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REV. J  
AS1895™/1

RATIONALE

FEDERAL SUPPLY CLASS  
5340

INTRODUCE OPTIONAL MARKING CODE FOR IMPROVED LEGIBILITY. REPLACE NOTE /16/ WHICH CURRENTLY SPECIFIES TO USE DRY FILM LUBRICANT ON NUTS WHERE THEIR ENVIRONMENT WOULD BE ABOVE 1000 °F BY THE NOTE TO ADD CODE LETTER "L" WHEN NUTS REQUIRE DFL. REASON: CURRENTLY, BOTH SILVER PLATED AND DFL NUTS ALREADY MEET THE 1200 °F TEMPERATURE REQUIREMENT OF THE PROCUREMENT SPECIFICATION, AS1895.

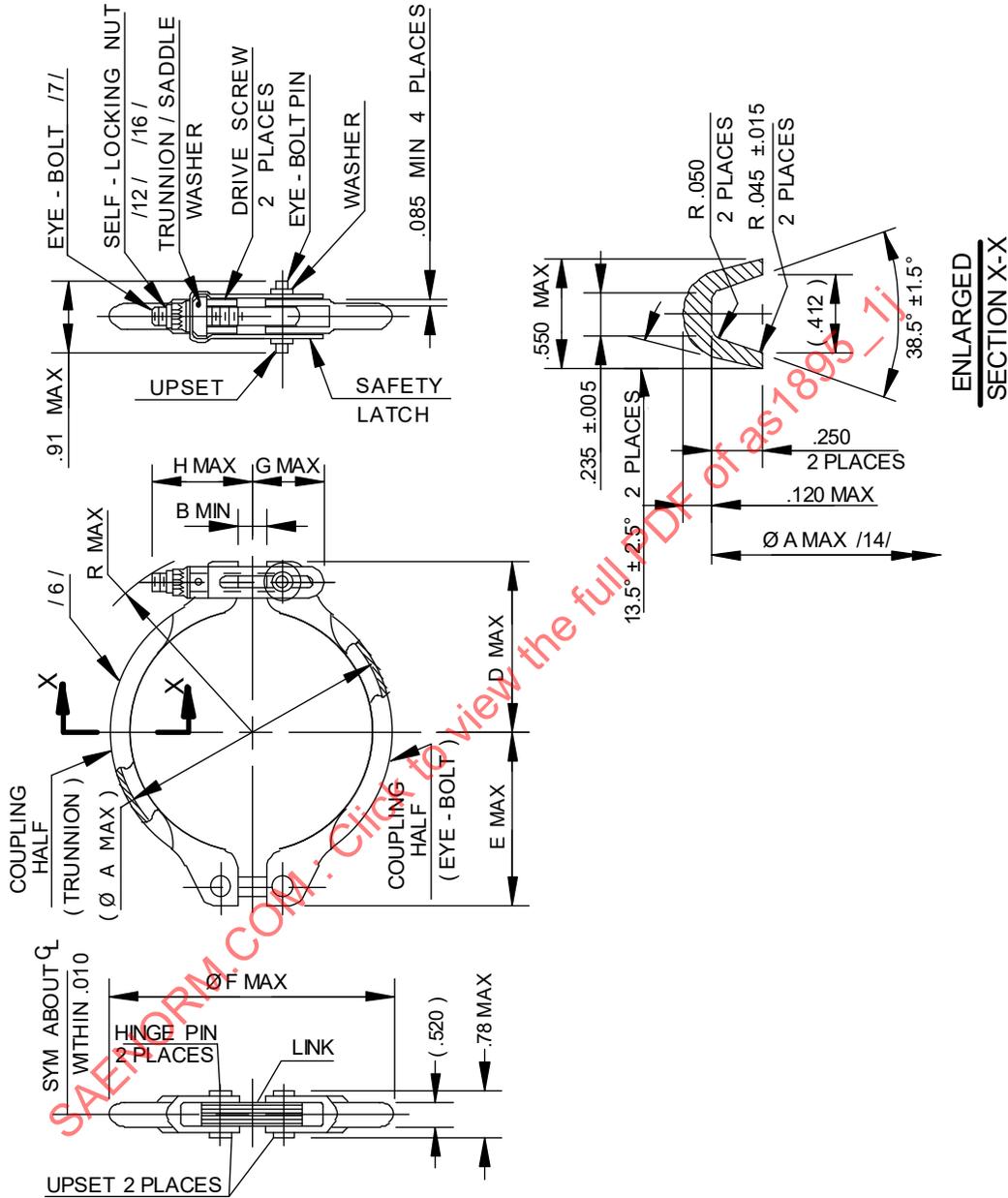
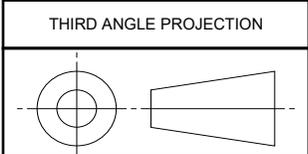


