

MIL-F-24227(SH)
 AMENDMENT 2
~~20 May 1988~~
 SUPERSEDING
 AMENDMENT 1
 12 June 1967

MILITARY SPECIFICATION

FITTINGS AND FLANGES, CAST BRONZE, SILVER-BRAZING
 SUITABLE FOR ULTRASONIC INSPECTION

This amendment forms a part of Military Specification MIL-F-24227(SHIPS), dated 18 May 1966, and is approved for use within the Naval Sea Systems Command, Department of the Navy and is available for use by all Departments and Agencies of the Department of Defense.

PAGE 1

1.2: Delete

"FITTINGS

	<u>Figure</u>	<u>Table</u>
Caps:	17	XX
Reducer (reducing one size)	7	X
Reducer (reducing two sizes)	8	X
Straight coupling	6	X"

and substitute:

"FITTINGS

	<u>Figure</u>	<u>Table</u>
Caps:	17	XX
Couplings and reducers:		
Reducer (reducing one size)	7	X
Reducer (reducing two sizes)	8	X
Straight coupling	6	X"

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2.2, under American Society for Testing and Materials, B61: Delete "Stem" and substitute "Steam".

3.1.1, first sentence: Delete and substitute: "Castings produced by continuous melt process and not identified with a heat no. or code may be accepted provided the controls are approved by the procuring activity and cognizant inspector."

AMSC N/A

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Table V: Delete "Tolerances on angles to be $\pm 0^\circ - 3$ inches" and substitute "Tolerances on angles to be $\pm 0^\circ - 30$ minutes".

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3.3.18, line 2: Delete "cuts of".

3.3.19, second sentence: Delete and substitute: "Drilled flanges shall be spot-faced on the back parallel to the face of the flange for the bolt-heads and nuts."

Table VI, column 1: Delete "1-5/16" and substitute "15/16".

3.4.1, line 1: Delete "fitting" and substitute "fitting, union".

3.4.1, item (c)(1): Delete "200S" and "150S".

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* Table VIII: Change as follows:

- (a) Column 1, Outside diameter of tube: Delete "0.504" and substitute "0.540".
- (b) Column M, opposite 3 inch iron pipe size: Delete "3.206" and substitute "3.286".

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Table XVIII, column Y: Delete and substitute:

Y Inches
0.831
.904
1.049
1.219
1.369
1.604

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Table XVIII, column f: Delete and substitute:

f	
Pitch diameter	
Maximum	Minimum
Inches	Inches
1.4492	1.4420
1.7801	1.7720
2.1102	2.1020
2.5407	2.5320
2.8609	2.8520
3.4610	3.4520

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Table XX, change as follows:

- (a) Column F, minimum, opposite 6 inch iron pipe size: Delete "6.670" and substitute "6.630".
- (b) Column F, maximum, opposite 6 inch iron pipe size: Delete "6.720" and substitute "6.730".
- (c) Column G₂: Delete "Maximum" and substitute "Minimum".
- (d) Column H₁: Delete "H₁" and substitute "H".
- (e) Last column, opposite 1-1/2 inch iron pipe size: Delete "2.28" and substitute "2.38".
- (f) Last column, opposite 6 inch iron pipe size: Delete "7.42" and substitute "7.56".

The margins of this amendment are marked with an asterisk to indicate where changes from the previous amendment 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 amendment.

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