

REV. C

SAE AS624

FEDERAL SUPPLY CLASS  
4720

RATIONALE

AS624C HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

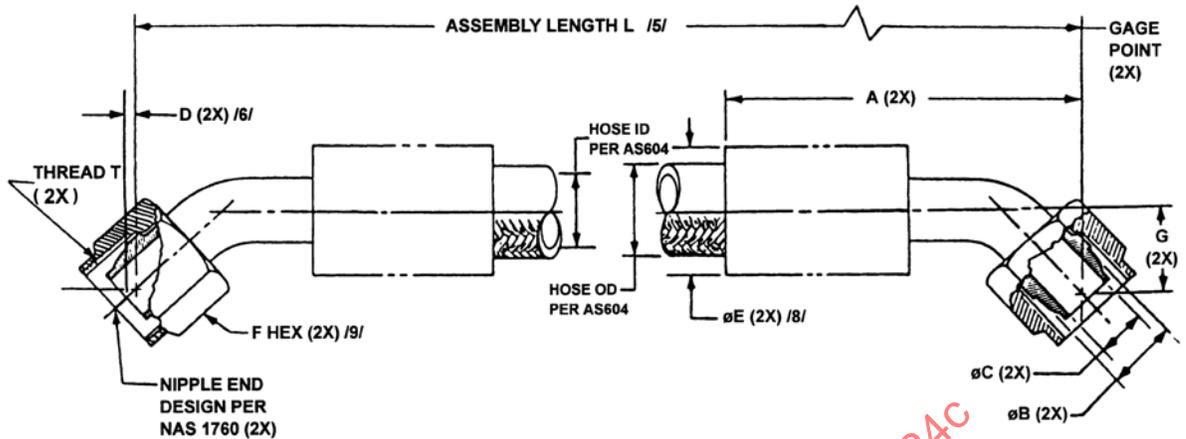


FIGURE 1 - HOSE AND FITTING DIMENSIONS

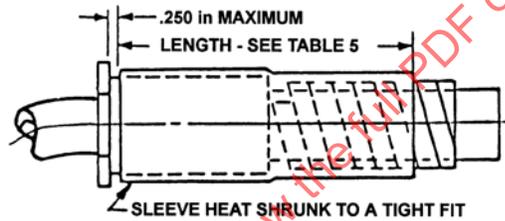


FIGURE 2 - TUBULAR/OIL ABRASION END /10/ /11/

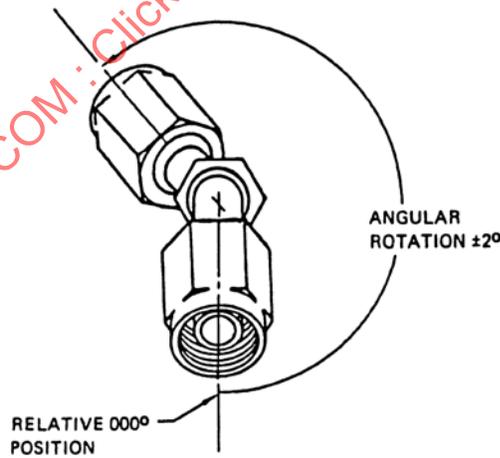
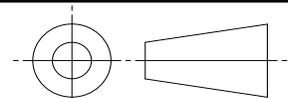


FIGURE 3 - FITTING ANGULAR ORIENTATION /19/

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THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3D

PROCUREMENT SPECIFICATION: AS604 /2/

**SAE Aerospace**  
An SAE International Group

**AEROSPACE STANDARD**

HOSE ASSEMBLY, 3000 psi, PTFE, FLARELESS,  
45° TO 45°, HEAVYWEIGHT

**SAE AS624**  
SHEET 1 OF 6

**REV. C**

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ISSUED 1984-07 REVISED 2001-05 REAFFIRMED 2013-01

TABLE 1 - ASSEMBLY DIMENSIONS

HOSE ASSEMBLY AS624 SIZE CODE	HOSE ASSEMBLY SIZE (REF)	THREAD T PER AS8879 (REF)	A MAX	B GAGE BASIC	C /7/ MIN	D (REF)	E MAX WITHOUT SLEEVING	F HEX (REF)
E	.250	.4375-20 UNJF-3B	2.17	.2930	.135	.11	.88	.56
G	.375	.5625-18 UNJF-3B	2.68	.4120	.240	.12	1.00	.69
H	.500	.7500-16 UNJF-3B	3.11	.5600	.340	.13	1.20	.88
J	.625	.8750-14 UNJF-3B	3.59	.6730	.410	.14	1.41	1.00
K	.750	1.0625-12 UNJ-3B	3.67	.8100	.510	.16	1.69	1.25
M	1.00	1.3125-12 UNJ-3B	4.44	1.0620	.760	.21	2.00	1.50
N	1.25	1.6250-12 UNJ-3B	4.65	1.3160	.925	.21	2.13	2.00

TABLE 1 (CONTINUED)

HOSE ASSEMBLY AS624 SIZE CODE	HOSE ASSEMBLY SIZE (REF)	G MIN	G MAX	INSPECTION BALL SIZE /7/ DIA IN
E	.250	.31	.50	.115
G	.375	.44	.62	.204
H	.500	.50	.75	.289
J	.625	.56	.81	.349
K	.750	.62	.88	.434
M	1.00	.81	1.09	.646
N	1.25	1.24	1.31	.786

