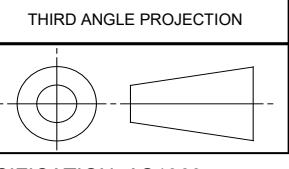
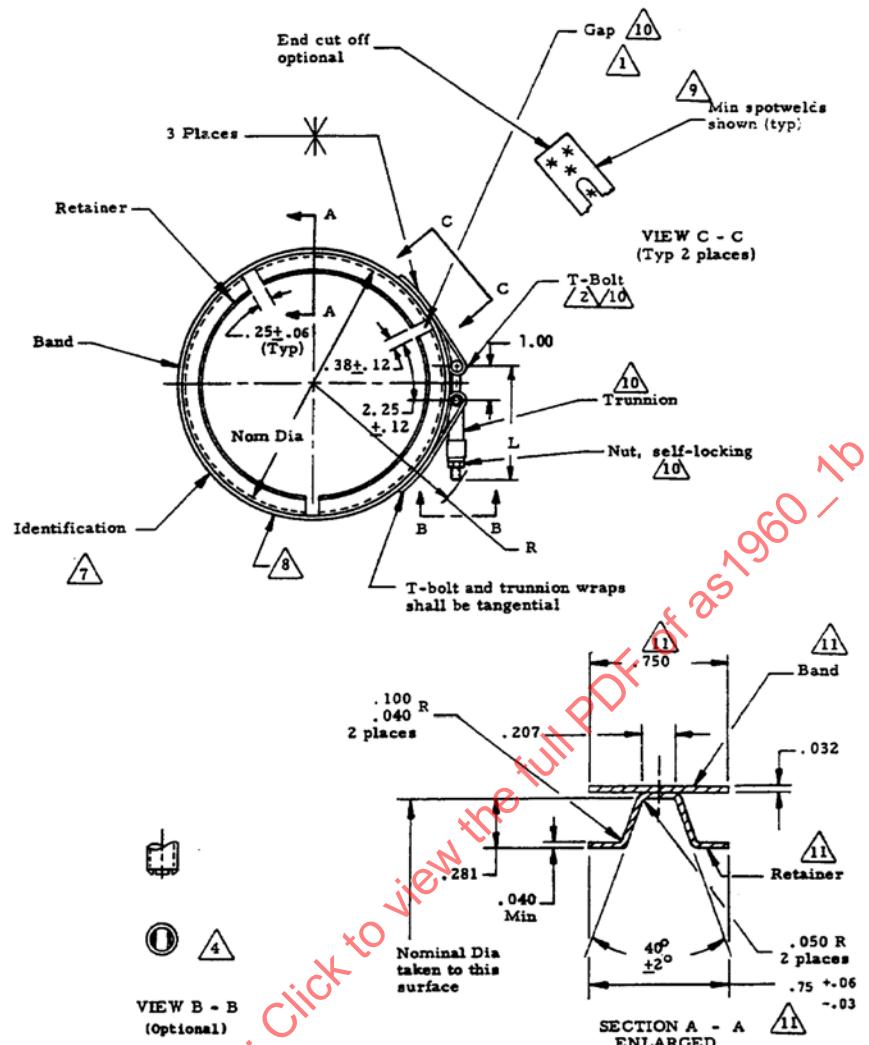


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|---|---|---|
| REV. B AS1960™/1 | <p style="text-align: center;">RATIONALE</p> <p>THIS TECHNICAL REPORT IS BEING STABILIZED BECAUSE IT COVERS TECHNOLOGY, PRODUCTS, OR PROCESSES WHICH ARE MATURE AND NOT LIKELY TO CHANGE IN THE FORESEEABLE FUTURE.</p> <p style="text-align: center;">STABILIZED NOTICE</p> <p>THIS DOCUMENT HAS BEEN DECLARED "STABILIZED" BY SAE G-3, AEROSPACE COUPLINGS, FITTINGS, HOSE, TUBING ASSEMBLIES COMMITTEE AND WILL NO LONGER BE SUBJECT TO PERIODIC REVIEWS FOR CURRENCY. USERS ARE RESPONSIBLE FOR VERIFYING REFERENCES AND CONTINUED SUITABILITY OF TECHNICAL REQUIREMENTS. NEWER TECHNOLOGY MAY EXIST.</p> | <p style="text-align: center;">FEDERAL SUPPLY CLASS 5340</p> |
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| CUSTODIAN: G-3/G-3A | PROCUREMENT SPECIFICATION: AS1960 | THIRD ANGLE PROJECTION  |
|  | AEROSPACE STANDARD COUPLING, SHEET METAL, 40° V-BAND, STANDARD LATCH | AS1960™/1 REV. B |



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| | AEROSPACE STANDARD COUPLING, SHEET METAL, 40° V-BAND, STANDARD LATCH | AS1960™/1 SHEET 1 OF 5 | REV. B |
|--|---|----------------------------------|---------------|

