

MIL-I-24063B(SH)
 15 December 1982
 SUPERSEDING
 MIL-I-24063A(SHIPS)
 29 December 1975
 (See 6.8)

MILITARY SPECIFICATION

INSERT SETS, SOUND ISOLATION FOR RISIC-1

FLEXIBLE CONNECTORS

This specification is approved for use by the Naval Sea Systems Command, Department of the Navy, and is available for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers elastomeric inserts used with rubber insert sound isolation coupling (RISIC-1) flexible connectors.

1.2 Classification. The elastomeric insert sets shall be of the styles, durometer ratings, and sizes specified in 1.2.2, and shall be designated by the applicable definitive Military Specification part number.

1.2.1 Insert set designation. Insert sets shall be designated in the following form (see 6.2.1 and 6.5):

	M24063 - XX
Military Specification code number _____	
Style, durometer rating, and size code	
number (see 1.2.2) _____	

1.2.2 Style, durometer rating, and size. The style, durometer rating, and size of the insert set are identified by two digits (see table I).

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commander, Naval Sea Systems Command, SEA 5523, Department of the Navy, Washington, DC 20362 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

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TABLE I. Code number to style, durometer rating, and size.

Nominal pipe size	Style A (see figure 1)		Style B (see figure 2)		Style D (see figure 3)	
	40 duro- meter	80 duro- meter	40 duro- meter	80 duro- meter	40 duro- meter	80 duro- meter
1/2	01	17	33	49		
3/4	02	18	34	50		
1	03	19	35	51		
1-1/4	04	20	36	52		
1-1/2	05	21	37	53		
2	06	22	38	54	70	86
2-1/2	07	23	39	55		
3	08	24	40	56	72	88
3-1/2	09	25	41	57		
4	10	26	42	58		
5	11	27	43	59		
6	12	28	44	60		
8	13	29				
(14 o.d.) 8						
(12-7/16 o.d.)	14	30				

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications and standards. Unless otherwise specified, the following specifications and standards of the issue listed in that issue of the Department of Defense Index of Specifications and Standards (DoDISS) specified in the solicitation, form a part of this specification to the extent specified herein.

SPECIFICATIONS

FEDERAL

QQ-B-639 - Brass, Naval, Flat Products (Plate, Bar, Sheet, and Strip).

QQ-S-781 - Strapping, Steel, and Seals.

PPP-B-601 - Boxes, Wood, Cleated, Plywood.

PPP-B-621 - Boxes, Wood, Nailed and Locked Corner.

PPP-B-636 - Boxes, Shipping, Fiberboard.

MILITARY

MIL-P-116 - Preservation-Packaging, Methods of.

STANDARDS

MILITARY

MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes.

MIL-STD-129 - Marking for Shipment and Storage.

MIL-STD-177 - Rubber Products, Terms for Visible Defects of.

MIL-STD-407 - Visual Inspection Guide for Rubber Molded Items.

(Copies of specifications and standards required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting officer.)

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. The issues of the documents which are indicated as DoD adopted shall be the issue listed in the current DoDISS and the supplement thereto, if applicable.

NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC. AGENT
National Motor Freight Classification.

(Application for copies should be addressed to the National Motor Freight Traffic Association, Inc., ATA TRAFFIC Dept., 1616 "P" Street, N.W., Washington, DC 20036.)

UNIFORM CLASSIFICATION COMMITTEE AGENT
Uniform Freight Classification Ratings, Rules and Regulations.

(Application for copies should be addressed to the Uniform Classification Committee Agent, Tariff Publication Officer, Room 1106, 222 South Riverside Plaza, Chicago, IL 60606.)

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

E 171 - Copper-Alloy Condenser Tube Plates, Spec. for.

D 395 - Rubber Property - Compression Set, Test for. (DOD adopted).

D 412 - Rubber Properties in Tension, Test for. (DOD adopted).

D 624 - Rubber Property - Tear Resistance, Test for. (DOD adopted).

