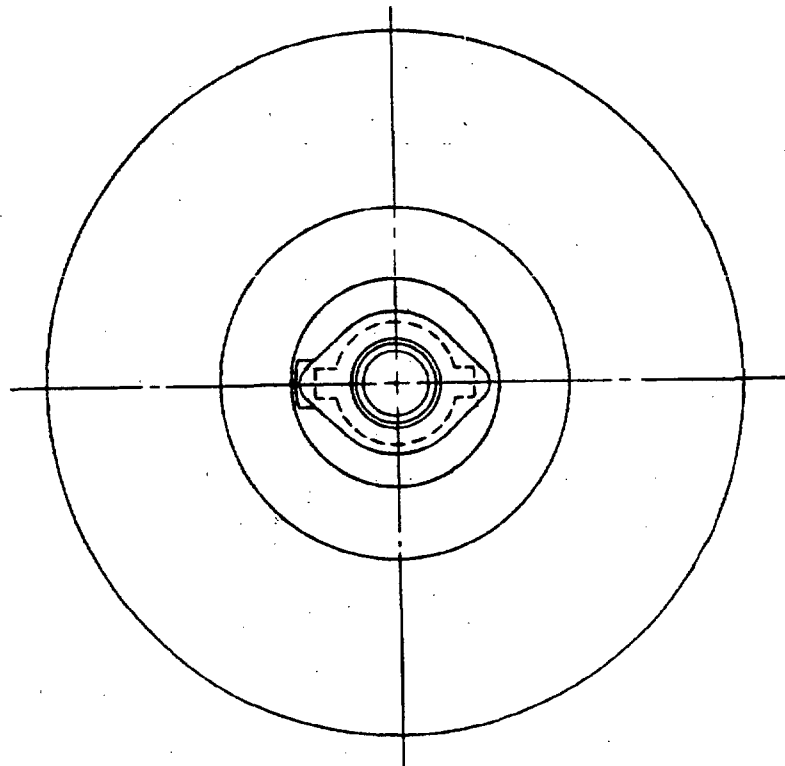
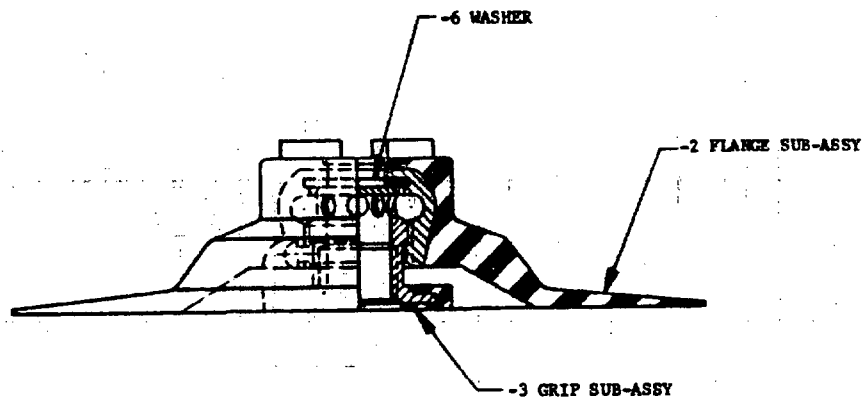


PROJECT NO. 4120-0205

FED. SUP CLASS
4220USER SYMBOLS:
NAVY - SH, MC
ARMY - AVREVIEWER SYMBOLS:
ARMY - AV
USAF - 84
NSA - C3

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-1 VALVE ASSY

FOR NOTES SEE SHEET 5

FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.
REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.

(A) ENTIRE STANDARD REVISED AND REDRAWN.

