

User activities:

Review activities:
ARMY - ME, AV
NAVY - AS
DLA - CS

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		FED. SUP CLASS 4730
<p>(a) TOLERANCES ON DIMENSIONS C AND N IN ACCORDANCE WITH MS24385. CONCENTRICITY: T, A, F, AND N SHALL BE CONCENTRIC WITHIN .005 TOTAL INDICATOR READING. MATERIAL: STEEL; ALUMINUM ALLOY; CORROSION RESISTANT STEEL (GRES); TITANIUM ALLOY; (SEE PROCUREMENT SPECIFICATION). FINISH: SEE PROCUREMENT SPECIFICATION. BREAK ALL SHARP EDGES AND REMOVE ALL HANGING BURRS AND SLIVERS. NO CODE LETTER IN PART NUMBER FOR STEEL. ADD D IN PLACE OF DASH FOR ALUMINUM ALLOY (EXCEPT 7075-T73). ADD J IN PLACE OF DASH FOR GRES, TYPE 304. ADD K IN PLACE OF DASH FOR GRES, TYPE 316. ADD S IN PLACE OF DASH FOR GRES, TYPE 347. ADD T IN PLACE OF DASH FOR TITANIUM ALLOY. ADD W IN PLACE OF DASH FOR 7075-T73 ALUMINUM ALLOY. TITANIUM IS NOT RECOMMENDED FOR USE IN OXYGEN SYSTEMS. EXAMPLE OF PART NUMBERS: MS24387-8 - BOLT, 1/2 TUBING, STEEL. MS24387D8 - BOLT, 1/2 TUBING, ALUMINUM ALLOY (EXCEPT 7075-T73). MS24387J8 - BOLT, 1/2 TUBING, GRES, TYPE 304. MS24387K8 - BOLT, 1/2 TUBING, GRES, TYPE 316. MS24387S8 - BOLT, 1/2 TUBING, GRES, TYPE 347. MS24387T8 - BOLT, 1/2 TUBING, TITANIUM ALLOY. MS24387W8 - BOLT, 1/2 TUBING, 7075-T73 ALUMINUM ALLOY.</p> <p>(F) DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: FRACTIONS $\pm 1/64$, DECIMALS $\pm .005$, ANGLES $\pm 5^\circ$.</p> <p>IN ADDITION TO THE SAMPLING REQUIREMENTS OF THE PROCUREMENT SPECIFICATION, THE CONE END SURFACE ON 100% OF THE BOLTS OF A LOT SHALL BE INSPECTED. 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.</p>		
(F) DENOTES CHANGES		
P.A. AIR FORCE-82 (F) Other Cast AIR FORCE-99	TITLE BOLT, FLUID PASSAGE, PRECISION TYPE	MILITARY STANDARD MS 24387
PROCUREMENT SPECIFICATION MIL-F-5509	SUPERSEDES:	SHEET 1 OF 2

FED. SUP CLASS
4730

(F)

DASH NO.	TUBING OD	THREAD T MIL-S-8879	A +.000 -.004	B ±.010	C	D	E	F +.010 -.000 DIA	(a) G (REF)	L DIA	M DIA	(a) N (REF)
4	1/4	.437-20UNJF-3A	.435	.781	.137	2.187	1.922	.469	.688	.343	.257	.172
5	5/16	.500-20UNJF-3A	.498	.781	.137	2.187	1.922	.531	.750	.406	.322	.234
6	3/8	.562-18UNJF-3A	.560	.875	.168	2.317	2.125	.594	.813	.468	.351	.297
8	1/2	.750-16UNJF-3A	.748	1.094	.562	2.667	2.593	.781	1.000	.625	.512	.391
10	5/8	.875-14UNJF-3A	.873	1.250	.593	2.962	2.877	.906	1.125	.750	.605	.484
12	3/4	1.062-12UNJ -3A	1.060	1.468	.656	3.312	3.161	1.094	1.375	.937	.757	.609
16	1	1.312-12UNJ -3A	1.310	1.687	.656	3.612	3.397	1.344	1.625	1.187	.925	.844

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P.A. AIR FORCE 82
Other Cust
AIR FORCE-99

TITLE

BOLT, FLUID PASSAGE, PRECISION TYPE

MILITARY STANDARD

MS 24387

PROCUREMENT SPECIFICATION
MIL-F-5509

SUPERSEDES:

SHEET 2 OF 2

DD FORM 672-1 Limited
Coordination

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

APPROVED 14 FEB 57 REVISED (F) FOR CHANGES SEE PAGES 1 & 2.