

Submitted for recognition as an American National Standard

FEDERAL SUPPLY CLASS
4720

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AS627

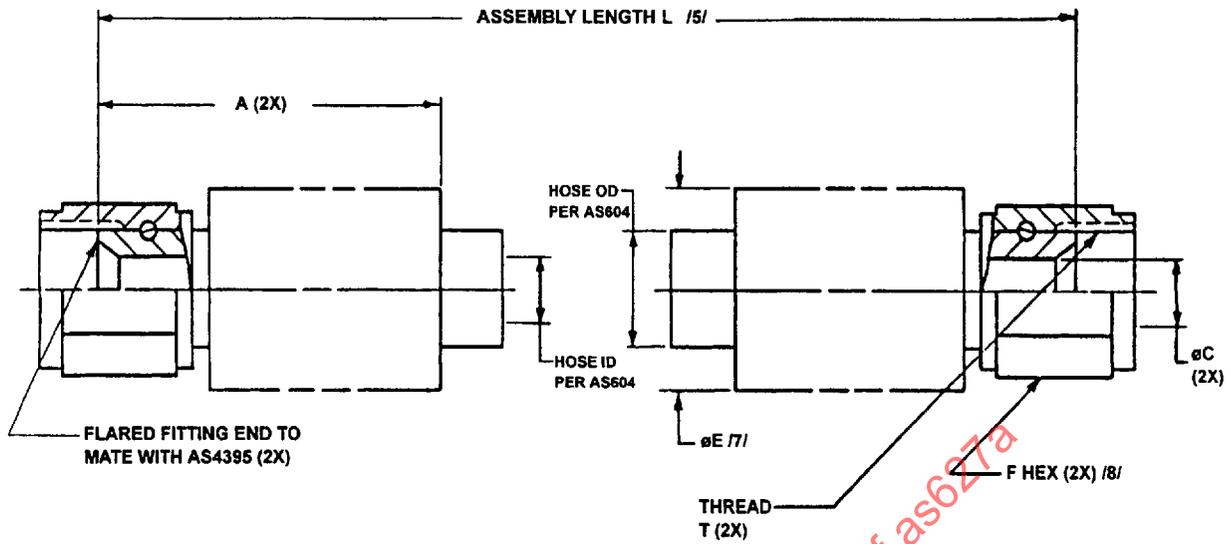


FIGURE 1 - HOSE AND FITTING DIMENSIONS

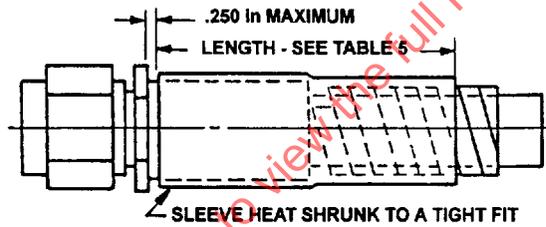


FIGURE 2 - TUBULAR/COIL ABRASION END /9/ /10/

TABLE 1 - ASSEMBLY DIMENSIONS

| HOSE ASSEMBLY NO. AND SIZE CODE | HOSE ASSEMBLY SIZE (REF) | THREAD T PER MIL-S-8879 (REF) | A MAX | C /6/ MIN | E MAX WITHOUT SLEEVING | F HEX (REF) | INSPECTION BALL SIZE /6/ DIA IN |
|---------------------------------|--------------------------|-------------------------------|-------|-----------|------------------------|-------------|---------------------------------|
| AS627-04 | .250 | .4375-20 UNJF-3B | 1.51 | .135 | .88 | .56 | .122 |
| AS627-06 | .375 | .5625-18 UNJF-3B | 1.80 | .240 | 1.00 | .69 | .216 |
| AS627-08 | .500 | .7500-16 UNJF-3B | 2.04 | .340 | 1.20 | .88 | .306 |
| AS627-10 | .625 | .8750-14 UNJF-3B | 2.31 | .410 | 1.41 | 1.00 | .369 |
| AS627-12 | .750 | 1.0625-12 UNJ-3B | 2.49 | .510 | 1.69 | 1.25 | .459 |
| AS627-16 | 1.00 | 1.3125-12 UNJ-3B | 2.57 | .760 | 2.00 | 1.50 | .684 |
| AS627-20 | 1.25 | 1.6250-12 UNJ-3B | 2.70 | .925 | 2.13 | 2.00 | .833 |

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, FLARED, STRAIGHT TO STRAIGHT, HEAVYWEIGHT

