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Superseding AS614B

Hose Assembly, Polytetrafluoroethylene, Metallic Reinforced,
4000 psi, 400 °F, Heavy Duty, Hydraulic and Pneumatic

RATIONALE

Added periodic testing requirements for fire resistant hose assemblies, relocated fire test qualification requirements from NOTES paragraph 6.1.1 to qualification testing paragraphs 3.5.2.14 and 4.6.16, and revised Tables 4A and 4B to reflect applicable fire test paragraph.

1. SCOPE

This Aerospace Standard (AS) defines the requirements for a heavy duty polytetrafluoroethylene (PTFE) lined, metallic reinforced, hose assembly suitable for use in high temperature, high pressure, 4000 psi, aircraft and missile hydraulic fluid systems.

2. APPLICABLE DOCUMENTS

The following publications form a part of this document to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order. In the event of conflict between the text of this document and references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

2.1 SAE Publications

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or 724-776-4970 (outside USA), www.sae.org.

AMS2486	Conversion Coating of Titanium Alloys, Fluoride-Phosphate Type
AMS4928	Titanium Alloy, Bars, Wire, Forgings, Rings, and Drawn Shapes, 6Al - 4V, Annealed
AMS4945	Titanium Alloy Tubing, Seamless, Hydraulic, 3Al - 2.5V, Controlled Contractile Strain Ratio, Cold Worked, Stress Relieved
AMS4965	Titanium Alloy, Bars, Wire, Forgings, and Rings, 6.0Al - 4.0V, Solution Heat Treated and Aged

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on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS614C>**

AMS5556	Steel, Corrosion and Heat-Resistant, Seamless or Welded Tubing, 18Cr - 11Ni - 0.70Cb (SAE 30347) Solution Heat Treated
AMS5557	Steel, Corrosion and Heat-Resistant, Seamless or Welded Hydraulic Tubing, 18.5Cr - 10.5Ni - 0.40Ti (SAE 30321), Solution Heat Treated
AMS5567	Steel, Corrosion Resistant, Seamless or Welded Hydraulic Tubing, 19Cr - 10Ni (SAE 30304), Solution Heat Treated
AMS5561	Steel, Corrosion and Heat-Resistant, Welded and Drawn or Seamless and Drawn tubing, 9.0Mn - 20Cr - 6.5Ni - 0.28N, High-Pressure Hydraulic
AMS5570	Steel, Corrosion and Heat-Resistant, Seamless Tubing, 18Cr - 11Ni - 0.40Ti (SAE 30321), Solution Heat Treated
AMS5571	Steel, Corrosion and Heat-Resistant, Seamless Tubing, 18Cr - 10.5Ni - 0.70Cb (Nb) (347), Solution Heat Treated
AMS5573	Steel, Corrosion and Heat-Resistant, Seamless Tubing, 17Cr - 12Ni - 2.5Mo (SAE 30316), Solution Heat Treated
AMS5575	Steel, Corrosion and Heat-Resistant, Welded Tubing, 18Cr - 10.5Ni - 0.70Cb(Nb) (SAE 30347), Solution Heat Treated
AMS5576	Steel, Corrosion and Heat-Resistant, Welded Tubing, 18Cr - 10.5Ni - 0.40Ti (SAE 30321), Solution Heat Treated
AMS5581	Nickel Alloy, Corrosion and Heat-Resistant, Seamless or Welded Tubing, 62Ni - 21.5Cr - 9.0Mo - 3.7Cb (Nb), Annealed
AMS5636	Steel, Corrosion-Resistant, Bars and Wire, 18Cr - 9.0Ni (SAE 30302) Solution Heat Treated and Cold Drawn, 100 ksi (689 MPa) Tensile Strength
AMS5637	Steel, Corrosion Resistant, Bars and Wire, 18Cr - 9.0Ni (SAE 30302) Solution Heated Treated, Cold Drawn and Stress Relieved, 125 ksi (862 MPa) Tensile Strength
AMS5639	Steel, Corrosion-Resistant, Bars, Wire, Forgings, Tubing, and Rings, 19Cr - 10Ni, Solution Heat Treated
AMS5643	Steel, Corrosion-Resistant, Bars, Wire, Forgings, Tubing, and Rings, 16Cr - 4.0Ni - 0.30Cb - 4.0Cu, Solution Heat Treated, Precipitation Hardenable
AMS5644	Steel Bars and Forgings, Corrosion Heat Resistant, 17Cr - 7Ni - 1Al
AMS5645	Steel, Corrosion and Heat Resistant, Bars, Wire, Forgings, Tubing, and Rings, 18Cr - 10Ni - 0.40Ti (321), Solution Heat Treated
AMS5646	Steel, Corrosion and Heat-Resistant, Bars, Wire, Forgings, Tubing, and Rings, 18Cr - 11Ni - 0.60Cb(Nb) (347), Solution Heat Treated
AMS5647	Steel, Corrosion-Resistant, Bars, Wire, Forgings, Tubing, and Rings, 19Cr - 9.5Ni, Solution Heat Treated
AMS5648	Steel, Corrosion and Heat-Resistant, Bars, Wire, Forgings, Tubing, and Rings, 17Cr - 12Ni - 2.5Mo (316), Solution Heat Treated

