

User activities:

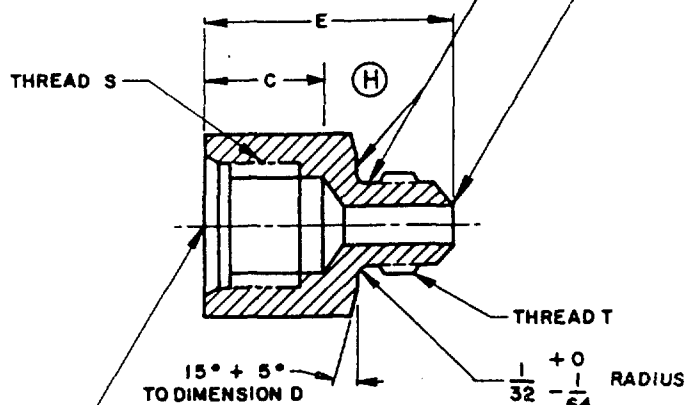
Review activities: ARMY-MI  
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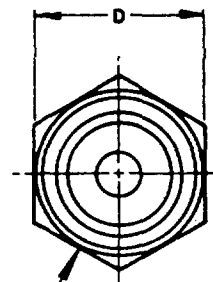
THESE SURFACES SHALL BE FREE FROM BURRS, LONGITUDINAL AND SPIRAL TOOL MARKS. SURFACE FINISH SHALL NOT EXCEED 32

EXTERNALLY THREADED FITTING END IN ACCORDANCE WITH MS 24385, STYLE E, FOR TUBE SIZE SPECIFIED, EXCEPT HEX AS SHOWN.

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BOSS DIMENSIONS IN ACCORDANCE WITH MS33649 FOR INTERNAL THREADED END.



MARK TWO OPPOSITE HEX SIDES WITH AN EQUILATERAL TRIANGLE TO DENOTE PRECISION TYPE. MARKING SHALL BE DEPRESSED .025 ± .010.

(a) THE TWO DASH NUMBERS IN THE PART NUMBER ARE CODED FOR THE TWO EQUIVALENT TUBE SIZES, EXPRESSED IN SIXTEENTHS. FOR EXAMPLE: MS24398-10-6 REFERS TO A STEEL FITTING WITH AN INTERNALLY THREADED END FOR 5/8 TUBE AND AN EXTERNALLY THREADED END FOR 3/8 OD TUBE.

MATERIAL: STEEL, ALUMINUM ALLOY; BARS. 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 D IN PLACE OF FIRST DASH FOR ALUMINUM ALLOY (EXCEPT 7075-T73).

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

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

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

ADD T IN PLACE OF FIRST DASH FOR TITANIUM ALLOY.

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

TITANIUM IS NOT RECOMMENDED FOR USE IN OXYGEN SYSTEMS.

EXAMPLE OF PART NUMBERS:

MS24398-8-6 - ADAPTER, 1/2 TUBING FOR INTERNAL THREADS AND 3/8 TUBING FOR EXTERNAL THREADS, STEEL.

MS24398D8-6 - ADAPTER, 1/2 TUBING FOR INTERNAL THREADS AND 3/8 TUBING FOR EXTERNAL THREADS, ALUMINUM ALLOY (EXCEPT 7075-T73).

MS24398J8-6 - ADAPTER, 1/2 TUBING FOR INTERNAL THREADS AND 3/8 TUBING FOR EXTERNAL THREADS, CRES, TYPE 304.

MS24398K8-6 - ADAPTER, 1/2 TUBING FOR INTERNAL THREADS AND 3/8 TUBING FOR EXTERNAL THREADS, CRES, TYPE 316.

MS24398S8-6 - ADAPTER, 1/2 TUBING FOR INTERNAL THREADS AND 3/8 TUBING FOR EXTERNAL THREADS, CRES, TYPE 347.

MS24398T8-6 - ADAPTER, 1/2 TUBING FOR INTERNAL THREADS AND 3/8 TUBING FOR EXTERNAL THREADS, TITANIUM ALLOY.

