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REV.
C

AS1895™/23

FEDERAL SUPPLY CLASS
5330

RATIONALE

QPL DATE REQUIREMENT EXTENDED UNTIL JULY 2022. QUALIFICATION CONTINGENCY NOTE ADDED TO SECOND PARAGRAPH OF NOTE 3.

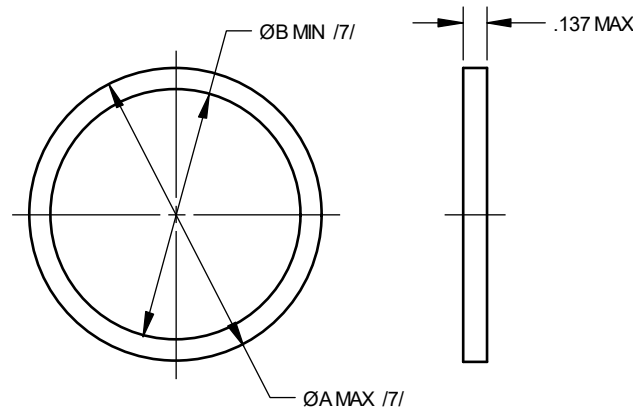


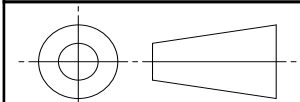
FIGURE 1 - SEAL ENVELOPE

TABLE 1 - DIMENSIONS AND WEIGHTS

PART NUMBER	(TUBE SIZE)	A	B	LB/EA MAX
AS1895/23-100	1.00	1.249	.948	.010
AS1895/23-125	1.25	1.499	1.198	.011
AS1895/23-150	1.50	1.749	1.448	.012
AS1895/23-175	1.75	1.999	1.698	.014
AS1895/23-200	2.00	2.249	1.948	.015
AS1895/23-225	2.25	2.499	2.198	.016
AS1895/23-250	2.50	2.749	2.448	.017
AS1895/23-275	2.75	2.999	2.698	.018
AS1895/23-300	3.00	3.249	2.948	.019
AS1895/23-325	3.25	3.499	3.198	.021
AS1895/23-350	3.50	3.749	3.448	.022
AS1895/23-400	4.00	4.249	3.948	.024
AS1895/23-450	4.50	4.749	4.448	.027
AS1895/23-500	5.00	5.249	4.948	.029
AS1895/23-550	5.50	5.749	5.448	.031
AS1895/23-600	6.00	6.249	5.948	.033
AS1895/23-650	6.50	6.749	6.448	.035
AS1895/23-700	7.00	7.249	6.948	.038
AS1895/23-750	7.50	7.749	7.448	.041

For more information on this standard, visit
<https://www.sae.org/standards/content/AS1895/23C>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3/G-3A

PROCUREMENT SPECIFICATION: AS1895 /3/



AEROSPACE STANDARD

HIGH CONFORMANCE SEAL, TYPE I AND II
STANDARD AND LOW PROFILE

AS1895™/23
SHEET 1 OF 2

REV.
C



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NOTES:

