

DETAIL SPECIFICATION SHEET

FITTINGS, PIPE, ALUMINUM-ALLOY THREADED, 150-POUND,
 OUTSIDE HEAD, INSIDE HEAD, AND FACE BUSHINGS

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-52618.

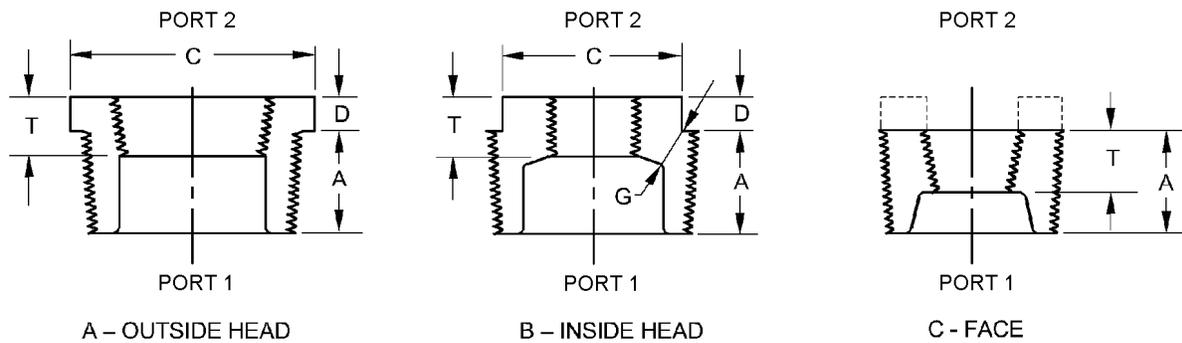


FIGURE 1. Bushings (not to scale).

REQUIREMENTS:

The fittings shall be as specified on figure 1.

The design, dimensions, and tolerances of bushings shall be in accordance with ASME B16.14.

Intended use is with water, oil, or air 150 psi (1.03 MPa) max at 72°F (22°C).

Aluminum shall be in accordance with MIL-DTL-52618.

Configuration designators shall be in accordance with table I.

TABLE I. Configuration code letter for fittings.

| Configuration code | Description of bushing |
|--------------------|------------------------|
| T | Outside head bushing |
| U | Inside head bushing |
| V | Face bushing |

Size code letter shall be in accordance with table II.

MIL-DTL-52618/8E

TABLE II. Size code numbers for bushings.

| Size code numbers | Nominal pipe size (inch x inch) | | Size code numbers | Nominal pipe size (inch x inch) | |
|-------------------|------------------------------------|-----------|-------------------|------------------------------------|-----------|
| | Port 1 | Port 2 | | Port 1 | Port 2 |
| 801 | 1/4 | x 1/8 | 838 | 2-1/2 | x 3/4 |
| 802 | 3/8 | x 1/4 | 839 | 2-1/2 | x 1/2 |
| 803 | 3/8 | x 1/8 | 840 | 3 | x 2-1/2 |
| 804 | 1/2 | x 3/8 | 841 | 3 | x 2 |
| 805 | 1/2 | x 1/4 | 842 | 3 | x 1-1/2 |
| 806 | 1/2 | x 1/8 | 843 | 3 | x 1-1/4 |
| 807 | 3/4 | x 1/2 | 844 | 3 | x 1 |
| 808 | 3/4 | x 3/8 | 845 | 3 | x 3/4 |
| 809 | 3/4 | x 1/4 | 846 | 3 | x 1/2 |
| 810 | 3/4 | x 1/8 | 847 | 3-1/2 | x 3 |
| 811 | 1 | x 3/4 | 848 | 3-1/2 | x 2-1/2 |
| 812 | 1 | x 1/2 | 849 | 3-1/2 | x 2 |
| 813 | 1 | x 3/8 | 850 | 3-1/2 | x 1-1/2 |
| 814 | 1 | x 1/4 | 851 | 3-1/2 | x 1-1/4 |
| 815 | 1 | x 1/8 | 852 | 3-1/2 | x 1 |
| 816 | 1-1/4 | x 1 | 853 | 4 | x 3-1/2 |
| 817 | 1-1/4 | x 3/4 | 854 | 4 | x 3 |
| 818 | 1-1/4 | x 1/2 | 855 | 4 | x 2-1/2 |
| 819 | 1-1/4 | x 3/8 | 856 | 4 | x 2 |
| 820 | 1-1/4 | x 1/4 | 857 | 4 | x 1-1/2 |
| 821 | 1-1/2 | x 1-1/4 | 858 | 4 | x 1-1/4 |
| 822 | 1-1/2 | x 1 | 859 | 4 | x 1 |
| 823 | 1-1/2 | x 3/4 | 860 | 5 | x 4 |
| 824 | 1-1/2 | x 1/2 | 861 | 5 | x 3-1/2 |
| 825 | 1-1/2 | x 3/8 | 862 | 5 | x 3 |
| 826 | 1-1/2 | x 1/4 | 863 | 5 | x 2-1/2 |
| 827 | 2 | x 1-1/2 | 864 | 5 | x 2 |
| 828 | 2 | x 1-1/4 | 865 | 6 | x 5 |
| 829 | 2 | x 1 | 866 | 6 | x 4 |
| 830 | 2 | x 3/4 | 867 | 6 | x 3-1/2 |
| 831 | 2 | x 1/2 | 868 | 6 | x 3 |
| 832 | 2 | x 3/8 | 869 | 6 | x 2-1/2 |
| 833 | 2 | x 1/4 | 870 | 6 | x 2 |
| 834 | 2-1/2 | x 2 | 871 | 8 | x 6 |
| 835 | 2-1/2 | x 1-1/2 | 872 | 8 | x 5 |
| 836 | 2-1/2 | x 1-1/4 | 873 | 8 | x 4 |
| 837 | 2-1/2 | x 1 | 874 | 8 | x 3-1/2 |
| | | | 875 | 8 | x 3 |

