INCH-POUND

MS27225C
14 May 2007
SUPERSEDING
MS27225B
7 September 1999

DETAIL SPECIFICATION SHEET

NIPPLE ASSEMBLY 45°, ADAPTER, HOSE TO TUBE, 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-5070.

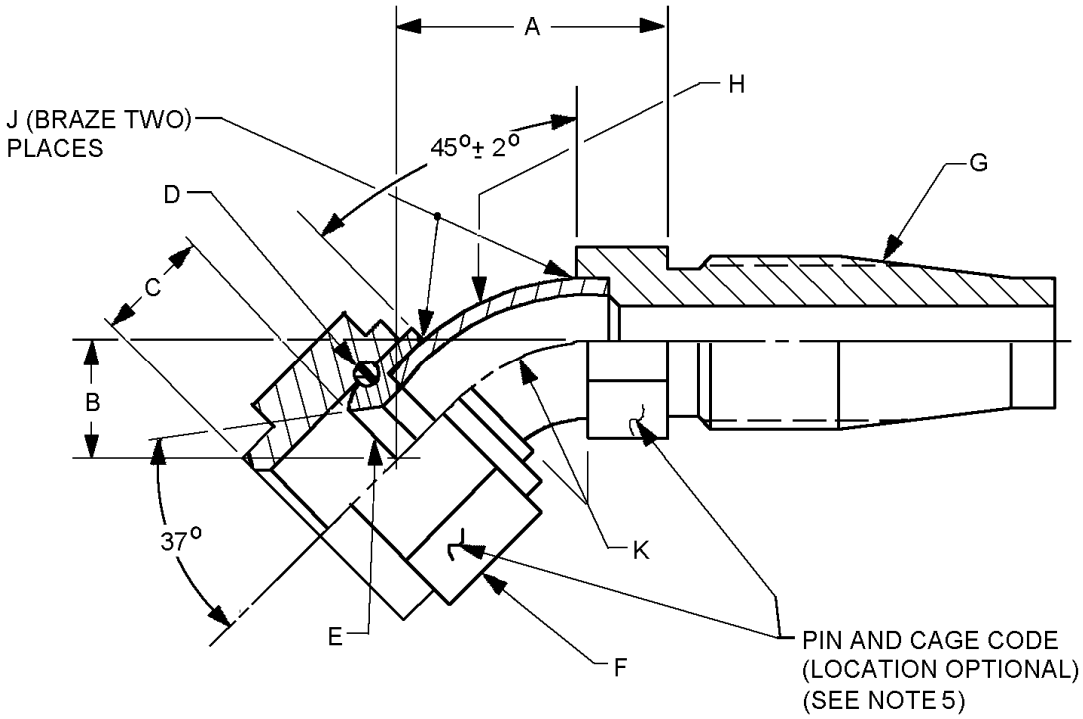

FIGURE 1. 45° Nipple assembly dimensions and configuration.

Dash number	A ±.035 (0.89) inches (mm)	B ±.035 (0.89) inches (mm)	C inches (mm)	D Wire PIN	E Shoulder PIN	F Nut PIN (see note 4)	G Nipple PIN	H Elbow PIN	K Rad (ref) inches (mm)
				MS27238	MS27236	SAE-AS4370	MS27239	MS27235	
-4	.758 (19.25)	.352 (8.94)	.37 (9.40)	-4	-4	-4	-4	-4	.38 (9.65)
-5	.909 (23.09)	.415 (10.54)	.38 (9.65)	-5	-5	-5	-5	-5	.44 (11.18)
-6	.965 (24.51)	.444 (11.28)	.38 (9.65)	-6	-6	-6	-6	-6	.50 (12.70)
-8	1.039 (26.39)	.456 (11.58)	.44 (11.18)	-8	-8	-8	-8	-8	
-10	1.171 (29.74)	.536 (13.61)	.50 (12.70)	-10	-10	-10	-10	-10	.62 (15.75)
-12	1.348 (34.24)	.625 (15.88)	.57 (14.48)	-12	-12	-12	-12	-12	.84 (21.34)
-16	1.436 (36.47)	.660 (16.76)	.63 (16.00)	-16	-16	-16	-16	-16	.97 (24.64)
-20	1.760 (44.70)	.768 (19.51)	.64 (16.26)	-20	-20	-20	-20	-20	1.19 (30.23)
-24	1.999 (50.77)	.867 (22.02)	.77 (19.56)	-24	-24	-24	-24	-24	1.38 (35.05)
-32	2.415 (61.34)	1.066 (27.08)	.92 (23.37)	-32	-32	-32	-32	-32	1.75 (44.45)