AMS5653	Steel, Corrosion and Heat-Resistant, Bars, Wire, Forgings, Tubing, and Rings, 17Cr - 12Ni - 2.5Mo (0.030 Max C) (316L), Solution Heat Treated
AMS5659	Steel, Corrosion-Resistant, Bars, Wire, Forgings, Rings, and Extrusions, 15Cr - 4.5Ni - 0.30Cb (Nb) - 3.5Cu, Consumable Remelted, Precipitation Hardenable
AMS5666	Nickel Alloy, Corrosion and Heat-Resistant, Bars, Forgings, Extrusions, and Rings, 62Ni - 21.5Cr - 9.0Mo - 3.65 (Cb [Nb]+Ta), Annealed
AMS5688	Steel, Corrosion-Resistant, Wire, 18Cr - 9.0Ni (SAE 30302), Spring Temper
AMS5689	Steel, Corrosion and Heat Resistant, Wire, 18Cr - 10.5Ni - 0.40Ti (SAE 30321), Solution Heat Treated
AMS5690	Steel, Corrosion and Heat Resistant, Wire, 17Cr - 12Ni - 2.5Mo (SAE 30316), Solution Heat Treated
AMS5697	Steel, Corrosion-Resistant, Wire, 19Cr - 9.5Ni (SAE 30304), Solution Heat Treated
AMS5743	Steel, Corrosion and Heat-Resistant, Bars and Forgings, 15.5Cr - 4.5Ni - 2.9Mo - 0.10N, Solution Heat Treated, Sub-Zero Cooled, Equalized, and Over-Tempered
AMS-QQ-P-35	Passivation Treatments for Corrosion-Resistant Steels
AMS-QQ-S-763	Steel, Corrosion Resistant, Bars, Wire, Shapes, and Forgings
AS150	Hose Assembly, Type Classifications of, Basic Performance and Fire Resistance
AS611	Hose Assembly and Tubing, Polytetrafluoroethylene, Cleaning Methods for
ARP908	Torque Requirements, Installation and Qualification Test, Hose and Tube Fitting
AS1055	Fire Testing of Flexible Hose, Tube Assemblies, Coils, Fittings, and Similar System Components
ARP1835	Preparation for Delivery, General Requirements for Hose Assemblies
AS2078	Test Methods, Hose Assemblies, Polytetrafluoroethylene (PTFE)
AS4375	Fitting End, Flareless, Design Standard
AS4395	Fitting End, Flared, Tube Connection, Design Standard
AS7003	Nadcap Program Requirements
AS7112	National Aerospace and Defense Contractors Accreditation Program Requirements for Fluid System Components
AS8879	Screw Threads - UNJ Profile, Inch, Controlled Radius Root with Increased Minor Diameter
AS33514	Fitting End, Standard Dimensions for Flareless Tube Connection and Gasket Seal
AS85421	Fittings, Tube, Fluid Systems, Separable, Beam Seal, 3000/4000 psi, General Specification for

2.2 ASME Publications

Available from American Society of Mechanical Engineers, 22 Law Drive, P.O. Box 2900, Fairfield, NJ 07007-2900, Tel: 973-882-1170, www.asme.org.

ASME B46.1 Surface Texture

ASME Y14.24 Types and Applications of Engineering Drawings

ASME Y14.34M Parts Lists, Data Lists, and Index Lists: Associated Lists

ASME Y14.35M Revision of Engineering Drawings and Associated Documents

ASME Y14.100 Engineering Drawing Practices

2.3 ASTM Publications

Available from ASTM International, 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959, Tel: 610-832-9585, www.astm.org.

ASTM A 262 Standard Recommended Practices for Detecting Susceptibility to Intergranular Attack in Stainless Steel

ASTM A 313 Standard Specification for Stainless Steel Spring Wire

ASTM A 580 Specification for Stainless and Heat Resisting Steel Wire

2.4 NAS Standards

Available from Aerospace Industries Association, 1000 Wilson Boulevard, Suite 1700, Arlington, VA 22209-3928, Tel: 703-358-1000, www.aia-aerospace.org.

NAS 847 Caps and Plugs, Protective, Dust and Moisture Seal

NAS 1760 Fitting End, Flareless Acorn, Standard Dimensions for

2.5 PRI Publications

Available from Performance Review Institute, 161 Thorn Hill Road, Warrendale, PA 15086-7527, Tel: 724-772-1616, www.pri-network.org.

PD2001 Qualified Product Management Council Procedures for Qualified Products Group

PD2101 Aerospace Quality Assurance, Product Standard, Qualification Procedures, Fluid Systems

2.6 U.S. Government Publications

Available from the Document Automation and Production Service (DAPS), Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094, Tel: 215-697-9495, <https://assist.daps.dla.mil/quicksearch/>.

MIL-HDBK-831 Preparation of Test Reports

MIL-H-5606 Hydraulic Fluid, Petroleum Based; Aircraft; Missile and Ordnance

MIL-PRF-680 Degreasing Solvent

MIL-PRF-7808 Lubricating Oil, Aircraft Turbine Engine, Synthetic Base

MIL-PRF-83282	Hydraulic Fluid, Fire Resistant Synthetic Hydrocarbon Base, Aircraft
MIL-PRF-87257	Hydraulic Fluid, Fire Resistant; Low Temperature, Synthetic Hydrocarbon Base, Aircraft and Missile
MIL-STD-130	Identification Marking of U.S. Military Property

2.7 Hose Assembly Procurement Specifications

Refer to AS614SUP1 for a listing of applicable hose assembly procurement standards applicable to this document.

