

User activities:

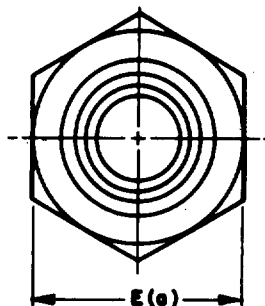
Review activities: ARMY-ME, AV

NAVY-A-S

DLA-CS

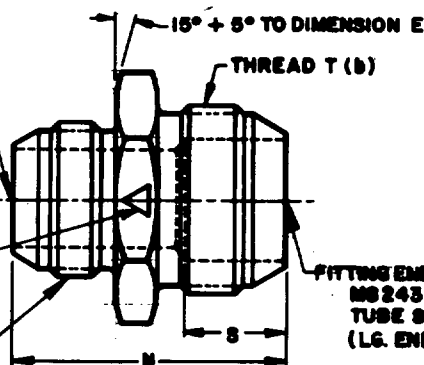
This Military Standard is approved for use by HQ AFLC CASO/LODS, Federal Center, Battle Creek, MI 49016, Department of the Air Force, and is available for use by all Departments and agencies of the Department of Defense.

FITTING END IN ACCORDANCE WITH MS 24385, STYLE E, FOR TUBE SIZE SPECIFIED (SM. END)



IDENTIFY PER MS24385

THREAD R (b)



FITTING END IN ACCORDANCE WITH MS24385, STYLE E, FOR TUBE SIZE SPECIFIED. (LG. END)

FED. SUP CLASS 4730

- (a) TOLERANCES ON HEX DIMENSIONS SHALL BE IN ACCORDANCE WITH MS24385.
 (b) PITCH DIAMETERS OF THREAD T AND THREAD R SHALL BE CONCENTRIC WITHIN .003 TOTAL INDICATOR READING.
- 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 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.
 ADD W IN PLACE OF DASH FOR 7075-T73 ALUMINUM ALLOY.
 TITANIUM IS NOT RECOMMENDED FOR USE IN OXYGEN SYSTEMS.
- EXAMPLE OF PART NUMBERS:
 MS24399-10 - REDUCER, 1/2 TO 3/16 TUBING STEEL.
 MS24399D10 - REDUCER, 1/2 TO 3/16 TUBING, ALUMINUM ALLOY - (EXCEPT 7075-T73).
 MS24399J10 - REDUCER, 1/2 TO 3/16 TUBING, CRES, TYPE 304.
 MS24399K10 - REDUCER, 1/2 TO 3/16 TUBING, CRES, TYPE 316.
 MS24399S10 - REDUCER, 1/2 TO 3/16 TUBING, CRES, TYPE 347.
 MS24399T10 - REDUCER, 1/2 TO 3/16 TUBING, TITANIUM ALLOY.
 MS24399W10 - REDUCER, 1/2 TO 3/16 TUBING, 7075-T73 ALUMINUM ALLOY.
- IN ADDITION TO THE SAMPLING REQUIREMENTS OF THE PROCUREMENT SPECIFICATION, THE SURFACE OF CONE ENDS ON 100% OF THE REDUCERS OF A LOT SHALL BE INSPECTED.
 BREAK ALL SHARP EDGES AND REMOVE ALL HANGING BURRS AND SLIVERS.
 DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: FRACTIONS $\pm 1/64$, DECIMALS $\pm .005$, ANGLES $\pm 1/2^\circ$.
 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.

(F) CERTAIN PROVISIONS OF THIS STANDARD ARE SUBJECT OF INTERNATIONAL STANDARDIZATION AGREEMENT STANAG 3323. WHEN REVISION OR CANCELLATION OF THIS STANDARD IS PROPOSED, THE DEPARTMENTAL CUSTODIANS WILL INFORM THEIR RESPECTIVE DEPARTMENTAL STANDARDIZATION OFFICES SO THAT APPROPRIATE ACTION MAY BE TAKEN RESPECTING THE INTERNATIONAL AGREEMENT CONCERNED.

