

INCH - POUND

MS123120D  
 7 July 2010  
 SUPERSEDING  
 MS123120C(USAF)THRUMS123150C(USAF)  
 7 June 1972

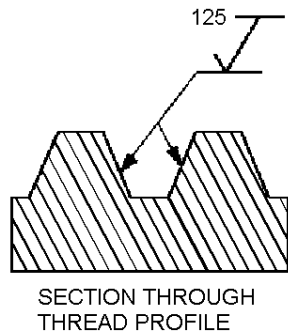
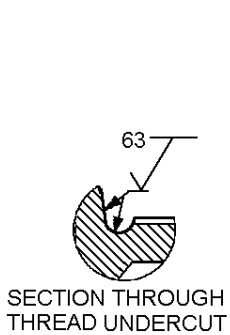
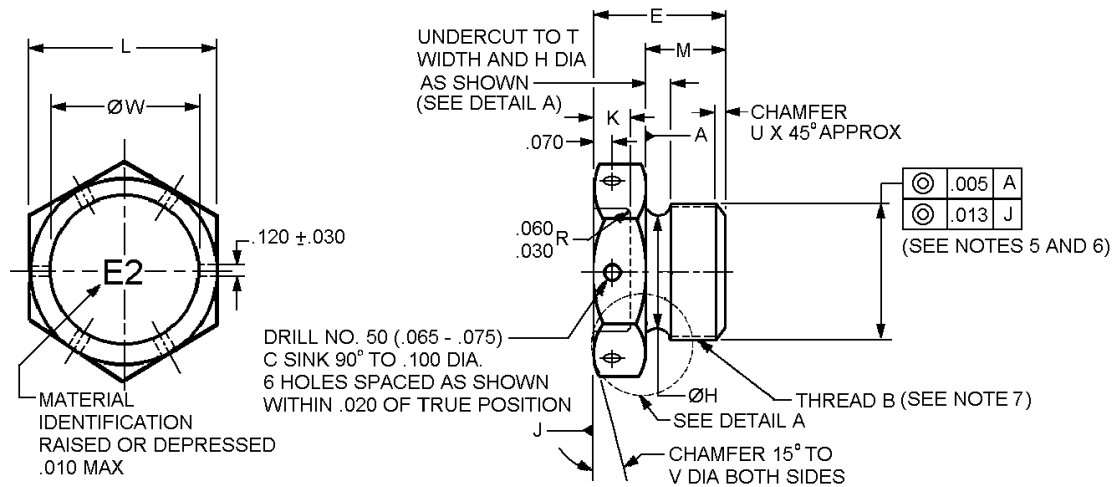
DETAIL SPECIFICATION SHEET

PLUG – STRAIGHT THREAD, O-RING SEAL, 1/4 INCH, ALUMINUM

Inactive for new design after 7 June 1972.  
 For new design use SAE-AS9902

This specification is approved for use by all Departments and Agencies of the Department of Defense.

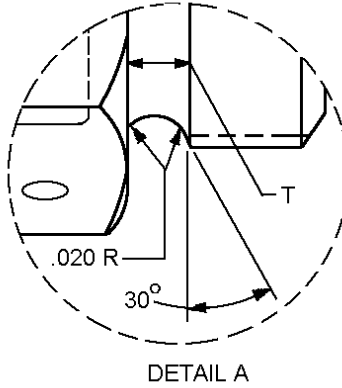
The requirements for acquiring the product described herein shall consist of this specification sheet.



Inches	mm
.005	0.13
.010	0.25
.013	0.33
.020	0.51
.030	0.76
.060	1.52
.065	1.65
.070	1.78
.075	1.91
.120	3.05
.188	4.78

FIGURE 1. Plug dimensions and configuration.

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Thread B	E Inches (mm)	H Dia. Inches (mm)	K Inches (mm)	L Inches (mm)	M Inches (mm)
.2500-28NF-3A	.540 (13.72)	.155 - .160 (3.94 - 4.06)	.130 (3.30)	.431 - .440 (10.95 - 11.18)	.320 (8.13)

T Inches (mm)	U Inches (mm)	V Dia Inches (mm)	W Inches (mm)	WT LBS Approx (grams)
.080 - .095 (2.03 - 2.41)	.020 - .050 (0.51 - 1.27)	.438 (11.13)	.250 (6.35)	.0037 (1.68)

## NOTES:

1. Dimensions are in inches.
2. Metric equivalents are given for information only.
3. Unless otherwise specified break sharp edges .003 - .005 inches (0.08 - 0.13 mm).
4. Unless otherwise specified tolerances for linear dimensions  $\pm 0.010$  inches (0.25 mm).
5. The concentricity of the hexagon, datum "J", with the thread pitch diameter (PD) shall be within the feature control frame, full indicator movement (FIM).
6. Datum "A" surfaces and PD of thread shall be concentric, parallel, flat, square and true (as applicable) to each other as specified in the feature control frame FIM.
7. Threads shall be in accordance with MIL-S-7742.
8. Surface texture unless otherwise specified shall be  $125\mu$  inches (0.00318 mm) except hex, as specified in ASME B46.1.

FIGURE 1. Plug dimensions and configuration - Continued.

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### REQUIREMENTS

Design and configuration: See figure 1.

Material: Aluminum accordance with SAE-AMS4120.

Finish: Anodic treatment in accordance with SAE-AMS2470.

Part or Identifying Number (PIN). The PIN to be used for plugs acquired to this specification is created as shown in the following example:

MS123120  
└───┬─── MS prefix and specification sheet number

Do not use unassigned PIN's.

MS123120D supersedes MS123120C(USAF)THRUMS123150C(USAF).

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. This document references the following:

MIL-S-7742  
ASME B46.1  
SAE-AMS2470  
SAE-AMS4120  
SAE-AS9902

### CONCLUDING MATERIAL

Custodians:

Army - AV  
Navy - AS  
Air Force - 99  
DLA - CC

Preparing activity:  
DLA - CC

(Project 4730-2010-101)

Review activities:

Army - AR, CR4, MI  
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 <https://assist.daps.dla.mil>.