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TABLE 2 - HOSE OR SLEEVE OUTSIDE DIAMETER /13/

| SLEEVE CODE | SLEEVE MATERIAL | TEMP. LIMIT °F | HOSE SIZE |
|-------------|---|----------------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|
| | | | .250 | .375 | .500 | .625 | .750 | 1.00 | 1.25 |
| NONE | (-) INDICATES HOSE ONLY, NO SLEEVE | 400 | .455 | .595 | .735 | .935 | 1.090 | 1.410 | 1.650 |
| | | | .395 | .535 | .675 | .875 | 1.030 | 1.350 | 1.590 |
| A | ABRASION SLEEVE TUBULAR (TFE-AS1291-CODE B) /9/ | 400 | .540 | .715 | .855 | 1.025 | 1.195 | 1.515 | 1.825 |
| | | | .468 | .635 | .770 | .960 | 1.125 | 1.445 | 1.755 |
| B | ABRASION SLEEVE COIL (NYLON AS1294) /10/ | 275 | .509 | .684 | .809 | 1.005 | 1.170 | 1.492 | 1.750 |
| | | | .413 | .584 | .733 | .923 | 1.088 | 1.408 | 1.690 |
| C | FIRESLEEVE (AS1072 SIL-FG) (15 min) /11/ /12/ /17/ | 400 | .688 | .875 | 1.000 | 1.250 | 1.375 | 1.750 | 2.000 |
| | | | .562 | .750 | .875 | 1.125 | 1.250 | 1.625 | 1.875 |
| E | ABRASION SLEEVE SHRINK-ON (FEP) /15/ | 350 | .458 | .638 | .773 | .973 | 1.148 | 1.438 | 1.688 |
| | | | .417 | .592 | .727 | .927 | 1.102 | 1.392 | 1.632 |
| F | ABRASION SLEEVE SHRINK-ON (POLYOLEFIN AS1073 - CODE B) /15/ | 275 | .490 | .670 | .795 | .997 | 1.174 | 1.482 | 1.740 |
| | | | .443 | .618 | .745 | .937 | 1.112 | 1.428 | 1.680 |
| G | FIRESLEEVE (AS1072 SIL-FG) (5 min) /11/ /12/ /16/ | 400 | .688 | .875 | 1.000 | 1.250 | 1.375 | 1.750 | 2.000 |
| | | | .562 | .750 | .875 | 1.125 | 1.250 | 1.625 | 1.875 |
| H | FIRESLEEVE INTEGRAL SILICONE (15 min) /17/ | 400 | .700 | .880 | 1.000 | 1.203 | 1.343 | 1.656 | 1.906 |
| | | | .640 | .820 | .940 | 1.143 | 1.283 | 1.596 | 1.846 |
| J | FIRESLEEVE INTEGRAL SILICONE (5 min) /16/ | 400 | .705 | .880 | 1.005 | 1.217 | 1.382 | 1.748 | 1.906 |
| | | | .645 | .820 | .945 | 1.143 | 1.280 | 1.593 | 1.846 |
| K | INTEGRAL ABRASION SLEEVE (BRAIDED) POLYESTER /14/ | 300 | .505 | .675 | .795 | .985 | 1.150 | 1.470 | 1.720 |
| | | | .480 | .645 | .765 | .955 | 1.120 | 1.440 | 1.680 |
| L | ABRASION SLEEVE COIL (PTFE-AS1293) /10/ | 400 | .522 | .692 | .817 | 1.007 | 1.172 | 1.492 | 1.750 |
| | | | .449 | .622 | .747 | .937 | 1.102 | 1.422 | 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% |

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AEROSPACE STANDARD

(R) HOSE ASSEMBLY, 3000 psi, PTFE, FLARED, STRAIGHT TO STRAIGHT, HEAVYWEIGHT

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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-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 (AS1073B) | 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 (STRAIGHT) (*) | LB/EA | .066 | .120 | .200 | .250 | .440 | .650 | 1.320 |

(*) 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 |

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NOTES:

1. MATERIALS:
 - a. HOSE AND FITTINGS PER AS604
 - b. SLEEVES - SEE APPLICABLE STANDARD PER TABLE 2
- /2/ THIS HOSE ASSEMBLY SHALL BE QUALIFIED IN ACCORDANCE WITH PROCUREMENT SPECIFICATION AS604. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.
3. MARKING SHALL BE PER AS604 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 ELECTROETCHED OR STAMPED ON THE BAND OR ON AN END FITTING OR A FIRESLEEVE CLAMP.
4. CONSTRUCTION AND PERFORMANCE PER AS604. FITTINGS SHALL BE PERMANENTLY ATTACHED TO THE HOSE.
- /5/ LENGTH "L" IS A FOUR DIGIT NUMBER OF WHICH THE FIRST THREE DIGITS DESCRIBE THE HOSE ASSEMBLY LENGTH IN WHOLE INCHES, AND THE FOURTH DIGIT, THE FRACTION OF AN INCH IN EIGHTHS. LENGTH "L" IS MEASURED FROM FACE OF SEAT TO FACE OF SEAT. FOR LENGTH TOLERANCES SEE TABLE 3.
- /6/ HOSE ASSEMBLY INSIDE DIAMETER SHALL BE VERIFIED BY PASSING THE DESIGNATED, OR LARGER, SPHERICAL BALL PER TABLE 1 THROUGH THE HOSE ASSEMBLY.
- /7/ DISTANCE ACROSS CORNERS OF THE COUPLING NUT MAY EXCEED THIS DIMENSION.
- /8/ STANDARD COUPLING NUTS SHALL BE IN ACCORDANCE WITH AN818 OR AS4370. NONSTANDARD COUPLING NUTS MAY BE USED, PROVIDED THEY ARE DIMENSIONALLY AND FUNCTIONALLY EQUIVALENT, AND PROVIDED THEY CANNOT BE REMOVED FROM THE FITTING.
- /9/ TUBULAR ABRASION (TFE) SLEEVES SHALL HAVE AN ID NO GREATER THAN HOSE OD + .05 in. AXIAL MOVEMENT OF THE SLEEVE INSTALLED ON THE HOSE SHALL NOT EXCEED .05 in. ENDS OF THE TUBULAR SLEEVE SHALL BE TERMINATED WITH A LENGTH OF MIL-I-23053/11 (FEP) CLASS 1 OR 2, COLOR CLEAR, PER TABLE 5 AND FIGURE 2.
- /10/ COIL ABRASION SLEEVES, WHEN ASSEMBLED ON A STRAIGHT HOSE, SHALL HAVE AN AVERAGE GAP BETWEEN COILS NOT EXCEEDING .05 in. DISPLACEMENT OF THE COILS OF THE SLEEVE, CAUSING A GREATER GAP, SHALL NOT BE CAUSE FOR REJECTION IF THE COILS CAN BE REPOSITIONED TO MEET THE GAP REQUIREMENTS. ENDS OF THE COIL SLEEVE SHALL BE TERMINATED WITH A LENGTH OF HEAT SHRINKABLE SLEEVING IN ACCORDANCE WITH TABLE 5 AND FIGURE 2. CODE "B" (NYLON COIL) ABRASION SLEEVES SHALL BE TERMINATED WITH MIL-I-23053/5, CLASS 1 OR 3, COLOR BLACK. CODE "L" (COIL ABRASION) SLEEVES SHALL BE TERMINATED WITH MIL-I-23053/12A, CLASS I, COLOR TRANSPARENT, PTFE (OPTIONAL MIL-I-23053/11 (FEP) CLASS 1 OR 2, COLOR CLEAR).
- /11/ 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/ 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/ DIAMETERS ARE LISTED FOR CLAMP SELECTION. TUBULAR SLEEVES MAY NOT BE A PERFECT ROUND AND SHALL BE MEASURED WITH A DIAMETER TAPE RULER (OFTEN REFERRED TO AS PI-TAPE).
- /14/ INTEGRAL ABRASION SLEEVE SHALL FORM AN INTEGRAL, PERMANENT PART OF THE HOSE AND SHALL TERMINATE A MAXIMUM OF .200 in FROM THE END OF THE COLLAR.
- /15/ FEP AND POLYOLEFIN SHRINK ABRASION SLEEVES SHALL BE SHRUNK TO A SNUG FIT OVER THE HOSE AND END FITTING COLLARS.
- /16/ ADD "AS1055 TYPE IIb CLASS A-S/P" TO IDENTIFICATION MARKING TO SHOW LEVEL OF COMPLIANCE, "FIRE RESISTANT" (5 min), WITH AS1055.
- /17/ ADD "AS1055 TYPE IIb CLASS B-S/P" TO IDENTIFICATION MARKING TO SHOW LEVEL OF COMPLIANCE, "FIRE PROOF" (15 min), WITH AS1055.
18. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.

| | | | | |
|--|---------------------------|---|------------------------------|-------------------------|
|  <p>SAE The Engineering Society For Advancing Mobility Land Sea Air and Space INTERNATIONAL 400 Commonwealth Drive, Warrendale, PA 15096-0001</p> | AEROSPACE STANDARD | | AS627 SHEET 4 OF 5 | REV. A |
| | (R) | HOSE ASSEMBLY, 3000 psi, PTFE, FLARED, STRAIGHT TO STRAIGHT, HEAVYWEIGHT | | |