3. TECHNICAL REQUIREMENTS

3.1 Qualification

Hose assemblies supplied in accordance with this document shall be representative of products which have been subjected to and which have successfully passed the qualification tests in this standard.

3.1.1 Manufacturer Qualification

A manufacturer producing a product in conformance to this procurement specification shall be accredited in accordance with the requirements of PD2101, AS7003 and AS7112, and shall be listed in a Performance Review Institute (PRI) Qualified Manufacturers List (QML).

3.1.2 Product Qualification

All products shall conform to the requirements of this procurement specification and shall be approved in accordance with the requirements of PD2001 and PD2101, for listing in a Performance Review Institute (PRI) Qualified Parts List (QPL).

3.2 Material

The hose assembly materials shall be uniform in quality, free from defects, consistent with good manufacturing practice, shall conform to applicable specifications and the requirements specified herein, and suitable for the purpose intended.

3.2.1 Metals

Metals used in the hose and fittings shall be corrosion-resistant and shall conform to the following specification:

a. Bars and Forgings:

- (1) AMS-QQ-S-763 Class 302 - Cond. A or Cond. B (AMS5636 or AMS5637)
- (2) AMS-QQ-S-763 Class 304 - Cond. A or Cond. B (AMS5639)
- (3) AMS-QQ-S-763 Class 304L - Cond. A (AMS5647)
- (4) AMS-QQ-S-763 Class 316 - Cond. A (AMS5648)
- (5) AMS-QQ-S-763 Class 316L - Cond. A (AMS5653)
- (6) AMS-QQ-S-763 Class 321 - Cond. A (AMS5645)
- (7) AMS-QQ-S-763 Class 347 - Cond. A (AMS5646)
- (8) AMS5643 17-4PH

- (9) AMS5644 17-7PH
- (10) AMS5659 15-5PH
- (11) AMS5743 AM-355
- (12) AMS4928 Titanium 6Al-4V Annealed
- (13) AMS4965 Titanium 6Al-4V Heat Treated
- (14) AMS5666 Nickel Alloy Type 625

b. Tubing:

- (1) AMS5567 Type 1 or Type 2 Stainless Steel Tubing, 304
- (2) AMS5573 Seamless Stainless Steel Tubing, 316
- (3) AMS5557 Type 1 or Type 2 Stainless Steel Tubing, 321
- (4) AMS5570 Seamless Stainless Steel Tubing, 321
- (5) AMS5571 Seamless Stainless Steel Tubing, 347
- (6) AMS5571 Seamless Stainless Steel Tubing, 347
- (7) AMS5575 Welded Stainless Steel Tubing, 347
- (8) AMS5556 Type 1 or Type 2 Stainless Steel Tubing, 347
- (9) AMS5561 Welded Stainless Steel Tubing, 21-6-9
- (10) AMS4945 Titanium 3Al-2.5V Texture Controlled
- (11) AMS5581 Type 1 or Type 2 Nickel Alloy Tubing, 625

c. Wire:

- (1) ASTM A 580/ A 313 Comp. 302 (AMS5688)
- (2) ASTM A 580/ A 313 Comp. 304 (AMS5697)
- (3) ASTM A 580/ A 313 Comp. 316 (AMS5690)
- (4) ASTM A 580/ A 313 Comp. 321 (AMS5689)

3.3 Design and Construction

The hose assembly shall consist of a seamless PTFE inner tube, corrosion-resistant steel-wire reinforcement, and corrosion-resistant steel or nickel alloy end fittings as required to meet the construction and performance requirements of this specification and as required for its intended use.

3.3.1 Inner Tube

The inner tube shall be of a seamless construction of virgin PTFE resin of uniform gage. It shall have a smooth bore and shall be free from pitting or projections on the inner surface. Additives may be included in the compound from which the tube is extruded.

3.3.2 Reinforcement

The reinforcement shall consist of corrosion-resistant steel wires conforming to the applicable specifications listed in 3.2.1. The wires shall be so arranged over the inner tube as to provide sufficient strength to ensure conformance with the requirements specified herein. Broken reinforcing wires shall be cause for rejection. Crossed-over reinforcing wires shall not be cause for rejection of the hose assembly.

3.3.3 Interlayers

Interlayers, if used, shall be of a suitable material and shall be resistant to pressure pounding and to all fluids with which the hose may come in contact during normal service. They shall be capable of withstanding temperatures of -65 to 400 °F and shall not extrude through the outer braid during testing or in service.

3.3.4 Fittings

All fittings shall be permanently attached and proven to meet the requirements herein. Standard hose assemblies shall have flared fittings to mate with AS4395; flareless fittings according to NAS 1760 to mate with AS33514 or AS4375; or beam seal fittings per AS85421. Fitting hex portions shall fit standard wrench openings.

3.3.4.1 Straight Fittings

Straight fittings shall be of one piece construction. Weld or braze joints must not be located in the fluid paths, except welded and redrawn corrosion-resistant steel tubing in accordance with 3.2.1 may be used.

