

INCH-POUND

MS21954B
 15 June 2000
 SUPERSEDING
 MS21954A
 16 May 1975

DETAIL SPECIFICATION SHEET

BODY, CLUSTER FITTING, TWO-WAY, 90°, FLARE

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

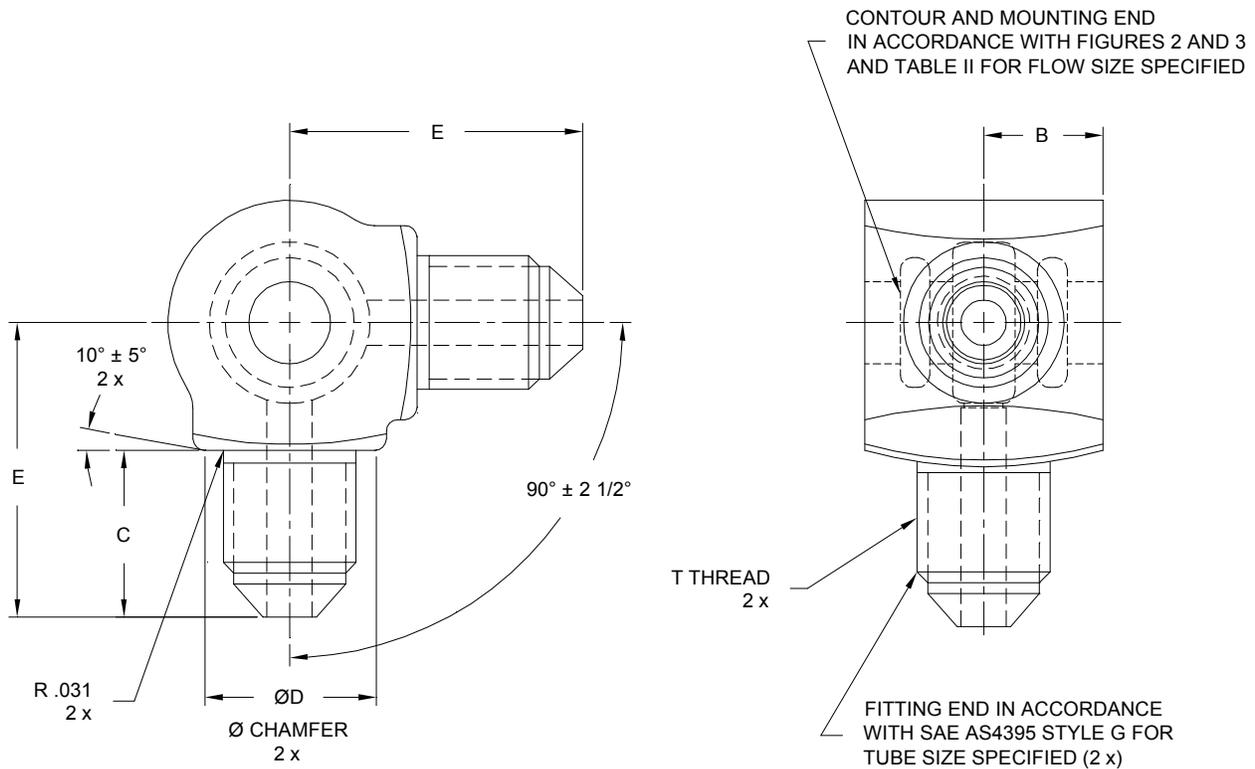


FIGURE 1. Body, cluster fitting.

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TABLE IA. Dimensions for low flow sizes.

