

AS1920 HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

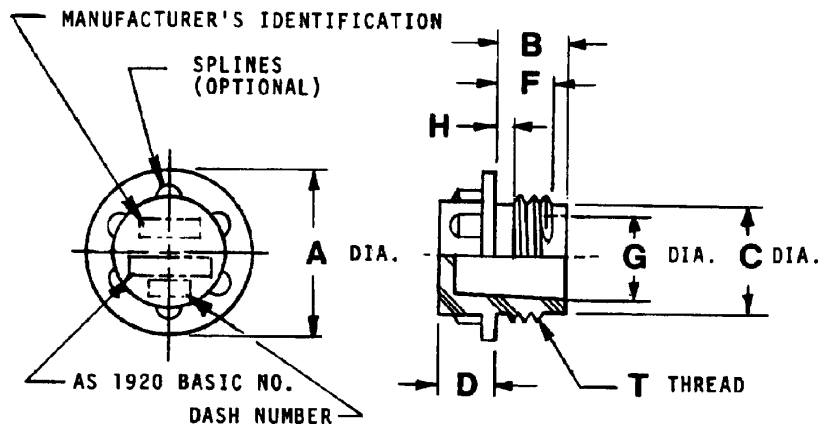


FIGURE 1 - PLUG CONFIGURATION

TABLE 1 - PLUG DIMENSIONS

DASH NO.	TUBE O.D.	T /3/ THREAD	A DIA.	B	C DIA. +.004 - .010	D	F	G DIA. +.012 - .000	H
-03	3/16	.3750-24	.500	.300	.323	.380	.210	.204	.060
-04	1/4	.4375-20	.560	.380	.375	.380	.300	.274	.080
-05	5/16	.5000-20	.630	.380	.438	.380	.300	.334	.080
-06	3/8	.5625-18	.690	.380	.493	.380	.300	.394	.080
-08	1/2	.7500-16	.880	.400	.672	.380	.320	.524	.100
-10	5/8	.8750-14	1.000	.450	.786	.380	.370	.654	.110
-12	3/4	1.0625-12	1.250	.500	.959	.380	.420	.804	.130
-16	1	1.3125-12	1.500	.480	1.209	.380	.420	1.050	.150

TABLE 2 - MAXIMUM TORQUE VALUES

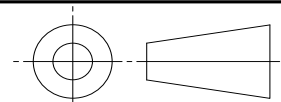
PLUG DASH NUMBER	TORQUE INCH-POUNDS
-03	3
-04	3
-05	4
-06	4
-08	6
-10	6
-12	6
-16	6

NOTES:

1. DIMENSIONS IN INCHES.
2. TOLERANCES $\pm .010$ " (UNLESS OTHERWISE SPECIFIED).
- 3/ UNIFIED THREAD FORM.
4. DRAFT PERMITTED ON "G" DIA., 2 DEGREES MAX.

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS1920>

THIRD ANGLE PROJECTION



CUSTODIAN: G-3



AEROSPACE STANDARD

PLUG-PROTECTIVE
DUST AND FLUID SEAL, FLARELESS FITTING

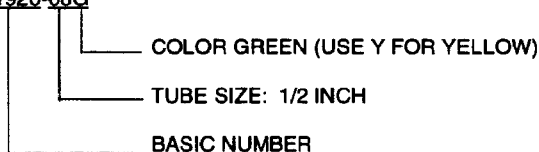
AS1920
SHEET 1 OF 2

Documents

NOTES (CONTINUED):

5. MATERIAL: POLYPROPYLENE PER L-P-394.
6. COLOR: YELLOW FOR HYDRAULIC SERVICE. GREEN FOR OXYGEN SERVICE. COLOR MUST BE SPECIFIED. YELLOW COLOR CODE Y OR GREEN COLOR CODE G MUST BE SPECIFIED IN THE PART NUMBER.
7. MARKING: PERMANENTLY MARK WITH MANUFACTURER'S NAME OR TRADEMARK AND THE AS1920 BASIC NUMBER WITH THE DASH NUMBER FROM TABLE 1 FOR SIZE DESIGNATION.

EXAMPLE OF PART NUMBER: AS1920-08G



8. WORKMANSHIP: PLUGS SHALL BE FREE FROM WARPAGE, CRACKS, CHIPPED EDGES, AND OTHER DEFECTS WHICH WOULD AFFECT PROPER FUNCTIONING.
9. INSTALLATION: PLUGS SHALL BE DESIGNED TO PERMIT INSTALLATION AND REMOVAL BY HAND WITH NOT MORE THAN 1 INCH-POUND OF THREAD FRICTION UNTIL THE SEALING SURFACE HAS COME INTO CONTACT WITH ITS MATING PART.
10. SEALING: PLUGS SHALL BE CAPABLE OF PROTECTING AND SEALING FLARELESS TUBE OR HOSE ASSEMBLIES TO A PNEUMATIC PRESSURE OF 2 TO 5 PSIG WITHOUT LEAKAGE. A SHOULDER GASKET OR "O" RING MAY BE USED WITH THESE PLUGS FOR SEALING "O" RING PORTS.
11. TORQUE: PLUGS SHALL PERFORM THEIR INTENDED USES AT TORQUES FROM HANDTIGHT TO THE MAXIMUM TORQUES SHOWN IN TABLE 2.
12. REPEATED ASSEMBLY: PLUGS SHALL BE CAPABLE OF 5 ASSEMBLIES AND REMOVALS WITH TORQUE IN TABLE 2 WITHOUT EVIDENCE OF SHREDDING.
13. INTENDED USE: AS A PROTECTIVE DUST AND MOISTURE SEAL FOR:
 - a. FLARELESS TUBE ASSEMBLIES WITH MS21922 SLEEVES OR NAS1760 FITTING ENDS.
 - b. FLARELESS HOSE ASSEMBLIES WITH NIPPLES CONFORMING TO NAS1760 FITTING ENDS.
 - c. BOSSES CONFORMING TO MS33649.

	AEROSPACE STANDARD		AS1920 SHEET 2 OF 2	 Documents
	PLUG-PROTECTIVE DUST AND FLUID SEAL, FLARELESS FITTING			

