

INCH-POUND

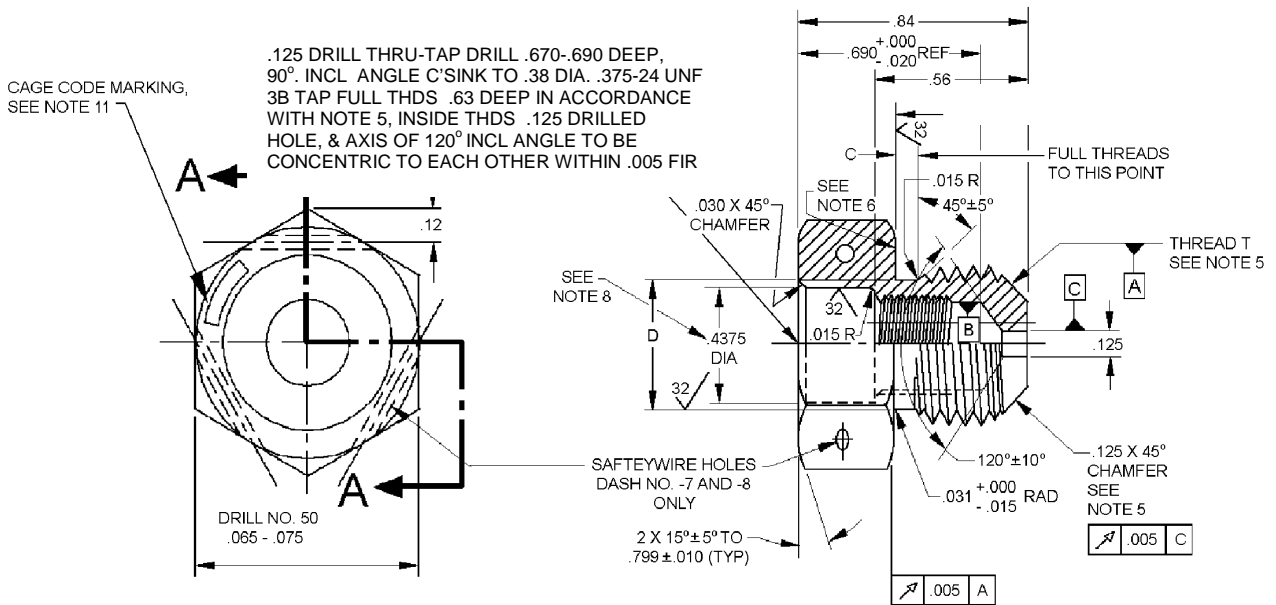
MS27612L
 30 August 2012
 SUPERSEDING
 MS27612K
 11 September 2006

DETAIL SPECIFICATION SHEET

ADAPTER, HYDRAULIC BLEEDER VALVE, AIRCRAFT WHEEL BRAKE

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.



Inches	mm	Inches	mm
.0010	0.03	.120	3.05
.002	0.05	.125	3.18
.0050	0.127	.180	4.57
.005	0.13	.38	9.65
.010	0.25	.4375	11.113
.015	0.38	.48	12.19
.030	0.76	.56	14.22
.031	0.79	.63	16.00
.065	1.65	.670	17.02
.075	1.91	.799	20.29
		.84	21.3

FIGURE 1. Adapter dimensions and configuration.

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Part or Identifying Number (PIN)	T Thread Size (see note 5)	B $\begin{matrix} +.003 \\ -.004 \\ (+0.08 \text{ mm} \\ -0.10 \text{ mm}) \end{matrix}$	C inch (mm)	D Dia. $\begin{matrix} +.002 \\ -.003 \\ (+0.05 \text{ mm} \\ -0.08 \text{ mm}) \end{matrix}$
MS27612-5	.5625-18UNJF-3A	.8130 (20.650 mm)	.083 $\begin{matrix} +.015 \\ -.000 \end{matrix}$.481 (12.22 mm)
MS27612-7 (see note 8)			$\left(\begin{matrix} 2.11 & +0.38 \\ & -0.00 \end{matrix} \right)$	
MS27618-7C (see notes 8 and 9)				
MS27612-6	.7500-16UNJF-3A	1.000 (25.40 mm)	.100 $\begin{matrix} +.009 \\ -.006 \end{matrix}$.660 (16.76 mm)
MS27612-8 (see note 8)			$\left(\begin{matrix} 2.54 & +.002 \\ & -.003 \end{matrix} \right)$	
MS27612-8C (see notes 8 and 9)				

NOTES:

- Dimensions are in inches.
- Metric equivalents are given for information only.
- Dimensioning and tolerancing in accordance with ASME Y14.5M. Unless otherwise specified, tolerances for decimals $\pm .005$ inch (0.13 mm), angles $\pm 5^\circ$.
- Surface texture: Symbols in accordance with ASME Y14.36, requirements in accordance with ASME B46.1. Unless otherwise specified, surfaces to be 150 $\mu\text{in } R_a$, except as noted.
- Thread T in accordance with MIL-S-7742.
- This surface to be a smooth conical surface free from burrs, tool marks and visible flat spots. Annular tool marks will be allowed to 100 $\mu\text{in } R_a$ maximum.
- "D" DIA and outside thread shall be concentric within .005 Full Indicator Reading (FIR)
- .4375 DIA and inside thread shall be concentric within .002 (FIR)
- Remove sharp edges, burr and slivers.
- MS27612-7, -7C, -8, and -8C adapters with safety wire holes are preferred for new design.
- Marking of part shall be any permanent marking method that will not damage the part. The minimum character height shall be 1/16 inch (.0625 inch) (1.57 mm).
- 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

FIGURE 1. Adapter dimensions and configuration - Continued.

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REQUIREMENTS

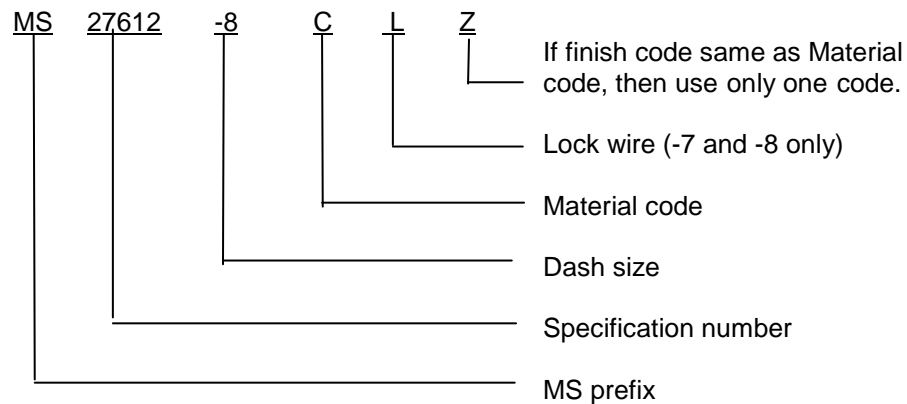
Material:

Code	Material
C	Carbon Steel bar, type 1117 in accordance with ASTM A108, ASTM A575, ASTM A576 or type 12214 in accordance with SAE AIR4127.
F	Alloy Steel bar in accordance with SAE AIR4127, or type 4130 SAE AMS6370 or SAE AMS-S-6758 or type 4140 SAE AMS6349 or SAE AMS6382.
S	Corrosion resistant steel in accordance with SAE AMS5659, SAE AMS5862, or alloy 15-5 PH in accordance with ASTM A564/A564M type XM-12 or UNS S15500. or SAE AMS5665.

Chemical Finish:

Code	Finish
C	Carbon steel: Cadmium in accordance with SAE-AMS-QQ-P-416, type II, class 3, 200 μ inches to 300 μ inches (5.08 μ m to 7.62 μ m) thick.
F	Carbon steel: Cadmium in accordance with SAE-AMS-QQ-P-416, type II, class 3, 200 μ inches to 300 μ inches (5.08 μ m to 7.62 μ m) thick.
S	Corrosion resistant steel: Passivate in accordance with SAE AMS2700, type 6 or 7.
Z	Carbon steel: Alternative chem finish, ASTM B633, type VI, FeZn 25.

PIN example:



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Guidance on use of alternative parts with less hazardous or non-hazardous materials. This specification provides an alternate material, corrosion resistant steel, and Zinc finish via the PIN. Users should select the PIN with the least hazardous material that meets the form, fit, and function requirements of their application.

Changes from previous issue. The margins of this specification are marked with vertical lines to indicate where changes from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous issue.

Referenced documents. This document references the following:

ASTM A108	
ASTM A564/A564M	SAE AMS2700
ASTM A575	SAE AMS5665
ASTM A576	SAE AMS5659
ASTM B633	SAE AMS5862
ASME B46.1	SAE AMS6349
ASME Y14.5M	SAE AMS6370
ASME Y14.36	SAE AMS-S-6758
SAE-AMS-QQ-P-416	SAE AMS6382
SAE AIR4127	MIL-S-7742

CONCLUDING MATERIAL

Custodians:

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

Preparing activity:

DLA-CC

(Project 4820-2012-014)

Review activities:

Army - AT
Navy - MC, SA
Air Force - 70, 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>.