

REV.
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AS4628

FEDERAL SUPPLY CLASS
4720

RATIONALE

AS4628D HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

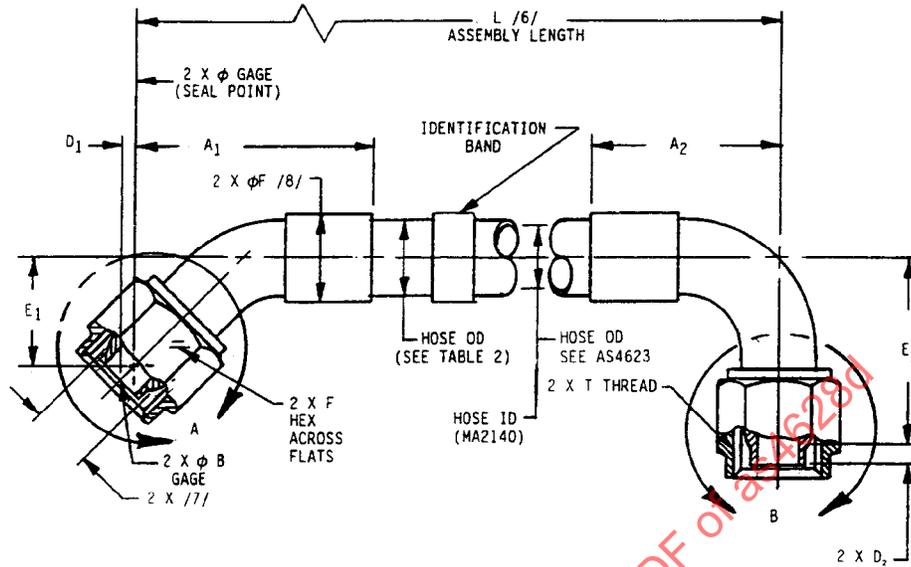


FIGURE 1 - HOSE ASSEMBLY, 45° ELBOW TO 90° ELBOW

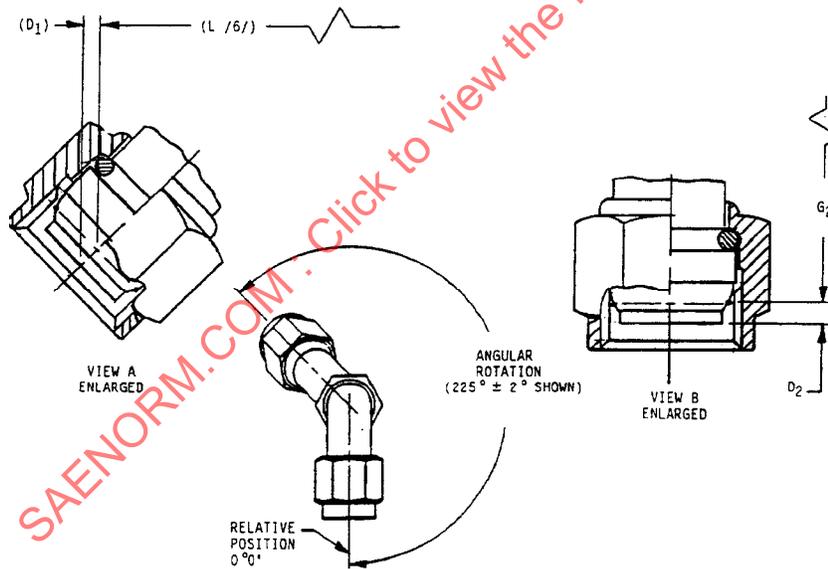
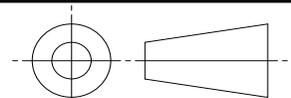


FIGURE 2 - FITTING ORIENTATION /19/

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THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3D

PROCUREMENT SPECIFICATION: /2/ AS4623



AEROSPACE STANDARD

HOSE ASSEMBLY, POLYTETRAFLUOROETHYLENE, PARA ARAMID REINFORCED, HEAVY-DUTY, 275 °F, 3000 PSI FLARELESS TITANIUM FITTINGS, INCLUDING JUMP SIZE, 45° TO 90°

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ISSUED 1992-06 REVISED 2009-07 REAFFIRMED 2015-04



AEROSPACE STANDARD

HOSE ASSEMBLY, POLYTETRAFLUOROETHYLENE, PARA ARAMID REINFORCED, HEAVY-DUTY, 275 °F, 3000 PSI FLARELESS TITANIUM FITTINGS, INCLUDING JUMP SIZE, 45° TO 90°

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TABLE 1 – HOSE AND FITTING DIMENSIONS

