

ADOPTION NOTICE

SAE-AS625, "HOSE ASSEMBLY, 3,000 PSI, TFE, FLARELESS, 45 DEG. TO 90 DEG., HEAVYWEIGHT", was adopted on 20-JUN-86 for use by the Department of Defense (DoD). Proposed changes by DoD activities must be submitted to the DoD Adopting Activity: Defense Supply Center Columbus, P.O. Box 3990, Attn: DSCC-VAI, Columbus, OH 43216-5000. Copies of this document may be purchased from the Society of Automotive Engineers 400 Commonwealth Drive Warrendale, Pennsylvania, United States, 15096-0001. <http://www.sae.org/>

Custodians:

Army - CR4
Navy - AS
Air Force - 11
DLA - CC

Adopting Activity:

DLA - CC

Reviewer Activities:

Army - AV, MI
Air Force - 99

SAENORM.COM : Click to view the full PDF of SAE-AS625b

FSC 4720

DISTRIBUTION STATEMENT A: Approved for public release; distribution is unlimited.

REV. B

AS625

FEDERAL SUPPLY CLASS
4720

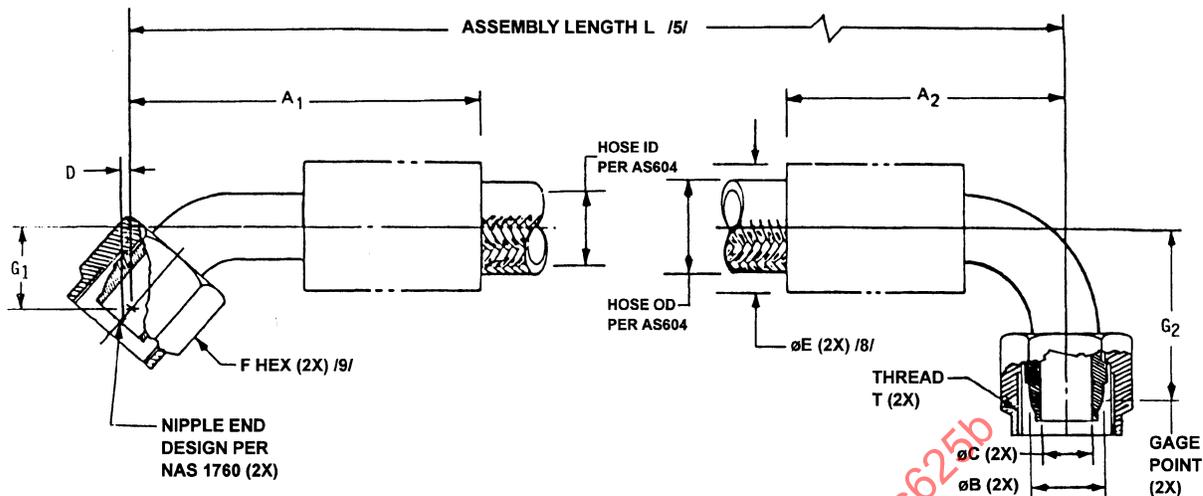


FIGURE 1 - HOSE AND FITTING DIMENSIONS

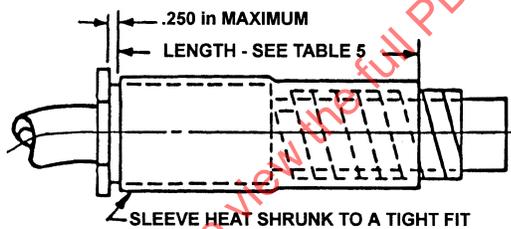


FIGURE 2 - TUBULAR/COIL ABRASION END /10/ /11/

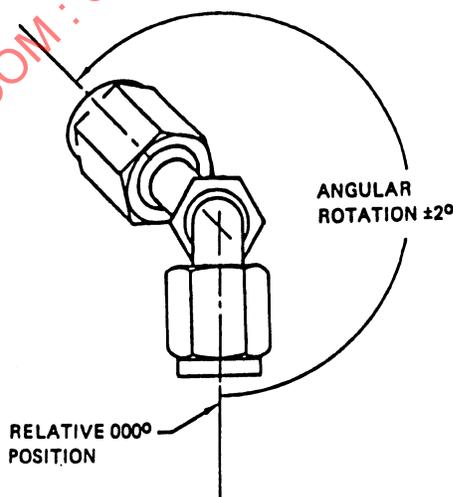


FIGURE 3 - FITTING ANGULAR ORIENTATION /19/

SAE Technical Standards Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user." SAE reviews each technical report at least every five years at which time it may be reaffirmed, revised, or cancelled. SAE invites your written comments and suggestions.

CUSTODIAN: SAE G-3/G-3D

PROCUREMENT SPECIFICATION: AS604 /2/

SAE The Engineering Society
For Advancing Mobility
Land Sea Air and Space
INTERNATIONAL
400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARD

(R) HOSE ASSEMBLY, 3000 psi, PTFE, FLARELESS,
