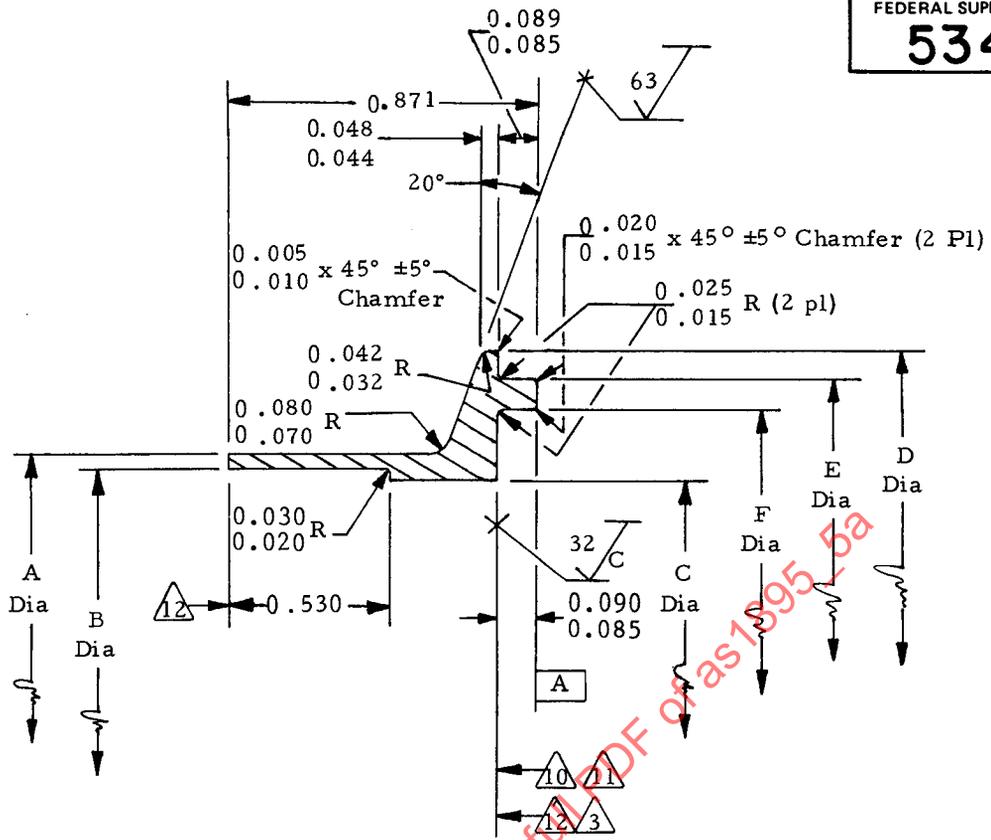


AS1895/5

FEDERAL SUPPLY CLASS
5340



PART NUMBER	NOM TUBE SIZE	A DIA +.000 -.005	B DIA +.005 -.000	C DIA +.005 -.000	D DIA ±.005	E DIA +.000 -.005	F DIA +.003 -.000	MAX WT IN LBS
AS1895/5-100	1.00	1.069	1.005	0.900	1.510	1.365	1.250	0.074
AS1895/5-125	1.25	1.319	1.255	1.150	1.760	1.615	1.500	0.095
AS1895/5-150	1.50	1.569	1.505	1.400	2.010	1.865	1.750	0.105
AS1895/5-175	1.75	1.819	1.755	1.650	2.260	2.115	2.000	0.126
AS1895/5-200	2.00	2.069	2.005	1.900	2.510	2.365	2.250	0.137
AS1895/5-225	2.25	2.319	2.255	2.150	2.760	2.615	2.500	0.158
AS1895/5-250	2.50	2.569	2.505	2.400	3.010	2.865	2.750	0.179
AS1895/5-275	2.75	2.819	2.755	2.650	3.260	3.115	3.000	0.189
AS1895/5-300	3.00	3.069	3.005	2.900	3.510	3.365	3.250	0.210
AS1895/5-325	3.25	3.319	3.255	3.150	3.760	3.615	3.500	0.221
AS1895/5-350	3.50	3.569	3.505	3.400	4.010	3.865	3.750	0.242
AS1895/5-400	4.00	4.069	4.005	3.900	4.510	4.365	4.250	0.263
AS1895/5-450	4.50	4.569	4.505	4.400	5.010	4.865	4.750	0.294
AS1895/5-500	5.00	5.069	5.005	4.900	5.510	5.365	5.250	0.326
AS1895/5-550	5.50	5.569	5.505	5.400	6.010	5.865	5.750	0.368
AS1895/5-600	6.00	6.069	6.005	5.900	6.510	6.365	6.250	0.399

SHEET	1	2	3
REV.	A	A	A

CUSTODIAN: SAE G-3/G-3A PROCUREMENT SPECIFICATION AS1895

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

AEROSPACE STANDARD
FLANGE, MALE, SEAM WELD,
TYPE II (LOW PROFILE)

AS1895/5
SHEET 1 OF 3

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ISSUED 12-85 REVISED (A) 2-88

NOTES:

1. Construction and Performance:

This flange, when mated with flange end per AS1895/15-XXX, flange P/N AS1895/6-XXX, flange P/N AS1895/9-XXX, seal P/N AS1895/7-XXX and coupling P/N AS1895/4-XXX, shall meet all the requirements of specification AS1895.

2. Material:

Dash numbers 100 through 350 - Nickel Alloy 625 in accordance with AMS 5666 or AMS 5599.

Dash numbers 400 to 600 - Nickel Alloy 718 in accordance with AMS 5596 or AMS 5662 in the precipitate hardened condition,



Sealing surface shall be free of scratches and surface finish shall be circular and concentric to bore diameter.

4. Do not use unassigned part codes.

5. Finish:

Descaled. Free of surface contamination.

6. Inspection Requirement - Manufacturer:

Penetrant inspect all flanges in accordance with MIL-I-6866.

7. Workmanship:

The flanges shall be free of sharp edges and burrs and shall be capable of mating under all tolerance conditions of the component parts.

8. Tolerances:

.XXX = ± 0.10 , .XX = ± 0.03 , angles = $\pm 1/2^\circ$.

9. Concentricity:

All diameters shall be concentric to bore diameter within .004 TIR.



Perpendicularity:

Noted surface to be perpendicular to C dia within .004 TIR.



Flatness:

Noted surface to be flat within .003 TIR.



Parallelism:

Noted surfaces to be parallel with surface marked A within .003 TIR.

13. All surfaces to be $\sqrt{125}$ except as noted.

14. Marking:

Mark packaging with supplier identification and AS1895/5-XXX part number.

15. Flatness Limit After Welding is .005 TIR. Exception:

For sizes 500 thru 600 (5.00-6.00 Inch) an increase to .007 TIR is acceptable.

CUSTODIAN: SAE G-3/G-3A

PROCUREMENT SPECIFICATION:

AS1895

AEROSPACE STANDARD

FLANGE, MALE, SEAM WELD,
TYPE II, (LOW PROFILE)

AS 1895/5

SHEET 2 OF 3