P.A. NAVY - AS Other Cust ARMY - ME USAF - 82	TITLE VALVE, LIFE RAFTS FLUSH TYPE, TOPPING OFF (FOR MULTIPLE LIFE RAFTS)	MILITARY STANDARD	
		MS22054	
PROCUREMENT SPECIFICATION NONE	SUPERSEDES MS22054 (ASG)	SHEET 1	OF 5

DD FORM 1 MAR 72 672-1 (Coordinated)

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PLATE NO. 23055

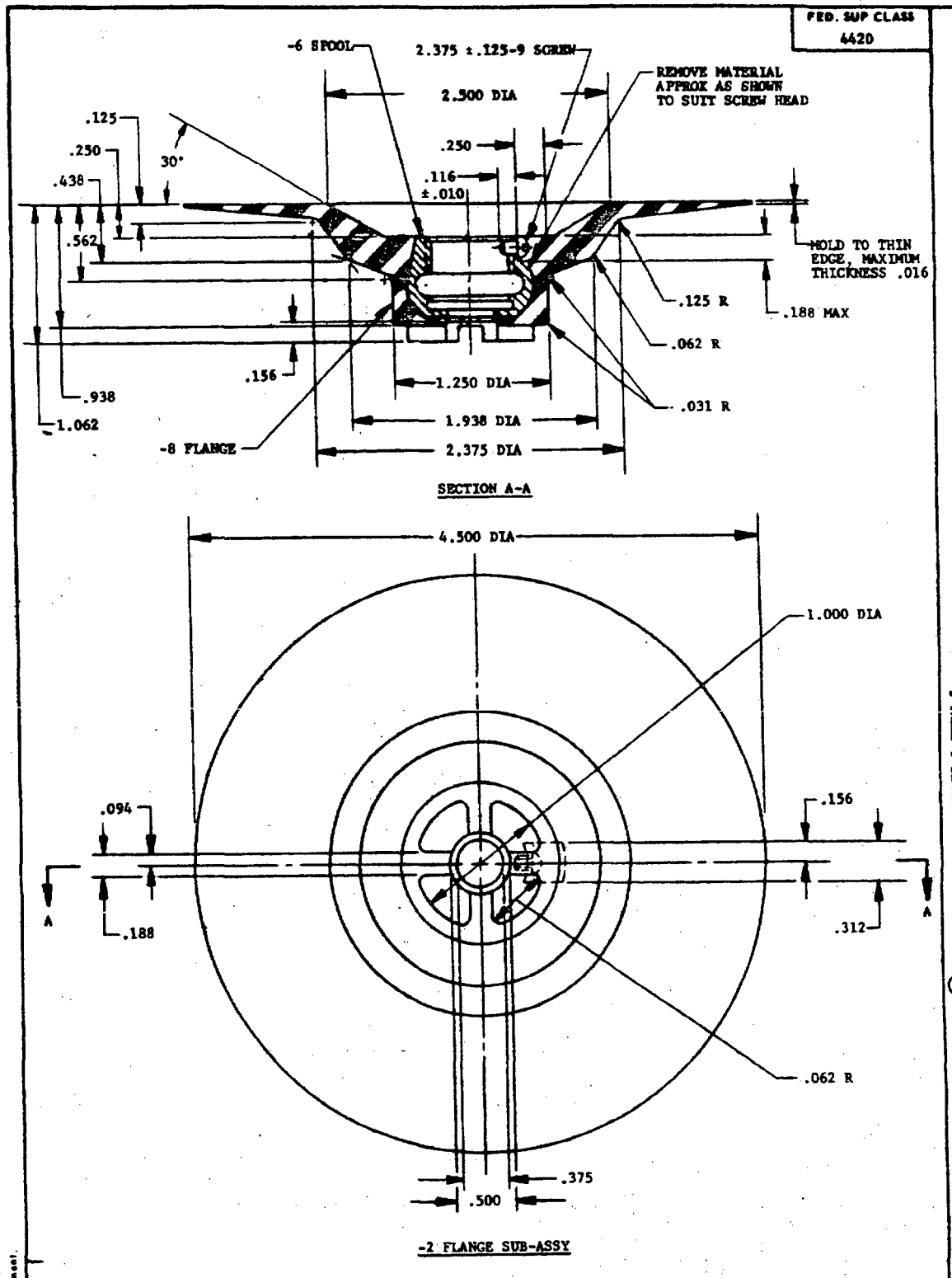
APPROVED 17 AUG 1961 REVISED (A) 22 JAN 1975

