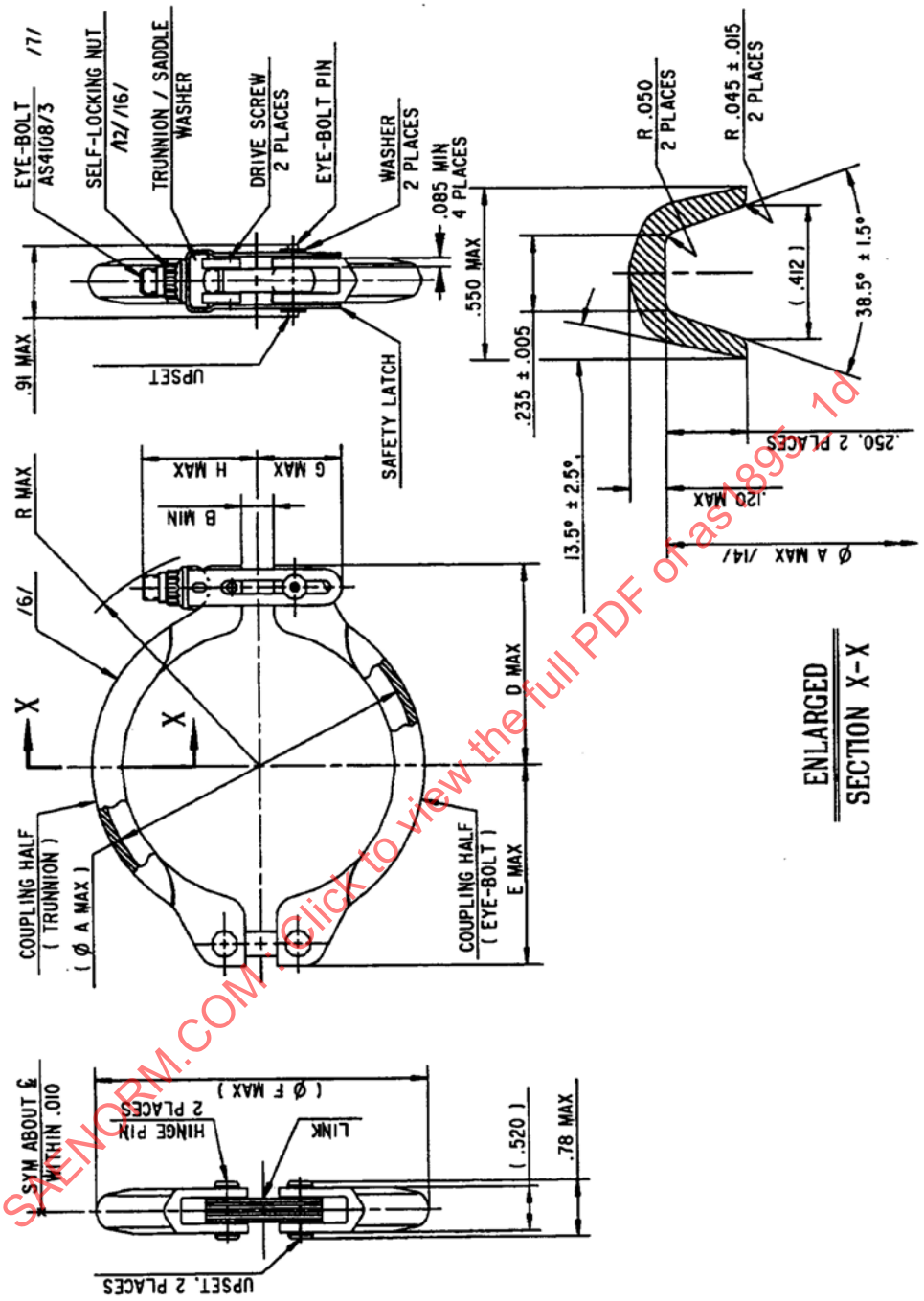
RATIONALE

FEDERAL SUPPLY CLASS
5340

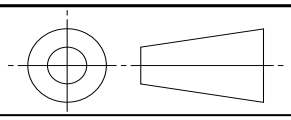
AS1895/1D HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.