Low Flow Size		Tube OD	Thread T SAE AS8879	B	C	D	E
Al Alloy 7075	Al Alloy 1/ 2014/2024						
W3L	-3L	.187	.375-24UNJF-3A	.500	.540	.710	1.109
W4L	-4L	.250	.4375-20UNJF-3A	.500	.625	.710	1.187
W5L	-5L	.312	.500-20UNJF-3A	.500	.625	.710	1.187
W6L	-6L	.375	.5625-18UNJF-3A	.500	.640	.710	1.203

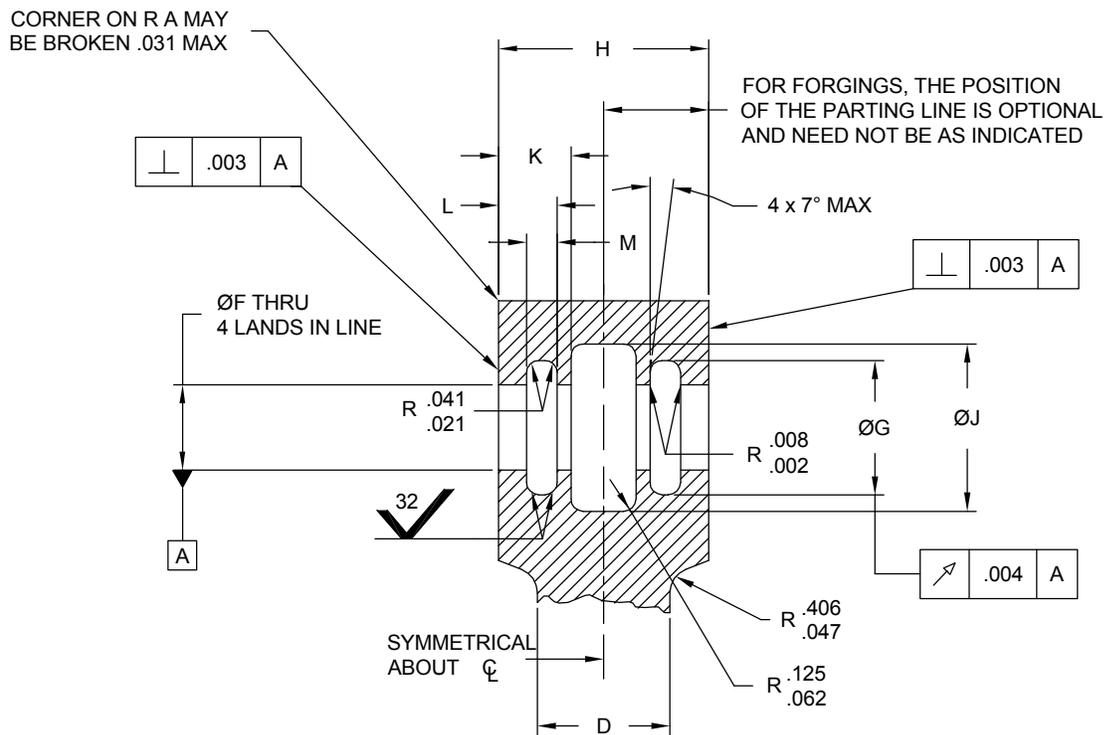
1/ Aluminum alloy 2014 and 2024 parts are cancelled. Use Aluminum alloy 7075 parts for new design. Cancelled parts may be used till stock is exhausted.

TABLE IB. Dimensions for high flow sizes.

High Flow Size		Tube OD	Thread T SAE AS8879	B	C	D	E
Al Alloy 7075	Al Alloy 1/ 2014/2024						
W4H	-4H	.250	.4375-20UNJF-3A	.594	.625	.710	1.438
W5H	-5H	.312	.500-20UNJF-3A	.594	.625	.710	1.438
W6H	-6H	.375	.5625-18UNJF-3A	.594	.648	.710	1.460
W8H	-8H	.500	.750-16UNJF-3A	.594	.750	.750	1.562

1/ Aluminum alloy 2014 and 2024 parts are cancelled. Use Aluminum alloy 7075 parts for new design. Cancelled parts may be used till stock is exhausted.