3.3.4.2 Other Fittings

Other fittings, including elbow fittings, shall be of one piece construction to the maximum extent possible. However, those made with other than one piece construction can use welded and redrawn corrosion-resistant steel tubing in accordance with 3.2.1 and shall employ a butt weld joint method.

3.3.4.3 End Fitting Collars (Sockets)

All end fitting collars (sockets) crimped or swaged, fabricated from Type 304 stainless steel are required to be capable of passing an embrittlement test as specified in ASTM A 262 Practice E, prior to assembly to the nipple or swaging operation. Sockets fabricated from stabilized austenitic steel (304L, 321, or 347) are acceptable without being subjected to the embrittlement test.

3.3.4.4 Fitting Finish

3.3.4.4.1 Corrosion Resistant Steel Parts

Unless otherwise specified, corrosion resistant steel parts shall be passivated in accordance with AMS-QQ-P-35.

3.3.4.4.2 Titanium Alloy Parts

Titanium alloy parts shall be fluoride phosphate coated per AMS2486.

3.4 Dimensions

The hose assembly dimensions, except for length, shall be as specified in Figure 1 and Table 1.

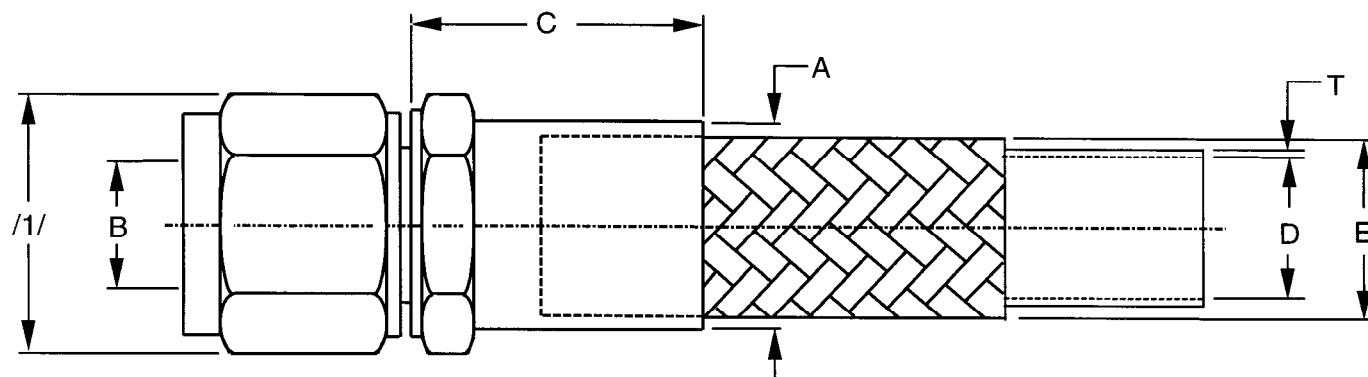


FIGURE 1 - HOSE AND FITTING DIMENSIONS

TABLE 1 - HOSE AND FITTING DIMENSIONS AS SHOWN IN FIGURE 1 (IN)

Hose Size	Rigid Tube OD (Ref)	Fitting OD A Max	Fitting ID B ²⁾ in	Socket Length C Max	Hose ID D Min	Hose OD E Min	Hose OD E Max	Unbraided Inner Tube Wall T Min	Spherical Ball Size for Determining Min Hose Assy. ID ²⁾ in Straight Fittings	Spherical Ball Size for Determining Min Hose Assy. ID ²⁾ in Elbow Fittings
04	0.250	0.875	0.135	2.25	0.212	0.405	0.465	0.035	0.122	0.115
06	0.375	1.000	0.240	2.50	0.298	0.535	0.595	0.035	0.216	0.204
08	0.500	1.200	0.340	2.75	0.391	0.675	0.735	0.045	0.306	0.289
10	0.625	1.406	0.410	3.00	0.485	0.875	0.935	0.045	0.369	0.349
12	0.750	1.687	0.510	3.25	0.602	1.030	1.090	0.045	0.459	0.434
16	1.000	2.000	0.760	3.75	0.852	1.350	1.410	0.050	0.684	0.646
20	1.250	2.100	0.925	3.88	1.101	1.560	1.650	0.050	0.833	0.786

¹ Cross corners of nut and socket hex may exceed "A" dimension.² Minimum Specified inside diameter shall be verified by passing a spherical ball through the hose assembly.

3.4.1 Hose Weight

Hose consisting of inner tube and reinforcement as outlined in 3.3.1 through 3.3.3 shall not exceed the maximum hose weights specified in Table 2A.

TABLE 2 - HOSE WEIGHTS AND PRESSURES

TABLE 2A - PHYSICAL REQUIREMENTS

Hose Size	(Nominal Tube Size)	Hose Weight Max ¹ lb/in	Bend Radius at Inside of Bend Minimum in	Volumetric Expansion Maximum cm ³ /in
04	0.250	0.022	3.000	0.080
06	0.375	0.037	5.000	0.120
08	0.500	0.045	5.750	0.180
10	0.625	0.070	6.500	0.276
12	0.750	0.105	7.750	0.375
16	1.000	0.170	9.625	0.940
20	1.250	0.220	12.000	1.250

¹ Hose weight shall be determined on a minimum length of 12 in.

