

RATIONALE

THIS PART STANDARD REPLACES MS28772 AND ADDS VISUAL QUALITY ASSURANCE, PACKAGING AND LABELING REQUIREMENTS FOR PROCUREMENT OF D - RINGS MOLDED FROM MIL-P-25732 NBR RUBBER. THE MS28772 PART NUMBERS HAVE BEEN RETAINED.

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SAE AS28772

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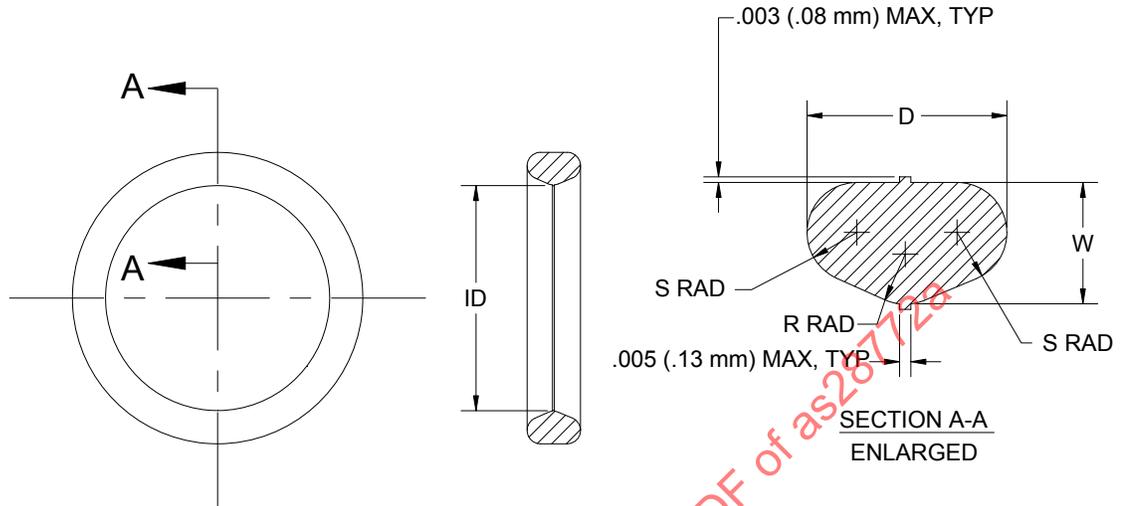
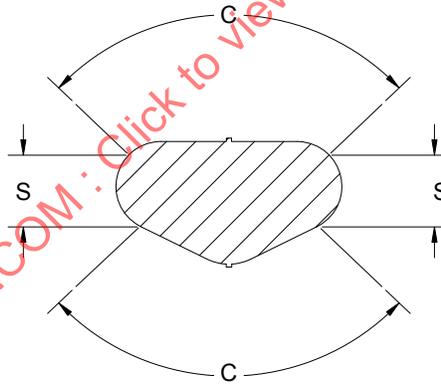


FIGURE 1 - D-RING

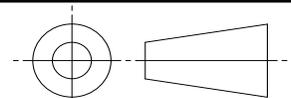


C - CRITICAL SURFACES
S - SECONDARY SURFACES

FIGURE 2 - SURFACES

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THIRD ANGLE PROJECTION



CUSTODIAN: SAE A-6/A-6C2

PROCUREMENT SPECIFICATION: NONE

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

(R) PACKING, PREFORMED ("D" RING, SHOCK STRUT)

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TABLE 1 - PART NUMBERS AND DIMENSIONS

PART NUMBER	ID		D		R RAD		S RAD		W		APPROX MASS			
	IN.	(mm)	IN.	(mm)	IN.	(mm)	IN.	(mm)	IN.	(mm)	LB/100	kg/100		
MS28772-335	2.725	69.215	±.005	±.127	±.010	±.254	±.010	±.254	±.005	±.127	1.670	.757		
MS28772-336	2.850	72.390									1.741	.790		
MS28772-337	2.975	75.565									1.812	.822		
MS28772-338	3.100	78.740									1.883	.855		
MS28772-339	3.225	81.915									1.954	.887		
MS28772-340	3.350	85.090									2.025	.918		
MS28772-341	3.475	88.265									2.097	.951		
MS28772-342	3.600	91.440	±.015	±.381	.375	9.525	.093	2.362	.078	1.981	.210	5.334	2.167	.983
MS28772-343	3.725	94.615											2.239	1.016
MS28772-344	3.850	97.790											2.310	1.048
MS28772-345	3.975	100.965											2.381	1.080
MS28772-346	4.100	104.140											2.452	1.112
MS28772-347	4.225	107.315											2.523	1.145
MS28772-348	4.350	110.490											2.594	1.176
MS28772-349	4.475	113.665											2.665	1.209