MIL-DTL-52618/8E

Thread direction code letter shall be in accordance with table III.

TABLE III. Thread direction code letter.

| Thread direction code letter | Thread direction |
|------------------------------|----------------------|
| X | Right-hand |
| Y | Left-hand |
| Z | Right- and left-hand |

Head code number letter shall be in accordance with table IV.

TABLE IV. Head code number.

| Code number | Head |
|-------------|-----------|
| 6 | Hexagonal |
| 8 | Octagonal |

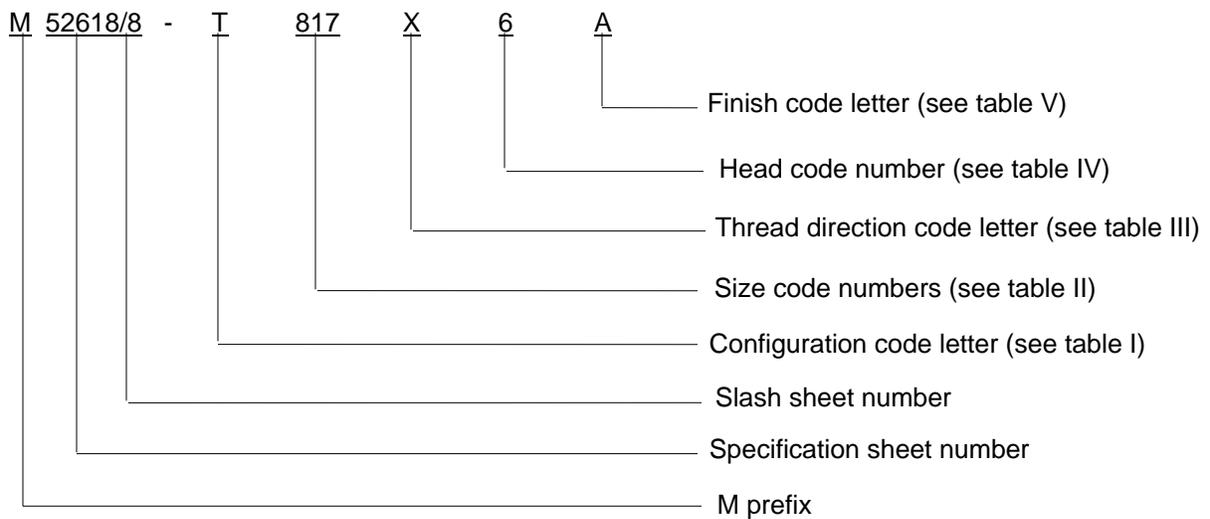
Finish shall be in accordance with MIL-DTL-52618.

Finish code letter shall be in accordance with table V.

TABLE V. Finish code letter.

| Finish code letter | Finish |
|--------------------|-------------|
| A | As cast |
| B | As extruded |
| C | Anodized |

Part or Identifying Number (PIN). The PIN consists of the letter M, specification sheet number, a dash, configuration code letter, size code numbers, thread direction code letter, head code number, and finish code letter. PIN's are assigned as follows:



MIL-DTL-52618/8E

PIN example: M52618/8-T817X6A indicates an outside head bushing 1-1/4 x 3/4 inch pipe, right hand threads, and finish is "as cast".

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-52618, this document references ASME B16.4.

CONCLUDING MATERIAL

Custodians:

Army - AT
Navy - AS
DLA - CC

Preparing activity:

DLA - CC

Review activities:

Army - CE
Navy - MC, SA

(Project 4730-2012-017)

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>.