D 2240 - Rubber Property - Durometer Hardness, Test for. (DOD adopted).

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.)

E.I. DUPONT DE NEMOURS

Bulletin E-05440 for 958-200 Series TFE-S Non-stick Finishes.

(Application for copies should be addressed to the E.I. DuPont De Nemours and Company, DuPont Building, Wilmington, DE 19898.)

(Industry association specifications and standards are generally available for reference from libraries. They are also distributed among technical groups and using Federal agencies.)

2.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein, the text of this specification shall take precedence.

3. REQUIREMENTS

3.1 Materials.

3.1.1 Elastomeric molding stock material. The elastomeric molding stock shall be a nitrite compound that can be compounded and cured to meet the physical properties of table II when tested as specified in 4.4. A suggested formulation for a compound of 80 durometer is given in 6.6.

TABLE II. Physical properties.

Physical property	40 durometer stock	80 durometer stock	Applicable test paragraph
Tensile strength (min)	1500 lb/in ²	2600 lb/in ²	4.4.1.1
Modulus of elasticity at 300 percent elongation (min)	320 lb/in ²	1400 lb/in ²	4.4.1.2
Tear (minimum)	110 lb/in ²	225 lb/in ²	4.4.1.3
Elongation (percent min)	600 percent	425 percent	4.4.1.4
Durometer shore A	40 ± 3	83 ± 3	4.4.1.5
Compression set (max)	43 percent	25 percent	4.4.1.6

3.1.2 Washer material. The free washer (part III of figures 1, 2, and 3) and the washer that is bonded to the thrust insert (part II of figures 1, 2, and 3) shall be fabricated of alloy no. 464 as specified in QQ-B-639 or UNS no. C46400 naval brass as specified in ASTM B 171.

3.1.3 Recovered material. Unless otherwise specified herein, all equipment, material, and articles incorporated in the products covered by this specification shall be new and shall be fabricated using materials produced from recovered materials to the maximum extent practicable without jeopardizing the intended use. The term "recovered materials" means materials which have been collected or recovered from solid waste and reprocessed to become a source of raw materials, as opposed to virgin raw materials. None of the above shall be interpreted to mean that the use of used or rebuilt products is allowed under this specification unless otherwise specifically specified.

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3.2 Design. An insert set consists of positioning insert (part I), a thrust insert which has a washer bonded to the insert (part II), and a thrust washer (part III); except for the style A, 8 inch nominal size (14 inch outside diameter) insert set (see figure 1) which has two thrust inserts (part II) and one thrust washer (part III).

3.2.1 Molding. The elastomeric inserts shall be molded and vulcanized into the shapes (part I and II) shown on figures 1, 2, and 3. Moldings shall be by either preform (see 3.2.1.1) or injection. Laminated moldings shall be prohibited.

3.2.1.1 Preformed molding. If preformed molding is used, the molding stock shall be extruded preform, tubed to a continuous circle with controlled inside diameter (i.d.) and o.d. and cut to a specific weight to fill the mold cavity. Preform may also be cut from rubber slab or milled stock.

3.2.2 Dimensions. The insert sets shall have the parts and dimensions shown on figure 1 (style A), figure 2 (style B), or figure 3 (style D). The dimensional tolerances shall be as specified in table III.

TABLE III. Dimensional tolerances.

Dimension (inches)	Fixed (inches)		Closure (inches \pm)
	Plus (+)	Minus (-)	
0 - 0.499	0.005	0.005	0.008
0.500 - 0.999	0.005	0.008	0.010
1.000 - 1.999	0.010	0.010	0.015
2.000 - 2.999	0.010	0.015	0.020
3.000 - 3.999	0.015	0.018	-----
4.000 - 4.999	0.015	0.021	-----
5.000 - 7.999	0.020	0.025	-----
8.000 and up	Multiply dimension by 0.003		-----

1/ This table applies to each dimension given on figures 1, 2, and 3 and not the nominal size of the insert set, except for the "A" dimension for part II which has a tolerance of plus 0.000 - (table III value).