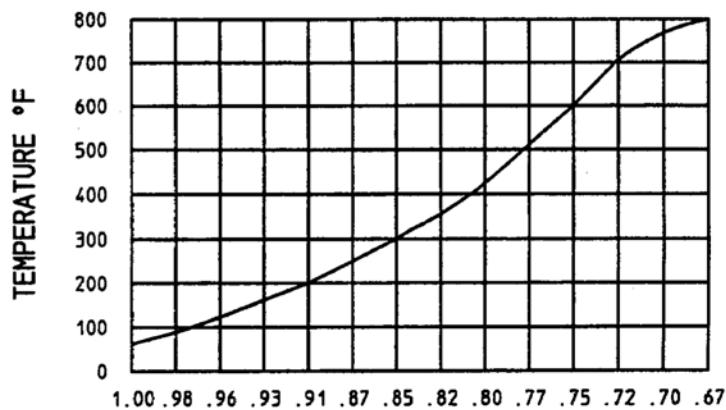


FIGURE 3 - TEMPERATURE CORRECTION FOR
300 SERIES STAINLESS STEEL /19/

TABLE 1

| PART NUMBER | TUBE OD | NOMINAL DIA | WEIGHT (LBS) | /8/ NUT TORQUE ± 5 IN. - LBS. | L $\pm .12$ | R MAX |
|----------------|---------|-------------|--------------|-----------------------------------|-------------|-------|
| AS1960/1 - 200 | 2.000 | 2.636 | .26 | 35 | 2.75 | 3.26 |
| AS1960/1 - 225 | 2.250 | 2.886 | .27 | | | 3.32 |
| AS1960/1 - 250 | 2.500 | 3.136 | .29 | | | 3.36 |
| AS1960/1 - 275 | 2.750 | 3.386 | .30 | | | 3.42 |
| AS1960/1 - 300 | 3.000 | 3.636 | .31 | 40 | | 3.50 |
| AS1960/1 - 350 | 3.500 | 4.136 | .35 | | | 3.39 |
| AS1960/1 - 400 | 4.000 | 4.636 | .38 | | | 3.57 |
| AS1960/1 - 450 | 4.500 | 5.136 | .40 | | | 3.77 |
| AS1960/1 - 500 | 5.000 | 5.636 | .44 | 45 | 3.00 | 4.00 |
| AS1960/1 - 550 | 5.500 | 6.136 | .47 | | | 4.32 |
| AS1960/1 - 600 | 6.000 | 6.636 | .50 | | | 4.52 |
| AS1960/1 - 650 | 6.500 | 7.136 | .52 | | | 4.73 |
| AS1960/1 - 700 | 7.000 | 7.636 | .55 | 50 | | 4.95 |
| AS1960/1 - 750 | 7.500 | 8.136 | .58 | | | 5.16 |
| AS1960/1 - 800 | 8.000 | 8.636 | .61 | | | 5.40 |
| AS1960/1 - 850 | 8.500 | 9.136 | .63 | | | 5.62 |
| AS1960/1 - 900 | 9.000 | 9.636 | .67 | | | 5.84 |

TABLE 2

| TUBE OD | D DIA | "N" LBS/INCH (LIMIT AT ROOM TEMPERATURE /17/ TO -65 °F) |
|------------|----------|---|
| 2.00 | 2.582 | 355 |
| 2.25 | 2.832 | 326 |
| 2.50 | 3.082 | 303 |
| 2.75 | 3.332 | 283 |
| 3.00 | 3.582 | 267 |
| 3.50 | 4.082 | 241 |
| 4.00 | 4.582 | 221 |
| 4.50 | 5.082 | 206 |
| 5.00 | 5.582 | 193 |
| 5.50 | 6.082 | 183 |
| 6.00 | 6.582 | 175 |
| 6.50 | 7.082 | 167 |
| 7.00 | 7.582 | 161 |
| 7.50 | 8.082 | 155 |
| 8.00 | 8.582 | 150 |

NOTES:

/1/ RETAINER GAP TO BE ROTATED TO CENTERLINE OF LATCH FOR TUBE OD 3.00 AND UNDER.

/2/ T-BOLT SHALL BE CURVED FOR TUBE OD 3.00 AND UNDER.

3. TOLERANCES: $.XX \pm .03$, $.XXX \pm .010$ OR AS NOTED.

/4/ T-BOLT FACE TO BE MARKED AS SHOWN IN VIEW B-B OR EQUIVALENT TYPE MARKING.

5. MATERIAL: STRAP - MIL-S-5059 COMP 301 1/2H (STAINLESS STEEL)
RETAINER - MIL-S-5059 COMP 301 1/4H (STAINLESS STEEL)
TRUNNION - MIL-S-5059 COMP 301/302 ANNEALED OR EQUIVALENT (STAINLESS STEEL)
T-BOLT - A-286 PER AMS 5732 OR AMS 5737 (STAINLESS STEEL)
NUT-Z1200J048 (ELASTIC STOP NUT CORP FED SUPPLY CODE 72962) STAINLESS STEEL SILVER
PLATED OR EQUIVALENT.

6. THREADS: T-BOLT AND NUT THREAD SHALL CONFORM TO MIL-S-8879.
T-BOLT: .2500-28 UNJF-3A
NUT: .2500-28 UNJF-3B

/7/ IDENTIFICATION: THE COUPLING SHALL BE MARKED WITH THE FOLLOWING MINIMUM INFORMATION:
AS PART NO. AS1960/1-XXX
MANUFACTURER'S NAME AND/OR TRADEMARK
DATE OF MANUFACTURE

/8/ TORQUE MARKING SHALL BE PERMANENTLY MARKED IN 1/8" MINIMUM HIGH LETTERS LOCATED AS SHOWN:
"CAUTION TORQUE TO (XX \pm 5) INCH LBS."

/9/ SPOTWELD PER MIL-W-6858, CLASS B.

/10/ LATCH COMPONENTS (RETAINERS, STRAPS, TRUNNION, ETC.) SHALL NOT BIND OR INTERFERE WITH OPERATION
OF T-BOLT.

/11/ BAND AND RETAINER LOCATION AND FORMING SHALL BE SYMMETRICAL ABOUT CENTERLINE WITHIN .020 TIR.



AEROSPACE STANDARD

COUPLING, SHEET METAL,
40° V-BAND, STANDARD LATCHAS1960™/1
SHEET 3 OF 5REV.
B