

INCH-POUND  
 MS35644G  
 09 May 2011  
 SUPERSEDING  
 MS35644F  
 25 November 1986

DETAIL SPECIFICATION SHEET  
 FILLER NECK: FUEL TANK – MILITARY VEHICLES

Inactive for new design after 22 January 1999.

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.

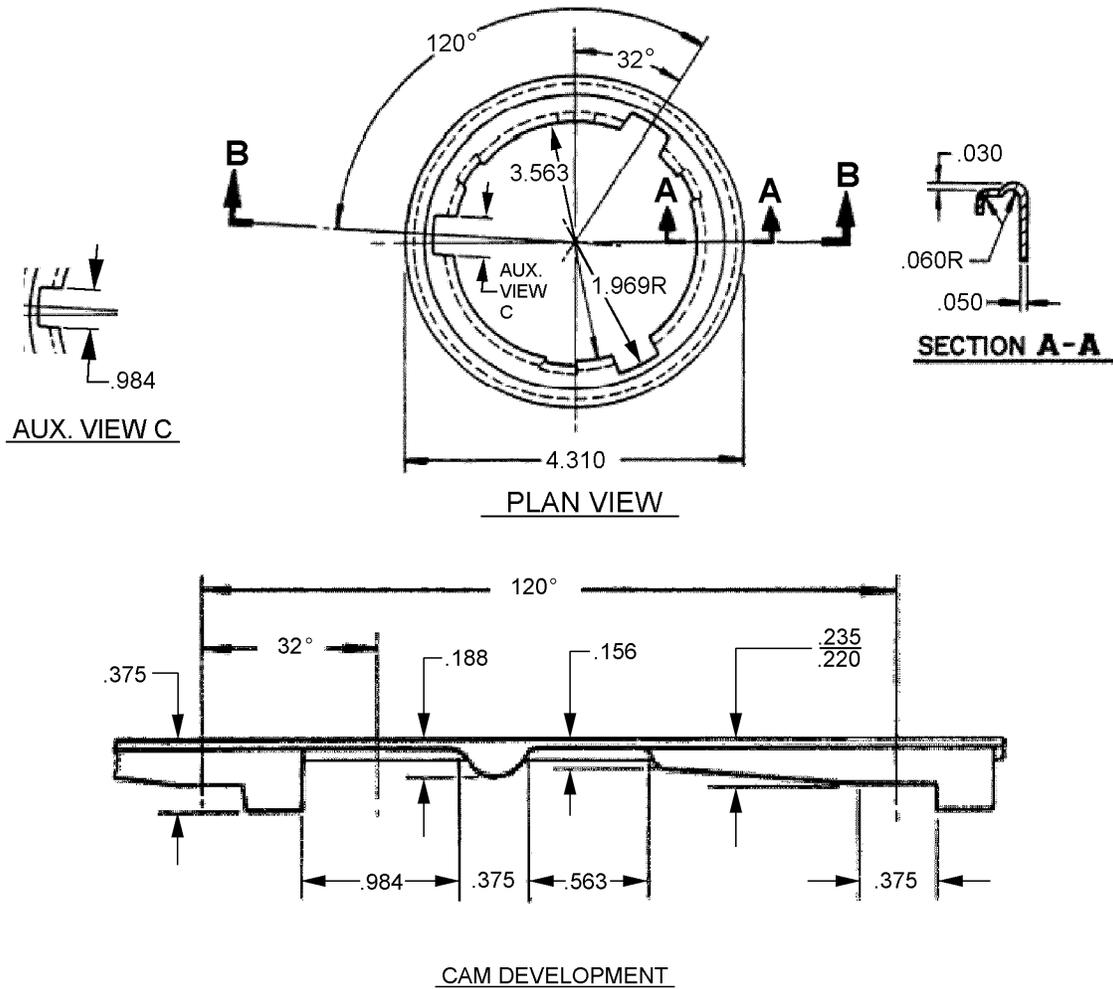


FIGURE 1. Filler neck.