2/ A fixed dimension is parallel to the mold parting line or the parting lines of major mold sections.

3/ A closure dimension is vertical to the mold parting line or the parting lines of major mold sections.

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3.3 Part III (free washer) finish. Only the free washer (part III of figures 1, 2, and 3) shall be tetrafluoroethylene (TFE) coated in accordance with DuPont Bulletin E-05440 covering the TFE 958-200 series coating or equal. The preferred coating colors are blue, black, or oxford gray as specified in DuPont Bulletin E-05440.

3.4 Part II washer bond. The thrust insert (part II) shall have a washer bonded to it as shown on figures 1, 2, and 3. The bond strength of the washer to the thrust insert shall be at least equal to the tensile strength of the nitrite compound used in the thrust insert.

3.5 Marking. Each insert (parts I and II) shall have the specification part number, contractor's name or trade mark and the quarter of year and year the insert was molded embossed or indelible ink stamped with 3/32 inch (minimum) lettering 0.015 to 0.030 inch high on the surface area indicated on figures 1, 2, and 3.

3.6 Workmanship. Elastomeric inserts shall be free from foreign inclusions, blisters, and voids when examined in accordance with 4.3.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or purchase order, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.2 Sampling for quality conformance inspection.

4.2.1 Lot. For purposes of sampling, a lot shall consist of all elastomeric inserts from the same batch of rubber and of the same style.

4.2.2 Sampling for examination. A random sample of inserts of different sizes and parts shall be selected from each lot in accordance with MIL-STD-105, inspection level II, acceptable quality level (AQL) 2.5 percent, and shall be subjected to the examination specified in 4.3.

4.2.3 Sampling for tests for elastomer stock. Samples for tests of elastomer stock shall be standard ASTM specimens, and shall be subjected to the tests specified in 4.4.1.1 through 4.4.1.4. Specimens shall be prepared for each batch of elastomer.

4.2.4 Sampling for durometer shore A and compression set. A random sample of inserts of different sizes and parts shall be selected from each lot in accordance with MIL-STD-105, inspection level II, AQL 2.5 percent, and shall be subjected to the tests specified in 4.4.1.5 and 4.4.1.6.

4.3 Examination. Each of the sample inserts selected in accordance with 4.2.2 shall be dimensionally and visually examined as specified in 4.3.1 and 4.3.2. Any insert in the sample containing one or more visual or dimensional defects shall be rejected and if the number of defective inserts in any sample exceeds the acceptance number for that sample, the lot represented by the sample shall be rejected.

4.3.1 Dimensional examination. Inserts shall be examined to determine conformance to the dimensional and tolerance requirements as specified in figures 1, 2, 3, and table III.

4.3.2 Visual examination. MIL-STD-407 shall be used to determine and evaluate defects through visual examination (a superficial line that has no apparent depth and does not open upon flexing or twisting is acceptable for delivery). Each sample (part I) insert shall be hand flexed and twisted and the surface of the sample insert shall show no evidence of the following defects; inserts with bonded washer, (part II), shall be inspected for evidence of the following defects (see MIL-STD-177 for definition of terms):

- (a) Flash lines.
- (b) Knit lines and knit marks.
- (c) Surface voids.
- (d) Surface punctures.
- (e) Backrind.
- (f) Inclusions.
- (g) Washer bonded to insert, part II only.

4.4 Tests.

4.4.1 Tests for elastomer stock. Elastomer stock used in the molding of the elastomeric inserts shall be tested as specified in 4.4.1.1 through 4.4.1.4 to determine conformance with 3.1.1.

4.4.1.1 Tensile properties. Test specimens, prepared in accordance with 4.2.3, shall be subjected to a tensile test in accordance with ASTM D 412.

4.4.1.2 Modulus of elasticity. Test specimens, prepared in accordance with 4.2.3, shall be tested in accordance with ASTM D 412.

4.4.1.3 Tear. Test specimens shall be prepared in accordance with 4.2.3 and ASTM D 624 to conform to die type C and tested in accordance with ASTM D 624.

