

MS27638D

TABLE I. Mandrel sleeve dimensions.

Part number	A	B	C	D	E	
	±.02	±.02	±.005	±.005	min	max
MS27638-4C	3.37	1.12	.325	.475	.225	.230
MS27638-6C	3.75	1.50	.300	.605	.322	.334
MS27638-8C	4.25	2.00	.355	.705	.440	.445
MS27638-10C	4.25	2.00	.295	.870	.575	.580

REQUIREMENTS:

1. Mandrel sleeves shall be in accordance with figure 1 and table I.
2. Material shall be S2 steel (UNS T41902) as specified in ASTM A681. Hardness shall be Rockwell C 58 to 60.
3. Finish shall be black oxide as specified in SAE AMS2485.
4. Radius or break all corners to .005 +.005/-.000, unless otherwise specified.
5. All burrs and slivers shall be removed.
6. Surface roughness, in accordance with ASME B46.1, shall not exceed 125 µin R_a, unless otherwise specified.
7. All tolerances shall be ±.005, unless otherwise specified.
8. The part number and manufacturer's part number shall be marked in accordance with MIL-DTL-83296.

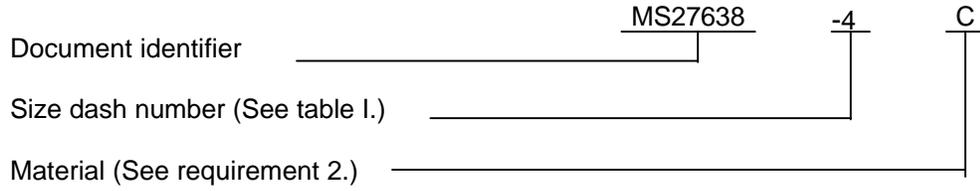
NOTES:

1. Dimensions are in inches, unless otherwise specified.
2. For hex, use commercial stock size tolerance as specified in SAE AMS2241M.
3. This part is for use with MIL-DTL-83298 hose.
4. This specification sheet takes precedence over documents referenced herein.
5. Referenced documents shall be of the issue listed in the issue of the Department of Defense Index of Specifications and Standards (DoDISS) and supplement thereto, cited in the solicitation.
6. Dimensioning and tolerancing are in accordance with ASME Y14.5M-1994.

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7. Part or Identifying Number (PIN):

Example of a PIN: MS27638-4C.



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

Preparing activity:
DLA - CC
(Project 4730-1040-042)

Review activities:
Air Force - 82
Navy -MC, SA