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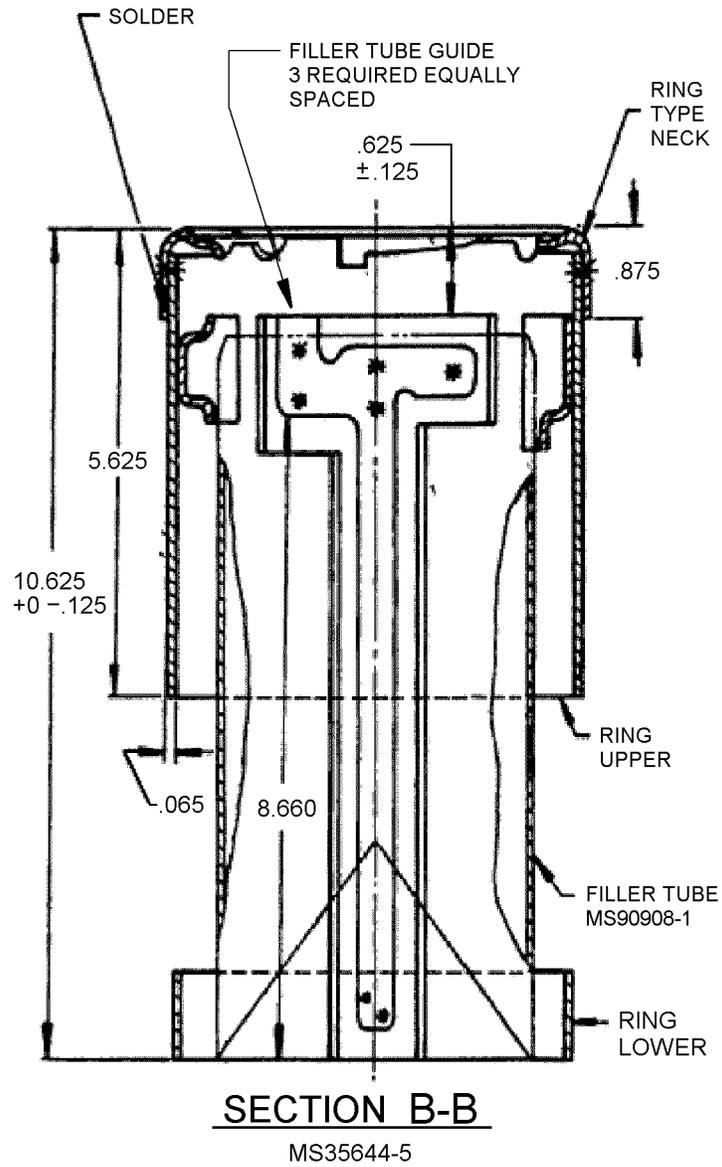
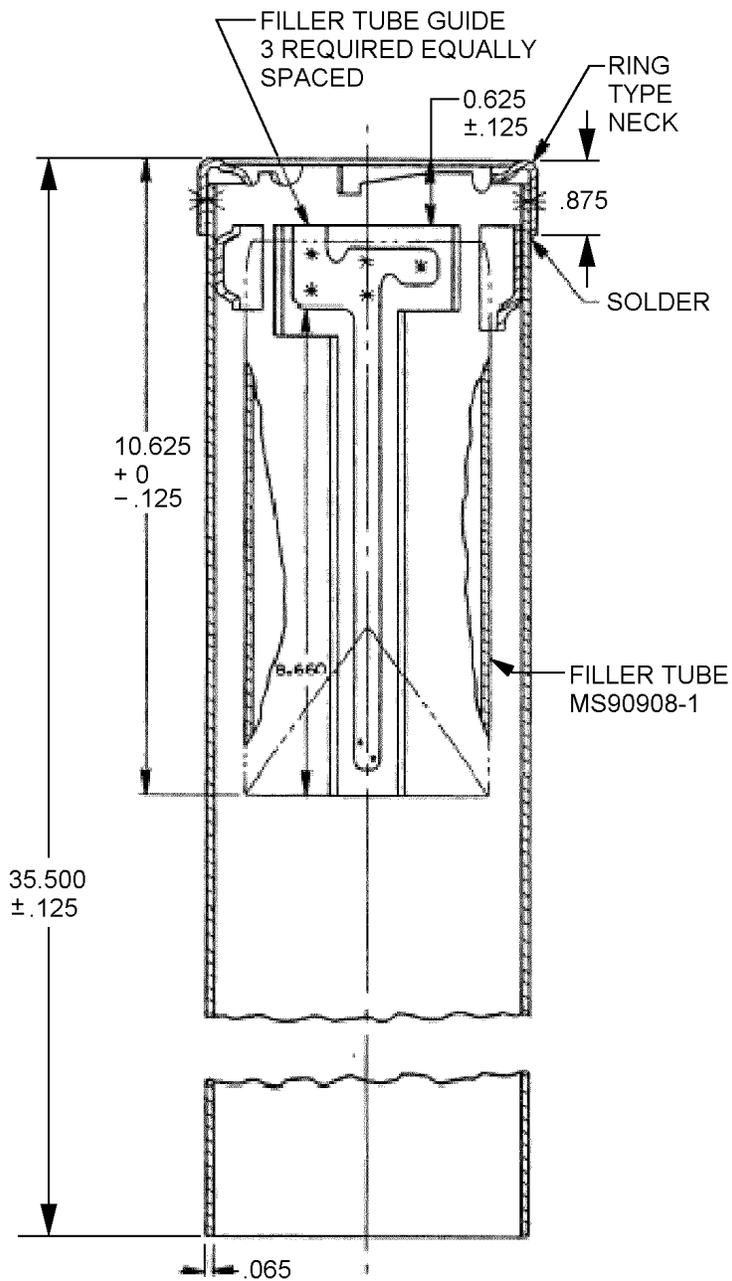


FIGURE 1. Filler neck – Continued.