TABLE 2B - PRESSURE REQUIREMENTS (PSI)

Operating Max	Proof Min	Burst Min Room Temperature	Burst Min Elevated Temperature
4000	8000	16 000	12 000

3.5 Performance

The inner tube and hose assembly shall meet the following performance requirements:

3.5.1 Inner Tube

3.5.1.1 Tube Roll

The tube shall not leak, split, burst, or show any evidence of malfunction when rolled to the flattening and rounding gaps of AS2078 (3000 psi and higher) values. The test method is specified in 4.6.2.1.

3.5.1.2 Tube Proof Pressure

The tube, without reinforcing wires, shall not leak, burst, or show any evidence of malfunction when tested to the AS2078 (3000 psi and higher) proof pressure values for 1 min. The test method is specified in 4.6.2.1.

3.5.1.3 Tensile Strength

The longitudinal tensile strength for all sizes of tubes shall be 2200 psi minimum. The transverse tensile strength for sizes -10 and larger shall be 1800 psi minimum. For sizes -08 and smaller the transverse tensile strength need not be tested. The test method is specified in 4.6.2.2.

3.5.1.4 Elongation

Elongation shall be a minimum of 200%. The test method is specified in 4.6.2.3.

3.5.1.5 Specific Gravity

The specific gravity values of the hose inner tube shall not exceed 2.155 apparent and 2.210 relative. The test method is specified in 4.6.2.4.

3.5.2 Hose Assembly

The hose, complete with reinforcing wires and assembled with end fittings, shall meet the following performance requirements:

3.5.2.1 Proof Pressure

The hose assembly shall withstand the proof pressure listed in Table 2 without malfunction or leakage. The test method is specified in 4.6.3.

3.5.2.2 Elongation and Contraction

The hose assembly shall not change in length by more than $\pm 2\%$ in 10 in of hose length when subjected to the operating pressure in Table 2 for a minimum of 5 min. The test method is specified in 4.6.4.

3.5.2.3 Volumetric Expansion

The volumetric expansion of the hose assemblies shall not exceed the limits specified in Table 2A. The test method is specified in 4.6.5.

3.5.2.4 Leakage

The hose assembly shall not leak (no external wetting) when subjected to two pressure cycles of 70% of minimum room temperature burst pressure. The test method is specified in 4.6.6.

3.5.2.5 Thermal Shock

The hose assemblies shall not leak nor show any evidence of malfunction when subjected to the Table 2B proof and high temperature burst pressure, after being thermally shocked by rapidly increasing hose temperature from -65 to 400 °F. The test method is specified in 4.6.7.

3.5.2.6 Impulse

The hose assemblies shall show no evidence of leakage from hose or fitting prior to completion of 100 000 pressure impulse cycles. The test method is specified in 4.6.8.

3.5.2.7 Assembly Flexibility

The hose assembly shall not leak nor show any evidence of malfunction when subjected to the Table 2B proof pressure after 400 000 flexure cycles. The test method is specified in 4.6.9.

3.5.2.8 Stress Degradation (Air Leakage)

The air leakage rate from the hose and two end fittings (not including "B" nuts) when held at the Table 2 operating pressure after completion of the stress degradation test shall not exceed 2.0 cm³/in/min. The test method is specified in 4.6.10.

3.5.2.9 Pneumatic Surge

There shall be no evidence of inner tube collapse, sponging or shedding of PTFE particles from the inner tube after 16 cycles of rapid reduction of pneumatic pressure from the Table 2B operating pressure to 0 psi. The test method is specified in 4.6.11.

3.5.2.10 Pneumatic Effusion

The effusion rate for any hose size shall not exceed 8.0 cm³/ft of hose length. The test method is specified in 4.6.12.

3.5.2.11 Repetitive Assembly Torque

The fitting shall withstand the repetitive assembly torque values specified in ARP908 without failure or leakage. There shall be no leakage, galling, or other malfunction of the fitting nut and interface connection during the specified pressure test. The test method is specified in 4.6.13.

3.5.2.12 Room Temperature Burst Test

The hose assembly shall not leak nor burst at any pressure below the room temperature burst value specified in Table 2B. The test method is specified in 4.6.14.

3.5.2.13 Electrical Conductivity

Hose assembly sizes -08 and smaller shall conduct a direct current equal to or greater than 6 μ A and sizes -10 and above a direct current equal to or greater than 12 μ A with a test potential of 1000 V DC. The test method is specified in 4.6.15.

3.5.2.14 Resistance to Fire

When the hose assembly is required to withstand a specified resistance to fire, the hose assembly may be fitted with an Integral Silicone or AS1072 Tubular, or equivalent, firesleeve and shall withstand the affects of the flame without leakage. The test method is specified in 4.6.16.

3.6 Screw Threads

Coupling nut threads shall be in accordance with AS8879 (ISO 3161). Thread tolerance increase of 10% during assembly or testing shall not be cause for rejection of the hose assembly.

3.7 Length

Tolerances on hose assembly lengths shall be as follows:

- a. ± 0.125 in for lengths under 18 in
- b. ± 0.250 in for lengths from 18 to 36 in exclusive
- c. ± 0.500 in for lengths from 36 to 50 in exclusive
- d. $\pm 1\%$ for lengths of 50 in and over

3.8 Part Numbering of Interchangeable Parts

All parts having the same manufacturer's part number shall be functionally and dimensionally interchangeable. The item identification and part number requirement of ASME Y14.100, ASME Y14.24, ASME Y14.35M, and ASME Y14.34M shall govern the manufacturer's part numbers and changes thereto.