1. MATERIAL: NICKEL ALLOY 718 PER AMS5589 OR AMS5596.
 2. FINISH: PASSIVATE PER AMS2700 TYPE 1, 2, OR 3, OR ELECTROPOLISH, OR MECHANICAL POLISH.
 - /3/ PARTS SHALL BE QUALIFIED IN A COMPLETE COUPLING ASSEMBLY IN ACCORDANCE WITH PROCUREMENT SPECIFICATION AS1895. PRODUCT SUPPLIED TO THIS SPECIFICATION SHALL BE MANUFACTURED BY AN ACCREDITED MANUFACTURER AS LISTED IN THE PERFORMANCE REVIEW INSTITUTE (PRI) QUALIFIED PRODUCTS LIST PRI-QPL-AS1895 FOR THIS STANDARD. SEE www.eAuditNet.com FOR CURRENT QPL ONLINE.
- THIS QPL REQUIREMENT SHALL BE IN EFFECT FOR PURCHASE ORDERS PLACED ON OR AFTER JULY 31, 2022. SUPPLIERS SEEKING LISTING ON THE INITIAL QPL MUST APPLY TO PRI FOR APPROVAL NO LATER THAN DECEMBER 31, 2021. UNTIL THE QPL IS IN EFFECT, USERS OF THIS STANDARD ARE ADVISED TO CONTROL SOURCE APPROVALS. LEGACY OR INVENTORIED HARDWARE MANUFACTURED PRIOR TO QPL REQUIRED DATE: JULY 31, 2022, MAY BE USED UNTIL DEPLETION VIA ACCEPTANCE BY OEM OR USER SUPPLEMENT ACCEPTANCE SHEETS. TRANSITION TO PRI-QPL SHALL BE COMPLETED BY JULY 31, 2022.
4. THIS SEAL, WHEN MATED WITH FLANGES AND COUPLINGS SPECIFIED IN AS1895, SHALL MEET ALL THE REQUIREMENTS OF SPECIFICATION AS1895.
 5. MARKING: MARK PACKAGING WITH SUPPLIER IDENTIFICATION AND AS1895-XXX PART NUMBER PER AS1895.
 6. ACCEPTANCE TEST: SEALS SHALL BE LEAKAGE TESTED USING A SAMPLING PLAN PER ANSI/ASQ Z1.4 AT AN INDEX VALUE OF 1%. THE SEALS SHALL BE COMPRESSED BETWEEN FLAT, PARALLEL PLATTENS OR FLANGES TO A DEPTH OF .089 TO .090 AND PRESSURIZED TO 400 PSI WHILE AT ROOM TEMPERATURE. LEAKAGE SHALL NOT EXCEED .01 SCFM PER INCH OF TUBE DIAMETER. SEAL FREE HEIGHT SHALL REMAIN WITHIN DRAWING TOLERANCE.
 - /7/ SEALS SHALL BE MADE OUT-OF-ROUND TO SNAP FIT INTO MALE FLANGES FOR EASE OF ASSEMBLY. DIAMETERS "A" AND "B" ARE SHOWN AS AVERAGE TO ALLOW FOR OUT OF ROUNDNESS. THE SEAL CROSS SECTION MAY BE SHAPED IN A NONRECTANGULAR FORM, BUT SHALL FIT INTO THE RECTANGULAR ENVELOPE DIMENSIONS. SEAL MANUFACTURERS ARE TO DETERMINE THE TOLERANCE TO MEET THE REQUIREMENTS OF AS1895.
 8. PARTS SHALL BE INDIVIDUALLY PACKAGED AND SHALL BE HANDLED IN PACKAGES UNTIL INSTALLATION IN FLANGE. METALLIC SEALS ARE FRAGILE AND MAY BE CRUSHED EASILY. DO NOT PLACE HEAVY OBJECTS ON PACKAGES.
 9. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACES TO BE 125 MICROINCHES Ra.
 10. THE FINISHED SEAL SHALL BE FREE OF SHARP EDGES AND BURRS.
 11. DIMENSIONING AND TOLERANCING: ANSI Y14.5M 1982.
 12. DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS .XXX = ± 0.010 , .XX = ± 0.03 . ANGULAR DIMENSIONS $\pm 5^\circ$.
 13. INTENDED USE: THE AS1895/23 HIGH CONFORMANCE SEAL IS INTENDED TO MINIMIZE LEAKAGE DUE TO OUT OF FLAT FLANGES. REFERENCE AS1895 FOR AFTER WELDING FLANGE FLATNESS LIMITS.
 14. EXAMPLE PART NUMBER: AS1895/23 - 200

_____ TUBE SIZE (200 = 2.00 IN TUBE)

_____ BASIC PART NUMBER
 15. REVISION INDICATOR: A CHANGE BAR (I) LOCATED IN THE LEFT MARGIN 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 DOCUMENT. AN (R) SYMBOL TO THE LEFT OF THE DOCUMENT TITLE INDICATES A COMPLETE REVISION OF THE DOCUMENT, INCLUDING TECHNICAL REVISIONS. CHANGE BARS AND (R) ARE NOT USED IN ORIGINAL PUBLICATIONS, NOR IN DOCUMENTS THAT CONTAIN EDITORIAL CHANGES ONLY.

	AEROSPACE STANDARD		AS1895™/23 SHEET 2 OF 2	REV. C
	HIGH CONFORMANCE SEAL, TYPE I AND II STANDARD AND LOW PROFILE			

