

REV.
C

SAE AS652

FEDERAL SUPPLY CLASS
4720

RATIONALE

ESTABLISH CUFF DIMENSIONAL REQUIREMENTS FOR INTEGRAL FIRE SLEEVE ON HOSE AND SLEEVE CODE H & J CONFIGURATIONS, FOR STANDARIZATION PURPOSES.

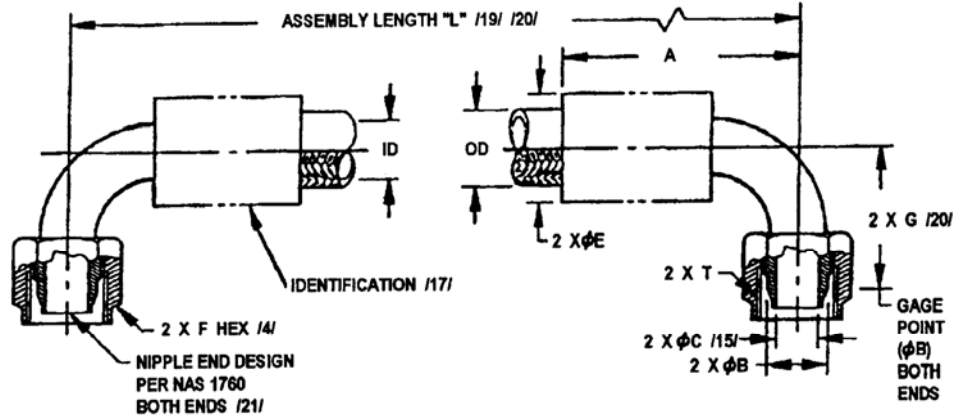


FIGURE 1 - HOSE ASSEMBLY

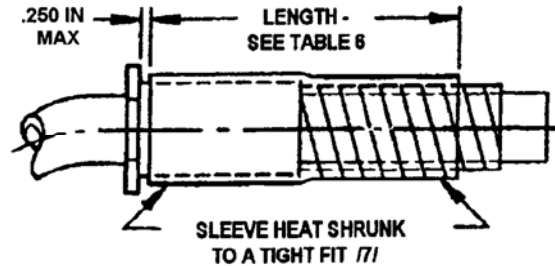


FIGURE 2 - ABRASION SLEEVE ATTACHMENT

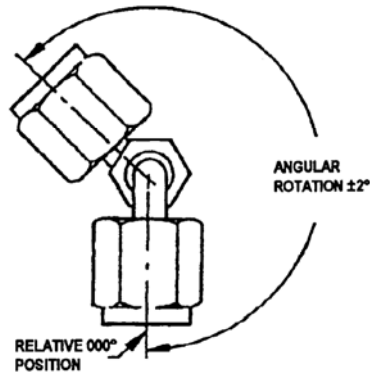
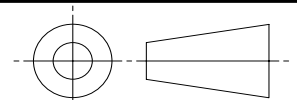


FIGURE 3 - FITTING ANGULAR POSITION /26/

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THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3D

PROCUREMENT SPECIFICATION: /14/ AS1946

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

HOSE ASSEMBLY, POLYTETRAFLUOROETHYLENE, METAL BRAID, MEDIUM PRESSURE, FLARELESS, 90° TO 90°

SAE AS652
SHEET 1 OF 7

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ISSUED 1992-06 REAFFIRMED 2007-07 REVISED 2011-06