3.9 Identification of Product

Equipment, assemblies, and parts shall be marked for identification in accordance with MIL-STD-130. The following special marking shall be added:

3.9.1 Fittings

The manufacturer's name or trademark shall be permanently marked on all end fittings.

3.9.2 Assembly

A permanent marking shall be applied on a fitting or on a permanent band, or bands, securely attached on the hose. The band shall be no wider than 1 in and shall not impair the flexibility or the performance of the hose. Unless otherwise specified, the marking on the fitting or band shall include the following information:

- a. Assembly manufacturer's name or trademark and assembly specification AS614
- b. CAGE code and complete hose assembly part number
- c. Operating pressure "4000 psi"
- d. Operating temperature "400 °F"
- e. Pressure test symbol "PT"
- f. Date of hose assembly manufacture expressed in terms of month and year
- g. Hose manufacturer's CAGE code number (required only when hose manufacturer is different than hose assembly manufacturer)
- h. Fire resistance type per AS1055, Type and Class or AS150 and Type (when applicable)

3.10 Workmanship

The hose assembly, including all parts, shall be constructed and finished in a thoroughly workmanlike manner. All surfaces shall be free from burrs. All sealing surfaces shall be smooth, except that annular tool marks up to 100 μ in Ra maximum per ASME B46.1 will be acceptable.

3.10.1 Dimensions and Tolerances

All pertinent dimensions and tolerances, where interchangeability, operation or performance of the hose assembly may be affected, shall be specified on all drawings.

3.10.2 Cleaning

All hose assemblies shall be free from oil, grease, dirt or other foreign materials, both internally and externally. Unless otherwise specified, hose assemblies shall be cleaned to Class 0 of AS611.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for Inspection

Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified, the supplier may utilize his own facilities or any commercial laboratory acceptable to the procuring activity. The procuring activity reserves the right to perform any of the inspections set forth in the specification, where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.2 Classification of Inspections

The examining and testing of hose assemblies shall be classified as:

- a. Qualification inspections (see 4.3)
- b. Quality conformance inspections (see 4.4)

4.3 Qualification Inspections

4.3.1 Qualification Test Samples

The number and length of test samples required to qualify each hose size are specified in Table 3. All specimens for each hose size are required for qualifying each of the methods of end fitting attachment and for each method of end fitting construction, bent tube or forged. Simultaneous qualification of different types of end fittings may be accomplished by having fittings of one type on one hose end and fittings of another type on the other end. If a supplier qualifies one end fitting outlet design and at a later date desires to qualify the other, two hose assemblies of each size to be qualified shall be subjected to the tests specified in 4.5.1.1.

TABLE 3 - LENGTH OF HOSE ASSEMBLIES FOR TEST (IN)

Hose Assy Size	Six Assemblies for Impulse Test (4.6.8)	Two Assemblies for Flex Test (4.6.9)	Six Assemblies for Other Tests ¹
04	15.0	19.0	18
06	22.5	26.5	18
08	26.5	30.0	18
10	30.5	34.0	18
12	36.0 (23.0 ²)	39.0	18
16	44.0 (28.0 ²)	47.0	18
20	53.0 (36.0 ²)	56.0	18

¹ One additional sample of each size in lengths as shown in Figure 4 shall be used for examination and electrical conductivity tests.

² Reduced assembly length if testing is performed at a 90 degree bend.

4.3.2 Qualification Test Sequence

Test sequence and procedure shall be as specified in Table 4 and, if applicable, 4.5.1.1.

4.3.3 Test Report, Test Samples and Data for the Procuring Activity

When the tests are conducted at a location other than the laboratory of the procuring activity, the following shall be furnished to that activity:

- a. Test Report: The test report shall be in accordance with MIL-HDBK-831 which shall include a report of all tests and outline description of the tests and conditions.
- b. Test Samples: Test samples when requested by the procuring activity. Samples subjected to qualification testing shall not be shipped as part of contract or order.
- c. Drawings: Three sets of assembly and subassembly drawings. The assembly drawings shall have a cut-away section showing all details in their normal assembly position and shall define all details and subassemblies.
- d. Sources: List of sources of hose or hose components, including source's name and product identification for inner tube, hose and assembly.

NOTE: Log sheets and recorded test data shall remain on file at the source test facility and are not to be sent to the qualifying activity unless specifically requested.

4.3.4 Qualification Inspection Methods

Qualification inspection methods shall consist of all the examinations and tests specified under 4.6.

4.4 Quality Conformance Inspections

Quality conformance inspections shall consist of the following tests:

- a. Individual tests (see 4.4.1) (100% inspection)
- b. Sampling tests (see 4.4.2)
- c. Periodic control tests (see 4.4.3)

4.4.1 Individual Tests

Each hose assembly shall be subjected to the following tests:

- a. Examination of product (see 4.6.1)
- b. Proof pressure test (see 4.6.3)

NOTE: Production samples that are proof pressure tested with water should be air dried prior to capping (see cleaning requirements, 3.10.2).