(R) FIGURE 1 - STANDARD PROFILE COUPLING

SAE values your input. To provide feedback on this Technical Report, please visit
http://www.sae.org/technical/standards/AS1895/1D

THIRD ANGLE PROJECTION



ISSUED 1985-12 REVISED 1996-05 REAFFIRMED 2013-01

CUSTODIAN: G-3/G-3A

PROCUREMENT SPECIFICATION: /3/ AS1895

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

COUPLING, V-RETAINER, SINGLE LATCH,
TYPE I STANDARD PROFILE

SAE AS1895/1
SHEET 1 OF 4

REV. D

(R) TABLE 1 - DIMENSIONS AND WEIGHTS

BASIC NUMBER AS1895/1 SIZE CODE /1/ /2/ /17/	(TUBE SIZE)	A	B	D	E	F	G	H	R	LB/EA MAX
150	1.50	2.385	.100	1.843	1.780	2.656	.968	1.410	2.126	.40
175	1.75	2.635	.150	1.880	1.857	2.906	.875	1.425	2.250	.41
200	2.00	2.885	.175	2.093	2.030	3.156	.898	1.450	2.360	.42
225	2.25	3.135	.175	2.130	2.107	3.406	.898	1.450	2.485	.44
250	2.50	3.385	.190	2.343	2.280	3.656	.925	1.475	2.569	.46
275	2.75	3.635	.190	2.468	2.410	3.906	.984	1.525	2.700	.49
300	3.00	3.885	.190	2.593	2.530	4.156	1.000	1.550	2.824	.51
325	3.25	4.135	.190	2.630	2.607	4.406	1.024	1.575	2.950	.54
350	3.50	4.385	.190	2.755	2.780	4.656	1.059	1.550	3.058	.57
400	4.00	4.885	.250	3.015	2.972	5.156	1.024	1.575	3.263	.63
450	4.50	5.385	.250	3.265	3.222	5.656	1.109	1.600	3.519	.67
500	5.00	5.885	.300	3.520	3.467	6.156	1.074	1.625	3.732	.72
550	5.50	6.385	.300	3.765	3.722	6.656	1.149	1.650	3.970	.77
600	6.00	6.885	.400	4.015	3.972	7.156	1.400	1.675	4.208	.81
650	6.50	7.385	.400	4.265	4.222	7.656	1.400	1.675	4.468	.86
700	7.00	7.885	.450	4.515	4.477	8.156	1.400	1.675	4.724	.93
750	7.50	8.385	.450	4.765	4.732	8.656	1.400	1.800	4.973	.98

NOTES:

/1/ (R) TABLE 2 - COUPLING COMPONENT MATERIAL

PART	MATL	TYPE	SPEC	REMARKS
COUPLING HALVES	CRES	A-286	AMS 5525 AMS 5732	SOLUTION AND PRECIPITATION HEAT TREATED. SEE /2/.
	NICKEL ALLOY	718	AMS 5596 AMS 5662	
TRUNNION/ SADDLE WASHER	CRES	A-286	AMS 5731 AMS 5732 AMS 5734 AMS 5737	SOLUTION AND PRECIPITATION HEAT TREATED OR EQUIVALENT MATERIAL PROPERTIES ACHIEVED BY COLD WORK.
	NICKEL ALLOY	713	AMS 5377	
EYEBOLT	CRES	A-286	AMS 5731 AMS 5732 AMS 5737	SEE /2/ AND /7/.
SAFETY LATCH	NICKEL ALLOY	718	AMS 5596	SOLUTION AND PRECIPITATION HEAT TREATED.
SELF-LOCKING NUT	CRES	A-286	AMS 5731 AMS 5732	SEE /2/ AND /7/.
EYEBOLT PIN	CRES	A-286	AMS 5731 AMS 5732	SOLUTION AND PRECIPITATION HEAT TREATED.
WASHER	CRES	303 OR 304	AMS 5640 AMS 5513	
LINK	CRES	A-286	AMS 5731 AMS 5732 AMS 5525	SOLUTION HEAT TREATED OR SOLUTION AND PRECIPITATION HEAT TREATED.
HINGE PIN	CRES	A-286	AMS 5731 AMS 5732 AMS 5734 AMS 5737	SOLUTION AND PRECIPITATION HEAT TREATED.
DRIVE SCREW	CRES CRES CRES NICKEL ALLOY	302HQ 305 A-286 718		

/2/ FINISH:

(R) a. SELF-LOCKING NUT: BLANK = SILVER PLATED OR L = DRY FILM LUBED.

b. COUPLING HALVES: INSIDE SURFACE OF ALL COUPLING HALVES SHALL BE COATED WITH SOLID DRY FILM LUBRICANT PER AS1895 AFTER PASSIVATION. A-286 CRES MATERIAL - PASSIVATE PER QQ-P-35 TYPES I, II, III, OR VIII AND/OR MECHANICAL POLISH OR ELECTROPOLISH TO REMOVE IRON PARTICLES.

c. 718 MATERIAL: NO FINISH REQUIRED. NOTE: THE OUTSIDES OF 718 COUPLING FLANKS SHALL HAVE LAY LINE MARKINGS WITH "—1000F—" (SEE AS1895).

d. EYEBOLT: LUBRICATE WITH FEL-PRO C102, FEL-PRO C-200 (FEL-PRO INC CAGE CODE 73165) OR EQUIVALENT.

