

Project No. 4730-0273

FED. SUP CLASS
4730

USED BY:
NAVY - 06
ARMY - 06
AF - 06
Navy - 06
AF - 06
ARMY - 06
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Navy - 06
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THREAD RELIEF 3 MAX
FULL THREADS TO THIS POINT

SEE DETAIL AA

24°

12°

Y DIA CHAMFER

45° ±5°

45° ±5°

SEE DETAIL BB

.010 RAD

.005

.030 RAD

.015

.015 RAD TYP FOR THREAD RUNOUT

.005

THREAD 1, MIL-G-6829
BOTH THREADED SECTIONS TO BE CONTINUATION OF SAME THREAD LEAD

SEE DETAIL AA

SEE DETAIL BB

CHAMFER RELIEF TO HEX PLATE SHALL BE WITHIN THE 15° ±5° ANGLE AND R DIA LIMITATION

THIS SURFACE SHALL BE SMOOTH AND FREE FROM TOOL MARKS, EXCEPT THAT ANNULAR TOOL MARKS WILL BE ALLOWED TO 100 MICROINCHES RHN MAX

THIS SURFACE SHALL BE SMOOTH AND FREE FROM TOOL MARKS, EXCEPT THAT ANNULAR TOOL MARKS WILL BE ALLOWED TO 63 MICROINCHES RHN MAX

DETAIL AA ENLARGED
GAGING DIMENSIONS FOR CAVITIES

DETAIL BB ENLARGED

1. CONCENTRICITY: D, C, AND Y (PITCH DIA) SHALL BE CONCENTRIC TO EACH OTHER WITHIN .006 TOTAL INDICATOR READING NO. F AND T (PITCH DIA) SHALL BE CONCENTRIC TO EACH OTHER WITHIN .005 TOTAL INDICATOR READING NO.

2. THREAD AND FACE OF HEX SHALL BE SQUARE WITHIN W WHEN MEASURED AT DIAMETER E.

3. REMOVE ALL BURRS, SLIVERS AND SHARP EDGES.

4. SURFACE TEXTURE IN ACCORDANCE WITH AMS 49.1 - 1962.

5. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS ±.010, ANGLES ±1/2°.

6. ON STYLE S FITTING END, THE L DIMENSION PROVIDES FOR A WASHER TO FORM BACKING PAGE AGAINST BULKHEAD, AND A .031 INCH LAND FOR POSITIONING IN BULKHEAD. ON STYLE E FITTING END NO WASHER IS REQUIRED.

7. EXAMPLE OF DESIGN IDENTIFICATION NUMBER: MS33515

SIZE OF FITTING END IN 16 THS
E - STYLE E
S - STYLE S
BASIC DESIGN NUMBER

* CERTAIN PROVISIONS (SCREW THREADS, HEXAGON SIZE AND UNDERCUT DIMENSIONS) OF THIS STANDARD ARE THE SUBJECT OF INTERNATIONAL STANDARDIZATION AGREEMENT ASAC AIR STD 17/15. WHEN REVISION OR CANCELLATION OF THIS STANDARD IS IMPROVED WHICH WILL AFFECT OR VIOLATE THE INTERNATIONAL AGREEMENT CONCERNED, THE PREPARING ACTIVITY WILL TAKE APPROPRIATE RECONCILIATION ACTION THROUGH INTERNATIONAL STANDARDIZATION CHANNELS, INCLUDING DEPARTMENTAL STANDARDIZATION OFFICES, IF REQUIRED.

FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN. REFERENCED DOCUMENTS SHALL REMAIN IN EFFECT IN DATE OF INVITATION FOR BID. THIS IS A DESIGN STANDARD. NOT TO BE USED AS A PART NUMBER.

FOR CHANGES SEE SHEETS 1 & 2

NAVY - 06 Other Code	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
USAF - 06		FITTING END, STANDARD DIMENSIONS FOR BULKHEAD FLARELESS TUBE CONNECTIONS	MS33515
ARMY - 06			
PROCUREMENT SPECIFICATION	EXPERIMENTAL		

DD FORM 1, 672-1 (Coordinated)

Previous Editions of this Form are Obsolete

APPROVED 1 Oct 53 REVISED 1 23 JAN 73

RECEIVED J. P. M. C. 1964