

INCH-POUND

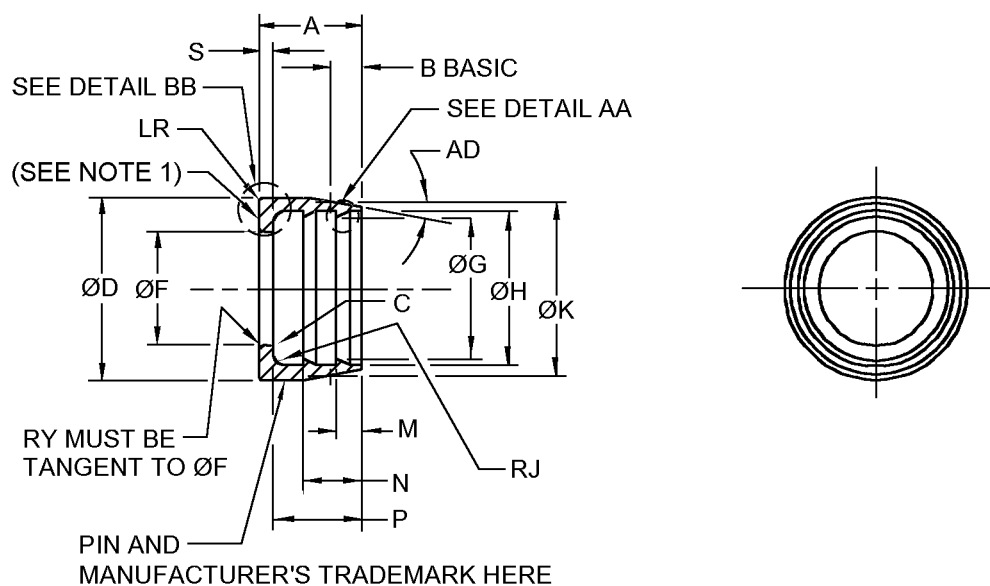
MS27070D
 24 September 2003
 SUPERSEDING
 MS27070C
 6 March 1969

DETAIL SPECIFICATION SHEET

SLEEVE, HOSE COUPLING

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 and MIL-DTL-27272.

FIGURE 1. Sleeve illustration.

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REQUIREMENTS

Intended use. This part is a component of MS27053 through MS27060 and MS27381 through MS27385.

Identification of product. The Part or Identifying Number (PIN) and the manufacturer's trademark shall be permanently marked on the part. This PIN for this part shall be as specified in table I (e.g., MS27070-4C).

Dimensions and tolerances. Dimensions are in inches. Unless otherwise specified, break or radius all corners .005, +.005, -.000. All diameters must be concentric within .005 full indicator movement.

Material. Corrosion-resistant steel, 17-4PH in accordance with SAE AMS5643. Heat treat to condition H-1150 with hardness of Rockwell C-28 to C-37.

Finish. Passivate in accordance with SAE AMS-QQ-P-35. Do not dry-film lubricate sizes -4, -5, and -6. On other sizes, dry-film lubricate radius Y and angle U; dry-film lubrication on D diameter and F diameter is acceptable; dry-film lubrication on taper AD not acceptable; and dry film lubrication beyond AE dimension on size -24 is not acceptable. All dry-film lubrication shall conform to SAE AS1701.

Sleeve illustration. See figure 1.

Remove all burrs and slivers.

Surface roughness. Unless otherwise specified, maximum surface roughness shall not exceed 125 μin . R_a in accordance with ASME B46.1.

Order of precedence. This specification takes precedence over the documents referenced herein. Unless otherwise specified, referenced documents shall be of the issue in effect on the date of solicitation.

TABLE I. Sleeve requirements.

PIN	A ±.005	B	C	D +.000 -.005	E ±.005	F		G		H		J max
MS27070												
-4C	.285	.0850	.005 max break	.375	-	.211	+.006 -.000	.266	+.005 -.000	.290	±.005	.015
-5C		.0757		.437	-	.274		.329		.354		
-6C		.0815		.500	-	.336		.390		.415		
-8C		.0955		.625	-	.432		.491		.525		
-10C		.1134		.745	.585	.532	+.004 -.000	.596		.631		
-12C		.1099	-	.875	.715	.658		.728		.705		-
-16C		.500	-	1.155	.985	.908	+.005 -.000	.978		1.013		-
-20C	.740	.1381	-	1.470	1.225	1.160		1.233		1.268		-
-24C	.760	-	-	1.740	1.490	1.410		1.520	+.005	1.555	±.002	-

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PIN	K ±.003	L		M ±.005	N ±.005	P ±.005	Q ±.002	S		U 1/ ±.5°	Y +.005 -.000			
MS27070														
-4C	.344	-	-	.060	.160	-	.012	.050	+.005 -.000	-	.040			
-5C	.408	-	-			-				-				
-6C	.468	-	-			-				-				
-8C	.589	-	-	.100	.225	-	.016	.055	±.005	-	45°			
-10C	.703	-	-			-		.060		-				
-12C	.834	-	-			-		.100		-				
-16C	1.084	.005	+.015 -.000			.370		-		-		-		
-20C	1.359			.190	.340			.590		-		-	-	
-24C	-									.010		max	-	-

See note at end of table.

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TABLE I. Sleeve requirements - Continued.

PIN	Z ±.005	AA ±.005	AB ±.005	AC ±.005	AD ±.25°	AE ±.005	AF +.005 -.000
MS27070							
-4C	-	-	-	-	10°	-	-
-5C	-	-	-	-		-	-
-6C	-	-	-	-		-	-
-8C	-	-	-	-		-	-
-10C	-	-	-	-		-	.005
-12C	-	-	-	-		-	
-16C	-	-	-	-		-	
-20C	-	-	-	-		-	
-24C	.174	.298	1.658	1.690	-	.260	

1/ Surface must be free from longitudinal scratches, nicks, or tool marks.

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.

CONCLUDING MATERIAL

Custodians:

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

Preparing activity:

DLA - CC

(Project 4730-0868-045)

Review activities:

Army - AR, AT, MI
Navy - MC, SA, SH
Air Force - 71