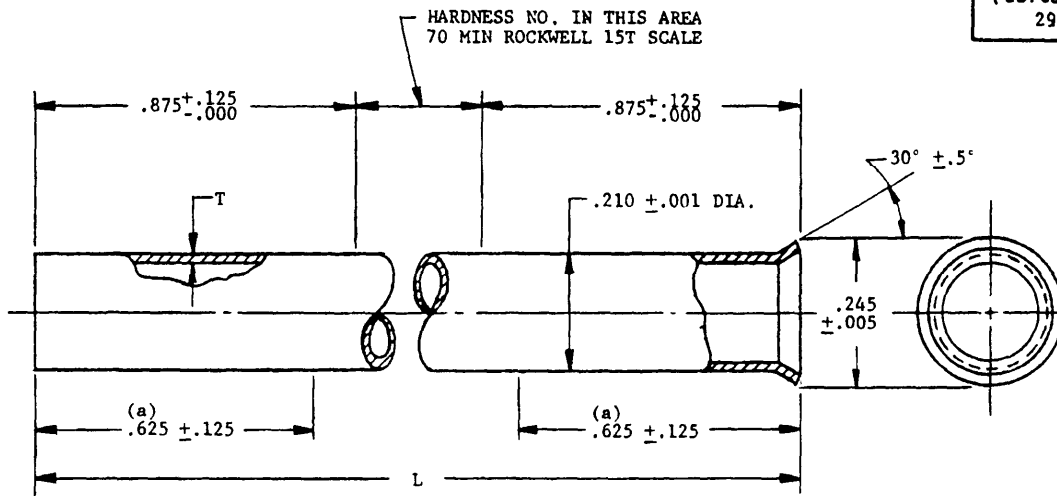


USER SYMBOLS:
NAVY - AS
USAF - 99

REVIEWER SYMBOLS:
NAVY - AS
USAF - 71

"Review/user information is current as of the date of this document.
For future coordination of changes to this document, draft circulation
should be based on the information in the current DODISS."

This military standard is approved for use by all Departments
& Agencies of the Department of Defense. Selection for all new
engineering and design applications and for repetitive use shall
be made from this document.



PART NUMBER	L +.032 -.000	T	
		MIN	MAX
23005-01	9.500	.009	.011
23005-02	9.531	.009	.011
23005-03	9.593	.009	.011
23005-04	11.562	.009	.011
23005-05	8.000	.009	.011
23005-06	10.063	.009	.011
23005-07	10.125	.009	.011
23005-08	10.406	.010	.012
23005-09	13.562	.010	.012
23005-10	5.906	.010	.012
23005-11	9.531	.015	.016
23005-12	9.593	.015	.016
23005-13	8.093	.009	.011
23005-14	9.531	.007	.008
23005-15	9.593	.007	.008
23005-16	9.093	.006	.007
23005-17	9.500	.006	.007
23005-18	9.531	.006	.007
23005-19	9.593	.006	.007
23005-20	10.125	.006	.007
23005-21	11.156	.006	.007
23005-22	11.218	.006	.007
23005-23	11.562	.006	.007
23005-24	7.843	.006	.007
23005-25	8.062	.006	.007
23005-26	8.093	.006	.007

(a) FLAME ANNEAL BOTH ENDS AFTER HEAT TREATMENT TO DIMENSIONS SHOWN PRIOR TO FLARING ONE END: HARDNESS 60-75 ROCKWELL 15T SCALE.

NOTES:

1. MATERIAL: ALUMINUM ALLOY 6061-T6 (UNS A96061) OR 6951-T6 (UNS A96951)
2. HEAT TREAT: MIL-H-6088
3. SURFACE TEXTURE 20/ALL OVER IN ACCORDANCE WITH ANSI B46.1.
4. FINISH: CHEMICAL FILM: MIL-C-5541, BEFORE FLAME ANNEAL.
5. STRAIGHTNESS: TUBE AXIS SHALL NOT DEVIATE MORE THAN .005 IN 10 INCH LENGTH.
6. DIMENSIONS IN INCHES.
7. TESTS: TESTS SHALL BE CONDUCTED IN ACCORDANCE WITH MIL-STD-105. INSPECTION LEVEL 1, AQL 0.65 FOR EACH TEST. DOUBLE OR MULTIPLE SAMPLING MAY BE USED.
INTERNAL PRESSURE: IMMERSED IN WATER, THE TUBE SHALL BE SUBJECTED TO 100 PSI AIR PRESSURE FOR AT LEAST 2-1/2 SECONDS. THERE SHALL BE NO VISIBLE LEAKAGE.
EXTERNAL PRESSURE: THE TUBE SHALL WITHSTAND 200 PSI APPLIED EXTERNALLY WITHOUT COLLAPSING.
HARDNESS TEST: TEST IN ACCORDANCE WITH FEDERAL TEST METHOD STANDARD NO. 151, METHOD 243.1.
FLARING AND FLARING TEST: FLARE AS NOTED ON STANDARD AND DYE PENETRANT INSPECT FLARED END FOR CRACKS.

FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.

(E) DENOTES CHANGE

P.A. NAVY - AS Other Cust USAF - 99 ARMY - AV	TITLE TUBE - OIL COOLER	MILITARY STANDARD	
		MS23005	
PROCUREMENT SPECIFICATION NONE	SUPERSEDES	SHEET 1	OF 1

APPROVED 25 JAN 1965 REVISED (A) 23 MAR 1967 (B) 9 FEB 1972 (C) 17 SEP 73 (D) 1 JUNE 1981 (E) 8 APR 1985