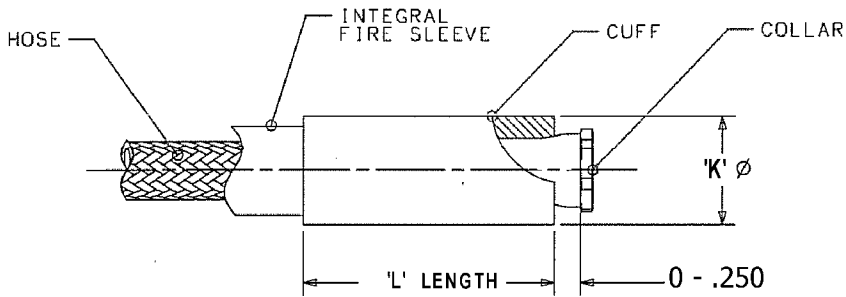


FIGURE 4 – SEE TABLE 8 /27/

TABLE 1 - DIMENSIONS

Hose Assembly No. & Size /24/	Hose Size (ref)	Fitting Mat /24/ /25/	Thread T per AS8879 (ref)	Hose ID Min (ref)	A Max	B Gage Basic	C Dia Min /15/	Min Ball Dia /15/	E Max Without Sleeving /16/	F Hex (ref)	G Min	G Max
AS652D (-03)	.188	CRES	.3750-24UNJF-3B	.110	1.340	.2340	.080	.068	.49	.500	.612	.761
		AL	.3750-24UNJF-3B	.110	1.340	.2340	.080	.068	.49	.500	.612	.761
		TI	.3750-24UNJF-3B	.110	1.340	.2340	.080	.068	.49	.500	.612	.761
AS652E (-04)	.250	CRES	.4375-20UNJF-3B	.173	1.410	.2930	.132	.112	.55	.562	.624	.768
		AL	.4375-20UNJF-3B	.173	1.410	.2930	.132	.112	.55	.562	.624	.768
		TI	.4375-20UNJF-3B	.173	1.410	.2930	.132	.112	.55	.562	.624	.768
AS652F (-05)	.313	CRES	.5000-20UNJF-3B	.235	1.580	.3500	.193	.164	.63	.625	.730	.917
		AL	.5000-20UNJF-3B	.235	1.580	.3500	.193	.164	.63	.625	.730	.917
		TI	.5000-20UNJF-3B	.235	1.580	.3500	.193	.164	.63	.625	.730	.917
AS652G (-06)	.375	CRES	.5625-18UNJF-3B	.298	1.700	.4120	.256	.218	.70	.688	.794	1.023
		AL	.5625-18UNJF-3B	.298	1.700	.4120	.256	.218	.70	.688	.794	1.023
		TI	.5625-18UNJF-3B	.298	1.700	.4120	.256	.218	.70	.688	.794	1.023
AS652H (-08)	.500	CRES	.7500-16UNJF-3B	.391	1.960	.5600	.340	.289	.83	.875	.912	1.218
		AL	.7500-16UNJF-3B	.391	1.960	.5600	.340	.289	.83	.875	.912	1.218
		TI	.7500-16UNJF-3B	.391	1.960	.5600	.340	.289	.83	.875	.912	2.906
AS652J (-10)	.625	CRES	.8750-14UNJF-3B	.485	2.370	.6730	.430	.366	.97	1.000	1.100	1.529
		AL	.8750-14UNJF-3B	.485	2.370	.6730	.430	.366	.97	1.000	1.100	1.529
		TI	.8750-14UNJF-3B	.485	3.623	.6730	.430	.366	.97	1.000	2.780	2.906
AS652K (-12)	.750	CRES	1.0625-12UNJ-3B	.615	2.650	.8100	.548	.466	1.17	1.250	1.400	1.772
		AL	1.0625-12UNJ-3B	.615	2.650	.8100	.548	.466	1.17	1.250	1.400	1.772
		TI	1.0625-12UNJ-3B	.615	4.260	.8100	.548	.466	1.17	1.250	3.020	3.283
AS652M (-16)	1.000	CRES	1.3125-12UNJ-3B	.851	3.340	1.0620	.778	.661	1.52	1.500	1.541	1.859
		AL	1.3125-12UNJ-3B	.851	3.340	1.0620	.778	.661	1.52	1.500	1.541	1.859
		TI	1.3125-12UNJ-3B	.851	5.290	1.0620	.778	.661	1.52	1.500	3.820	4.067
AS652N (-20)	1.250	CRES	1.6250-12UNJ-3B	1.101	3.670	1.3160	1.000	.850	2.00	2.000	1.900	2.091
		AL	1.6250-12UNJ-3B	1.101	4.400	1.3160	1.000	.850	2.00	2.000	3.400	3.641
		TI	1.6250-12UNJ-3B	1.101	5.650	1.3160	1.000	.850	2.00	2.000	4.665	4.891
AS652P (-24)	1.500	CRES	1.8750-12UNJ-3B	1.344	4.190	1.5650	1.250	1.063	2.28	2.125	2.285	2.644
		AL	1.8750-12UNJ-3B	1.344	5.170	1.5650	1.250	1.063	2.28	2.125	4.050	4.292
		TI	1.8750-12UNJ-3B	1.344	6.670	1.5650	1.250	1.063	2.28	2.125	5.550	5.792