4.4.1.4 Elongation. Test specimens, prepared in accordance with 4.2.3, shall be tested in accordance with ASTM D 412.

4.4.1.5 Durometer shore A. Sample elastomeric inserts, selected in accordance with 4.2.4, shall be tested in accordance with ASTM D 2240 to determine compliance with 3.1.1.

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4.4.1.6 Compression set. Sample inserts selected in accordance with 4.2.4 shall be tested in accordance with method B of ASTM D 395 to determine compliance with 3.1.1. Samples shall be conditioned at 158°F for 22 hours.

4.5 Failure to meet the tests specified in 4.4.1.1 through 4.4.1.6 shall be cause for rejection of all elastomeric inserts molded from the lot which the specimens or samples represent.

4.6 Packaging inspection. Sample packages and packs and the inspection of the packaging, packing and marking for shipment and storage shall be in accordance with the requirements of section 5 and the documents specified therein.

5. PACKAGING

(The preparation for delivery requirements specified herein apply only for direct Government acquisitions. For the extent of applicability of the preparation for delivery requirements of referenced documents listed in section 2, see 6.3.)

5.1 Talc/talcum. When used in the packaging process (that is, dusting of item(s)), talc shall be asbestos free. A certificate of compliance shall be required stating the dusting material is asbestos free (see 6.2.2).

5.2 Packaging. Packaging shall be level A or C, as specified (see 6.2.1).

5.2.1 Level A. Inserts shall be packaged utilizing method III of MIL-P-116 by placing the insert in an opaque envelope or bag, or in a snug-fitting paperboard folding or setup box. Envelopes and bags maybe of a plastic, plastic-paper, or barrier material suitable for the intended purpose that will assure no loss of package contents. Sealing and closure shall be effected by heat-sealing, adhesives or pressure-sensitive tape as applicable for the type package used. Staples shall not be used for package closure. Bags or envelopes shall not be used for packages when the net weight exceeds 5 pounds (1b).

5.2.2 Level C. Inserts shall be cleaned and packaged to afford protection against deterioration, and physical damage from the supply source to the first receiving activity for immediate use. The contractor's normal (retail or wholesale) cleaning and packaging methods may be utilized, when such meet the requirements of this level.

5.3 Packing. Packing shall be level A, B, or C, as specified (see 6.2.1).

5.3.1 Level A. Inserts, packaged as specified (see 6.2.1), shall be packed into a close-fitting, overseas type, style grade optional shipping container conforming to PPP-B-601 or PPP-B-621. Closure and strapping shall be in accordance with the box specification. Strapping shall conform to QQ-S-781, class 1, type I or IV, finish B.

5.3.2 Level B. Inserts, packaged as specified (see 6.2.1), shall be packed as specified for level A except that the boxes may be domestic type, or packed in a class weather resistant fiberboard box conforming to PPP-B-636. Closure and strapping shall be in accordance with the box specification.

5.3.3 Level C. Inserts, packaged as specified (see 6.2.1), shall be packed in a container in a manner to insure carrier acceptance and safe delivery at destination at the lowest applicable rate. Containers shall comply with Uniform Freight or National Motor Freight Classification Rules, or regulations or other carrier rules as applicable to the mode of transportation.

5.4 Marking. In addition to any special marking required herein or by the contract or order (see 6.2.1), interior packages and exterior shipping containers shall be marked in accordance with MIL-STD-129.

5.4.1 Special marking. Each package shall contain the marking specified in 3.5.

6. NOTES

6.1 Intended use. The elastomeric inserts specified in this specification are for use in the maintenance and repair of RISIC-1 (formerly E.B. type) flexible connectors.

6.2 Ordering data.

6.2.1 Acquisition requirements. Acquisition documents should specify the following:

- (a) Title, number, and date of this specification.
- (b) Military Specification part number required (see 1.2.1 and 6.5).
- (c) Levels of packaging and packing required (see 5.2 and 5.3).
- (d) Special marking required (see 5.4).

