

INCH-POUND

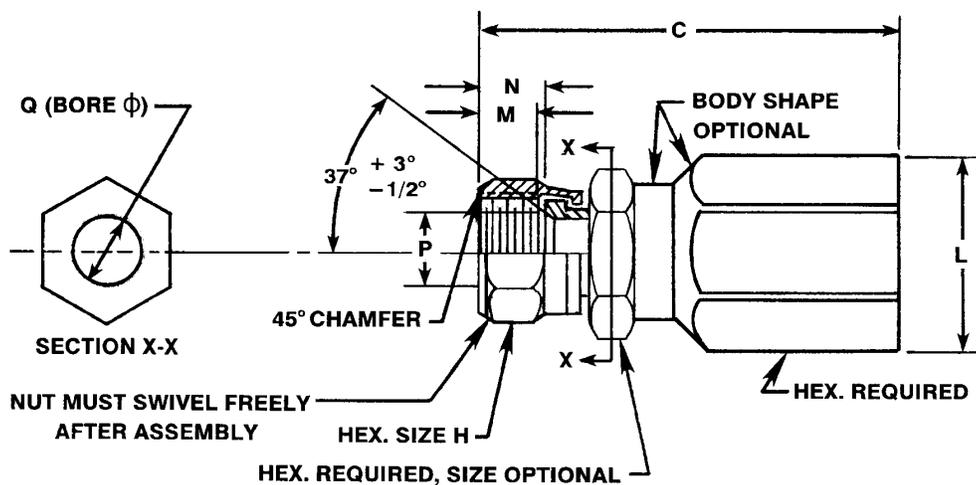
MIL-DTL-52525/5B
30 June 1998
SUPERSEDING
MIL-F-52525/5A
30 June 1987

DETAIL SPECIFICATION SHEET

FITTINGS, HOSE, SCREW-ON TO 37° FLARE FEMALE SWIVEL,
STRAIGHT, TYPE 100R1

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-52525. The fittings described herein are for use with
MIL-DTL-52471, type 100R1, single wire braid hose.



NOTE:
1. DIMENSION P TO BE CONCENTRIC WITH
DIMENSION Q WITHIN 0.015 FIM

FIGURE 1. Fitting, screw-on to 37° flare, straight.

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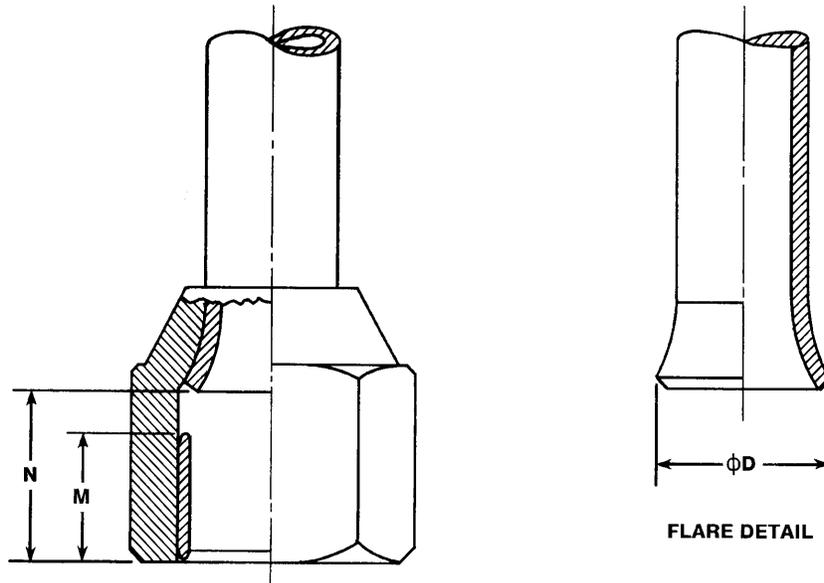


FIGURE 2. Alternate termination radial flare.

TABLE I. Dimensions for type 100R2 fittings. 1/

Part number	Hose dash no.	Hose I.D.	Tube dash no.	Tube O.D.	Thread size	C Maximum	H Hex size	L Maximum
M52525/5-4-4	4	1/4	4	1/4	7/16-20	3.00	9/16	0.87
M52525/5-4-5	4	1/4	5	5/16	1/2-20	2.80	5/8	0.87
M52525/5-6-6	6	3/8	6	3/8	9/16-18	3.32	11/16	1.09
M52525/5-8-8	8	1/2	8	1/2	3/4-16	3.65	7/8	1.20
M52525/5-8-10	8	1/2	10	5/8	7/8-14	3.87	1	1.20
M52525/5-12-12	12	3/4	12	3/4	1-1/16-12	4.76	1-1/4	1.59
M52525/5-16-16	16	1	16	1	1-5/16-12	5.50	1-1/2	2.02
M52525/5-20-20	20	1-1/4	20	1-1/4	1-5/8-12	4.96	2	2.46

1/ All dimensions not shown shall conform to SAE J516.

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TABLE I. Dimensions for type 100R2 fittings - Continued. 1/

Part number	M Minimum	N +0.030 -0.015	P ±0.005	Q Minimum
M52525/5-4-4	0.300	0.344	0.295	0.11
M52525/5-4-5	0.331	0.375	0.355	0.11
M52525/5-6-6	0.333	0.375	0.435	0.26
M52525/5-8-8	0.375	0.422	0.570	0.38
M52525/5-8-10	0.461	0.500	0.680	0.38
M52525/5-12-12	0.469	0.562	0.850	0.57
M52525/5-16-16	0.563	0.594	1.000	0.78
M52525/5-20-20	0.563	0.625	1.410	1.010

1/ All dimensions not shown shall conform to SAE J516.

TABLE II. Maximum operating pressures of fittings.

Hose I.D.	PSI
1/4	5000
5/16	4250
3/8	4000
1/2	3500
5/8	2750
3/4	2250
1	2000
1-1/4	625

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TABLE III. Over-tightening torque for swivel nut.

Tube O.D.	Torque
	inch pounds (in-lb)
1/4	135
5/16	180
3/8	270
1/2	450
5/8	650
3/4	900
1	1200

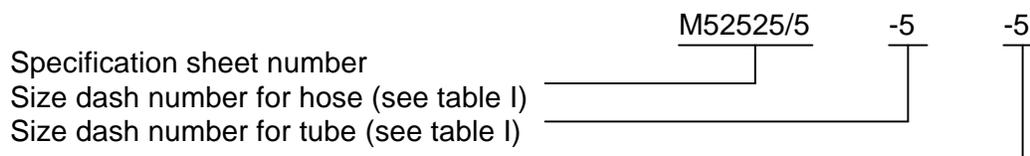
REQUIREMENTS:

1. Fittings shall be accordance with figure 1 and table I through III.
2. Materials and finishes shall be as specified in MIL-DTL-52525.
3. Marking shall include the manufacturer's name or trademark, size, and hose identifier R2. Location of marking is optional.

NOTES:

1. Dimensions are in inches.
2. Part number.

Example of a Military part number: M52525/5-5-5



CONCLUDING MATERIAL

Custodian:
 Army - AT
 Air Force - 99

Preparing activity:
 DLA - CC

(Project 4730-0859-05)

Review activities:
 Air Force - 82
 Army - AR