

This standard has been approved by the BUREAU OF NAVAL WEAPONS
Department of the Navy and is mandatory for use by
all activities. All other military activities are required
to employ this standard where suitable.

P.A.

Other Cust

TITLE

NIPPLE, ROSE FITTING
AMS 5639 CRES STEEL

PROCUREMENT SPECIFICATION

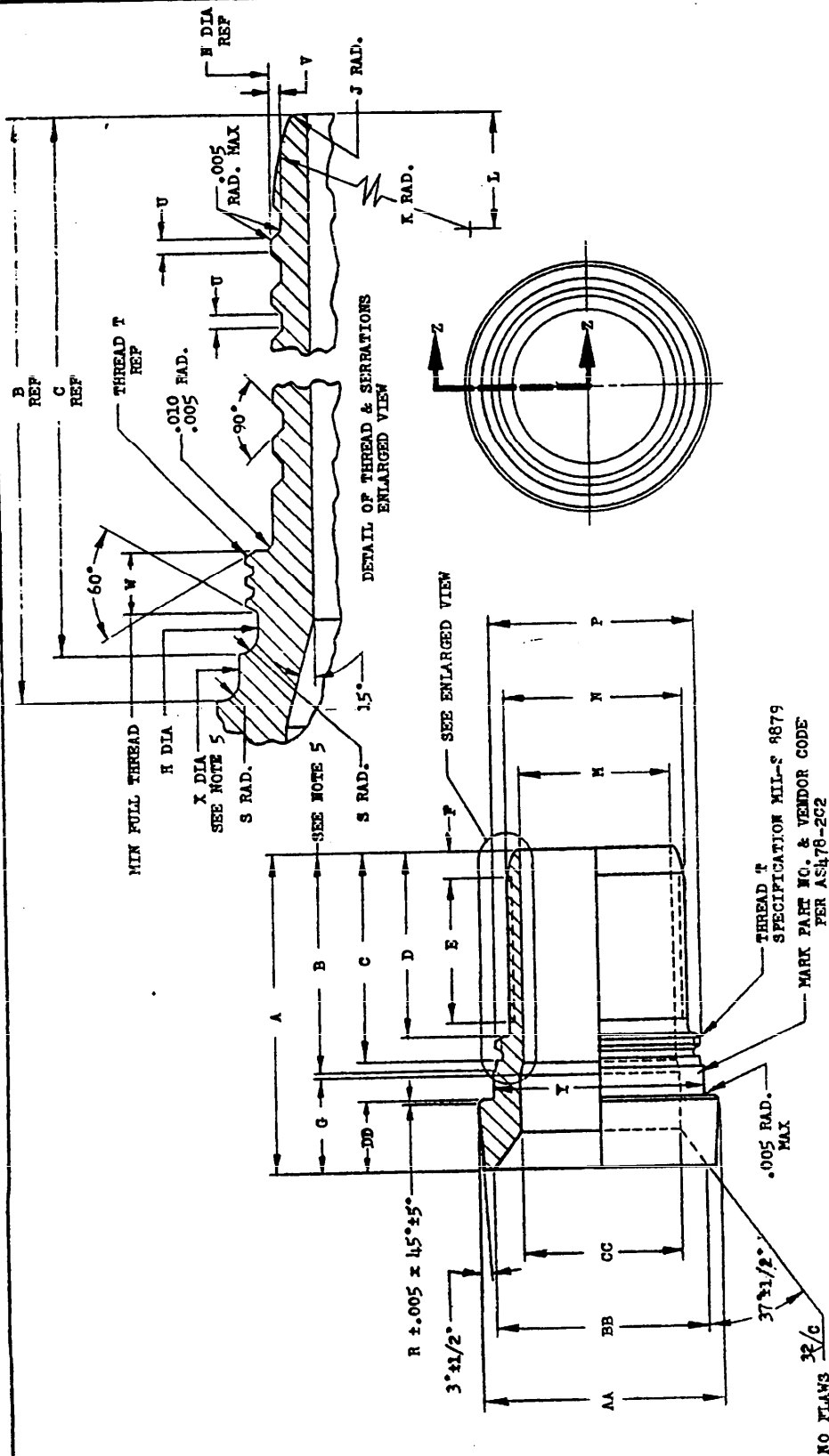
SUPERSEDES:

MILITARY STANDARD

MS18081 (WP)

SHEET 1 OF 2

FED. SUP CLASS
4730



- NOTES:
1. ALL DIAMETERS MUST BE CONCENTRIC WITH EACH OTHER WITHIN .005 TIR.
 2. BREAK SHARP EDGES .005-.015 AND REMOVE ALL BURRS. TOLERANCES: DECIMALS $\pm .010$, ANGLES $\pm 1^\circ$.
 3. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS $\pm .010$, ANGLES $\pm 1^\circ$.
 4. SURFACE ROUGHNESS: PER MIL-STD-10. NOT TO EXCEED $63/\mu$ UNLESS OTHERWISE SPECIFIED.
 5. CONFIGURATION OF NIPPLE SIZES -.03, -.06, -.12 & -.24 IS GOVERNED BY DIAMETER X AND LENGTH B.
 6. MATERIAL: CORROSION RESISTANT STEEL AMS 5639.
 7. HARDNESS: ROCKWELL B 75-80.
 8. PASSIVATION: A.) DEGREASE.
B.) IMMERSE FOR NOT LESS THAN 20 MINUTES IN A SOLUTION OF 1 VOLUME OF NITRIC ACID (SP GR 1.42) AND 9 VOLUMES OF WATER AT ROOM TEMPERATURE.

