

INCH-POUND

MS27077D
 14 January 2014
 SUPERSEDING
 MS27077C
 25 September 2003

DETAIL SPECIFICATION SHEET

FLANGE, SWIVEL, RETAINING

This specification sheet 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 sheet and MIL-DTL-27272.

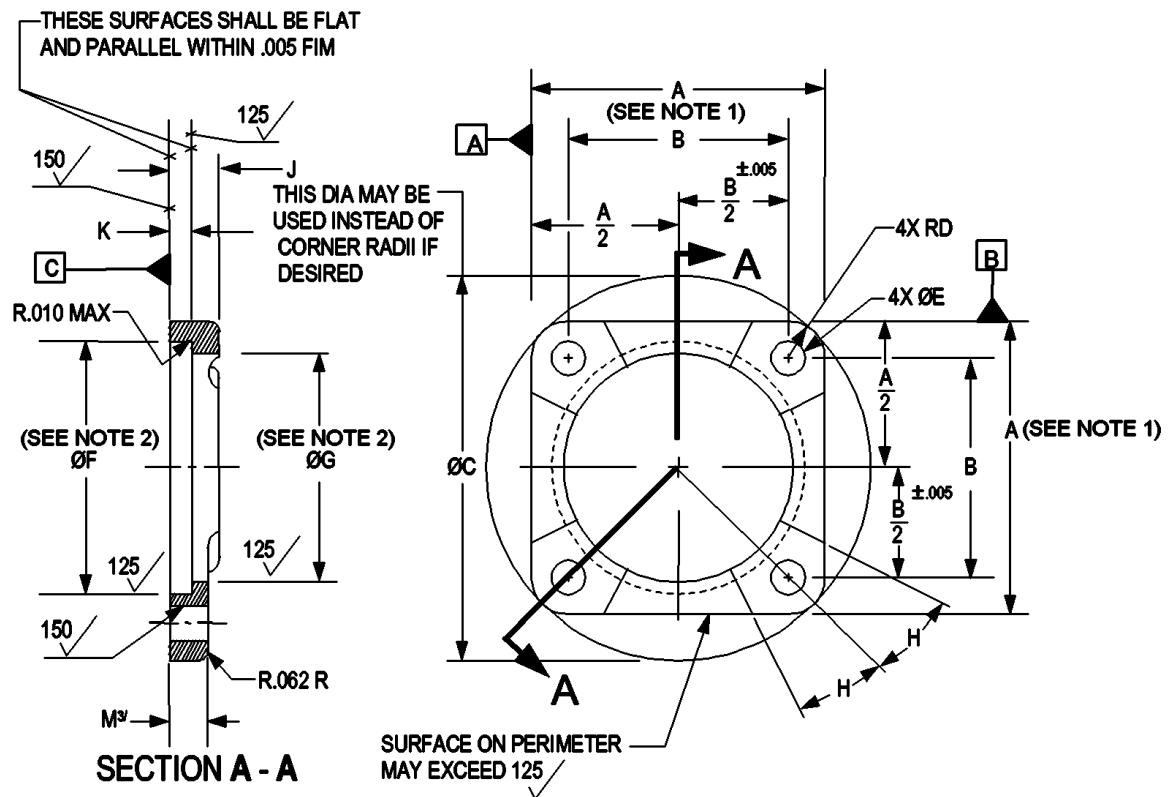


FIGURE 1. Flange illustration.

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Size and material code	A (see note 1)		B ±.005	C ±.015	D ±.016	E +.010 -.000
-8C	1.390	±.016	.950	1.782	.219	.205
-10C	1.468		1.038	1.906		
-12C	1.594		1.156	2.094		
-16C	1.750		1.312	2.312		
-20C	2.188	±.020	1.656	2.875	.266	.266
-24C	2.375		1.812	3.094	.281	

Size and material code	F (see note 2) +.005 -.000	G (see note 2) +.010 -.000	H ±.5° (see note 6)	J ±.016	K +.005 -.000	M (see note 7) +.015 -.005
-8C	.885	.750	20°	.297	.136	.234
-10C	1.010	.880				
-12C	1.260	1.125				
-16C	1.510	1.375	18°	.359	.168	.297
-20C	1.854	1.688	16°			
-24C	2.135	1.938				

NOTES:

1. Reduction of dimensions by 7° max draft angle permissible if forged.
2. Diameters F and G shall be concentric within .010 inch full indicator movement (FIM).
3. Unless otherwise specified, break or radius all corners .005, +.005, -.000 inch.
4. Surface roughness. Unless otherwise specified, maximum surface roughness shall not exceed 125 μ in R_a in accordance with ASME B46.1.
5. Remove all burrs and slivers.
6. H dimension equally applies to all 4 holes.
7. Part may be forged or machined from bar. If machined, thickness shall be to dimension M.

FIGURE 1. Flange illustration - Continued.

REQUIREMENTS

Flange illustration. See figure 1.

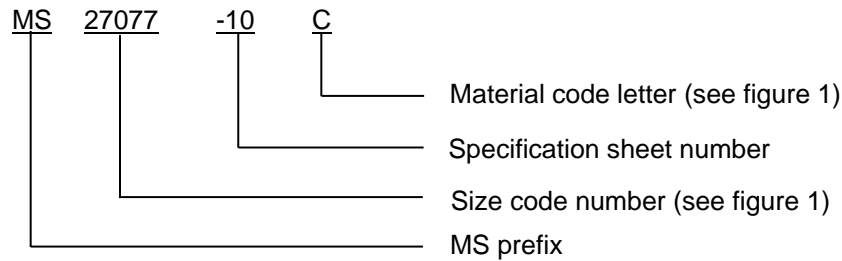
Intended use. This part is a component of MS27062, MS27064, and MS27066. This is a design standard for manufacturing purposes. The item is only procured as an integral part of adapter assemblies.

Material. Corrosion-resistant steel (CRES), class 304, condition A, in accordance with SAE-AMS-QQ-S-763 or 304 CRES in accordance with SAE-AMS5639.

Finish. Passivate in accordance with SAE-AMS2700 method 1, type 6 or 7.

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PIN: The PIN consists of prefix "MS", the specification sheet number, dash number for swivel flange size, and the letter "C" for material. Unassigned PIN's shall not be used.



PIN example:

MS27077-10C indicates a swivel flange size 10, CRES.

Order of precedence. Unless otherwise noted herein or in the contract, in the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

Referenced documents shall be of the issue in effect on date of invitations for bid.

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-27272, this document references the following:

MS27062	SAE-AMS-QQ-S-763
MS27064	SAE-AMS2700
MS27066	SAE-AMS5639
ASME B46.1	

CONCLUDING MATERIAL

Custodians:

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

Preparing activity:

DLA - CC

(Project 4730-2013-105)

Review activities:

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

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.dla.mil>.