FIGURE 1 - STANDARD PROFILE COUPLING

For more information on this standard, visit <https://www.sae.org/standards/content/AS1895/1/J/>



CUSTODIAN: G-3/G-3A

PROCUREMENT SPECIFICATION: AS1895 /3/



**AEROSPACE STANDARD**

COUPLING, V-RETAINER, SINGLE LATCH,  
TYPE I STANDARD PROFILE

AS1895™/1  
SHEET 1 OF 5

REV. J

**TABLE 1 - DIMENSIONS AND WEIGHTS**

BASIC NUMBER AS1895/1 SIZE CODE /1/ /2/ /17/	(TUBE SIZE)	A	B	D	E	F	G	H	R	LB/EA MAX
150	1.50	2.385	.100	1.843	1.780	2.656	.968	1.410	2.126	.40
175	1.75	2.635	.150	1.880	1.857	2.906	.875	1.425	2.250	.41
200	2.00	2.885	.175	2.093	2.030	3.156	.898	1.450	2.360	.42
225	2.25	3.135	.175	2.130	2.107	3.406	.898	1.450	2.485	.44
250	2.50	3.385	.190	2.343	2.280	3.656	.925	1.475	2.569	.46
275	2.75	3.635	.190	2.468	2.410	3.906	.984	1.525	2.700	.49
300	3.00	3.885	.190	2.593	2.530	4.156	1.000	1.550	2.824	.51
325	3.25	4.135	.190	2.630	2.607	4.406	1.024	1.575	2.950	.54
350	3.50	4.385	.190	2.755	2.780	4.656	1.059	1.550	3.058	.57
400	4.00	4.885	.250	3.015	2.972	5.156	1.024	1.575	3.263	.63
450	4.50	5.385	.250	3.265	3.222	5.656	1.109	1.600	3.519	.67
500	5.00	5.885	.300	3.520	3.467	6.156	1.074	1.625	3.732	.72
550	5.50	6.385	.300	3.765	3.722	6.656	1.149	1.650	3.970	.77
600	6.00	6.885	.400	4.015	3.972	7.156	1.400	1.675	4.208	.81
650	6.50	7.385	.400	4.265	4.222	7.656	1.400	1.675	4.468	.86
700	7.00	7.885	.450	4.515	4.477	8.156	1.400	1.675	4.724	.93
750	7.50	8.385	.450	4.765	4.732	8.656	1.400	1.800	4.973	.98

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NOTES:

/1/

**TABLE 2 - COUPLING COMPONENT MATERIAL**

PART	MATL	TYPE	SPEC	REMARKS
COUPLING HALVES	CRES	A286	AMS5525 AMS5732	SOLUTION PRECIPITATION HEAT TREATED. /2/
	NICKEL ALLOY	718	AMS5596 AMS5662	
TRUNNION/ SADDLE WASHER	CRES	A286	AMS5731 AMS5732 AMS5734 AMS5737	SOLUTION AND PRECIPITATION HEAT TREATED OR EQUIVALENT MATERIAL PROPERTIES ACHIEVED BY COLD WORK.
	NICKEL ALLOY	713	AMS5377	INVESTMENT CASTING.
EYEBOLT	CRES	A286	AMS5731 AMS5732 AMS5737	/2/ AND /7/
SAFETY LATCH	NICKEL ALLOY	718	AMS5596	SOLUTIONS AND PRECIPITATION HEAT TREATED.
SELF-LOCKING NUT	CRES	A286	AMS5731 AMS5732 AMS5737	/2/ AND /7/
EYEBOLT PIN	CRES	A286	AMS5731 AMS5732	SOLUTION AND PRECIPITATION HEAT TREATED.
WASHER	CRES	303 OR 304	AMS5640 AMS5513	
LINK	CRES	A286	AMS5731 AMS5732 AMS5525	SOLUTION HEAT TREATED OR SOLUTION AND PRECIPITATION HEAT TREATED.
HINGE PIN	CRES	A286	AMS5731 AMS5732 AMS5734 AMS5737	SOLUTION AND PRECIPITATION HEAT TREATED.
DRIVE SCREW	CRES CRES CRES NICKEL ALLOY	302HQ 305 A286 718		

/2/ FINISH:

- a. SELF-LOCKING NUT: BLANK = SILVER PLATED AMS2410 OR AMS2411 OR L = DRY FILM LUBED (NO SILVER PLATING).
- b. COUPLING HALVES:
  - CRES A286 COUPLING HALVES: PASSIVATE PER AMS2700 TYPE 1, TYPE 2, TYPE 3, OR TYPE 8, MECHANICAL POLISH OR ELECTRO-POLISH TO REMOVE IRON PARTICLES. INSIDE SURFACE OF COUPLING HALVES SHALL BE COATED WITH SOLID DRY FILM LUBRICANT PER AS1895.
  - NICKEL ALLOY 718 COUPLING HALVES: NO FINISH REQUIRED. INSIDE SURFACE OF COUPLING HALVES SHALL BE COATED WITH SOLID DRY FILM LUBRICANT PER AS1895.
- c. EYEBOLT: LUBRICATE WITH ANTI-SEIZING COMPOUND. MAY USE "HEAVY DUTY ANTI-SEIZE" COMPOUND #LB 8009 FROM LOCTITE® (CAGE CODE 05972) OR EQUIVALENT.

