

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

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<p>FITTING END IN ACCORDANCE WITH MS24386, STYLE E, FOR TUBE SIZE SPECIFIED.</p>		<p>FED. SUP CLASS 4730</p>
<p>(a) THIS SURFACE SHALL BE FREE FROM LONGITUDINAL AND SPIRAL TOOL MARKS. ANNULAR TOOL MARKS SHALL NOT EXCEED 32 MICROINCHES AA (SEE ANSI B46.1).</p> <p>MATERIAL: STEEL; ALUMINUM ALLOY; CORROSION RESISTANT STEEL (CRES); TITANIUM ALLOY; BARS, SHAPES OR FORGINGS (SEE PROCUREMENT SPECIFICATION).</p> <p>FINISH: SEE PROCUREMENT SPECIFICATION.</p> <p>DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCE: FRACTIONS $\pm 1/64$.</p> <p>NO CODE LETTER IN PART NUMBER FOR STEEL.</p> <p>ADD D IN PLACE OF DASH FOR ALUMINUM ALLOY (EXCEPT 7075-T73).</p> <p>ADD J IN PLACE OF DASH FOR CRES, TYPE 304.</p> <p>ADD K IN PLACE OF DASH FOR CRES, TYPE 316.</p> <p>ADD S IN PLACE OF DASH FOR CRES, TYPE 347.</p> <p>ADD T IN PLACE OF DASH FOR TITANIUM ALLOY.</p> <p>ADD W IN PLACE OF DASH FOR 7075-T73 ALUMINUM ALLOY.</p> <p>TITANIUM IS NOT RECOMMENDED FOR USE IN OXYGEN SYSTEMS.</p> <p>EXAMPLE OF PART NUMBERS:</p> <p>MS24389-8 - TEE, 1/2 TUBING, STEEL.</p> <p>MS24389D8 - TEE, 1/2 TUBING, ALUMINUM ALLOY (EXCEPT 7075-T73).</p> <p>MS24389J8 - TEE, 1/2 TUBING, CRES, TYPE 304.</p> <p>MS24389K8 - TEE, 1/2 TUBING, CRES, TYPE 316.</p> <p>MS24389S8 - TEE, 1/2 TUBING, CRES, TYPE 347.</p> <p>MS24389T8 - TEE, 1/2 TUBING, TITANIUM ALLOY.</p> <p>MS24389W8 - TEE, 1/2 TUBING, 7075-T73 ALUMINUM ALLOY.</p> <p>BREAK ALL SHARP EDGES AND REMOVE ALL HANGING BURRS AND SLIVERS.</p> <p>IN ADDITION TO THE SAMPLING REQUIREMENTS OF THE PROCUREMENT SPECIFICATION, THE SURFACE OF THE CONE ENDS ON 100% OF THE TEES OF A LOT SHALL BE INSPECTED.</p> <p>FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.</p> <p>REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.</p>		
<p>(F) DENOTES CHANGES</p>		
<p>P.A. AIR FORCE-99 (F)</p> <p>Other Case</p> <p>AIR FORCE-99</p>	<p>TITLE</p> <p>TEE, TUBE, INTERNAL THREAD ON RUN, PRECISION TYPE</p>	<p>MILITARY STANDARD</p> <p>MS 24389</p>
<p>PROCUREMENT SPECIFICATION</p> <p>MIL-F-5509</p>	<p>SUPERSEDES:</p> <p>AN784 (F)</p>	<p>SHEET</p> <p>1 OF 2</p>

APPROVED 14 FEB 67 REVISED A 6 MAR 58 B 30 DEC 59 C 10 FEB 67 D 16 JUN 78 E 22 MAR 79 F 16 APR 82

FED. SUP CLASS
4730

DASH NO.	TUBING OD	THREAD T (REF)	J +3/64 -0	K +3/64 -0	Q +3/64 -0	R +3/64 -0	U RAD	V	W MIN	X MIN	Y +3/64 -0	Z DIA
2	1/8	5/16-24UNJF-3A	23/32	5/8	29/32	1-15/32	1/16	1/2	15/32	5/16	29/32	9/16
3	3/16	3/8 -24UNJF-3A	13/16	11/16	31/32	1- 1/2	3/32	9/16	1/2		31/32	5/8
4	1/4	7/16-20UNJF-3A	29/32	3/4	1- 3/16	1- 3/4		3/4	13/16		7/16	1- 3/16
5	5/16	1/2 -20UNJF-3A	15/16							3/4		
6	3/8	9/16-18UNJF-3A	1- 1/32	13/16	1- 1/4	2	1/8	7/8	25/32		1- 9/32	7/8
8	1/2	3/4 -16UNJF-3A	1- 1/4	1	1- 7/16	2- 5/32		1-1/16	29/32	1/2	1-15/32	1-1/16
10	5/8	7/8 -14UNJF-3A	1-15/32	1- 5/32	1- 5/8	2- 3/8						
12	3/4	1-1/16-12UNJ -3A	1- 3/4	1-11/32	1-13/16	2- 5/8		1-5/16	1- 3/32	5/8	1- 7/8	1-7/16
16	1	1-5/16-12UNJ -3A	2- 1/16	1-17/32	2- 1/16	2-27/32		1-5/8	1- 5/16	3/4	2- 3/32	1-11/16
20	1-1/4	1-5/8 -12UNJ -3A	2- 5/16	1-23/32	2- 1/4	3- 1/32		1-7/8	1- 1/2	7/8	2- 1/4	2

User activities:

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P.A. AIR FORCE-99 Other Cast AIR FORCE-99	TITLE TEE, TUBE, INTERNAL THREAD ON RUN, PRECISION TYPE	MILITARY STANDARD
PROCUREMENT SPECIFICATION ML-F-5509	SUPERSEDES: AN704 (F)	MS24389
		SHEET 2 OF 2

DD FORM 672-1 Limited
Coordination

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

4730-F270

APPROVED 14 FEB 67 REVISED (F) FOR CHANGES SEE PAGES 1 & 2. 16 April 1982