ØD AND GAGE ØE. PERPENDICULARITY REQUIREMENT REMOVED FROM REFERENCE ØC. TABLE 1 REDRAWN TO ADD "REF" TO DIM C AND D. NOTE 3 REVISED TO STATE CURRENT QML NOTE. GENERAL UPDATING OF SPECIFICATIONS BEING SPECIFIED HEREIN. CHANGE BAR NOTE REVISED. NOTE 17 ADDED.

REV.  
B

AS1895™/18

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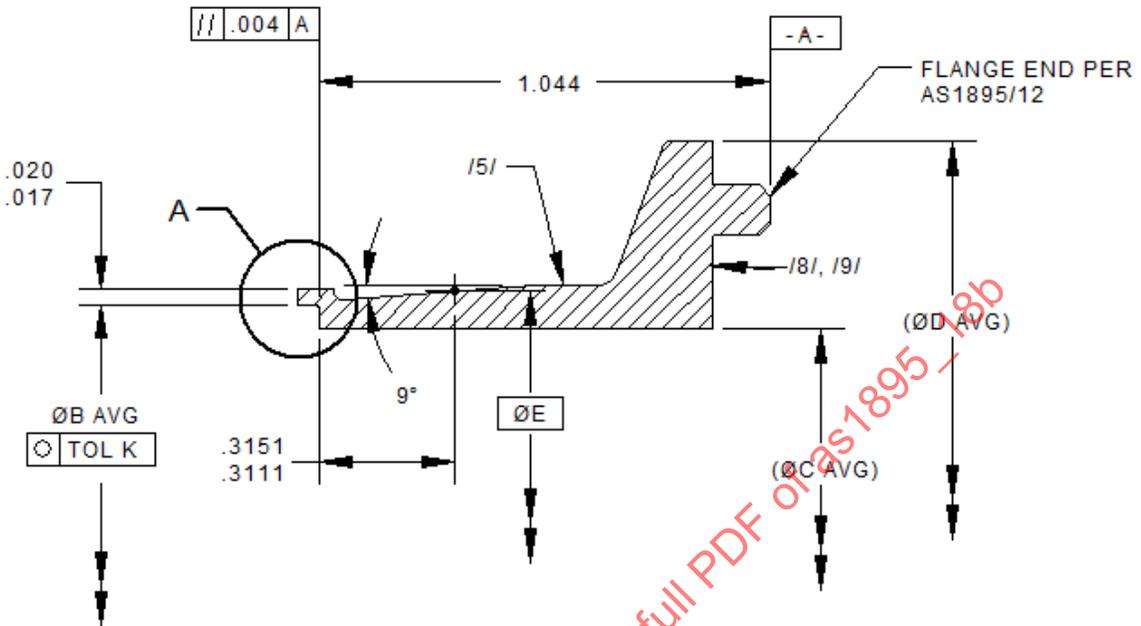
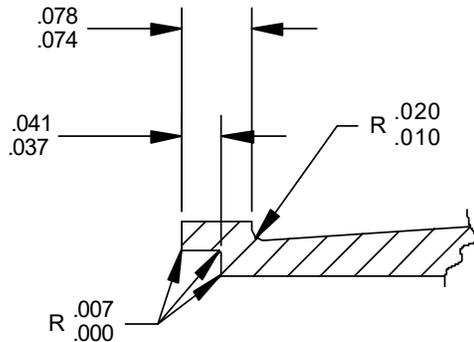