TABLE 4A - QUALIFICATION TEST SEQUENCE AND NUMBER OF SAMPLES¹
(INNER TUBE AND HOSE ASSEMBLIES 1-9)

	Inner Tube	Inner Tube	Hose Assembly 1	Hose Assembly 2	Hose Assembly 3	Hose Assembly 4	Hose Assembly 5	Hose Assembly 6	Hose Assembly 7	Hose Assembly 8	Hose Assembly 9
4.6.1.1 Examination of Product ²	0	0									
4.6.2.1 Proof Pressure ²	0	0									
4.6.2.1 Tube Roll ²	0	0									
4.6.2.2 Tensile Strength ²	0	0									
4.6.2.3 Elongation ²	0	0									
4.6.2.4 Specific Gravity ²	0	0									
4.6.1.2 Examination of Product			0	0	0	0	0	0	0	0	0
4.6.3 Proof Pressure			0	0	0	0	0	0	0	0	0
4.6.4 Elongation and Contraction			0	0							
4.6.5 Volumetric Expansion					0	0					
4.6.6 Leakage							0	0			
4.6.7 Thermal Shock							0	0			
4.6.8 Impulse: Unaged											0
Air Aged											
Oil Aged											
4.6.9 Assembly Flexibility			0	0							
4.6.10 Stress Degradation									0	0	
4.6.11 Pneumatic Surge									0	0	
4.6.12 Pneumatic Effusion					0	0					
4.6.13 Repetitive Assy Torque			0	0							
4.6.14 Room Temp Burst Pressure					0	0					
4.6.15 Electrical Conductivity											
4.6.16 Fire Resistance (when required)											

¹ One circle "0" means one inspection.

² Production lot records may be used to verify conformance to these tests when the PTFE tube or hose assembly being used is an established production item.

TABLE 4B - QUALIFICATION TEST SEQUENCE AND NUMBER OF SAMPLES¹
(HOSE ASSEMBLIES 10-18)

	Hose Assembly 10	Hose Assembly 11	Hose Assembly 12	Hose Assembly 13	Hose Assembly 14	Hose Assembly 15	Hose Assembly 16	Hose Assembly 17	Hose Assembly 18
4.6.1.1 Examination of Product ²									
4.6.2.1 Proof Pressure ²									
4.6.2.1 Tube Roll ²									
4.6.2.2 Tensile Strength ²									
4.6.2.3 Elongation ²									
4.6.2.4 Specific Gravity ²									
4.6.1.2 Examination of Product	0	0	0	0	0	0	0	0	0
4.6.3 Proof Pressure	0	0	0	0	0		0	0	0
4.6.4 Elongation and Contraction									
4.6.5 Volumetric Expansion									
4.6.6 Leakage									
4.6.7 Thermal Shock									
4.6.8 Impulse: Unaged	0								
Air Aged		0	0						
Oil Aged				0	0				
4.6.9 Assembly Flexibility									
4.6.10 Stress Degradation									
4.6.11 Pneumatic Surge									
4.6.12 Pneumatic Effusion									
4.6.13 Repetitive Assy Torque									
4.6.14 Room Temp Burst Pressure									
4.6.15 Electrical Conductivity						0			
4.6.16 Fire Resistance (when required)							0	0	0

¹ One circle "0" means one inspection.

² Production lot records may be used to verify conformance to these tests when the PTFE tube or hose assembly being used is an established production item.

4.4.2 Sampling Tests

The following inspections and tests shall be performed in the order indicated on eight hose assemblies with straight fittings at each end selected at random from each inspection lot. The inspection lot shall consist of approximately, but not more than, 3000 hose assemblies, all of one dash size manufactured under essentially the same conditions, but not necessarily during one continuous run. One hose assembly tested from each lot of 375 hose assemblies is also permitted.

- a. Internal cleanliness (AS611, Class 0)
- b. Leakage tests (see 4.6.6)
- c. Room temperature burst pressure test (see 4.6.14)
- d. Specific gravity tests (apparent and relative) (see 4.6.2.4)

4.4.3 Periodic Control Tests

4.4.3.1 Hose Assemblies

The following inspections and tests shall be performed as indicated on eight hose assemblies manufactured from bulk hose lengths selected at random from each inspection lot. The inspection lot shall consist of not more than 20 000 ft of hose, all of one dash number size, manufactured under essentially the same conditions but not necessarily during one continuous run. Two hose assemblies manufactured and tested from each lot of 5000 ft of hose is also permitted.

4.4.3.1.1 Assembly

Four hose assemblies or one hose assembly from a lot of 5000 ft in accordance with Table 3 shall be subjected to the following tests in the order indicated:

- a. Elongation and contraction test (see 4.6.4)
- b. Impulse test (see 4.6.8) (unaged samples only and may have straight fittings on both ends)

4.4.3.1.2 Assembly and Inner Tube

Four hose assemblies or one hose assembly from a lot of 5000 ft in accordance with Table 3 shall be subjected to the following tests in the order indicated:

- a. Stress degradation test (see 4.6.10)
- b. Electrical Conductivity test (see 4.6.15)

4.4.3.2 Fire Resistant Hose Assemblies

The following test shall be performed, as defined below, on one hose assembly of each QPL listed fire sleeve configuration type, Integral Silicone or AS1072 Tubular Sleeve, produced within the PRI defined reporting year. The test sample shall be built by production personnel using the same processes as used for product approval to the QPL.