MS24398W8-6 - ADAPTER, 1/2 TUBING FOR INTERNAL THREADS AND 3/8 TUBING FOR EXTERNAL THREADS, 7075-T73 ALUMINUM ALLOY.

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

DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCE: FRACTIONS ±1/64.

IN ADDITION TO THE SAMPLING REQUIREMENTS OF THE PROCUREMENT SPECIFICATION, THE SURFACE OF THE CONE ENDS ON 100% OF THE ADAPTERS 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.

(H) DENOTES CHANGES

P.A. AIR FORCE-82 (H) Other Cust AIR FORCE-99 NAVY-AS	TITLE <b>ADAPTER, STRAIGHT, TUBE TO BOSS PRECISION TYPE</b>	MILITARY STANDARD <b>MS24398</b>
PROCUREMENT SPECIFICATION MIL-F-5509	SUPERSEDES: <b>-AN034-</b>	SHEET 1 OF 2

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DASH NO.	INTERNALLY THREADED END			EXTERNALLY THREADED END		D	E
	TUBING OD	THREAD S (REF)	C	TUBING OD	THREAD T (REF)		
3- 2	3/16	3/8 -24UNJF-3B	33/64	1/8	5/16-24UNJF-3A	.625	1- 3/16
4- 2	1/4	7/16-20UNJF-3B	39/64	3/16	3/8 -24UNJF-3A	.688	1-19/64
4- 3				1/4	7/16-20UNJF-3A	.750	1- 1/2
5- 4	5/16	1/2 -20UNJF-3B	47/64	1/4	7/16-20UNJF-3A	.813	1-25/64
6- 4	3/8	9/16-18UNJF-3B	39/64	5/16	1/2 -20UNJF-3A	1.000	1- 3/8
6- 5				3/8	9/16-18UNJF-3A	+ .003 - .004	1-37/64
8- 4	1/2	3/4 -16UNJF-3B	47/64	1/4	7/16-20UNJF-3A	1.125	1-43/64
8- 5				5/16	1/2 -20UNJF-3A		1-21/32
8- 6	5/8	7/8 -14UNJF-3B	51/64	3/8	9/16-18UNJF-3A	1.375	1-41/64
10- 4				1/2	3/4 -16UNJF-3A		1- 3/4
10- 5				3/8	9/16-18UNJF-3A		1-13/16
10- 6				1/2	3/4 -16UNJF-3A		1-59/64
10- 8	3/4	1-1/16-12UNJ -3B	59/64	5/8	7/8 -14UNJF-3A	1.625	2- 1/64
12- 6				3/8	9/16-18UNJF-3A		1-59/64
12- 8	1	1-5/16-12UNJ -3B	61/64	1/2	3/4 -16UNJF-3A	1.875	2- 1/32
12-10				5/8	7/8 -14UNJF-3A		2- 7/64
16- 6				3/4	1-1/16-12UNJ -3A		2-13/64
16- 8				1/2	3/4 -16UNJF-3A		2-11/64
16-10	1-1/4	1-5/8 -12UNJ -3B	1	5/8	7/8 -14UNJF-3A	1.875	2- 1/4
16-12				3/4	1-1/16-12UNJ -3A		2-21/64
20- 8				1	1-5/16-12UNJ -3A		2-19/64
20-10							
20-12							
20-16							

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P.A. AIR FORCE-82 (H)	TITLE	MILITARY STANDARD
Other Cast AIR FORCE-99 NAVY- AS	ADAPTER, STRAIGHT, TUBE TO BOSS, PRECISION TYPE	MS 24398
PROCUREMENT SPECIFICATION MIL-F-5509	SUPERSEDES: <del>AN-994</del>	SHEET 2 OF 2

DD FORM 672-1 Limited  
Coordination

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

APPROVED 14 FEB 87 REVISED (H) FOR CHANGES SEE PAGES 1 &amp; 2.

4730-8008