6.2.2 Data requirements. When this specification is used in an acquisition which incorporates a DD Form 1423, Contract Data Requirements List (CDRL), the data requirements identified below shall be developed as specified by an approved Data Item Description (DD Form 1664) and delivered in accordance with the approved CDRL incorporated into the contract. When the provisions of DAR 7-104.9(n)(2) are invoked and the DD Form 1423 is not used, the data specified below shall be delivered by the contractor in accordance with the contract or purchase order requirements. Deliverable data required by this specification is cited in the following paragraphs.

Paragraph No.	Data requirement title	Applicable DID No.	Option
5.1	Certificate of compliance	DI-E-2121	-----

(Data item descriptions related to this specification, and identified in section 6 will be approved and listed as such in DoD 5000.19L., Vol. II, AMSDL. Copies of data item descriptions required by the contractors in connection with specific acquisition functions should be obtained from the Naval Publications and Forms Center or as directed by the contracting officer.)

6.2.2.1 The data requirements of 6.2.2 and any task in sections 3, 4, or 5 of the specification required to be performed to meet a data requirement may be waived by the contracting/acquisition activity upon certification by the offeror that identical data were submitted by the offeror and accepted by the Government under a previous contract for identical item acquired to this specification. This does not apply to specific data which may be required for each contract, regardless of whether an identical item has been submitted previously (for example, test reports).

6.3 Sub-contracted material and parts. The preparation for delivery requirements of referenced documents listed in section 2 do not apply when material and parts are acquired by the contractor for incorporation into the equipment and lose their separate identity when the equipment is shipped.

6.4 Explanation of terms. The following explanation of terms apply to words and phrases as used in this specification:

- (a) RISIC - Rubber insert sound isolation coupling.
- (b) RISIC-1 - Formerly known as the "E.B." joint.
- (c) Part I - Positioning insert.
- (d) Part II - Thrust insert.
- (e) Part III - tetrafluoroethylene coated thrust washer.
- (f) Durometer - Hardness of the insert.
- (g) Bonded washer - The washer that is bonded to the base of the thrust insert.
- (h) Free washer - The washer installed between the bonded washer and the retaining nut of RISIC-1 flexible connectors.
- (i) Style - The particular design of the elastomeric insert.

6.5 Military specification part number. The military specification part number is a definitive part number which corresponds to the style of insert covered by this specification and defines the requirements of the options presented in this specification. The military specification code number (M24063 and MIL-I-24063) with a dash after it and the style, durometer rating and size code number are combined to form the definitive military specification part number (see 1.2.1).

6.6 Suggested formulation (80 durometer). Although inserts molded of the compound specified in table IV have been proven to meet all requirements of this specification through laboratory testing, the use of this formulation in no way relieves the manufacturer from meeting all physical and dimensional requirements of this specification.

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TABLE IV. Elastomeric formulation.

Ingredient ^{1/}	Parts per hundred polymer for 80 durometer ^{2/} inserts
Chemigum N-300	100.0
Zinc oxide	5.0
Stearic acid	1.5
Agrite resin	1.0
Hi-Sil 233	40.0
Ethylene-glycol	4.0
HAF black ASTM N 330	36.0
ESSN	1.0
Cumar 2-1/2 R-16	
Neville resin	10.0
Spider brand sulfur	0.3
ALTEX	2.0
TE-80	2.0
Cure 30 minutes at 320°F	

^{1/} Where trade or proprietary names appear, equivalent ingredients may be substituted.