BASIC HOSE ASSEMBLY NO. 4628 SIZE CODE	FITTING TYPE	THREAD T PER AS8879	A ₁ MAX	A ₂ MAX	B GAGE BASIC	(C) HEX	D ₁	D ₂	E ₁		E ₂		E ₃		F MAX	BALL SIZE MIN THRU 7/ IN
									MAX	MIN	MAX	MIN	MAX	MIN		
E	S	0.4375-20UNJF-3B	2.160	1.180	0.2930	0.56	0.11	0.16	0.475	0.350	0.770	0.645	0.69	0.102		
G	S	0.5625-18UNJF-3B	2.460	2.180	0.4120	0.69	0.12	0.16	0.500	0.375	0.840	0.715	0.80	0.174		
H	S	0.7500-16UNJF-3B	2.740	2.538	0.5600	0.88	0.13	0.19	0.560	0.435	0.940	0.845	0.97	0.267		
J	S	0.8750-14UNJF-3B	3.785	3.375	0.6730	1.00	0.14	0.20	0.670	0.545	1.210	1.085	1.15	0.323		
K	S	1.0625-12UNJ-3B	4.810	3.940	0.8100	1.25	0.16	0.23	0.705	0.580	1.400	1.275	1.38	0.433		
M	S	1.3125-12UNJ-3B	5.540	4.510	1.0620	1.50	0.21	0.30	0.840	0.715	1.625	1.500	1.66	0.646		
N	S	1.5625-12UNJ-3B	6.770	5.310	1.3160	1.81	0.03	0.04	0.875	0.750	1.825	1.700	2.32	0.786		

TABLE 2 – HOSE OR SLEEVE OUTSIDE DIAMETERS /10/

SLEEVE CODE	SLEEVE MATERIAL	TEMP LIMIT °F	HOSE SIZE											
			0.250	0.375	0.500	0.625	0.750	1.000	1.250	1.500	1.750	2.000		
-	(-) INDICATES HOSE ONLY NO SLEEVE (SEE AS4623)	275	--	--	--	--	--	--	--	--	--	--	--	--
A	FIRESLEEVE (AS1072 SIL-FG) (5 MIN) /11/12/13/	275	0.930/0.730	1.070/0.880	1.205/1.015	1.370/1.130	1.590/1.380	1.847/1.677	2.130/1.950					
B	ABRASION SLEEVE SHRINK-ON (POLYOLEFIN AS1073-CODE B) /20/	275	0.620/0.540	0.770/0.690	0.917/0.839	1.042/0.948	1.314/1.206	1.623/1.511	1.896/1.784					
K	INTEGRAL ABRASION SLEEVE (BRAIDED) POLYESTER /21/	275	0.555/0.635	0.675/0.755	0.840/0.920	0.995/1.025	1.205/1.305	1.502/1.602	1.775/1.875					

TABLE 3 – HOSE ASSEMBLY LENGTH TOLERANCES

HOSE ASSEMBLY LENGTH	TOLERANCE
UNDER 18 IN	± 0.125 IN
18 TO 36 IN EXCLUSIVE	± 0.250 IN
36 TO 50 IN EXCLUSIVE	± 0.500 IN
50 IN AND OVER	±1%

TABLE 4 – CUFF LENGTHS

HOSE SIZE	LENGTH (INCHES) ± 0.25
0.250	2.25
0.375	2.75
0.500	3.50
0.625	4.25
0.750	5.75
1.000	6.00
1.250	6.75

TABLE 5 – MAXIMUM HOSE AND FITTING WEIGHTS

HOST OR SLEEVE CODE	HOSE, PART OR SLEEVE	UNITS	HOSE SIZE 0.250	HOSE SIZE 0.375	HOSE SIZE 0.500	HOSE SIZE 0.625	HOSE SIZE 0.750	HOSE SIZE 1.000	HOSE SIZE 1.250
--	HOSE ONLY (SEE AS4623)	LB/IN	--	--	--	--	--	--	--
A	FIRE SLEEVE (AS1072 SIL-FG) (5 MIN) /14/	LB/IN	--	--	--	--	--	--	--
B	ABRASION SLEEVE (AS1073 - CODE B) /20/	LB/IN	0.0018	0.0018	0.0032	0.0032	0.0049	0.0082	0.0082
NONE	FIRE SLEEVE CLAMP	LB/EA	0.020	0.020	0.021	0.021	0.025	0.025	0.032
NONE	FITTING END (45°) /15/	LB/EA	0.066	0.110	0.154	0.275	0.535	0.944	TBD /9/
NONE	FITTING END (90°) /15/	LB/EA	0.077	0.121	0.176	0.297	0.560	0.947	TBD /9/
K	ABRASION SLEEVE POLYESTER WITH HOSE /21/	LB/IN	0.013	0.017	0.023	0.026	0.035	0.058	0.078

