

INCH-POUND

MS27225B
7 September 1999
SUPERSEDING
MS27225A
27 March 1972

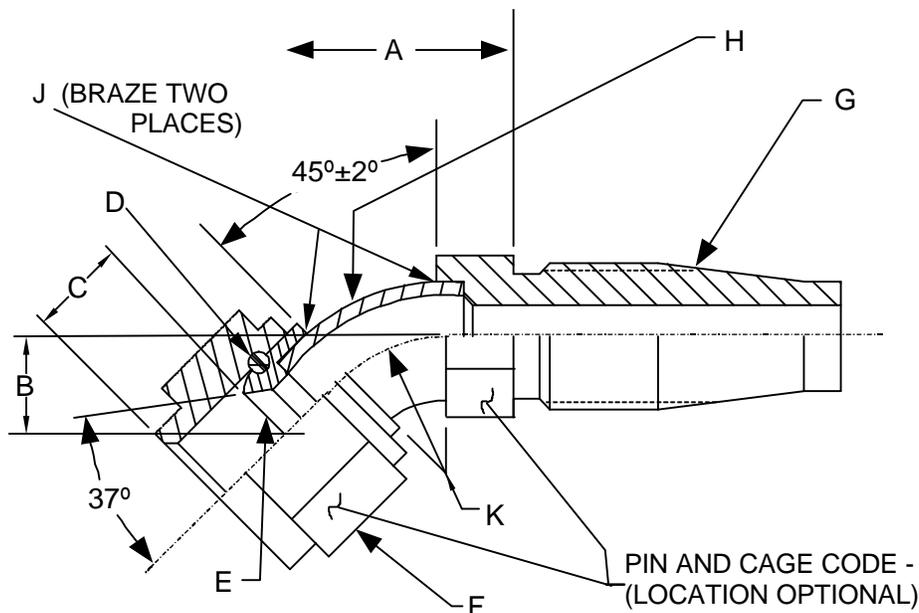
DETAIL SPECIFICATION SHEET

45° NIPPLE ASSEMBLY, ADAPTER, HOSE TO TUBE, REUSABLE, HYDRAULIC, FUEL AND OIL LINES

This specification is approved for use by all Departments and Agencies of the Department of Defense.

The requirements for acquiring the product described herein shall consist of this specification sheet and the issue of MIL-DTL-5070 listed in that issue of the Department of Defense Index of Specifications and Standards (DoDISS) specified in the solicitation.

REQUIREMENTS



NOTE: NUT MUST SWIVEL FREELY AFTER ASSEMBLY

FIGURE 1. Assembly illustration.

TABLE I. Assembly composition.

PIN	A ±0.035	B ±0.035	C	D Wire PIN	E Shoulder PIN	F Nut PIN	G Nipple PIN	H Elbow PIN	K Rad (ref)
MS27225				MS27238	MS27236	AS4370	MS27239	MS27235	
-4	0.758	0.352	0.37	-4	-4	-4	-4	-4	0.38
-5	0.909	0.415	0.38	-5	-5	-5	-5	-5	0.44
-6	0.965	0.444		-6	-6	-6	-6	-6	0.50
-8	1.039	0.456	0.44	-8	-8	-8	-8	-8	
-10	1.171	0.536	0.50	-10	-10	-10	-10	-10	0.62
-12	1.348	0.625	0.57	-12	-12	-12	-12	-12	0.84
-16	1.436	0.660	0.63	-16	-16	-16	-16	-16	0.97
-20	1.760	0.768	0.64	-20	-20	-20	-20	-20	1.19
-24	1.999	0.867	0.77	-24	-24	-24	-24	-24	1.38
-32	2.415	1.066	0.92	-32	-32	-32	-32	-32	1.75

Intended use. This part is a component of MS27226.

Dimensions and tolerances. Dimensions are in inches. Unless otherwise specified, tolerances are as follows: angles $\pm 1^\circ$; decimals ± 0.005 .

Braze. Steel: Braze at points J in accordance with AWS C3.4, C3.5, C3.6, or C3.7.
Aluminum: Braze at points J in accordance with SAE AMS2672.

Heat treatment. Steel: Heat treat in accordance with MIL-H-6875 after braze so that Rockwell hardness of nipple is C-25.

Aluminum: Heat treat in accordance with SAE AMS-H-6088, condition T6, after braze.

Finish. Steel: Plating requirements shall be based upon the materials selected for the adapters. Ion vapor deposition of aluminum, zinc-nickel plating, electroless nickel plating, brush plating, or electromagnetic deposition are candidate processes that may be used to provide corrosion resistance and wear tolerance, and to meet finish requirements. If cadmium plating is used, the plating shall be without dye, in accordance with QQ-P-416, Type I, Class 3, after heat treat and before assembling nut. It is recommended that the use of cadmium plating be used only when other platings cannot meet performance requirements.

Aluminum: Anodize in accordance with MIL-A-8625, Type II, dye blue, after heat treat and before assembling nut.

Identification of product. The part or identifying number (PIN) and the manufacturer's Commercial and Government Entity (CAGE) Code or trademark shall be permanently marked on the assembly or marked on a removable tag securely attached to the assembly. The PIN for this assembly shall be as shown in table I (e.g., MS27225-4).

Order of precedence. This specification sheet takes precedence over the documents referenced herein. Unless otherwise specified in the solicitation, referenced documents shall be of the issue in effect on the date of solicitation.

CHANGES FROM PREVIOUS ISSUE. Marginal notations are not used in this revision to identify changes with respect to the previous issue, due to the extent of the changes.

Custodians:

Army - AT
Navy - AS
Air Force - 99

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