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4420

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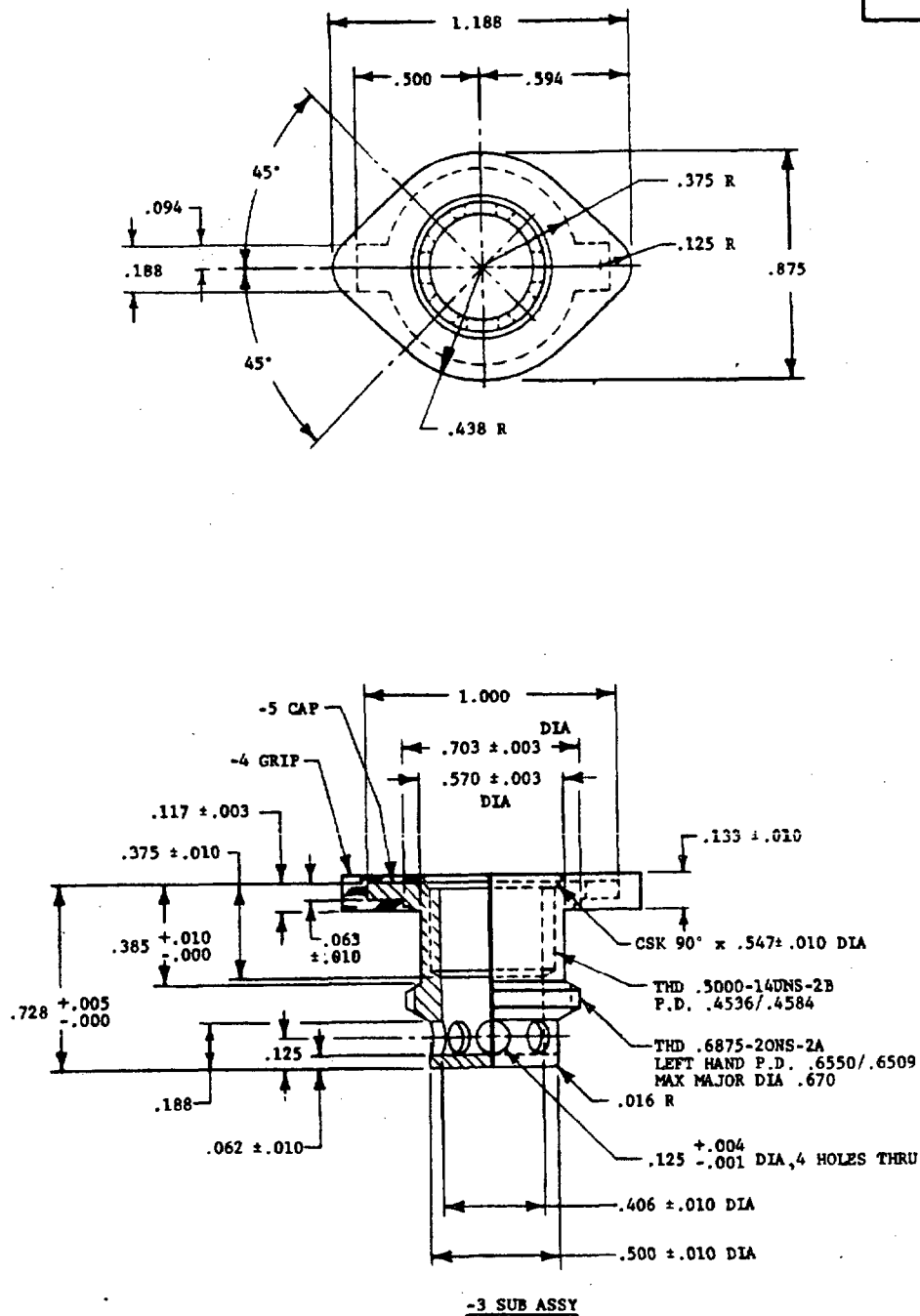
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PROCUREMENT SPECIFICATION NONE	SUPERSEDES: MS22054 (ASG)	SHEET 2 OF 5

