

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

User activities:

This Military Standard is approved for use by HQ AFPC, CASO/LODS, Federal Center, Barrio Crotti, CI 49016, Department of the Air Force, and is available for use by all Departments and agencies of the Department of Defense.

TOLERANCE UP TO AND INCLUDING -6 SIZE $\pm 2 \frac{1}{2}^\circ$, ABOVE -6 SIZE $\pm 1 \frac{1}{2}^\circ$.		EXCEPT AS NOTED, FITTING END IN ACCORDANCE WITH MS 24385, STYLE G, FOR TUBE SIZE SPECIFIED. (2 ENDS)		FED. SUP CLASS 4730	
<p>MARK EACH WRENCH PAD WITH AN EQUI LATERAL TRIANGLE TO DENOTE PRECISION TYPE. MARKING SHALL BE DEPRESSED $.025 \pm .010$.</p> <p>THREAD T</p> <p>URAD</p> <p>H RAD</p> <p>THREAD T</p> <p>M</p> <p>FITTING END IN ACCORDANCE WITH MS 24386, STYLE S, FOR TUBE SIZE SPECIFIED.</p>		<p>DRILL THRU IN ACCORDANCE WITH MS 24385.</p> <p>DRILL DEPTH M</p> <p>V</p> <p>ACROSS WRENCH FLATS</p>			

DASH NO.	TUBING OD	THREAD T (REF)	G DIA	H RAD	M $+3/64$ -0	Q $+3/63$ -0	U RAD
2	1/8	5/16-24UNJF-3A	5/16	1/32	1-13/32	53/64	1/16
3	3/16	3/8-24UNJF-3A	3/8		1-7/16	57/64	
4	1/4	7/16-20UNJF-3A	7/16		1-37/64	61/64	
5	5/16	1/2-20UNJF-3A	1/2		1-39/64	1-1/64	
6	3/8	9/16-18UNJF-3A	9/16	3/32	1-51/64	1-5/64	3/32
8	1/2	3/4-16UNJF-3A	3/4		2-3/32	1-11/64	
10	5/8	7/8-14UNJF-3A	7/8		2-3/8	1-35/64	1/8
12	3/4	1-1/16-12UNJ-3A	1-1/16		2-21/32	1-49/64	
16	1	1-5/16-12UNJ-3A	1-5/16		2-25/32	1-59/64	3/16
20	1-1/4	1-5/8-12UNJ-3A	1-5/8		3-7/64	2-5/32	
24	1-1/2	1-7/8-12UNJ-3A	1-7/8		3-13/32	2-21/64	
28	1-3/4	2-1/4-12UNJ-3A	2-1/4		3-25/32	2-19/32	
32	2	2-1/2-12UNJ-3A	2-1/2	4-3/32	2-7/8		

DASH NO.	V $\pm 1/64$	W APPROX	X APPROX
2	5/16	5/16	3/16
3	3/8		1/4
4	7/16		
5	1/2	1/2	5/16
6	9/16		
8	3/4	5/8	7/16
10	7/8	3/4	
12	1-1/16	7/8	1/2
16	1-5/16	1-1/16	5/8
20	1-5/8	1-1/4	3/4
24	1-7/8	1-7/16	7/8
28	2-1/4	1-3/4	1-1/16
32	2-9/16	1-15/16	1-3/16

⑥ DENOTES CHANGES

P.A. AIR FORCE-99 Other Cast AIR FORCE-99	⑥ TITLE TEE, TUBE, BULKHEAD, PRECISION TYPE	MILITARY STANDARD MS 24395
PROCUREMENT SPECIFICATION MIL-F-6809	SUPERSEDES: -AN834-⑥	SHEET 1 OF 2

APPROVED 14 FEB 57 REVISED A 6 MAR 58 B 20 APR 60 C 10 FEB 67 D 10 OCT 68 E 16 JUN 78 F 22 MAR 79 G 16 APR 82

DD FORM 672-1 Limited Coordination

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

4730-F276

FED. SUP CLASS
4730

MATERIAL: STEEL; ALUMINUM ALLOY; CORROSION RESISTANT STEEL (CRES); TITANIUM ALLOY; BARS, SHAPES, OR FORGINGS (SEE PROCUREMENT SPECIFICATION).

FINISH: SEE PROCUREMENT SPECIFICATION.

NO CODE LETTER IN PART NUMBER FOR STEEL.

ADD W IN PLACE OF DASH FOR 7075-T73 ALUMINUM ALLOY.

ADD D IN PLACE OF DASH FOR ALUMINUM ALLOY (EXCEPT 7075-T73).

ADD J IN PLACE OF DASH FOR CRES, TYPE 304.

ADD K IN PLACE OF DASH FOR CRES, TYPE 316.

ADD S IN PLACE OF DASH FOR CRES, TYPE 347.

ADD T IN PLACE OF DASH FOR TITANIUM ALLOY.

TITANIUM IS NOT RECOMMENDED FOR USE IN OXYGEN SYSTEMS.

EXAMPLE OF PART NUMBERS:

MS24395-8 - TEE, 1/2 TUBING, STEEL.

MS24395D8 - TEE, 1/2 TUBING, ALUMINUM ALLOY (EXCEPT 7075-T73).

MS24395J8 - TEE, 1/2 TUBING, CRES, TYPE 304.

MS24395K8 - TEE, 1/2 TUBING, CRES, TYPE 316.

MS24395S8 - TEE, 1/2 TUBING, CRES, TYPE 347.

MS24395T8 - TEE, 1/2 TUBING, TITANIUM ALLOY.

MS24395W8 - TEE, 1/2 TUBING, 7075-T73 ALUMINUM ALLOY.

USE WASHER CONFORMING TO AN960 TO FORM BACKING FACE WHEN INSTALLED AGAINST BULKHEAD.

BREAK ALL SHARP EDGES AND REMOVE ALL HANGING BURRS AND SLIVERS.

DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCE: FRACTIONS $\pm 1/64$.

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.

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.

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P.A. AIR FORCE-99 Other Code AIR FORCE-99	6	TITLE TEE, TUBE, BULKHEAD, PRECISION TYPE	MILITARY STANDARD MS 24395
PROCUREMENT SPECIFICATION MIL-F-5509		SUPERSEDES: AN964-6	SHEET 2 OF 2

DD FORM 672-1 Limited
Coordination

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APPROVED 14 FEB 87 REVISED 6 FOR CHANGES SEE PAGES 1 & 2. 16 Apr 82