

INCH-POUND

MS27236A
 22 September 2000
 SUPERSEDING
 MS27236
 6 August 1964

DETAIL SPECIFICATION SHEET

SHOULDER - DESIGNED FOR 45° AND 90° SWIVEL NUT HOSE TO TUBE
 ADAPTERS, REUSABLE, HYDRAULIC, FUEL AND OIL LINES

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 sheet and MIL-DTL-5070E.

REQUIREMENTS.

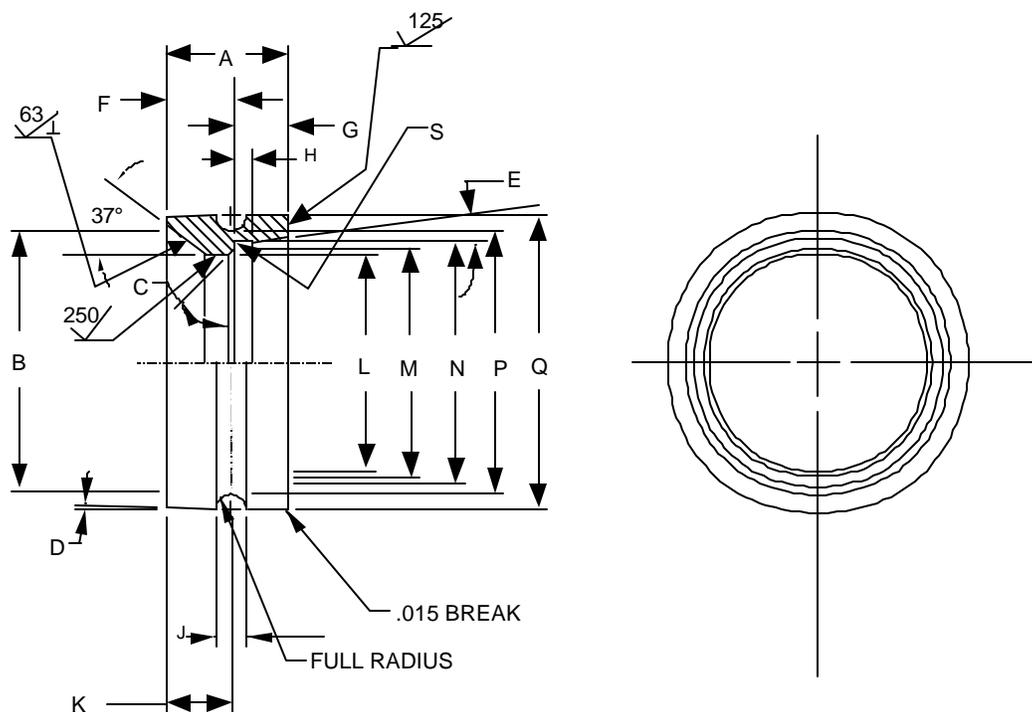


FIGURE 1. Shoulder illustration.

MS27236A

TABLE I. Shoulder composition.

PIN	A	B	C	D	E	F	G	H	J
MS27236	±.007	Dia					(ref)		
-4	.344	.305 .285	0°	0°	30°	.190 .185	.156	.118 .089	.076
-5	.406	.365 .345				.253 .248			.086
-6	.422	.445 .425				.269 .264			
-8	.437	.580 .560	34°	2°	10°	.285 .280	.250	.046 .031	.100
-10	.500	.690 .670		1.5°		.347 .342			
-12	.531	.860 .840				10°			.284 .279
-16		1.118 1.088	.077 .062						
-20	.594	1.425 1.395		.046 .031	.347 .342				
-24	.656	1.640 1.610	.409 .404						
-32	.781	2.255 2.225	.534 .529						

PIN	K	L	M	N	P	Q	S
MS27236	±.002	Dia	Dia	Dia	Dia	Dia	
-4	.129	.178		.254 .251	.298 .293	.384 .379	.015 x 45° max. break
-5	.173	.209		.316 .313	.346 .341	.447 .442	
-6	.196	.272		.379 .376	.403 .398	.504 .499	
-8	.225	.365	.420	.504 .501	.564 .559	.684 .679	.015 .010 radius
-10	.261	.490	.545	.629 .626	.679 .674	.800 .795	
-12	.214	.615	.670	.754 .751	.821 .816	.972 .967	
-16	.243	.865	.920	1.004 1.001	1.088 1.080	1.219 1.213	.030 radius
-20	.322	1.115	1.170	1.254 1.251	1.385 1.377	1.531 1.525	
-24	.338	1.329	1.420	1.504 1.501	1.638 1.630	1.781 1.775	
-32	.414	1.829	1.920	2.004 2.001	2.263 2.255	2.406 2.400	.015 .010 radius

MS27236A

Intended use. This part is a component of MS27223 and MS27225.

Dimensions and tolerances. Dimensions are in inches. Unless otherwise specified, tolerances are as follows: angles $\pm 5^\circ$; decimals ± 0.005 . Break or radius all corners .010/.005 (max./min.). All diameters shall be concentric within .010 total indicator reading.

Materials: Sizes -4 through -6: 1137 steel, cold drawn, in accordance with ASTM A108.
Sizes -8 through -32: aluminum alloy 6061, T651, in accordance with SAE AMS QQ-A 225/8.

Surface roughness. Unless otherwise specified, maximum surface roughness shall be 125 μin R_a in accordance with ASME B46.1.

Workmanship. Break all sharp edges and remove all burrs and slivers.

Identification of product. The part or identifying number (PIN) and the manufacturer's Commercial and Government Entity (CAGE) Code or trademark shall be permanently marked on the shoulder or on a removable tag securely attached to the shoulder. The PIN for this part shall be as shown in table I (e.g., MS27236-4).

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

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 - AT
Navy - AS
Air Force - 99
DLA - CC

Preparing activity:

DLA - CC

(Project 4730-0709)

Review activities:

Army - AV
Navy - MC, SA
Air Force - 11, 82