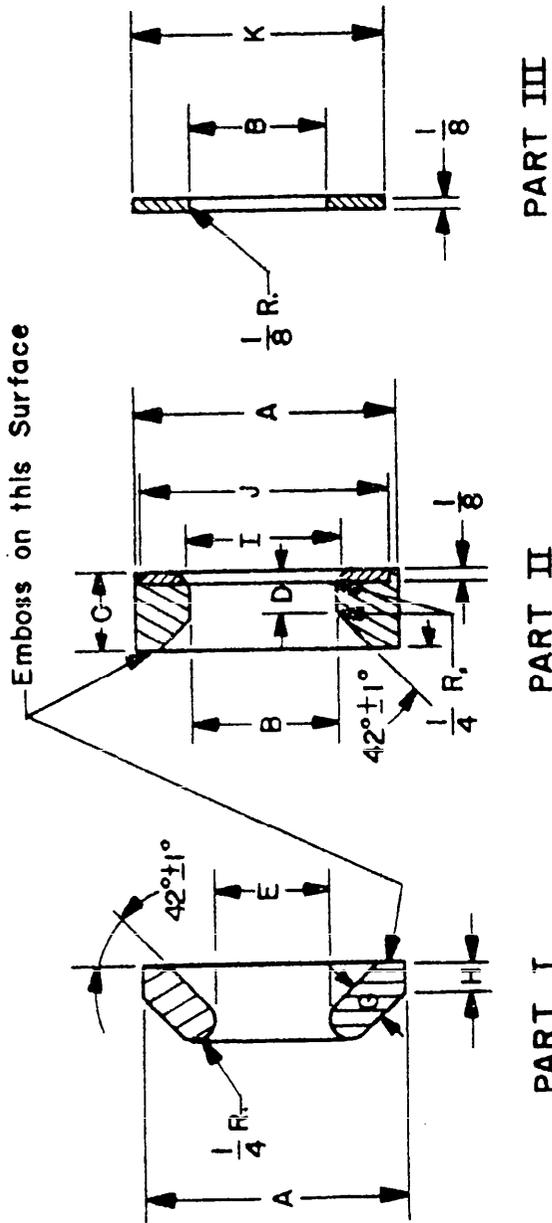
^{2/} Modification to this formulation is necessary in order to make the softer 40 durometer inserts.

6.7 Cross reference of classifications. The following is a comparison of the classification between MIL-I-24063A(SHIPS) and MIL-I-24063B(SH).

<u>MIL-I-24063A</u>	<u>MIL-I-24063B</u>
Style A	Style A
Style B	Style B
Style C	Deleted
Style D	Style D
Style E	Deleted
Style F	Deleted
Style G	Deleted

6.8 Changes from previous issue. Asterisks are not used in this revision to identify changes with respect to the previous issue, due to the extensiveness of the changes.

Preparing activity:
Navy - SH
(Project 4730-N208)