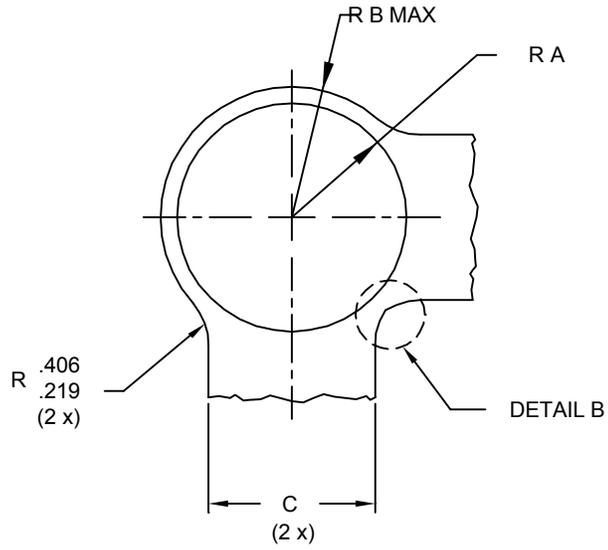
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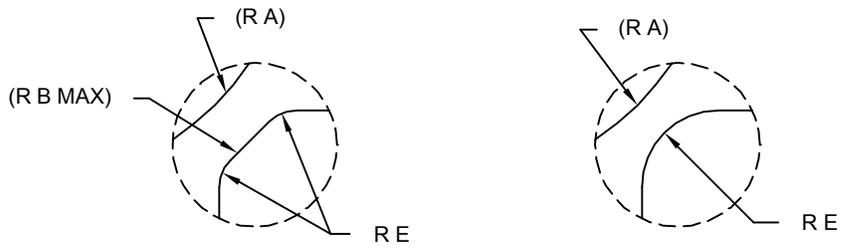
MOUNTING END DIMENSIONS

FIGURE 2. Mounting end.

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CONTOUR DIMENSIONS EXTERNAL



DETAIL B ENLARGED

DETAIL B SHOWS SINGLE OR DOUBLE FILLET,
WHICHEVER IS APPLICABLE TO TABLE II, FOOTNOTE 3/
FOR ALL FILLETS BETWEEN LEGS.

FIGURE 3. External contour.

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TABLE II. Dimensions for contour and mounting end.

Type Fitting	A ± .031	B Max 1/	C Max 2/	D Max 2/	E ± .031 3/	F ± .0005	G ± .004	H ± .005	J ± .010	K ± .010	L ± .004	M ± .005
Low Flow	.562	.636	.844	.995	.125	.5000	.664	1.000	.797	.312	.249	.143
High Flow	.812	.909	.844	1.188	.375	.8125	1.045	1.188	1.078	.375	.283	.175

1/ B radius is the max envelope dimension for forging draft, flash, and other projections on A radius.

2/ Dimensions C and D represent the max envelope which shall be large enough to meet final part dimensions.

3/ Fillet radius E between legs shall not intersect A radius.

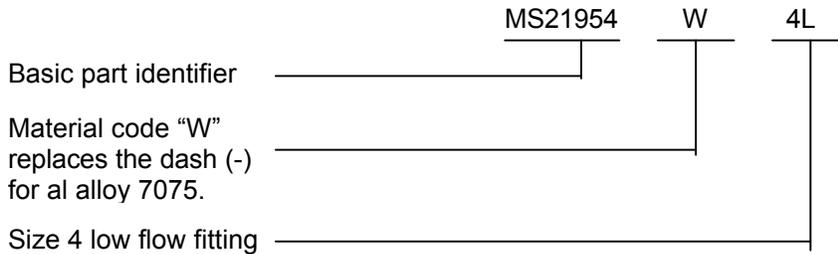
REQUIREMENTS:

1. The requirements for acquiring the product described herein shall consist of this specification sheet and SAE AS4875/1.
2. Material: Aluminum alloy 7075-T73 per AMS-QQ-A-225/9. Aluminum alloy forging, 7075-T73 per AMS-QQ-A-367.
3. Finish: See acquisition standard SAE AS4875/1. Aluminum alloy 7075 fittings shall be dyed brown.
4. All machined surfaces shall be finished to 250 μ in R_a , unless otherwise specified. Surface finish shall be in accordance with ASME B46.1.
5. Fittings shall be free of all burrs and slivers.

NOTES:

1. Dimensions in inches. Unless otherwise specified, tolerances: decimals \pm .010, angles \pm 1/2°.
2. Dimensioning and tolerancing per ASME Y14.5.
3. Part Identification number (PIN)

Example of PIN: MS21954W4L



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

Preparing activity:
DLA - CC

(Project 4730-0818)

Review activities:
Air Force - 82
Navy - SA