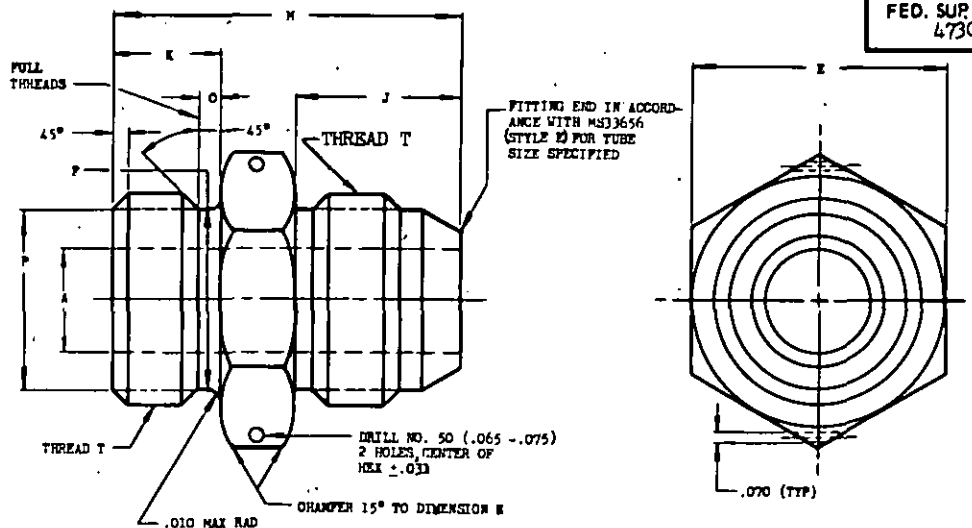


User Activities: Army-ME,AV
Navy-AS
Air Force-99

Review activities: Army-ME,AV
Navy-AS
Air Force-99
DLA-CS

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CONCENTRICITY: P AND T (PITCH DIAMETER) SHALL BE CONCENTRIC WITHIN .005 TOTAL INDICATOR READING. SQUARENESS BETWEEN THREAD T AND FACE OF HEX SHALL NOT EXCEED .005 WHEN MEASURED AT DIAMETER E.

MATERIAL: STEEL, ALUMINUM ALLOY; BARS OR SHAPES. TITANIUM ALLOY; BARS, SHAPES, OR FORGINGS.

SEE PROCUREMENT SPECIFICATION.

FINISH: SEE PROCUREMENT SPECIFICATION.

ADD L TO PART NUMBER TO INDICATE NIPPLE WITH LOCKWIRE HOLES.

NO CODE LETTER IN PART NUMBER FOR STEEL.

- Ⓒ ADD D IN PLACE OF DASH FOR ALUMINUM ALLOY (EXCEPT 7075-T73).
- ADD T IN PLACE OF DASH FOR TITANIUM ALLOY. TITANIUM IS NOT RECOMMENDED FOR USE IN OXYGEN SYSTEMS.
- Ⓒ ADD W IN PLACE OF DASH FOR 7075-T73 ALUMINUM ALLOY.

EXAMPLE OF PART NUMBERS:

- MS24487-4 - NIPPLE, 1/4 TUBING, STEEL, WITHOUT LOCKWIRE HOLES.
 - Ⓒ MS24487DL - NIPPLE, 1/4 TUBING, ALUMINUM ALLOY (EXCEPT 7075-T73), WITH LOCKWIRE HOLES.
 - MS24487TBL - NIPPLE, 1/2 TUBING, TITANIUM ALLOY, WITH LOCKWIRE HOLES.
 - Ⓒ MS24487WBL - NIPPLE, 1/2 TUBING, 7075-T73 ALUMINUM ALLOY, WITH LOCKWIRE HOLES.
- BREAK ALL SHARP EDGES AND REMOVE ALL HANGING BURRS AND SLIVERS WHICH MIGHT BECOME DISLODGED UNDER USAGE.

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.

Ⓒ denotes changes

P.A. Air Force-99 Other Cust	International Interest	TITLE NIPPLE, TUBE, 37° TO 45° SEAT	MILITARY STANDARD
Procurement Specification MIL-F-5509	SUPERSEDES:	MS24487 PAGE 1 OF 2	

DD FORM 672 (Coordinated) PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

4730-1013

APPROVED 11 APR 58 REVISED (A) 10 FEB 67 (B) 16 JUN 78 (C) 22 MAR 79

FED. SUP. CLASS
4730User Activities: Army-ME, AV
Navy-AS
Air Force-99
DLA-CSReview activities: Army-ME, AV
Navy-AS
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DLA-CS

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DASH NO.	TUBING OD	THREAD T (REF)	A DIA (REF)	E (REF)	F +.002 -.003 DIA	J (REF)	K	M	O +.015 -.000	P DIA	WEIGHT MAX (LBS.)		
											STEEL	ALLOY	TI CRES ALLOY
2	1/8	5/16-24UNJF-3A	.062	.563	.250	.448	5/16	63/64	.063	7/32			
3	3/16	3/8-24UNJF-3A	.125	.625	.312	.479	21/64	1-1/32		9/32			
4	1/4	7/16-20UNJF-3A	.172	.688	.364	.550	3/8	1-7/32	.075	11/32			
5	5/16	1/2-20UNJF-3A	.234	.750	.426	.556	27/64	1-5/16	.083	13/32			
6	3/8	9/16-18UNJF-3A	.297	.813	.481	.657	15/32	1-1/2	.094	5/8			
8	1/2	3/4-16UNJF-3A	.391	1.000	.660	.758	17/32	1-13/64	.107	3/4			
10	5/8	7/8-14UNJF-3A	.484	1.125	.773	.864	19/32	1-29/32	.125	15/16			
12	3/4	1-1/16-12UNJF-3A	.609	1.375	.945	.911		1-61/64					
16	1	1-5/16-12UNJF-3A	.844	1.825	1.195								

P.A. Air Force-99 Other Cust	International Interest	TITLE NIPPLE, TUBE, 37° TO 45° SEAT	MILITARY STANDARD MS 24487
Procurement Specification MIL-F-5509	SUPERSEDES:		PAGE 2 OF 2

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4730-1013

APPROVED 11 APR 58 REVISED For changes see page 1. 22 MAR 79