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AS624™

FEDERAL SUPPLY CLASS
4720

RATIONALE

ADD CONFIGURATION FOR A NEW "N" CODE THIN WALL INTEGRAL FIRESLEEVE (15 MINUTE); TABLE 2 DIMENSIONS CHANGED TO ALIGN WITH AS604 AND AS627-632 STANDARDS; NOTE 2 CHANGED TO CURRENT PRI STANDARD.

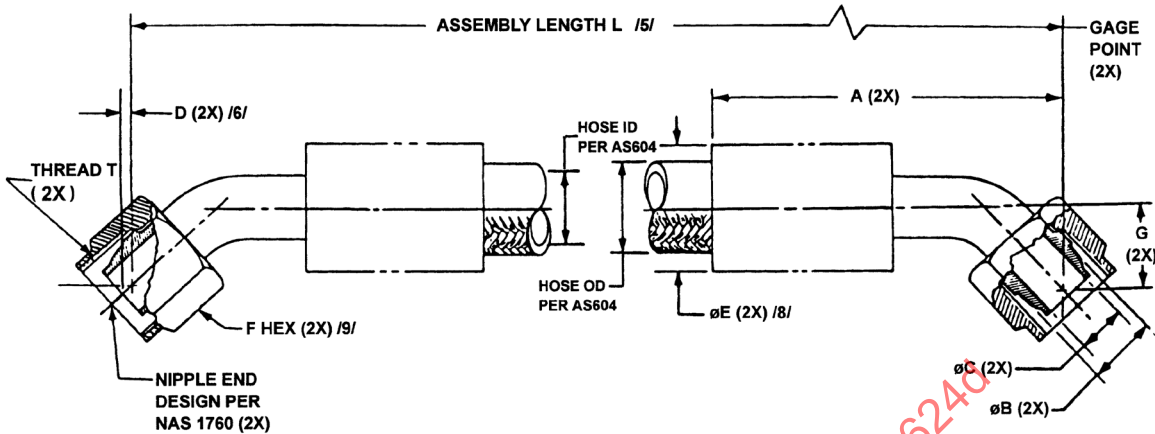


FIGURE 1 - HOSE AND FITTING DIMENSIONS

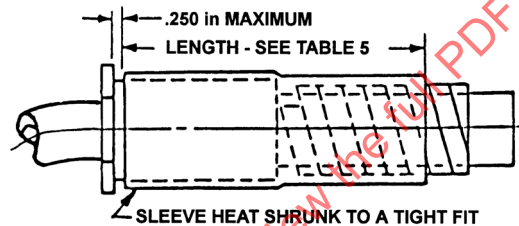


FIGURE 2 - TUBULAR/COIL ABRASION END /10/ /11/

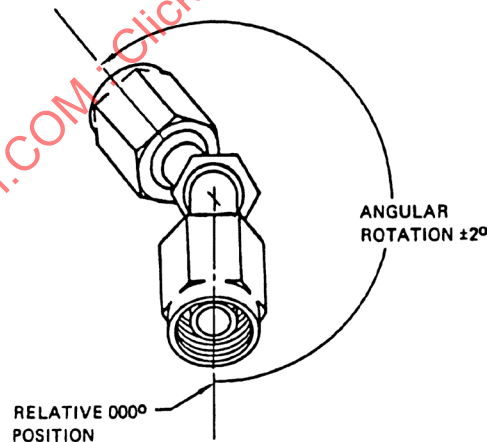
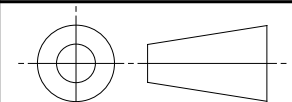


FIGURE 3 - FITTING ANGULAR ORIENTATION /19/

For more information on this standard, visit
<https://www.sae.org/standards/content/AS624D/>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3D

PROCUREMENT SPECIFICATION: AS604 /2/



AEROSPACE STANDARD

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

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ISSUED 1984-07 REAFFIRMED 2013-01 REVISED 2022-05

TABLE 1 - ASSEMBLY DIMENSIONS

HOSE ASSEMBLY AS624 SIZE CODE	HOSE ASSEMBLY SIZE (REF)	THREAD T PER AS8879 (REF)	A MAX	B GAGE BASIC	C / I/ 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 - ASSEMBLY DIMENSIONS (CONTINUED)

HOSE ASSEMBLY AS624 SIZE CODE	HOSE ASSEMBLY SIZE (REF)	G MIN	G MAX	INSPECTION BALL SIZE / I/ 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



AEROSPACE STANDARD

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

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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	.465 .405	.595 .535	.735 .675	.935 .875	1.090 1.030	1.410 1.350	1.650 1.560
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	FIRESLEEVE (AS1072 SIL-FG) (15 MINUTES) /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	FIRESLEEVE (AS1072 SIL-FG) (5 MINUTES) /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	FIRESLEEVE INTEGRAL SILICONE (15 MINUTES) /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	FIRESLEEVE INTEGRAL SILICONE (5 MINUTES) /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
N	THIN WALL FIRESLEEVE INTEGRAL SILICONE (15 MINUTES) /18/	400	.650 .590	.790 .730	.930 .870	1.130 1.070	1.295 1.235	1.630 1.570	1.860 1.800

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

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TABLE 4 - WEIGHTS (NOMINAL)

HOSE OR SLEEVE CODE	HOSE OR TYPE SLEEVE	UNITS	HOSE SIZE .250	HOSE SIZE .375	HOSE SIZE .500	HOSE SIZE .625	HOSE SIZE .750	HOSE SIZE 1.00	HOSE SIZE 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	FIRESLLEEVE (15 MINUTES) 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	FIRESLLEEVE (5 MINUTES) AS1072	LB/IN	.007	.010	.011	.015	.017	.021	.025
H	FIRESLLEEVE INTEGRAL (15 MINUTES) ON HOSE	LB/IN	.022	.042	.056	.081	.102	.154	.190
J	FIRESLLEEVE INTEGRAL (5 MINUTES) 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
N	THIN WALL FIRESLLEEVE INTEGRAL (15 MINUTES) ON HOSE	LB/IN	.020	.038	.052	.072	.101	.163	.173
NONE	FIRESLLEEVE CLAMP (*)	LB/EA	.020	.020	.025	.026	.026	.033	.038
NONE	FITTING END (45°) (*)	LB/EA	.078	.130	.221	.327	.597	.860	1.581

(*) NOTE: FIRESLLEEVE 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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HOSE ASSEMBLY, 3000 PSI, PTFE, FLARELESS,
45° TO 45°, HEAVYWEIGHT

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