

INCH-POUND

MS28746D
22 September 2000
SUPERSEDING
MS28746C
30 August 1983

DETAIL SPECIFICATION SHEET

FITTING END - HOSE, SWIVEL, DETACHABLE, FLANGED, 4 BOLT, 45°

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 MIL-DTL-5070E.

REQUIREMENTS.

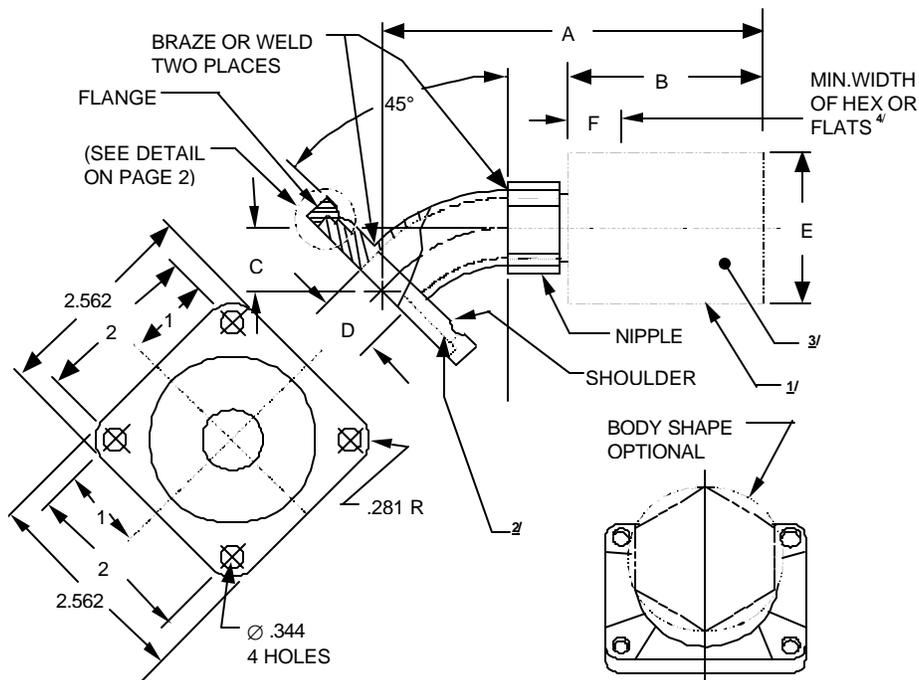


FIGURE 1. Flange illustration.

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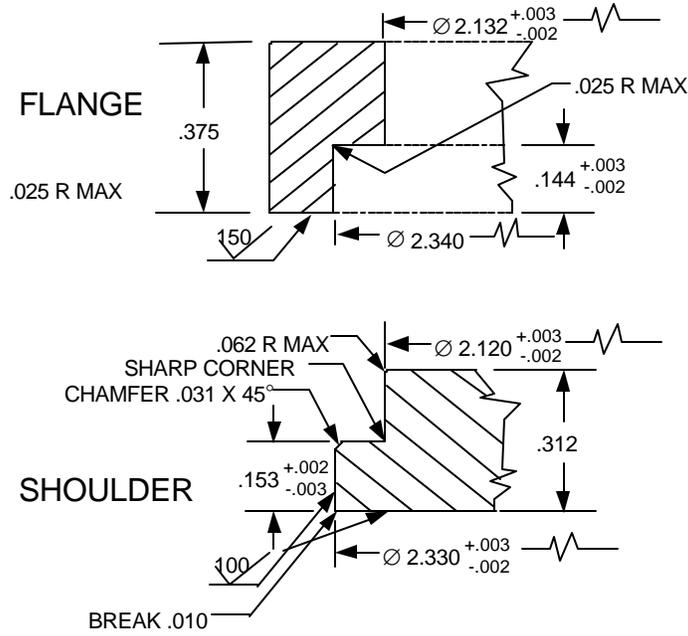


FIGURE 1. Flange illustration - Continued.

TABLE I. Flange composition.

PIN MS28746	Tubing OD	A max	B max	C	D dia	E max dia	F ^{4/}	Weight pounds (approx.)
-24	1.500	4.047	1.844	.812	1.281	2.188	.625	1.013
-32	2.000	4.859	2.250	.953	1.750	2.625	.875	1.264

Notes.

- 1/ If width diametrically across flats or hex is less than the body diameter, the flats or hex shall extend the full length of the body.
- 2/ Diameters after plating must be concentric with each other within .005 total indicator reading.
- 3/ The manufacturer's PIN and CAGE Code shall be permanently marked on the body.
- 4/ Hex or flats shall fit standard wrench openings.

Dimensions and tolerances. Dimensions are in inches. Unless otherwise specified, tolerances are as follows: angles $\pm 5^\circ$; decimals $\pm .005$.

Materials. Flange: 1137 steel in accordance with ASTM A108.

Nipple and shoulder: 1137 steel in accordance with ASTM A108.

Tubing: 1010 steel in accordance with SAE-AMS-T-5066.

Body: aluminum alloy 2024 in accordance with SAE AMS-QQ-A-225/6.

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 in accordance with QQ-P-416. Zinc plating shall be in accordance with ASTM B 633. It is recommended that the use of cadmium plating be used only when other platings cannot meet performance requirements.

Aluminum alloy: Anodize in accordance with MIL-A-8625.

Workmanship. Break all sharp edges and remove all hanging burrs and slivers that might become dislodged under usage.

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 flange or on a removable tag securely attached to the flange. The PIN for this part shall be as shown in table I (e.g., MS28746-24).

Order of precedence. This specification sheet takes precedence over the documents referenced herein. Unless otherwise specified, 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.

CONCLUDING MATERIAL

Custodians:
Army - AT
Navy - AS
Air Force - 99
DLA - CC

Preparing activity:
DLA - CC

(Project 4730-0713)

Review activities:
Army - AV
Air Force - 11, 82