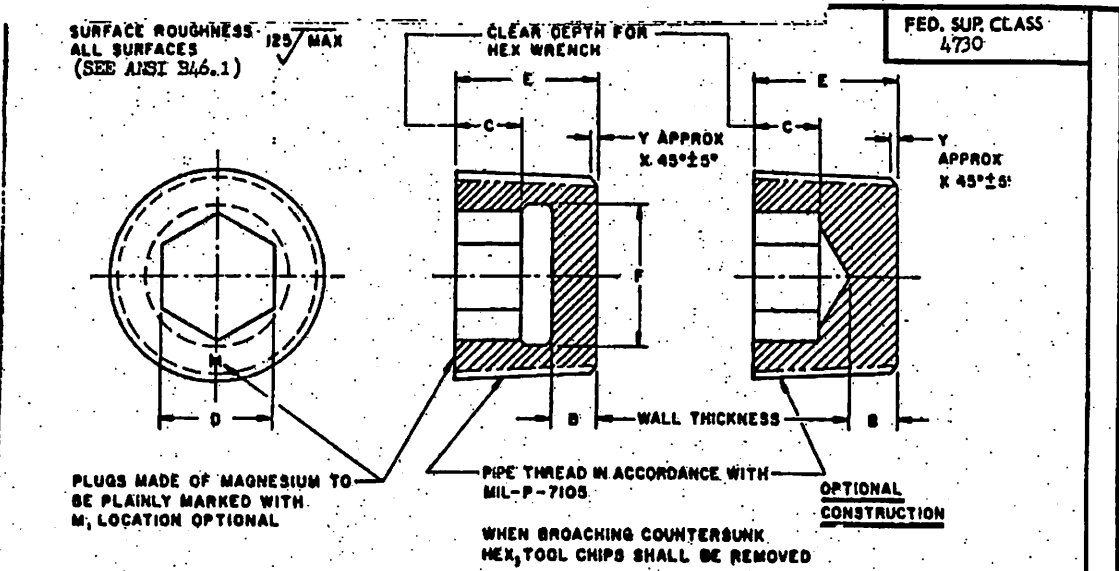


This standard is approved for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document when applicable.  
 Review activities: Army - ME, AV; Navy - A3; Air Force - 99; DLA-CS  
 Direct activities: Army - ME, AV; Navy - A3; Air Force - 99



MATERIAL: STEEL; BARS, RODS, OR FORGINGS; MIL-S-5626; HARDEN (OIL QUENCH) AND TEMPER, ROCKWELL HARDNESS C26-32.

(A) ALUMINUM ALLOY; BARS; AMS4121 (2014-T6) or QQ-A-225/9 (7075-T73), FORGINGS; QQ-A-367 (7075-T73); COPPER ALLOY; BARS, RODS, OR FORGINGS; SEE PROCUREMENT SPECIFICATION.

MAGNESIUM ALLOY; BARS, SHAPES, OR RODS; QQ-M-31.

CORROSION RESISTANT STEEL (CRES); BARS, SHAPES, OR FORGINGS; QQ-S-763 (TYPE 347).

TITANIUM ALLOY; SEE PROCUREMENT SPECIFICATION.

TITANIUM IS NOT RECOMMENDED FOR USE IN OXYGEN SYSTEMS.

FINISH: STEEL, ALUMINUM ALLOY, COPPER ALLOY, CRES, TITANIUM ALLOY; SEE PROCUREMENT SPECIFICATION. MAGNESIUM ALLOY; MIL-M-3171, TYPE III.

NO CODE LETTER IN PART NUMBER FOR PLATED STEEL.

ADD U IN PLACE OF DASH FOR UNPLATED STEEL.

(A) ADD D IN PLACE OF DASH FOR 2014-T6 ALUMINUM ALLOY. (A) ADD W IN PLACE OF DASH FOR 7075-T73 ALUMINUM ALLOY.

ADD C IN PLACE OF DASH FOR COPPER ALLOY.

ADD M IN PLACE OF DASH FOR MAGNESIUM ALLOY.

ADD S IN PLACE OF DASH FOR CRES.

ADD T IN PLACE OF DASH FOR TITANIUM ALLOY.

- EXAMPLE OF PART NUMBERS:
- MS27769-2 - PLUG, 1/8 ANPT, PLATED STEEL.
  - MS27769U2 - PLUG, 1/8 ANPT, UNPLATED STEEL.
  - (A) MS27769D2 - PLUG, 1/8 ANPT, 2014-T6 ALUMINUM ALLOY.
  - MS27769C2 - PLUG, 1/8 ANPT, COPPER ALLOY.
  - MS27769M2 - PLUG, 1/8 ANPT, MAGNESIUM ALLOY.
  - MS27769S2 - PLUG, 1/8 ANPT, CRES.
  - MS27769T2 - PLUG, 1/8 ANPT, TITANIUM ALLOY.
  - (A) MS27769W2 - PLUG, 1/8 ANPT, 7075-T73 ALUMINUM ALLOY.

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

PLUGS TO BE USED AS PERMANENT INSTALLATION ONLY.

MAGNESIUM ALLOY PLUGS SHALL NOT BE USED IN HYDRAULIC SYSTEMS OR HYDRAULIC VALVES.

DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCE: DECIMALS ±.010.

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.

(A) denotes changes

P.A. Air Force-99 Other Cust Navy-A3	International Interests	TITLE	MILITARY STANDARD
		PLUG, PIPE, COUNTERSINK HEX HEAD	MS27769
Procurement Specification MIL-F-5509	SUPERSEDES:	AN932	PAGE 1 OF 2

APPROVED 13 Apr 79 REVISED (A) 30 Apr 79

FED. SUP. CLASS  
4730

APPROVED 13 Apr 79 REVISED (A) For changes see page 1. 30 Apr 79

DASH NO.	PIPE	THREAD	ANPT	Pipe	B MIN	C MIN	D MIN	E MAX	F MAX	X	WEIGHT MAX (LBS.)	STEEL	AL	COPPER	MAGNESIUM	ALLOY	ALLOY	CRES	ALLOY		
1	1/16	1/8		.094	.125	.1875	.1895	.270	.187												
2	1/8			.219	.2500	.3125	.3155	.410	.326												
3	1/4			.312	.3750	.3780	.540	.463	.400												
4	3/8			.438	.6250	.6290	.5655	.550	.681												
5	1/2			.453	.7500	.7540	.710	1.072	.080												
6	3/4																				
7	1																				
8	1-1/4																				

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Review activities: Army - ME, AV  
Navy - AS  
Air Force - 99  
DIA - OS

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

P.A.  
Air Force-99  
Other Cust  
Navy-AS

International Interest

TITLE

PLUG, PIPE, COUNTERSINK HEX HEAD

MILITARY STANDARD

MS27769

SUPERSEDES: AN932

Procurement Specification  
MIL-P-5509

DD FORM 1 MAY 73 672 (Continued)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

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