USER SYMBOLS:
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ARMY - AV

REVIEWER SYMBOLS:
ARMY - AV
USAF - 84
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FED. SUP CLASS
4420

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PROCUREMENT SPECIFICATION NONE	SUPERSEDES: MS22045 (ASG)	SHEET 3 OF 5

DD FORM 672-1 (Coordinated)

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PLATE NO. 23085

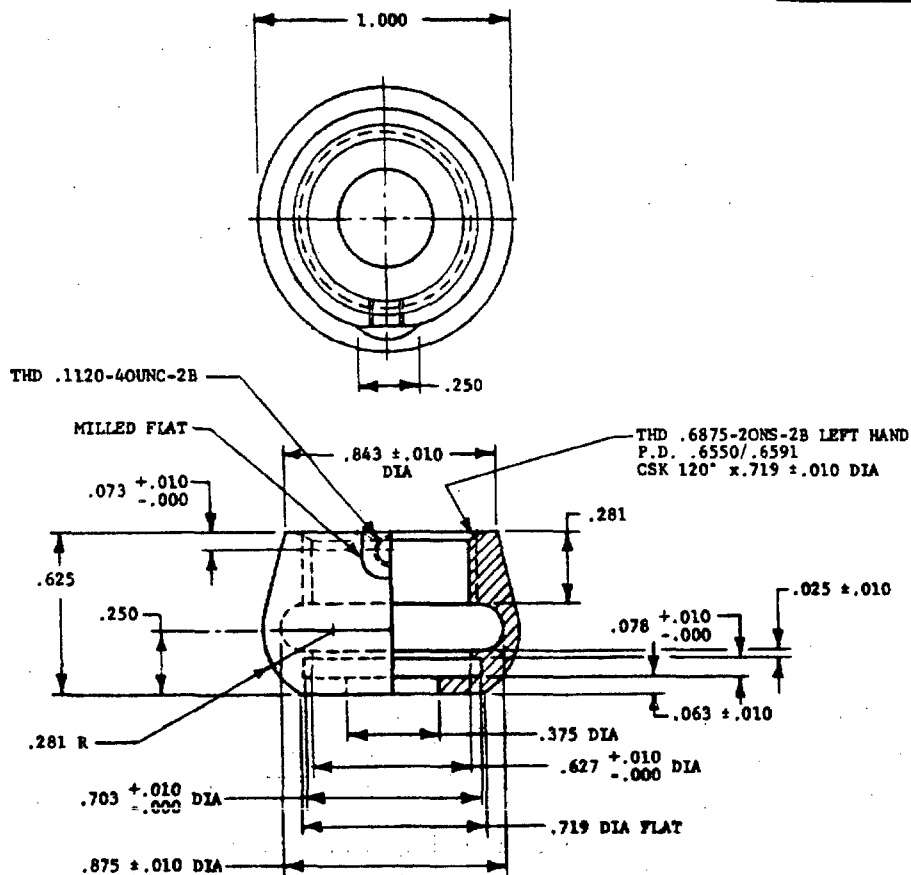
USER SYMBOLS:
NAVY - SH, MC
ARMY - AV

REVIEWER SYMBOLS:
ARMY - AV
USAF - 84
NSA - CS

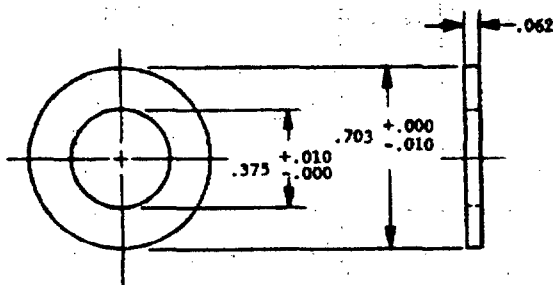
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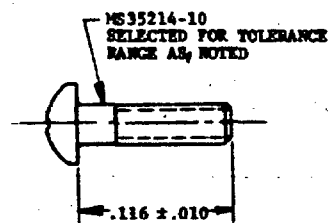
FED. SUP CLASS
4420



-6 SPOOL



-7 WASHER



-9 SCREW

SELECTED ITEM PART

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P.A. NAVY - AS Other Cust ARMY - ME USAF - 82	TITLE VALVE, LIFE RAFTS FLUSH TYPE, TOPPING OFF (FOR MULTIPLE LIFE RAFTS)	MILITARY STANDARD MS22054
PROCUREMENT SPECIFICATION NONE	SUPERSEDES: MS22054 (ASG)	SHEET 4 OF 5

DD FORM 672-1 (Coordinated)
1 MAR 72

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PLATE NO. 22000

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TEST REQUIREMENTS: THE MOLDED RUBBER FLANGE -8 OF -2 SUB ASSY SHALL NOT STRIP AWAY FROM THE BRASS SPOOL -6 OF THE TOPPING OFF VALVE, NOR SHALL THE RUBBER FLANGE (-8) FAIL BELOW 75 LBS., WHEN INSPECTED AS FOLLOWS:
"THE RUBBER FLANGE -8 SHALL BE SLIT INTO SIX EQUAL SEGMENTS. TWO OF THE DIAMETRICAL OPPOSITE SEGMENTS SHALL BE CLAMPED IN THE JAWS OF A SUITABLE INSPECTION APPARATUS OPERATING WITH THE MOVABLE JAW SEPARATING AT A RATE OF $2 \pm 1/8$ INCHES PER MINUTE UNDER NO LOAD. THE JAWS SHALL BE OPERATED UNTIL FAILURE OCCURS. (THIS INSPECTION SHALL BE REPEATED FOR EACH REMAINING TWO DIAMETRICAL OPPOSITE SEGMENTS.) THE SEGMENTS UNDER TEST SHALL BE OBSERVED FOR CONFORMANCE TO REQUIREMENTS." CERTIFICATE OF COMPLIANCE SHALL BE FURNISHED WHEN REQUIRED.

NOTES:

1. MATERIAL: -6 SPOOL AND -5 CAP SHALL BE BRASS, SPECIFICATION QQ-B-626 COMPOSITION 360, HALF HARD;
-7 WASHER, -8 FLANGE, AND -4 GRIP SHALL BE SYNTHETIC OR NATURAL RUBBER, COMMERCIAL.
2. THREADS TO BE IN ACCORDANCE WITH HANDBOOK H28.
3. HARDNESS: WASHER, SHORE DUROMETER 65 TO 70; FLANGE AND GRIP, SHORE DUROMETER 50 TO 60.
4. ALL RUBBER SECTIONS SHALL BE MOLDED AND CURED.
5. WASHER SHALL BE SECURELY CEMENTED IN PLACE USING A SUITABLE RUBBER TO METAL CEMENT. CARE MUST BE TAKEN TO KEEP THREADS AND OPENING FREE OF CEMENT.
6. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: THREE PLACE DECIMALS $\pm .016$, ANGLES $\pm 1/2^\circ$.

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PROCUREMENT SPECIFICATION NONE	SUPERSEDES MS22054 (ASG)	SHEET 5 OF 5

DD FORM 672-1 (Coordinated)

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PLATE NO. 2205