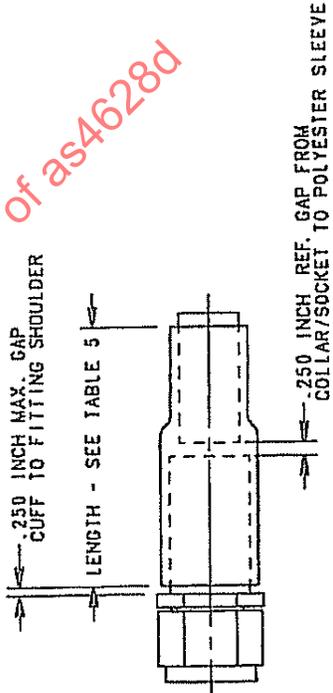


FIGURE 3 – POLYESTER ABRASION SLEEVE CUFF /21/

NOTES:

1. MATERIALS:

- a. HOSE AND FITTINGS - PER AS4623.
 - b. THE COLLARS MAY BE STAINLESS STEEL /15/.
 - c. SLEEVES - SEE APPLICABLE STANDARDS, TABLE 2.
- /2/ PROCUREMENT SPECIFICATION: AS4623 EXCEPT AS SPECIFIED ON THIS STANDARD. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED AND ASSEMBLED BY AN ACCREDITED MANUFACTURER OR ASSEMBLED BY AN ACCREDITED DISTRIBUTOR LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST (QPL) PRI-QPL-4623 FOR THIS STANDARD. SEE www.eauditnet.com FOR CURRENT QPL ON-LINE.
3. CONSTRUCTION AND PERFORMANCE PER AS4623. FITTINGS SHALL BE PERMANENTLY ATTACHED TO HOSE.
4. OPERATING CHARACTERISTICS PER AS4623.
- /5/ MARKING: MARKING SHALL BE PER AS4623 ON A STAINLESS STEEL BAND NOT OVER 1.0 in WIDE OR ON THE 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 MOVEMENT AND RESULTANT CHAFING. IT SHALL BE OF SUFFICIENT STRENGTH TO PREVENT REMOVAL BY HAND. HOSE ASSEMBLY DATE AND "PT" SYMBOL SHALL BE PERMANENTLY MARKED ON THE BAND OR ON AN END FITTING OR A FIRESLEEVE CLAMP. MARKING BAND SHALL BE COVERED WITH TRANSPARENT POLYOLEFIN SHRINK SLEEVE PER AS1073 CODE A.
- /16/ HOSE LENGTH: 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 DIAMETER" TO "GAGE DIAMETER". FOR LENGTH TOLERANCES, SEE TABLE 3. TO CONVERT "GAGE DIAMETER" TO "GAGE DIAMETER" TO "END TO END" MEASUREMENT, ADD D₁ TO LENGTH "L".
- /7/ HOSE ASSEMBLY INSIDE DIAMETER SHALL BE VERIFIED BY PASSING THE DESIGNATED, OR LARGER, SPHERICAL BALL PER TABLE 1 THROUGH THE HOSE ASSEMBLY.
- /8/ DISTANCE ACROSS CORNERS OF COUPLING NUT MAY EXCEED THIS DIMENSION.
- /9/ FITTING ENDS SIZE -4 THRU -16 MUST COMPLY WITH NAS1760; FITTINGS FOR HOSE SIZE -20 AND LARGER TO COMPLY WITH AS4703. FITTINGS SHALL MATE WITH AS33514 OR AS4375, FOR SIZES THRU -16 AND WITH AS4658 OR AS4659 IN SIZES -20 AND LARGER. -20 AND LARGER NUTS SHALL CONFORM TO AS4660 OR AS4702. STANDARD COUPLING NUTS SHALL BE IN ACCORDANCE WITH OR EQUIVALENT TO AS1790 OR AS1792.
- /10/ CLAMP DIAMETERS: DIAMETERS ARE LISTED FOR CLAMP SELECTION. TUBULAR SLEEVES MAY NOT BE A PERFECT ROUND AND SHALL BE MEASURED WITH A DIAMETER TAPE RULE (OFTEN REFERRED TO AS A PI-TAPE).
- /11/ SLEEVE DIAMETERS: THE TABLE 2 SLEEVE DIAMETERS FOR AS1072 SLEEVES APPLY WHEN THE SLEEVE IS COMPRESSED, OR CLAMPED TO CONTACT THE HOSE, IN THIS CASE, A WRINKLE MAY OCCUR OVER APPROXIMATELY 10% OF THE SLEEVE CIRCUMFERENCE.
- /12/ FIRESLEEVE: 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 FIRESLEEVE, WHICH EXPOSE THE FIBERGLASS, SHALL BE COATED WITH RTV SILICONE RUBBER.
- /13/ IDENTIFICATION MARKING: ADD "AS1055 TYPE IIb CLASS A-S/P" TO IDENTIFICATION MARKING TO SHOW LEVEL OF COMPLIANCE, "FIRE RESISTANT 275 °F (5 min), WITH AS1055."

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