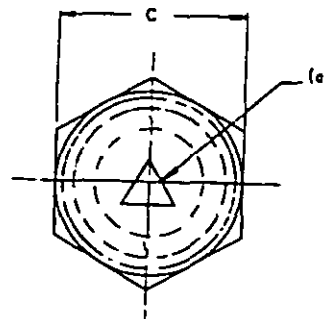
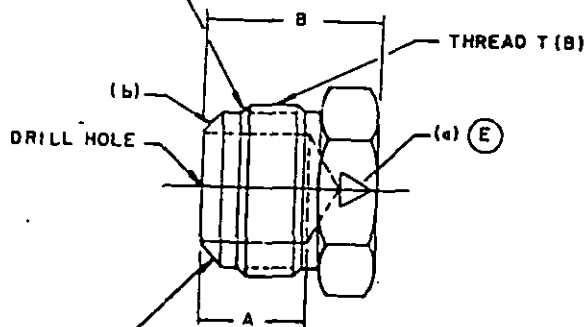


FED. SUP CLASS
4730FITTING END IAW MS 33656
STYLE E, FOR SIZE TUBE SPECIFIED.

THIS SURFACE SHALL BE A SMOOTH CONICAL SURFACE, FREE FROM LONGITUDINAL AND SPIRAL TOOL MARKS AND VISIBLE FLAT SPOTS. ANNULAR TOOL MARKS WILL BE ALLOWED TO 32. SEE ANSI B46.1

- (E) (a) MARK WITH AN EQUILATERAL TRIANGLE ON HEX FACE OR ON TWO OPPOSITE HEX FLATS PER MS24385 TO DENOTE PRECISION TYPE. MARKING SHALL BE DEPRESSED .025 ± .010.
- (b) CONICAL SURFACE AND THREAD T (PITCH DIA) SHALL BE CONCENTRIC WITHIN .005 TOTAL INDICATOR READING.
- MATERIAL: STEEL, ALUMINUM ALLOY: BARS, OR RODS. 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 U IN PLACE OF DASH FOR 7075-T73 ALUMINUM ALLOY.
- TITANIUM IS NOT RECOMMENDED FOR USE IN OXYGEN SYSTEMS.
- EXAMPLE OF PART NUMBERS:
- MS24404-B - PLUG, 1/2 TUBING, STEEL.
- MS24404DB - PLUG, 1/2 TUBING, ALUMINUM ALLOY (EXCEPT 7075-T73).
- MS24404JB - PLUG, 1/2 TUBING, CRES, TYPE 304.
- MS24404KB - PLUG, 1/2 TUBING, CRES, TYPE 316.
- MS24404SB - PLUG, 1/2 TUBING, CRES, TYPE 347.
- MS24404TB - PLUG, 1/2 TUBING, TITANIUM ALLOY.
- MS24404UB - PLUG, 1/2 TUBING, 7075-T73 ALUMINUM ALLOY.
- BREAK ALL SHARP EDGES AND REMOVE ALL HANGING BURRS AND SLOVERS.
- 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 PLUGS 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.

(E) DENOTES CHANGES

P. AIRFORCE 82 Other Code AIR FORCE 99	INTERNATIONAL INTEREST (E)	TITLE PLUG, TUBE, PRECISION TYPE	MILITARY STANDARD MS 24404
PROCUREMENT SPECIFICATION MIL - F - 5509	SUPERSEDES:	SHEET 1 OF 2	

DD FORM 1, 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

USER ACTIVITIES:

ACTIVITIES ARMY-ME, AV
NAVY-AS
DLA-CS

RE

military standard is approved for use by all Departments and Agencies of the Department of Defense
action for all new engineering and design applications and for repetitive use shall be made from this document

APPROVED 6 MAR 58 REVISED (A) 10 FEB 67 (B) 16 JUN 78 (C) 22 MAR 79 (D) 16 APR 82 (E) 22 JUN 82

FED. SUP CLASS
4730

USER ACTIVITIES.

REVIEWER ACTIVITIES ARMY-ME, AV
NAVY-AS
DLA-CSThis military standard is approved for use by all Departments and Agencies of the Department of Defense
Subject for all new engineering and design applications and for repetitive use shall be made from this
document

DASH NO.	TUBING OD	THREAD T (REF)	A	B	C	
2	1/8	5/16-24UNJF-3A	15/32	51/64	.438	+.003 -.004
3	3/16	3/8-24UNJF-3A		53/64		
4	1/4	7/16-20UNJF-3A	17/32	67/64	.500	
5	5/16	1/2-20UNJF-3A		69/64		
6	3/8	9/16-18UNJF-3A	9/16	13/16	.563	+.004
8	1/2	3/4-16UNJF-3A	5/8	15/16	.750	
10	5/8	7/8-14UNJF-3A	69/64	1- 7/64	.875	
12	3/4	1-1/16-12UNJ -3A	13/16	1-13/64	1.125	
16	1	1-5/16-12UNJ -3A		1- 9/32	1.375	+.005
20	1-1/4	1-5/8-12UNJ -3A	3/4	1-23/64	1.688	+.016
24	1-1/2	1-7/8-12UNJ -3A	13/16	1-31/64	2.000	
28	1-3/4	2-1/4-12UNJ -3A	25/32	1-39/64	2.375	+.020
32	2	2-1/2-12UNJ -3A	53/64	1-47/64	2.625	

APPROVED 6 MAR 58 REVISED (E) FOR CHANGES SEE PAGES 1 & 2. 16 APR 82

P. A. AIR FORCE 82	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
Order Cost		PLUG, TUBE, PRECISION TYPE	MS 24404
AIR FORCE 99			
PROCUREMENT SPECIFICATION	SUPERSEDES:	SHEET 2	OF 2
MIL-F-5509			