PART NUMBER	ID		D		R RAD		S RAD		W		APPROX MASS			
	IN.	(mm)	IN.	(mm)	IN.	(mm)	IN.	(mm)	IN.	(mm)	LB/100	kg/100		
MS28772-425	4.475	113.665	±.005	±.127	±.010	±.254	±.010	±.254	±.006	±.152	4.634	2.102		
MS28772-426	4.600	116.840									4.757	2.157		
MS28772-427	4.725	120.015	±.015	±.381	.531	13.487	.125	3.175	.105	2.667	.275	6.985	4.878	2.213
MS28772-428	4.850	123.190											5.000	2.268
MS28772-429	4.975	126.365											5.122	2.323
MS28772-430	5.100	129.540											5.244	2.379
MS28772-431	5.225	132.715											5.366	2.433
MS28772-432	5.350	135.890											5.488	2.489
MS28772-433	5.475	139.065											5.609	2.545
MS28772-434	5.600	142.240											5.731	2.599
MS28772-435	5.725	145.415											5.853	2.655
MS28772-436	5.850	148.590	±.023	±.584	.531	13.487	.125	3.175	.105	2.667	.275	6.985	5.975	2.722
MS28772-437	5.975	151.765											6.097	2.765
MS28772-438	6.225	158.115											6.341	2.877
MS28772-439	6.475	164.465											6.585	2.987
MS28772-440	6.725	170.815											6.829	3.097
MS28772-441	6.975	177.165											7.073	3.209
MS28772-442	7.225	183.515											7.317	3.319
MS28772-443	7.475	189.865											7.561	3.429
MS28772-444	7.725	196.215											7.805	3.540
MS28772-445	7.975	201.295											8.048	3.651
MS28772-446	8.475	215.265											8.536	3.872
MS28772-447	8.975	227.965											9.025	4.094
MS28772-448	9.475	240.665											9.512	4.315
MS28772-449	9.975	253.365											10.000	4.536
MS28772-450	10.475	266.065											10.487	4.757
MS28772-451	10.975	278.765	±.030	±.762	.531	13.487	.125	3.175	.105	2.667	.275	6.985	10.975	4.978
MS28772-452	11.475	291.465											11.464	5.200
MS28772-453	11.975	304.165											11.951	5.422
MS28772-454	12.475	316.865											12.439	5.642
MS28772-455	12.975	329.565											12.927	5.864
MS28772-456	13.475	342.265											13.414	6.084
MS28772-457	13.975	354.965											13.902	6.306
MS28772-458	14.475	367.665											14.389	6.526
MS28772-459	14.975	380.365											14.878	6.743
MS28772-460	15.475	393.065											15.366	6.970

APPLICATION

THESE D-RINGS TYPICALLY ARE USED AS ROD SEALS IN SHOCK STRUTS. THEY SHOULD NOT BE USED IN CONJUNCTION WITH ANY HYDRAULIC FLUID OTHER THAN THAT CONFORMING TO MIL-PRF-5606. THESE D-RINGS HAVE A SERVICE TEMPERATURE RANGE OF -65 TO +160 °F (-54 TO +71 °C).

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	(R) PACKING, PREFORMED ("D" RING, SHOCK STRUT)		

APPLICABLE REFERENCES:

SAE PUBLICATIONS:

AVAILABLE FROM SAE INTERNATIONAL, 400 COMMONWEALTH DRIVE, WARRENDALE, PA 15096-0001, TEL: 877-606-7323 (INSIDE USA AND CANADA) OR 724-776-4970 (OUTSIDE USA), www.sae.org.