- a. Test sample size: Fire testing shall be performed on the smallest hose size for each of the QPL listed fire sleeve type produced during the reporting year.
- b. Fire Test: Fire testing shall be performed to the requirements of AS1055.
- c. Flow Condition: Fire testing shall be performed at the lowest flow (most critical) condition, $1 \times ID^2$ or $5 \times ID^2$, for each QPL approved product.
- d. Test Duration: Fire testing shall be performed at the longest (most critical) test duration; fireproof (15 min) or fire resistant (5 min) for each QPL approved product.

4.4.3.2.1 Where an assembly fails to meet the $1 \times ID^2$ flow condition, an additional assembly may be tested for conformance to the lesser $5 \times ID^2$ condition. If the assembly passes the $5 \times ID^2$, product invoking the $5 \times ID^2$ are unaffected by the $1 \times ID^2$ failure.

4.4.3.2.2 Where an assembly fails to meet the 15 min test duration, but exceeds 5 min, only assemblies imposing the 15 min duration are affected.

4.4.3.2.3 Where the smallest QPL size fails the test, the next larger QPL qualified size may be tested. Should that test size pass the test, only the smallest size tested is affected.

4.4.4 Rejection and Retest

Where one or more items selected from a lot fails to meet the specifications, all items in the lot shall be rejected. In the event of a failed fire test, all assemblies manufactured from the suspect material (Integral Silicone or AS1072 Tubular Sleeve) under the applicable Type Designation shall be rejected.

4.4.4.1 Resubmitted Lots

Once a lot (or part of a lot) has been rejected by a procuring activity (Government or industry), before it can be resubmitted for tests, full particulars concerning the cause of previous rejection and the action taken to correct the defects in the lot shall be furnished, in writing, by the contractor.

4.4.5 Inspection Procedure

All inspection plans shall be single sample plans with an accept number of zero.

4.4.6 Destructive Test Sample

Prior to testing, a letter "D" shall be permanently marked on each end fitting of those assemblies used for destructive tests (see 4.4.2 and 4.4.3).

4.5 Test Conditions

4.5.1 Fitting Ends

Qualification tests shall be conducted on assemblies using straight type swivel ends, except for the impulse test samples requiring 90° elbow fitting at one end. Satisfactory completion of qualification tests shall also constitute qualification approval for hose assemblies having other fittings that have an identical attachment method and design and meet the requirements of this document.

4.5.1.1 Additional Fitting End Designs

If qualification approval is desired for other type end fitting, two additional hose assemblies with the type fittings and of the size to be qualified shall be subjected to the following tests in the sequence indicated:

- a. Examination of product (see 4.6.1)
- b. Proof pressure test (see 4.6.3)
- c. Leakage test (see 4.6.6)
- d. Repetitive assembly torque test (see 4.6.13)
- e. Room temperature burst pressure test (see 4.6.14)

4.5.2 Preparation of Sample

4.5.2.1 Unless otherwise specified, length of sample assemblies shall be in accordance with Table 3.

4.5.2.2 Oil Aging

In all tests using oil aged samples, the hose assemblies shall be filled with a high temperature test fluid and soaked in an air oven at a temperature of 400 °F for seven days. All air shall be excluded from the bore of the assembly during the test. No pressure shall be applied to the assembly during the aging period.

4.5.2.3 Air Aging

Air aged samples shall be kept in air at a temperature of 400 °F for seven days.

4.5.2.4 Unaged Samples

Unaged assemblies shall be as manufactured.

4.5.3 Test Fluids

Unless otherwise specified, the pressure test fluid shall be hydraulic oil conforming to MIL-H-5606, MIL-PRF-87257 or water. Where a high temperature test fluid is specified, the test fluid shall be MIL-PRF-83282 hydraulic fluid, MIL-PRF-7808 lubricating oil, or equivalent, unless otherwise specified by the user.

4.5.4 Pressure Measurements

Unless otherwise specified, all pressures shall have a tolerance of ± 100 psi.

4.5.5 Temperature Measurements

Unless otherwise specified, temperature measurements shall be taken within 6 in of the hose assemblies under test. Unless otherwise specified, all temperatures shall have a tolerance of $+15^{\circ}\text{F}$, -5°F .

4.5.6 End Connections

Except as otherwise noted, each hose end shall be connected to a male fitting end in accordance with AS4395, AS33514, or AS4375, lubricated with either MIL-H-5606 or the test fluid, MIL-PRF-87257, and utilizing the installation torque range specified in ARP908.

4.6 Inspection Methods

4.6.1 Examination of Product

4.6.1.1 Inner Tube (PTFE)

Each length of tubing shall be examined to determine conformance to this specification with respect to material, size, workmanship, and dimensions.

4.6.1.2 Hose Assembly

All hose assemblies shall be visually inspected to determine conformance to this document with respect to material, size and workmanship. Broken or missing reinforcing wires or any evidence of malfunction shall be cause for rejection. Crossed over reinforcing wires shall not be cause for rejection.

4.6.2 Tube Tests

4.6.2.1 Tube Roll and Proof Pressure Test

Each length of tubing shall be subjected to a tube roll and proof pressure test in accordance with AS2078. The flattening gap, rounding gap, and proof pressure values shall be as specified for 3000 psi and higher. The test media shall be air or water.

4.6.2.2 Tensile Strength

The tube shall be subjected to the tensile strength test in accordance with AS2078.