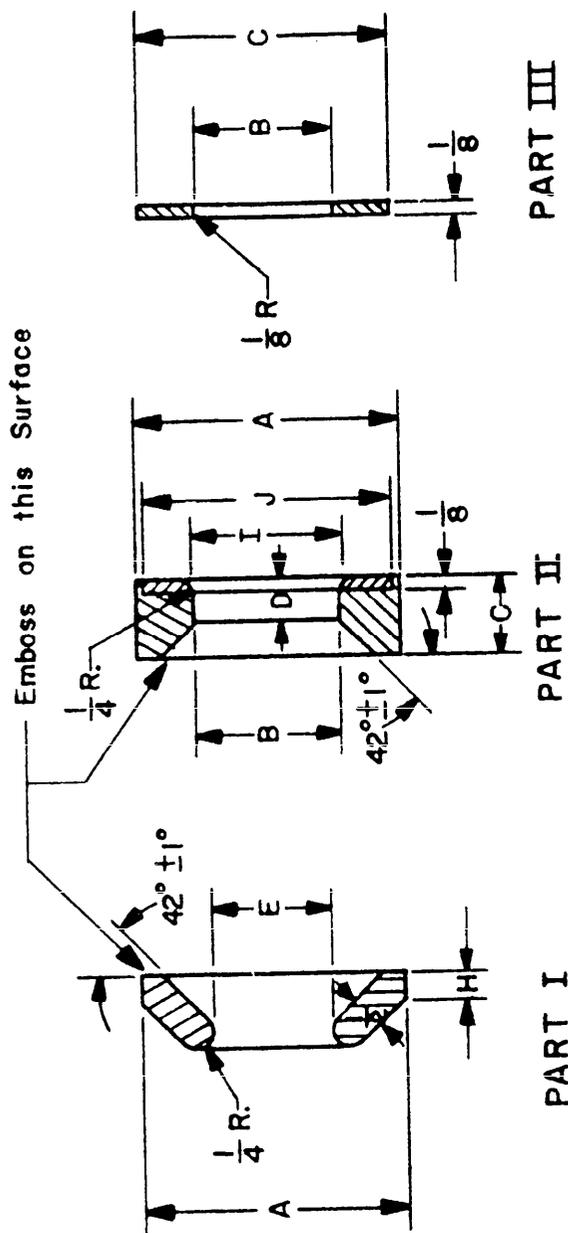
SH 7852A

Nominal size Inches	A Inches	B Inches	C Inches	D Inches	E Inches	F Inch	G Inch	H Inches	I Inches	K Inches
1/2	3.110	1-5/8		1/2	1-1/8	1/2	1/2	1.793	3.064	2-21/32
3/4	3.298	1-3/4		1/2	1-5/16	1/2	1/2	1.918	3.251	2-29/32
1	3.548	2-1/16		1/2	1-9/16	1/2	1/2	2.231	3.501	3-3/32
1-1/4	3.860	2-3/8		1/2	1-7/8	1/2	1/2	2.543	3.814	3-13/32
1-1/2	4.235	2-11/16		1/2	2-1/4	1/2	1/2	2.856	4.129	3-27/32
2	4.673	3-1/8		1/2	2-11/16	1/2	1/2	3.293	4.626	4-9/32
2-1/2	5.230	3-5/8		1/2	3-1/4	1/2	1/2	3.793	5.189	4-29/32
3	5.980	4-3/16	1-1/8	9/16	3-3/4	7/16	1/2	4.356	5.937	5-19/32
3-1/2	6.480	4-3/4	1-1/8	9/16	4-1/4	7/16	1/2	4.918	6.439	6-1/32
4	6.980	5-1/4	1-1/8	9/16	4-3/4	7/16	1/2	5.418	6.937	6-17/32
4-1/2	7.976	6-1/4	1-1/8	9/16	5-3/4	7/16	1/2	6.418	7.826	7-17/32
5	9.222	7-3/8	1-1/8	1-1/16	6-7/8	7/16	1/2	7.543	9.064	8-21/32
6	13.958	10	1-5/16	1-1/16	---	---	---	10.000	13.876	13-17/32
8	12.401	9-11/16	1-1/2	3/4	9-1/8	1/2	3/4	9.6876	12.319	12-7/16

NOTE 1. THE 8 INCH SIZE INSERT SET HAVING A 1/4 INCH "A" DIMENSION SHALL CONSIST OF TWO PART II INSERTS. (ONE WITHOUT WASHER) AND ONE PART III.

NOTE 2. THE TOLERANCE ON THE "A" DIMENSION FOR PART II IS +0.000 8 - (TABLE III VALUE)

FIGURE 1. Style A inserts.