	<b>AEROSPACE STANDARD</b>	<b>AS1895™/1</b> SHEET 3 OF 5	<b>REV.</b> <b>J</b>
	COUPLING, V-RETAINER, SINGLE LATCH, TYPE I STANDARD PROFILE		

/3/ QUALIFICATION:

FOR SIZES 150 THRU 600 INCLUSIVE:

PROCUREMENT SPECIFICATION: PARTS SHALL BE QUALIFIED IN A COMPLETE COUPLING ASSEMBLY IN ACCORDANCE WITH PROCUREMENT SPECIFICATION AS1895, EXCEPT AS SPECIFIED IN THIS STANDARD. PRODUCT MANUFACTURED TO THIS STANDARD SHALL MEET THE REQUIREMENTS SPECIFIED HEREIN AND THE PROCUREMENT SPECIFICATION. ORIGINAL COMPONENT MANUFACTURERS (OCM) SHALL BE LISTED IN THE PRI QUALIFIED PRODUCTS LIST (QPL) PRI-QPL-AS1895 FOR THIS STANDARD. SEE [www.eAuditNet.com](http://www.eAuditNet.com) FOR CURRENT QPL ONLINE.

FOR SIZES 650 THRU 750 INCLUSIVE:

PROCUREMENT SPECIFICATION: PARTS SHALL BE QUALIFIED IN A COMPLETE COUPLING ASSEMBLY IN ACCORDANCE WITH PROCUREMENT SPECIFICATION AS1895, EXCEPT AS SPECIFIED IN 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). USERS ARE ADVISED TO CONTROL SOURCE APPROVAL BY STANDARD PAGE SUPPLEMENT OR SIMILAR MEANS.

4. ACCEPTANCE TEST:

EACH COUPLING SHALL BE SUBJECT TO A HYDROSTATIC PROOF PRESSURE TEST PER AS1895.

5. INTERMATEABILITY:

THIS COUPLING, WHEN MATED WITH FLANGES, FLANGE ENDS, AND SEAL CONFORMING TO AS1895/2-XXX, AS1895/3-XXX, AS1895/7-XXX, AS1895/10-XXX, AS1895/11-XXX, AS1895-12-XXX, AS1895/13-XXX, AS1895/18-XXX, AS1895/19-XXX, AND AS1895/23-XXX, SHALL MEET ALL THE REQUIREMENTS OF SPECIFICATION AS1895.

/6/ MARKING:

ELECTROCHEMICAL ETCHING PER AS478-7A2 OR LASER MARKING PER AS478-15A2 OR 15B2. THE COUPLING SHALL BE MARKED AS FOLLOWS:

- a. AS1895/1 (FULL PART NUMBER)
- b. SUPPLIER PART NO.
- c. SUPPLIER NAME, TRADEMARK, OR CAGE CODE
- d. DATE OF MANUFACTURE
- e. TORQUE - "CAUTION: TORQUE TO 120 LB-IN  $\pm$  5 LB-IN" /12/

/7/ THREADS:

- a. EYEBOLT AND NUT THREADS CONFORM TO AS8879
- b. EYEBOLT THREAD .3125-24UNJF-3A
- c. SELF-LOCKING NUT THREAD .3125-24UNJF-3B
- d. EYEBOLT ULTIMATE TENSILE STRENGTH 160 KSI MINIMUM
- e. EYEBOLT QUALITY CONFORMANCE IAW AS4108/3

8. OPERATING TEMPERATURE: -65 TO +1200 °F FLUID TEMPERATURE.

9. BREAK EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.

10. DIMENSIONING AND TOLERANCING: ASME Y14.5M-1982.

11. DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS .XXX =  $\pm$ .010, .XX =  $\pm$ .03, ANGULAR DIMENSIONS  $\pm$ 0°30'.

/12/ TORQUE - COUPLING INSTALLATION TORQUE = 120 LB-IN  $\pm$  5 LB-IN.

/13/ THE FOOL PROOF SAFETY FEATURE RESULTS IN AN INCREASE OF OVERALL ENVELOPE DIMENSION R MAX BY .020 INCH MAXIMUM AND IN A WEIGHT INCREASE OF .026 POUND MAXIMUM.

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