

INCH-POUND
 MIL-DTL-52618/1E
 26 January 2012
 SUPERSEDING
 MIL-DTL-52618/1D
 25 November 2002

DETAIL SPECIFICATION SHEET

FITTINGS, PIPE, ALUMINUM-ALLOY THREADED, 150-POUND,
 90-DEGREE ELBOWS, TEES, CROSSES, 45-DEGREE
 ELBOWS AND COUPLINGS (STRAIGHT SIZES)

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 sheet specification and MIL-DTL-52618.

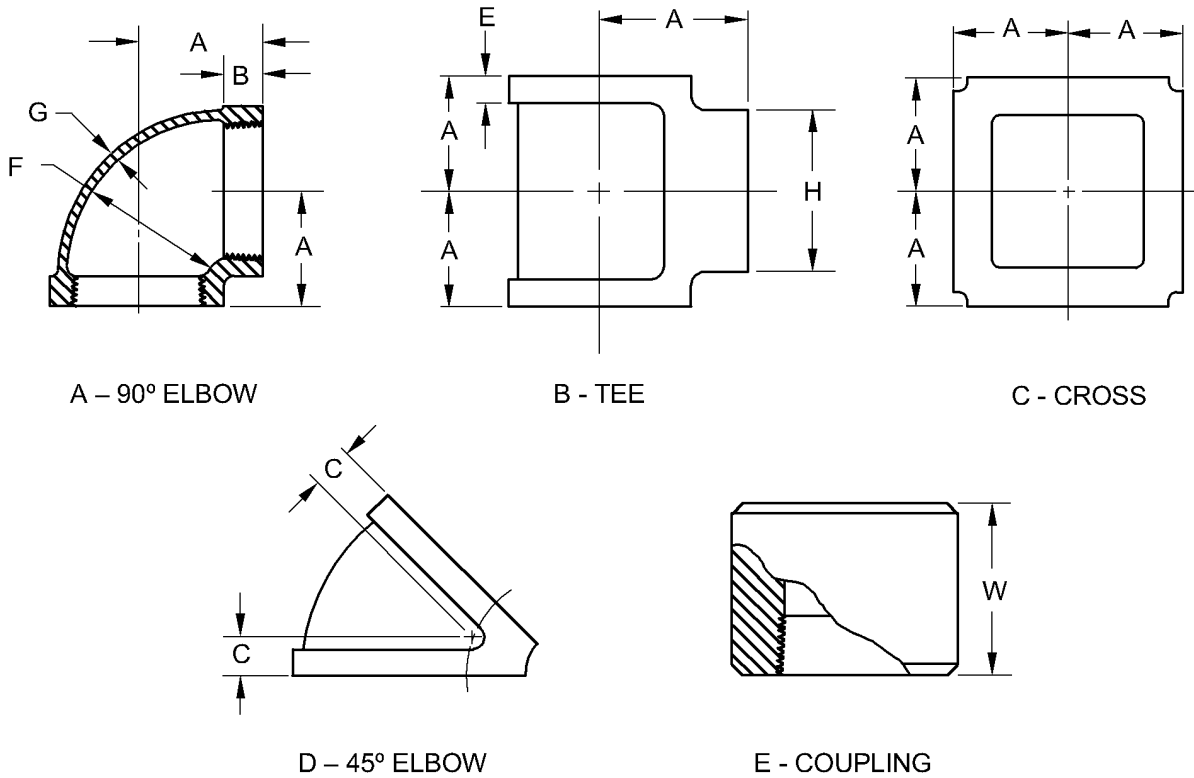


FIGURE 1. 90° elbows, tees, crosses, 45° elbows, and couplings.

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REQUIREMENTS:

The fittings shall be as specified in figure 1.

The design, dimensions, and tolerances of couplings and street elbows shall be in accordance with ASME B16.3 class 150.

Aluminum shall be in accordance with MIL-DTL-52618.

Intended use is with water, oil, or air 150 psi (1.03 MPa) max at 72°F (22°C).

Configuration designators shall be in accordance with table I.

TABLE I. Configuration code letter for fittings.

Configuration code	Description
A	90° Elbow
B	Tee
C	Cross
D	45° Elbow
E	Coupling

Size code numbers shall be in accordance with table II.

TABLE II. Size code numbers for fittings.

Size code numbers	Nominal pipe size (inch)
01	1/8
02	1/4
03	3/8
04	1/2
05	3/4
06	1
07	1 - 1/4
09	2
10	2 - 1/2
11	3
12	3 - 1/2
13	4
14	5
15	6
16	8
17	10
18	12

Pipe threads shall be in accordance with MIL-DTL-52618.

Pipe thread direction code shall be in accordance with table III.

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TABLE III. Thread direction code letter.

Thread direction code letter	Thread direction
X	Right-hand
Y	Left-hand
Z	Right- and left-hand

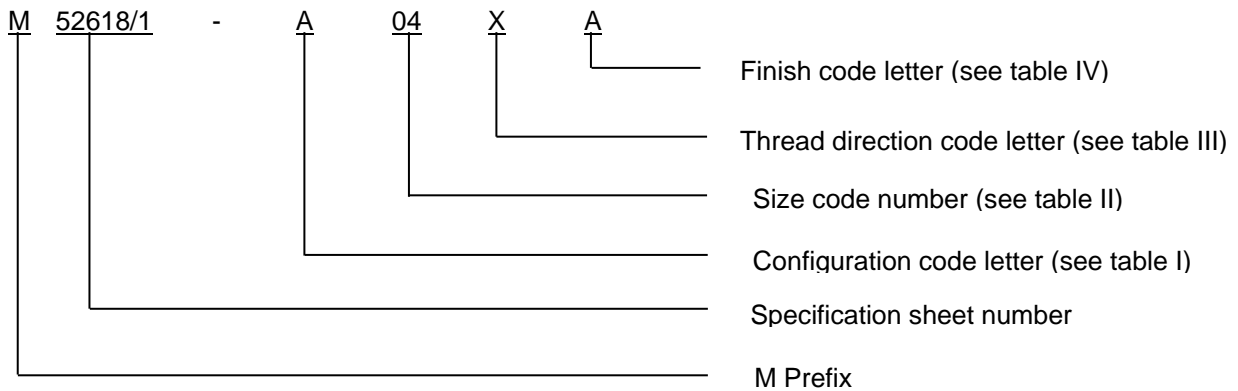
Finish shall be in accordance with MIL-DTL-52618.

Finish code letter shall be in accordance with table IV.

TABLE IV. Finish code letter.

Finish	Finish code letter
As cast	A
As extruded	B
Anodized	C

Part or Identifying Number (PIN). The PIN consists of the letter M, specification sheet number, a dash, configuration code letter, size code number, thread direction code letter and finish code. PIN numbers are assigned as follows:



PIN example: M52618/1-A04XA indicates a 90° elbow for a 1/2 inch pipe, right hand threads, and finish is “as cast”.

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.

Referenced documents. In addition to MIL-DTL-52618, this document references ASME B16.3.

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CONCLUDING MATERIAL

Custodians:

Army - AT

Navy - AS

DLA - CC

Preparing activity:

DLA - CC

Review activities:

Army - CE

Navy - MC, SA

(Project 4730-2012-010)

NOTE: The activities listed above were interested in this document as of the date of this document. Since organizations and responsibilities can change, you should verify the currency of the information above using the ASSIST Online database at <https://assist.daps.dla.mil>.