

REV.
C

AS1654

FEDERAL SUPPLY CLASS
4730

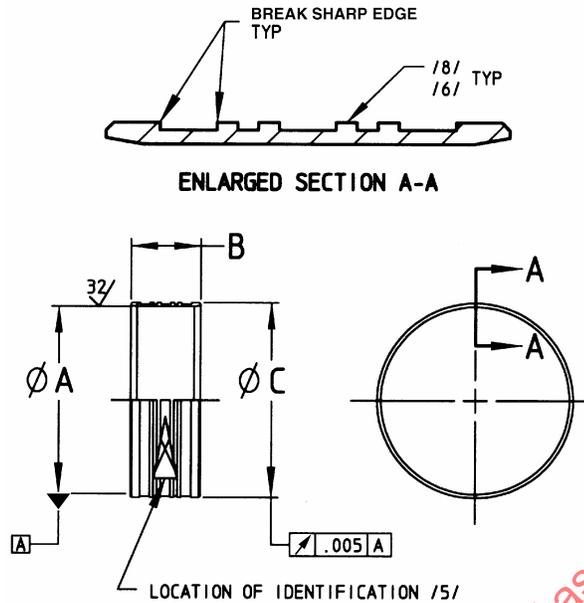
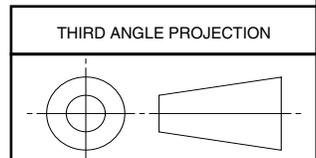


FIGURE 1 - SLEEVE

TABLE 1 - DIMENSIONS AND WEIGHTS /6/

BASIC NO. AS1654 /14/ SIZE CODE	NOM TUBE SIZE REF	DIMENSIONS			LB/EA NOM REF ALUM	LB/EA NOM REF CRES	LB/EA NOM REF TI
		A ±.002	B	C ±.004			
08	.500	.692	.590	.762	.004	.010	.006
10	.625	.817	.590	.887	.004	.012	.007
12	.750	.997	.670	1.067	.006	.017	.010
16	1.000	1.273	.750	1.343	.008	.022	.013
20	1.250	1.523	.750	1.593	.009	.027	.015
24	1.500	1.793	.750	1.863	.011	.031	.018
28	1.750	2.045	.750	2.114	.012	.035	.020
32	2.000	2.317	.780	2.387	.015	.042	.024
36	2.250	2.567	.780	2.636	.016	.046	.026
40	2.500	2.817	.780	2.887	.018	.051	.029
48	3.000	3.317	.780	3.387	.021	.060	.034
56	3.500	3.831	.780	3.901	.025	.070	.040
64	4.000	4.337	.780	4.407	.028	.079	.045



CUSTODIAN: SAE G-3/G-3A

PROCUREMENT SPECIFICATION: /4/ AS1650

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

SLEEVE, THREADLESS - FLEXIBLE, FIXED CAVITY,
SELF-BONDING

AS1654
SHEET 1 OF 3

**REV.
C**

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ISSUED 1992-03 REVISED 2004-09

NOTES:

/1/ MATERIAL:

- a. CODE LETTER A - TYPE 2024-T351, T6, T851, T8510 OR T8511 ALUMINUM ALLOY PER AMS-QQ-A-225/6, AMS 4120, AMS 4339, AMS-QQ-A-200/3, WW-T-700/3, ASTM B 211 OR ASTM B 241.
 - b. CODE LETTER C -
 1. TYPE 17-4PH, CONDITION H1075 STA, CORROSION RESISTANT STEEL PER AMS 5643.
 2. TYPE 15-5PH, CONDITION H1150 STA, CORROSION RESISTANT STEEL PER AMS 5659.
 3. TYPE 303 SERIES, CONDITION A, CORROSION RESISTANT STEEL PER AMS 5638, AMS 5640 OR ASTM A 582.
 4. TYPE 304, CONDITION A, CORROSION RESISTANT STEEL PER AMS 5560, AMS 5639, QQ-S-763 OR ASTM A 376.
 - c. CODE LETTER T -
 1. TYPE 6AL-4V, CONDITION A, TITANIUM ALLOY PER AMS 4911, AMS 4928 OR AMS 4967 (MIL-T-9047).
 2. TYPE CP-70, CONDITION A, COMMERCIAL PURE TITANIUM PER AMS 4901 OR AMS 4921 (MIL-T-9047).
2. HEAT TREATMENT:
- a. MATERIAL CODE LETTER A - IF THE RAW MATERIAL IS PROCURED IN THE SOLUTION TREATED CONDITION, AGE TO THE FINAL CONDITION PER AMS-H-6088 OR AMS 2770.
 - b. MATERIAL CODE LETTER C -
 1. TYPE 17-4PH - AGE TO CONDITION H1075 PER MIL-H-6875 OR AMS 2759/3.
 2. TYPE 15-5PH - AGE TO CONDITION H1150 PER MIL-H-6875 OR AMS 2759/3.
 3. TYPE 303 SERIES - NONE.
 - c. MATERIAL CODE LETTER T - NONE.
3. FINISH:
- a. MATERIAL CODE LETTER A - ANODIZE PER AMS 2472 OR MIL-A-8625, TYPE I, CLASS 1, DICHROMATE SEALED, OR TYPE II, CLASS 2, DYE MAGENTA SIMILAR IN COLOR TO FED-STD-595 NO. 17142, DUPLEX SEALED.
 - b. MATERIAL CODE LETTER C -
 1. TYPE 17-4PH OR 15-5PH - PASSIVATE PER AMS-QQ-P-35, TYPE II OR TYPE VIII.
 2. TYPE 303 SERIES - PASSIVATE PER AMS-QQ-P-35, TYPE II.
 3. TYPE 304 - PASSIVATE PER AMS-QQ-P-35, TYPE VI OR VII.
 - c. MATERIAL CODE LETTER T - NONE.