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TABLE 2 - HOSE OR SLEEVE OUTSIDE DIAMETER /14/

SLEEVE CODE	SLEEVE MATERIAL	TEMP. LIMIT °F	HOSE SIZE	HOSE SIZE	HOSE SIZE	HOSE SIZE	HOSE SIZE	HOSE SIZE	HOSE SIZE
			.250	.375	.500	.625	.750	1.00	1.25
NONE	(-) INDICATES HOSE ONLY, NO SLEEVE	400	.455 .395	.595 .535	.735 .675	.935 .875	1.090 1.030	1.410 1.350	1.650 1.590
A	ABRASION SLEEVE TUBULAR (TFE-AS1291-CODE B) /10/	400	.540 .468	.715 .635	.855 .770	1.025 .960	1.195 1.125	1.515 1.445	1.825 1.755
B	ABRASION SLEEVE COIL (NYLON AS1294) /11/	275	.509 .413	.684 .584	.809 .733	1.005 .923	1.170 1.088	1.492 1.408	1.750 1.690
C	FIRE SLEEVE (AS1072 SIL-FG) (15 min) /12/ /13/ /18/	400	.688 .562	.875 .750	1.000 .875	1.250 1.125	1.375 1.250	1.750 1.625	2.000 1.875
E	ABRASION SLEEVE SHRINK-ON (FEP) /16/	350	.458 .417	.638 .592	.773 .727	.973 .927	1.148 1.102	1.438 1.392	1.688 1.632
F	ABRASION SLEEVE SHRINK-ON (POLYOLEFIN AS1073 - CODE B) /16/	275	.490 .440	.670 .610	.795 .745	.997 .937	1.174 1.112	1.482 1.428	1.740 1.680
G	FIRE SLEEVE (AS1072 SIL-FG) (5 min) /12/ /13/ /17/	400	.688 .562	.875 .750	1.000 .875	1.250 1.125	1.375 1.250	1.750 1.625	2.000 1.875
H	FIRE SLEEVE INTEGRAL SILICONE (15 min) /18/	400	.700 .640	.880 .820	1.000 .940	1.203 1.143	1.343 1.283	1.656 1.596	1.906 1.846
J	FIRE SLEEVE INTEGRAL SILICONE (5 min) /17/	400	.705 .645	.880 .820	1.005 .945	1.217 1.143	1.382 1.280	1.748 1.593	1.906 1.846
K	INTEGRAL ABRASION SLEEVE (BRAIDED) POLYESTER /15/	300	.505 .480	.675 .645	.795 .765	.985 .955	1.150 1.120	1.470 1.440	1.720 1.680
L	ABRASION SLEEVE COIL (PTFE-AS1293) /11/	400	.522 .449	.692 .622	.817 .747	1.007 .937	1.172 1.102	1.492 1.422	1.750 1.690

TABLE 3 - 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 4 - WEIGHTS (NOMINAL)

HOSE OR SLEEVE CODE	HOSE OR TYPE SLEEVE	UNITS	HOSE SIZE						
			.250	.375	.500	.625	.750	1.00	1.25
NONE	HOSE ONLY	LB/IN	.012	.028	.040	.062	.086	.140	.154
A	ABRASION SLEEVE (TFE-AS1291-CODE B)	LB/IN	.003	.004	.004	.005	.007	.009	.011
B	ABRASION SLEEVE (NYLON AS1294)	LB/IN	.001	.002	.003	.003	.004	.005	.007
C	FIRESLEEVE (15 min) AS1072	LB/IN	.007	.010	.011	.015	.017	.021	.025
E	ABRASION SLEEVE (FEP)	LB/IN	.002	.003	.003	.005	.006	.007	.009
F	ABRASION SLEEVE (AS1073-CODE B)	LB/IN	.002	.003	.003	.004	.005	.006	.008
G	FIRESLEEVE (5 min) AS1072	LB/IN	.007	.010	.011	.015	.017	.021	.025
H	FIRESLEEVE INTEGRAL (15 min) ON HOSE	LB/IN	.022	.042	.056	.081	.102	.154	.190
J	FIRESLEEVE INTEGRAL (5 min) ON HOSE	LB/IN	.022	.042	.056	.081	.102	.154	.190
K	ABRASION SLEEVE POLYESTER WITH HOSE	LB/IN	.013	.028	.039	.060	.082	.130	.160
L	ABRASION SLEEVE (PTFE-AS1293)	LB/IN	.003	.004	.005	.005	.006	.007	.009
NONE	FIRESLEEVE CLAMP (*)	LB/EA	.020	.020	.025	.026	.026	.033	.038
NONE	FITTING END (45°) (*)	LB/EA	.078	.130	.221	.327	.597	.860	1.58

(\*) NOTE: FIRESLEEVE CLAMP AND FITTING END ARE IN POUNDS EACH.

TABLE 5 - SLEEVE LENGTH

HOSE SIZE	LENGTH (INCHES)
.250	2.00 ± .25
.375	
.500	2.50 ± .25
.625	
.750	3.00 ± .25
1.00	
1.25	3.50 ± .25