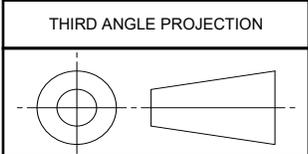
FIGURE 1 - TYPICAL SECTION



ENLARGED VIEW A

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CUSTODIAN: G-3/G-3A

PROCUREMENT SPECIFICATION: AS1895 /3/



**AEROSPACE STANDARD**

FLANGE, MALE, INTEGRAL, WELD RING,  
TYPE I STANDARD PROFILE

**AS1895™/18**  
SHEET 1 OF 3

**REV.  
B**

ISSUED 1992-06 REAFFIRMED 2013-01 REVISED 2021-03

**TABLE 1 - DIMENSIONS B-K AND WEIGHTS**

PART NUMBER	(TUBE SIZE) DIA	B ±.002	C REF	D REF	E	K	LB/EA MAX
AS1895/18-150	1.50	1.504	1.450	2.250	1.592	.002	.33
AS1895/18-175	1.75	1.754	1.700	2.500	1.842	.002	.38
AS1895/18-200	2.00	2.004	1.950	2.750	2.092	.002	.42
AS1895/18-225	2.25	2.254	2.200	3.000	2.342	.002	.47
AS1895/18-250	2.50	2.504	2.440	3.250	2.592	.003	.52
AS1895/18-275	2.75	2.755	2.680	3.500	2.842	.003	.58
AS1895/18-300	3.00	3.005	2.920	3.750	3.093	.003	.63
AS1895/18-325	3.25	3.255	3.170	4.000	3.343	.003	.69
AS1895/18-350	3.50	3.505	3.410	4.250	3.593	.004	.74
AS1895/18-400	4.00	4.005	3.900	4.750	4.093	.004	.84
AS1895/18-450	4.50	4.505	4.380	5.250	4.593	.005	.95
AS1895/18-500	5.00	5.005	4.870	5.750	5.093	.005	1.07
AS1895/18-550	5.50	5.505	5.360	6.250	5.593	.006	1.17
AS1895/18-600	6.00	6.005	5.850	6.750	6.093	.006	1.29
AS1895/18-650	6.50	6.505	6.340	7.250	6.593	.007	1.41
AS1895/18-700	7.00	7.005	6.830	7.750	7.093	.007	1.53
AS1895/18-750	7.50	7.505	7.320	8.250	7.593	.008	1.65

NOTES:

1. MATERIAL:

- a. DASH NUMBERS 150 THROUGH 350: NICKEL ALLOY 625 IN ACCORDANCE WITH AMS5666, AMS5599, OR AMS5581.
- b. DASH NUMBERS 400 AND LARGER: NICKEL ALLOY 718 IN ACCORDANCE WITH AMS5596, AMS5662, OR AMS5589 IN THE PRECIPITATE HARDENED CONDITION.

2. FINISH: DESCALED AND FREE OF SURFACE CONTAMINATION

/3/ PROCUREMENT SPECIFICATION: AS1895, EXCEPT AS SPECIFIED ON THIS STANDARD. PRODUCT MANUFACTURED TO THIS STANDARD SHALL MEET THE REQUIREMENTS SPECIFIED HEREIN AND THE PROCUREMENT SPECIFICATION. ORIGINAL COMPONENT MANUFACTURERS (OCM) AND VALUE ADDED DISTRIBUTORS (VAD) SHALL BE LISTED IN THE NADCAP QUALIFIED MANUFACTURER LIST (QML) FOR THIS PRODUCT TYPE. THE QML IS AVAILABLE AT [www.eAuditNet.com](http://www.eAuditNet.com).

4. THIS FLANGE, WHEN MATED WITH FLANGE END PER AS1895/13-XXX, FLANGE P/N AS1895/3-XXX, FLANGE P/N AS1895/11-XXX OR AS1895/19-XXX, SEALS P/N AS1895/7-XXX OR AS1895/23-XXX, AND COUPLINGS P/N AS1895/1-XXX OR AS1895/22-XXX SHALL MEET ALL THE REQUIREMENTS OF SPECIFICATION AS1895.

/5/ MARKING: MARK FLANGE WITH SUPPLIER IDENTIFICATION AND AS1895/18-XXX PART NUMBER PER AS1895.

6. MAXIMUM VARIATION OF WALL (RADIAL) THICKNESS IN ANY DIAMETRAL PLANE TO BE WITHIN .004 TOTAL.

7. FLANGES ARE DESIGNED FOR FUSION WELDING TO TUBING IN ACCORDANCE WITH AWS D17.1/D17.1M.

/8/ INTENDED USE: FLATNESS LIMIT AFTER WELDING PER AS1895.

/9/ WORKMANSHIP: THE FLANGES SHALL BE FREE OF SHARP EDGES AND BURRS AND SHALL BE CAPABLE OF MATING UNDER ALL TOLERANCE CONDITIONS OF THE COMPONENT PARTS.

FLANGES SHALL BE FREE OF STREAKS, STAINS, DISCOLORATION, OR DEPOSITS.

SEALING SURFACE SHALL BE FREE OF SCRATCHES AND SURFACE FINISH SHALL BE CIRCULAR AND CONCENTRIC TO BORE DIAMETER.

10. INSPECTION REQUIREMENT - MANUFACTURER: PENETRANT INSPECT ALL FLANGES IN ACCORDANCE WITH ASTM E1417. ACCEPTANCE CRITERIA: .015 DIA MAXIMUM ROUNDED INDICATIONS, NO LINEAR OR CRACK INDICATIONS.

	<b>AEROSPACE STANDARD</b>		<b>AS1895™/18</b> SHEET 2 OF 3	<b>REV.</b> <b>B</b>
	FLANGE, MALE, INTEGRAL, WELD RING, TYPE I STANDARD PROFILE			