PART III

PART II

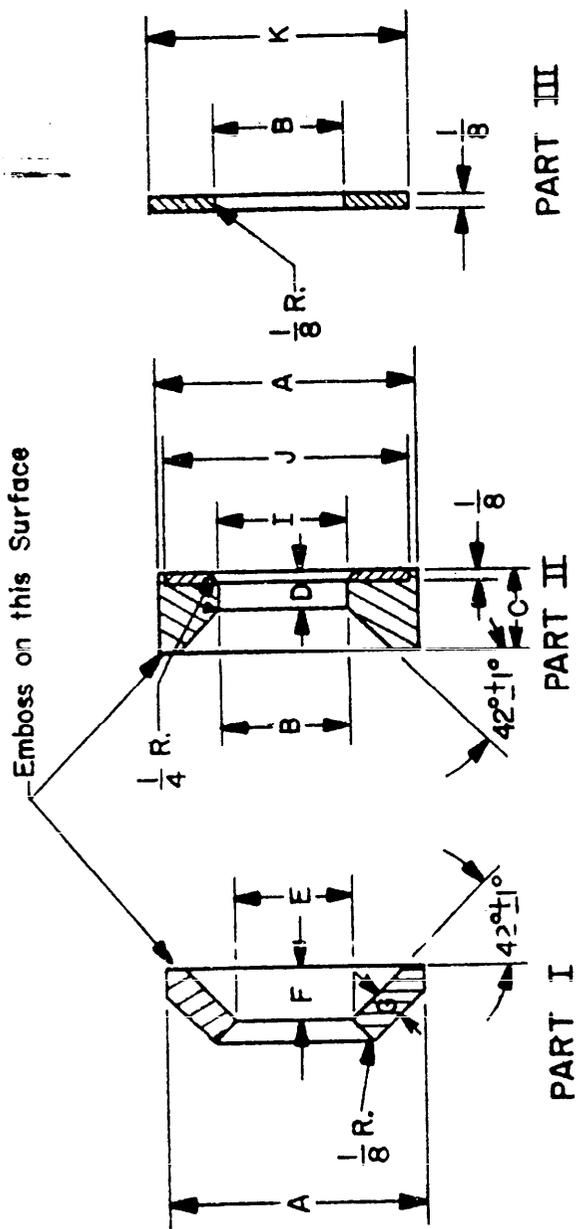
PART I

SH 7853A

Nominal size Inches	A Inches	B Inches	C Inches	D Inches	E Inches	F Inches	G Inches	H Inch	I Inches	J Inches
3/4	3-15/16	1-1/8	1-1/16	7/16	1-1/8	-1/8	2.621	5/8	1.293	2-29/32
1	3-1/8	1-5/16	1-15/16	3/8	1-5/16	-3/32	2.808	1/2	1.480	3-3/32
1-1/4	3-5/8	1-9/16	1-1/16	7/16	1-9/16	-1/16	3.307	1/2	1.730	3-19/32
1-1/2	3-7/8	1-7/8	1-1/8	3/8	1-7/8	-1/16	3.557	3/8	2.043	3-27/32
2	4-7/16	2-1/4	1-1/16	3/8	2-1/4	-1/16	4.120	7/16	2.418	4-13/32
2-1/2	4-15/16	2-11/16	1-1/8	3/8	2-11/16	-5/32	4.620	3/8	2.855	4-29/32
3	5-1/2	3-1/8	1-1/16	7/16	3-1/8	-1/16	5.181	3/8	3.293	5-15/32
3-1/2	6-9/16	3-3/4	1-1/8	3/8	3-3/4	-5/32	5.681	1/2	3.918	6-31/32
4	7	4-1/4	1-1/16	3/4	4-1/4	-1/8	6.243	1/2	4.418	6-17/32
4-1/2	8-1/4	5-3/8	1-3/16	13/16	5-3/4	-5/32	6.680	3/8	5.543	8-31/32
5	9-1/4	6-3/8	1-3/16	9/16	6-3/4	-1/8	7.929	7/16	6.543	9-7/32
6		7-1/2	1-1/16		6-7/8	-3/16	8.835		7.668	

NOTE:
 1. THE TOLERANCE ON THE "A" DIMENSION FOR PART II IS +0.000 - (TABLE III VALUE)

FIGURE 2. Style B inserts.



SH 7855A

Nominal size Inches	A Inches	B Inches	C Inches	D Inch	E Inches	F Inch	G Inch	H Inches	I Inches	K Inches
2	5	2-3/4	1-3/16	5/8	2-3/8	7/8	1/2	4-31/32	2.918	4-39/64
3	5-1/2	3-1/4	1-3/16	5/8	2-7/8	7/8	1/2	5-15/32	3.418	5-7/64

NOTE 1. THE TOLERANCE ON THE "A" DIMENSION FOR PART II IS +0,000 - (TABLE III VALUE)

FIGURE 3. Style D inserts.

FOLD

DEPARTMENT OF THE NAVY



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