NOTES:
1. Dimensions are in inches.
2. Metric equivalents are given for information only.
3. Unless otherwise specified, tolerances are as follows: angles ±1°; decimals ±.005 inches (0.01 mm).
4. Nut shall swivel freely after assembly.
5. Part or Identifying Number (PIN).

FIGURE 1. 45° Nipple assembly dimensions and configuration - Continued.

REQUIREMENTS:

Dimensions and configurations: The design, construction, and physical dimensions shall be in accordance with MIL-DTL-5070 and figure 1 in case of conflict between this drawing and MIL-DTL-5070, this drawing shall govern.

Intended use: This part is a component of MS27226.

Materials: Materials shall be in accordance with MIL-DTL-5070.

Finish: Finish shall be in accordance with MIL-DTL-5070. Platings are applied after heat treats and before assembling nut.

Color identification: Color identification shall be in accordance with MIL-DTL-5070.

Braze.

Steel: Braze at points J in accordance with AWS C3.4, AWS C3.5, AWS C3.6, or AWS C3.7.

Aluminum: Braze at points J in accordance with SAE-AMS2672.

Titanium: Braze at points J.

Heat treatment:

Steel: Heat treat in accordance with SAE-AMS-H-6875 after braze so that Rockwell hardness of nipple is C-25.

Aluminum: Heat treat in accordance with SAE-AMS2770, condition T6, after braze.

Titanium: Heat treatment in accordance with SAE-AMS2801, temper STA900, after braze.

PIN example:

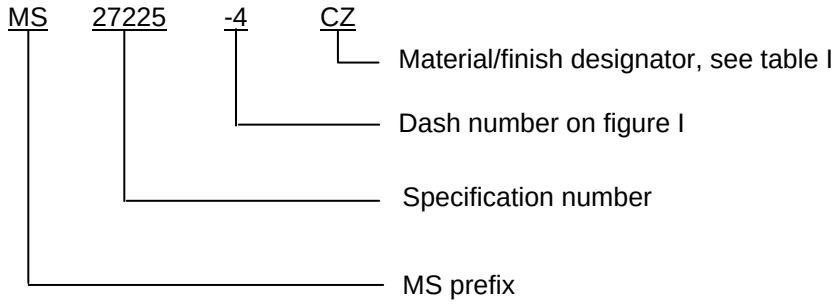

TABLE I. Code for material and finish.

Code	Dash size	Material/finish
CC	-4 through -6	Carbon Steel - cadmium plating
CZ	-4 through -6	Carbon steel - zinc plating
SS	-4 through -6	Corrosion resistant steel - N/A
AA	-8 through -32	Aluminum - anodic coating
TA	-4 through -32	Titanium - anodized or fluoride phosphated.

To the users of this document, it is recommended that the use of carbon steel material with cadmium plating be used only when the other materials and finishes specified in this document cannot meet performance requirements.

Identification of product. The PIN and the manufacturer's Commercial and Government Entity (CAGE) Code or trademark shall be permanently marked on the assembly, see figure 1, or marked on a removable tag securely attached to the assembly.

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-5070, this document references the following:

MS27226	AWS C3.6
MS27235	AWS C3.7
MS27236	SAE-AMS-H-6875
MS27238	SAE-AMS2801
MS27239	SAE-AMS2672
AWS C3.4	SAE-AMS2770
AWS C3.5	SAE-AS4370

CONCLUDING MATERIAL

Custodians:
Army - AT
Navy - AS
Air Force - 99
DLA - CC

Preparing activity:
DLA - CC

(Project 4730-2005-044)

Review activities:
Army - AV
Navy - MC, SA
Air Force - 11, 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 http://assist.daps.dla.mil.