APPROVED 26 April 1965 REVISED

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AMS 5639 CRES STEEL

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SHEET 2 OF 2

FED. SUP CLASS
4730

PART NO.	A ±.005	B	C ±.005	D ±.005	E	F	G	H	J	K	L	M	N ±.003	P	R ±.005
MS18081-03	.859	.583 .573	.531	.437	.312	.062	.290 .275	.178 .173	.046 .030	—	—	.070 .067	.135	.2160 .2106	.010
MS18081-04	.891	—	.593	.500	.359	.062	.280 .265	.250 .245	.046 .030	—	—	.134 .130	.213	.2812 .2758	.010
MS18081-05	.922	—	.593	.500	.359	.062	.296 .281	.329 .324	.046 .030	—	—	.191 .185	.266	.3650 .3588	.010
MS18081-06	1.094	—	.718	.625	.469	.062	.359 .344	.388 .383	.046 .030	—	—	.255 .249	.330	.4210 .4148	.010
MS18081-08	1.328	.947 .927	.875	.750	.578	.094	.406 .391	.437 .432	.010 .005	.210	.094	.339 .333	.420	.4987 .4906	.018
MS18081-10	1.562	—	1.062	.937	.703	.125	.468 .453	.625 .613	.020 .010	.625	.203	.424 .418	.525	.6863 .6791	.018
MS18081-12	1.547	1.135 1.115	1.062	.937	.703	.125	.453 .438	.686 .675	.020 .010	.625	.203	.549 .543	.650	.7487 .7406	.018
MS18081-16	1.604	—	1.062	.937	.703	.125	.515 .500	.998 .988	.020 .010	.625	.203	.784 .778	.900	1.0611 1.0524	.018
MS18081-20	1.975	—	1.344	1.187	.953	.125	.593 .578	1.240 1.230	.020 .010	1.155	.250	1.003 .997	1.155	1.3110 1.3023	.018
MS18081-24	2.063	1.416 1.396	1.344	1.187	.953	.125	.681 .666	1.428 1.418	.020 .010	1.155	.250	1.255 1.249	1.406	1.4985 1.4898	.018

PART NO.	S	THREAD T MIL-S-8879	U ±.0015	V ±.0015	W ±.005	X	Y	AA	BB	CC	DD	WEIGHT MAX LBS
MS18081-03	.010 ±.0005	.2160-32 UNJF-3A	.008	.012	.047	.221 .216	.235 .227	.325 .322	.250 .245	.128 .123	.188 .183	.007
MS18081-04	.020	.2812-32 UNJF-3A	.008	.012	.047	—	.291 .283	.378 .375	.300 .295	.175 .170	.183 .178	.010
MS18081-05	.020	.3650-28 UNJF-3A	.008	.015	.047	—	.368 .360	.441 .438	.360 .355	.237 .231	.199 .194	.013
MS18081-06	.031	.4210-28 UNJF-3A	.015	.015	.047	—	.429 .421	.503 .500	.440 .435	.300 .295	.223 .218	.017
MS18081-08	.031	.5000-20 UNJF-3A	.015	.015	.078	.515 .498	.563 .555	.683 .680	.575 .570	.394 .390	.296 .291	.035
MS18081-10	.031	.6875-24 UNJF-3A	.015	.015	.081	—	.681 .676	.799 .796	.685 .680	.488 .484	.312 .307	.057
MS18081-12	.031	.7500-20 UNJF-3A	.015	.015	.081	.765 .749	.814 .806	.974 .971	.855 .850	.612 .608	.300 .295	.070
MS18081-16	.031	1.0625-18 UNJF-3A	.015	.015	.081	—	1.067 1.061	1.224 1.218	1.108 1.098	.822 .815	.343 .338	.115
MS18081-20	.031	1.3125-18 UNJF-3A	.015	.015	.112	—	1.312 1.302	1.536 1.530	1.445 1.405	1.054 1.051	.375 .370	.206
MS18081-24	.031	1.5000-18 UNJF-3A	.015	.015	.112	1.498 1.489	1.562 1.552	1.786 1.781	1.630 1.620	1.303 1.297	.434 .429	.270

APPROVED 26 APR 1965 REVISED