NOTES (CONTINUED):

/3/ QUALIFICATION: PARTS SHALL BE QUALIFIED IN A COMPLETE COUPLING ASSEMBLY IN ACCORDANCE WITH PROCUREMENT SPECIFICATION AS1895. USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVAL(S) BY STANDARD PAGE SUPPLEMENT SHEET OR SIMILAR MEANS.

4. ACCEPTANCE TEST: EACH COUPLING SHALL BE SUBJECT TO A HYDROSTATIC PROOF PRESSURE TEST PER AS1895.

5. (R) INTERMATEABILITY: THIS COUPLING, WHEN MATED WITH FLANGES, FLANGE ENDS, AND SEALS CONFORMING TO AS1895/2-XXX, AS1895/3-XXX, AS1895/7-XXX, AS1895/10-XXX, AS1895/11-XXX, AS1895/12-XXX, AS1895/13-XXX, AS1895/18-XXX, AS1895/19-XXX, AND AS1895/23-XXX SHALL MEET ALL THE REQUIREMENTS OF SPECIFICATIONS AS1895.

/6/ (R) MARKING: BY ELECTROCHEMICAL ETCHING PER AS478-7A2 OR LASER MARKING PER AS478-15A2. THE COUPLING SHALL BE MARKED AS FOLLOWS:

a. AS1895/1
b. SUPPLIER PART NO.
c. SUPPLIER NAME OR TRADEMARK AND CAGE CODE
d. DATE OF MANUFACTURE
e. TORQUE - "CAUTION: TORQUE TO 120 ± 5 lb-in" /12/

/7/ THREADS:

a. EYEBOLT AND NUT THREADS CONFORM TO MIL-S-8879
b. EYEBOLT THREAD .3125-24UNJF-3A
c. SELF-LOCKING NUT THREAD .3125-24UNJF-3B

8. OPERATING TEMPERATURE: -65 TO +1200 °F FLUID TEMPERATURE.

9. BREAK EDGES .003 TO .015 UNLESS OTHERWISE SPECIFIED.

10. DIMENSIONING AND TOLERANCING: ANSI Y14.5M 1982

11. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS .XXX = ±.010, .XX = ±.03, ANGULAR DIMENSIONS ±0.5°.

/12/ TORQUE - COUPLING INSTALLATION TORQUE = 120 ± 5 lb-in.

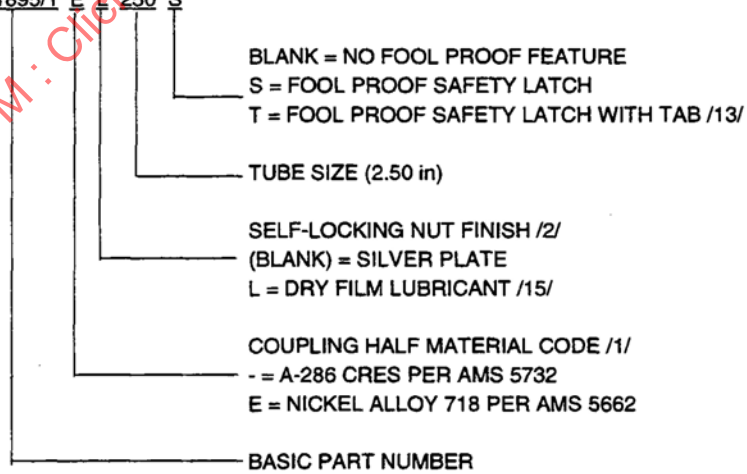
/13/ THE FOOL PROOF SAFETY FEATURE RESULTS IN AN INCREASE OF R MAX BY .020 in MAX, AND IN A WEIGHT INCREASE OF .026 lb MAX.

/14/ DIA A MAX IS FOR MACHINING PURPOSES ONLY, TO BE INSPECTED DURING MACHINING OPERATION.

15. THE (R) IS FOR THE CONVENIENCE OF THE USER IN LOCATING AREAS WHERE TECHNICAL REVISIONS, NOT EDITORIAL CHANGES, HAVE BEEN MADE TO THE PREVIOUS ISSUE OF THIS STANDARD.

/16/ (R) INTENDED USE: USE SOLID FILM LUBRICATED NUTS AT NUT TEMPERATURES OF 1000 °F AND OVER.

/17/ (R) EXAMPLE OF PART NUMBER: AS1895/1 E - 250 S



NOTE: AS1895/1-250 IS SAME SIZE COUPLING AS ABOVE, WITH A-286 COUPLING HALVES, A SILVER PLATED NONLUBRICATED NUT, AND WITHOUT FOOL PROOF FEATURE.