TABLE 2 - TOLERANCES

HOSE ASSEMBLY LENGTH	TOLERANCE
UNDER 18 IN	±.125
18 TO 36 IN EXCLUSIVE	±.250
36 TO 50 IN EXCLUSIVE	±.500
50 IN AND OVER	±1%

TABLE 3 - HOSE AND SLEEVE CODES

HOSE OR SLEEVE CODE	SLEEVE MATERIAL	TEMP. LIMIT °F
-	(-) INDICATES HOSE ONLY, NO SLEEVE (AS639)	450
A	ABRASION SLEEVE TUBULAR (PTFE - AS1291 - CODE B) /6/	450
B	ABRASION SLEEVE COIL (NYLON AS1294) /7/	275
C	FIRE SLEEVE (AS1072 SIL-FG) (15 MIN) /8/ /9/ /13/	450
E	ABRASION SLEEVE SHRINK-ON (FEP) /11/	350
F	ABRASION SLEEVE SHRINK-ON (POLYOLEFIN AS1073 - CODE B) /11/	275
G	FIRE SLEEVE (AS1072 SIL-FG) (5 MIN) /8/ /9/ /12/	450
H	FIRE SLEEVE INTEGRAL SILICONE (AS1723) (15 MIN) /13/ /27/	450
J	FIRE SLEEVE INTEGRAL SILICONE (5 MIN) /12/ /27/	450
K	INTEGRAL ABRASION SLEEVE (BRAIDED) POLYESTER /10/	300
L	ABRASION SLEEVE COIL (PTFE - AS1293) /7/	450

TABLE 4 - HOSE AND SLEEVE OUTSIDE DIAMETERS

HOSE OR SLEEVE CODE	TOLERANCE	HOSE SIZE /5/	HOSE SIZE /5/	HOSE SIZE /5/	HOSE SIZE /5/	HOSE SIZE /5/	HOSE SIZE /5/	HOSE SIZE /5/	HOSE SIZE /5/	HOSE SIZE /5/	HOSE SIZE /5/
-	MAX	.285	.343	.406	.469	.585	.687	.812	1.140	1.390	1.707
	MIN	.234	.304	.367	.430	.546	.641	.766	1.078	1.328	1.637
A	MAX	.390	.473	.524	.620	.715	.818	.955	1.295	1.550	1.841
	MIN	.320	.393	.454	.515	.645	.748	.870	1.210	1.450	1.771
B	MAX	.339	.409	.472	.535	.669	.767	.896	1.224	1.474	1.807
	MIN	.260	.330	.393	.456	.590	.681	.810	1.122	1.372	1.681
C	MAX	.692	.692	.780	.840	.970	1.090	1.220	1.590	1.900	2.190
	MIN	.533	.533	.598	.658	.778	.908	1.038	1.288	1.658	1.898
E	MAX	.301	.375	.438	.507	.635	.749	.887	1.288	1.440	1.761
	MIN	.248	.320	.383	.452	.578	.679	.811	1.146	1.358	1.667
F	MAX	.341	.411	.474	.547	.663	.769	.904	1.244	1.482	1.823
	MIN	.278	.348	.411	.484	.600	.699	.834	1.158	1.396	1.729
G	MAX	.692	.692	.780	.840	.970	1.090	1.220	1.590	1.900	2.190
	MIN	.533	.533	.598	.658	.778	.908	1.038	1.288	1.658	1.898
H	MAX	.641	.641	.704	.766	.891	1.016	1.141	1.454	1.704	2.016
	MIN	.537	.594	.657	.719	.844	.949	1.074	1.394	1.649	1.957
J	MAX	.641	.641	.704	.766	.891	1.016	1.141	1.454	1.704	2.016
	MIN	.537	.594	.657	.719	.844	.949	1.074	1.394	1.649	1.957
K	MAX	.378	.430	.499	.559	.665	.772	.887	1.210	1.460	1.782
	MIN	.320	.390	.450	.510	.625	.726	.841	1.148	1.398	1.712
L	MAX	.375	.445	.508	.571	.687	.789	.914	1.242	1.492	1.809
	MIN	.267	.333	.407	.470	.586	.681	.828	1.138	1.388	1.697