45° TO 90°, HEAVYWEIGHT

AS625
SHEET 1 OF 6

REV. B

SAENORM.COM : Click to the full PDF of as625b

ISSUED 1984-07 REVISED 2000-10

REV.
B

AS625

TABLE 1 - ASSEMBLY DIMENSIONS

HOSE ASSEMBLY AS625 SIZE CODE	HOSE ASSEMBLY SIZE (REF)	THREAD T PER AS8879 (REF)	A ₁ MAX	A ₂ MAX	B GAGE BASIC	C /7/ MIN	D (REF)	E MAX WITHOUT SLEEVING	F HEX (REF)
E	.250	.4375-20 UNJF-3B	2.17	1.58	.2930	.135	.11	.88	.56
G	.375	.5625-18 UNJF-3B	2.68	1.80	.4120	.240	.12	1.00	.69
H	.500	.7500-16 UNJF-3B	3.11	2.40	.5600	.340	.13	1.20	.88
J	.625	.8750-14 UNJF-3B	3.59	3.04	.6730	.410	.14	1.41	1.00
K	.750	1.0625-12 UNJ-3B	3.67	3.35	.8100	.510	.16	1.69	1.25
M	1.00	1.3125-12 UNJ-3B	4.44	4.26	1.0620	.760	.21	2.00	1.50
N	1.25	1.6250-12 UNJ-3B	4.65	4.72	1.3160	.925	.21	2.13	2.00

TABLE 1 (CONTINUED)

HOSE ASSEMBLY AS625 SIZE CODE	HOSE ASSEMBLY SIZE (REF)	G ₁ MIN	G ₁ MAX	G ₂ MIN	G ₂ MAX	INSPECTION BALL SIZE /7/ DIA IN
E	.250	.31	.50	.69	.88	.115
G	.375	.44	.62	.88	1.09	.204
H	.500	.50	.75	1.00	1.31	.289
J	.625	.56	.81	1.19	1.50	.349
K	.750	.62	.88	1.38	1.75	.434
M	1.00	.81	1.09	1.69	2.06	.646
N	1.25	1.24	1.31	2.51	2.57	.786

REV.
B

AS625

TABLE 2 - HOSE OR SLEEVE OUTSIDE DIAMETER /14/

SLEEVE CODE	SLEEVE MATERIAL	TEMP. LIMIT °F	HOSE SIZE .250	HOSE SIZE .375	HOSE SIZE .500	HOSE SIZE .625	HOSE SIZE .750	HOSE SIZE 1.00	HOSE SIZE 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%

REV.
B

AS625

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	1.580
NONE	FITTING END (90°) (*)	LB/EA	.078	.136	.233	.327	.615	.945	1.710

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

TABLE 5 - SLEEVE LENGTH

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