APPROVED 14 FEB 57 REVISED (A) 13 FEB 58 (B) 10 FEB 67 (C) 16 JUN 78 (D) 22 MAR 79 (E) 10 APR 82 (F) 20 JUL 84

P.A. AIR FORCE- 82 Other Cust	TITLE	MILITARY STANDARD
AIR FORCE- 99	REDUCER, TUBE, PRECISION TYPE	MS24399
PROCUREMENT SPECIFICATION MIL-F-5509	SUPERSEDES:	SHEET 1 OF 2

DD FORM 672-1 Limited Coordination

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

PROJECT NO. 4730-F610

27 Jul 84

FED. SUP CLASS
4730

DASH NO.	LARGE END		SMALL END		E	N	S
	TUBING OD	THREAD T (REF)	TUBING OD	THREAD R (REF)			
1	3/16	3/8 -24UNJF-3A	1/8	5/16-24UNJF-3A	.625	1-11/64	5/8
2	1/4	7/16-20UNJF-3A			3/16	3/8 -24UNJF-3A	.688
3			1- 9/32	37/64			
4	5/16	1/2 -20UNJF-3A	1/4	7/16-20UNJF-3A	.750	1-23/64	39/64
5	3/8	9/16-18UNJF-3A	1/8	5/16-24UNJF-3A	.813	1-19/64	5/8
6			3/16	3/8 -24UNJF-3A		1-21/64	
7			1/4	7/16-20UNJF-3A		1-13/32	
8			5/16	1/2 -20UNJF-3A			
9	1/2	3/4 -16UNJF-3A	1/8	5/16-24UNJF-3A	1.000	1-27/64	23/32
10			3/16	3/8 -24UNJF-3A		1-29/64	
11			1/4	7/16-20UNJF-3A		1-17/32	
12			5/16	1/2 -20UNJF-3A			
13			3/8	9/16-18UNJF-3A			
14	5/8	7/8 -14UNJF-3A	1/4	7/16-20UNJF-3A	1.125	1-21/32	51/64
15			3/8	9/16-18UNJF-3A		1- 3/4	
16			1/2	3/4 -16UNJF-3A			
17	3/4	1-1/16-12UNJ -3A	1/4	7/16-20UNJF-3A	1.375	1-51/64	57/64
18			5/16	1/2 -20UNJF-3A		1-57/64	
19			3/8	9/16-18UNJF-3A			
20			1/2	3/4 -16UNJF-3A			
21			5/8	7/8 -14UNJF-3A		2	
22	1	1-5/16-12UNJ -3A	1/4	7/16-20UNJF-3A	1.625	1-27/32	-
23			5/8	7/8 -14UNJF-3A		2- 3/64	
24			3/4	1-1/16-12UNJ -3A		2- 5/32	
25	1-1/4	1-5/8 -12UNJ -3A	1/4	7/16-20UNJF-3A	1.875	1-57/64	55/64
26			3/4	1-1/16-12UNJ -3A		2- 1/4	
27			1	1-5/16-12UNJ -3A			
28	1-1/2	1-7/8 -12UNJ -3A	1	1-5/16-12UNJ -3A	2.125	2-23/64	29/32
29						1-1/4	
30	1	1-5/16-12UNJ -3A	1/2	3/4 -16UNJF-3A	1.625	2- 5/32	57/64

User activities:

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

This Military Standard is approved for use by HQ AFLC, CASO/LODS, Federal Center, Battle Creek, MI. 49016, Department of the Air Force, and is available for use by all Departments and agencies of the Department of Defense.

P.A. AIR FORCE-82
Other Cust

AIR FORCE-99

TITLE

REDUCER, TUBE, PRECISION TYPE

MILITARY STANDARD

MS 24399

PROCUREMENT SPECIFICATION
MIL-F-5509

SUPERSEDES:

SHEET 2 OF 2

DD FORM 672-1 Limited
Coordination

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

PROJECT NO. 4730-F610

APPROVED 12 FEB 57 REVISED (F) FOR CHANGES SEE PAGE 1