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**SECTION B-B**

MS35644-9

FIGURE 1. Filler neck – Continued.

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Inches	mm	Inches	mm	Inches	mm	Inches	mm
.030	0.76	.188	4.78	.984	24.99	5.560	141.22
.050	1.27	.375	9.53	1.310	33.27	5.625	142.88
.060	1.52	.469	11.91	1.969	50.01	8.660	219.96
.065	1.65	.563	14.30	2.375	60.33	10.625	269.88
.125	3.18	.625	15.88	3.563	90.50	35.500	901.70
.156	3.96	.875	22.23	4.310	109.47		

## NOTES:

1. Dimensions are in inches. Tolerances are  $\pm .010$  on decimals,  $\pm 1^\circ$  on angles.
2. Metric equivalents are given for information only.
3. For design feature purposes, this standard takes precedence over acquisition documents referenced herein.
4. In the event of a conflict between the text of this standard and the references cited herein, the text of this standard shall take precedence.
5. This document is not intended to limit construction to features other than as shown herein by dimensions, notations or referenced documents.

FIGURE 1. Filler neck – Continued.

## Requirements:

Filler tube MS90908-1 is included as a part of filler neck assembly MS35644-1, -5 and -9.

This neck shall mate with MS35645 cap, fuel tank: tactical vehicle, fording. Specified Test depicted in procurement specification referenced therein shall apply. This neck shall also mate with caps MS51300 and MS53075.

Material: Steel sheet, low-carbon 0.15% maximum, grade 1008 to 1012 HR or CR with temper 4 or temper 5 in accordance with QQ-S-698.

Optional material: ASTM-A1011/A1011M, Grade CS, Type B, ASTM-A1008/A1008M, Grade CS, Type B, or tubing in accordance with ASTM-A513 Grades 1008 or 1010.

Steel sheet or strip hot rolled pickled and oiled or cold rolled oiled, drawing quality ASTM-A507; steel sheet Carbon cold rolled drawing quality ASTM-A619/A619M; steel carbon cold rolled strip temper 4 or 5 ASTM-A109/A109M.

Joint at filler neck and upper ring shall be air and water tight.

Welding rod shall be type I in accordance with SAE-AMS6457. Resistance spot welding shall be in accordance with AWS-D8.7M and AWS-D8.9M. Arc welding shall be type I in accordance with AWS-D1.1/D1.1M.

Solder shall be composition 40 or 50 in accordance with J-STD-004, J-STD-005, and J-STD-006 or composition 40 or 50 in accordance with ASTM-B32.

Parts shall be free from burrs and sharp edges.

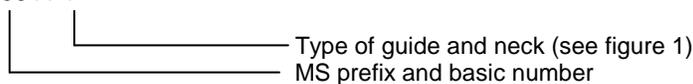
Protective coating prior to installation of strainer: Assembly shall be protected with zinc coating in accordance with ASTM-A153/A153M or zinc coating (electrodeposited) in accordance with ASTM-B633, Fe/Zn 5, type VI.

Guide shall properly position and support filler tube MS90908-1 without binding.

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Part or Identifying Number (PIN)

Example of a PIN: MS35644-1



PIN	Type of guide	Type of neck
MS35644-1	Open	Flange
MS35644-5	Open	Ring
MS35644-9	Open	Ring

Marking shall consist of the PIN and manufacturer's identification in accordance with MIL-STD-130.

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. This document references the following:

MIL-STD-130	ASTM-A1008/A1008M
MS35645	ASTM-A1011/A1011M
MS51300	ASTM-B32
MS53075	ASTM-B633
QQ-S-698	AWS-D1.1/D1.1M
ASTM-A109/A109M	AWS-D8.7M
ASTM-A153/A153M	AWS-D8.9M
ASTM-A507	J-STD-004
ASTM-A513	J-STD-005
ASTM-A619/A619M	J-STD-006
	SAE-AMS6457

## CONCLUDING MATERIAL

Custodians:  
 Army – AT  
 Navy – SH  
 Air Force – 99  
 DLA – CC

Preparing activity:  
 DLA – CC  
 (Project 2910-2010-004)

Review activities:  
 Army – AR, CR4  
 Navy – MC, SA, YD  
 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.daps.dla.mil>.