AMS2817 PACKAGING AND IDENTIFICATION, PREFORMED PACKINGS

ARP5316 STORAGE OF ELASTOMERS AND SEAL ASSEMBLIES WHICH INCLUDE AN ELASTOMER ELEMENT PRIOR TO HARDWARE ASSEMBLY

U.S. GOVERNMENT PUBLICATIONS

AVAILABLE FROM DODSSP, SUBSCRIPTION SERVICES DESK, BUILDING 4D, 700 ROBBINS AVENUE, PHILADELPHIA, PA 19111-5094 OR <http://assist.daps.dla.mil/quicksearch> OR www.daps.mil.

MIL-P-25732 PACKING, PREFORMED, PETROLEUM FLUID RESISTANT, LIMITED SERVICE AT 275 DEG. F (135 DEG. C)

MIL-PRF-5606 HYDRAULIC FLUID, PETROLEUM BASE; AIRCRAFT, MISSILE, AND ORDNANCE.

MIL-STD-413 VISUAL INSPECTION GUIDE FOR RUBBER O-RINGS.

ASQ PUBLICATIONS

AVAILABLE FROM AMERICAN SOCIETY FOR QUALITY, 600 NORTH PLANKINTON AVENUE, MILWAUKEE, WI 53203 OR www.asq.org.

ANSI/ASQ Z1.4 SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES

REQUIREMENTS

1. MATERIAL: THE MATERIAL SHALL BE IN ACCORDANCE WITH MIL-P-25732.
2. DIMENSIONAL AND VISUAL INSPECTION: PRIOR TO INSPECTION, MOLD FLASH SHALL BE REMOVED FROM THE D-RING IN SUCH A MANNER THAT THE D-RINGS CONFORM TO THE REQUIREMENTS SPECIFIED HEREIN. EXAMINATION FOR DEFECTS IN APPEARANCE AND WORKMANSHIP SHALL BE IN ACCORDANCE WITH MIL-STD-413. THE SAMPLE SIZE SHALL BE IN ACCORDANCE WITH INSPECTION LEVEL II OF ANSI/ASQ Z1.4 WITH AQL OF 1.0 EXCEPT THAT THE ACCEPTANCE NUMBER SHALL BE ZERO. EXAMINATION FOR DIMENSIONAL DEFECTS SHALL BE MADE TO THE TOLERANCES SPECIFIED ABOVE. THE SAMPLE SIZE SHALL BE IN ACCORDANCE WITH INSPECTION LEVEL II OF ANSI/ASQ Z1.4 WITH AQL OF 1.0 EXCEPT THAT THE ACCEPTANCE NUMBER SHALL BE ZERO. IF THE PURCHASER REQUIRES A DIFFERENT SAMPLING PLAN OR VISUAL INSPECTION CRITERIA, PURCHASER AND MANUFACTURER SHALL AGREE PRIOR TO TIME OF ORDER.
3. LOT ACCEPTANCE: THE REQUIREMENTS ARE LISTED IN MIL-P-25732. THE LOT CERTIFICATION REPORT SHALL BE FURNISHED TO THE PURCHASER WHEN THE PRODUCT IS SHIPPED. THE MANUFACTURER OF THE D-RINGS SHALL BE RESPONSIBLE FOR THE REQUIRED INSPECTIONS AND LOT ACCEPTANCE TESTS. PURCHASER RESERVES THE RIGHT TO SAMPLE AND PERFORM ANY CONFIRMATORY INSPECTION DEEMED NECESSARY TO ENSURE THAT THE D-RINGS CONFORM TO THE SPECIFIED REQUIREMENTS.

PART NUMBER: THE D-RING PART NUMBERS ARE DESIGNATED AS MS28772-XXX, WHERE XXX INDICATES THE DASH SIZE.

4. IDENTIFICATION AND PACKAGING: PACKAGING SHALL BE IN ACCORDANCE WITH AMS2817 WITH THE EXCEPTION THAT, IF REQUESTED BY CONTRACT, EACH PACKAGE SHALL BEAR THE FOLLOWING IDENTIFICATION OF A RECOGNIZABLE SIZE:

- NATIONAL STOCK NUMBER

IF REQUIRED BY THE PURCHASER, THE MANUFACTURER SHALL INDIVIDUALLY PACKAGE ALL THE D-RINGS.

5. SHELF LIFE REQUIREMENTS OF ARP5316 APPLY TO THESE D-RINGS.

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