

User activities
Navy CG MCReview activities
Army AT ME
Air Force 82
DLA CS

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FED SUP CLASS
4730

DETAIL A

THRU THREAD DESIGN
REFERENCE CLEARANCE ENVELOPE SEE NOTE 8

BLIND TAP DESIGN

MIN DIA FOR UNRESTRICTED FLOW OF FLUID MAY BE ANY SIZE OR SHAPE PROVIDED CLEARANCE IS MAINTAINED TO J DEPTH FOR FITTING

PD MUST BE SQUARE WITH SURF K WITHIN N FIR ACROSS G DIA MIN

PD MUST BE CONCENTRIC WITH G DIA WITHIN .030 FIR AND WITH D DIA WITHIN .005 FIR (FULL INDICATOR RATING)

G DIA REF (NOTE 4)

POINT OF TANGENCY
RADIUS OR EDGE BREAK

RAISED SURFACE

G DIA REF (NOTE 4)

RECESSED SURFACE

TYPICAL CONTOURS SURROUNDING MACHINED PORT

A DASH NUMBER	TUBE OD MIN	THREAD 1 PER MIL-S-8879	A DIA +.015 -.000	B MIN SEE NOTE 7	C DIA	D DIA +.005 -.000	E +.015 -.000	G DIA MIN	J MIN A	N	
01		.2500 28 UNJF 3B	.359	.330	.062	.264		.478	.402	.002	
02	.125	.3125 24 UNJF 3B	.438	.482		.328	.063	.602	.577	.003	
03	.188	.3750 24 UNJF 3B	.500	.538	.125	.390		.665	.583		
04	.250	.4375 20 UNJF 3B	.562	.568	.172	.454	.075	.728	.656		
05	.312	.5000 20 UNJF 3B	.625		.234	.517		.790		.004	
06	.375	.5625 18 UNJF 3B	.688	.598	.297	.580	.083	.852	.709		
07	.438	.6250 18 UNJF 3B	.750	.614	.360	.643	.094	.915	.725		
08	.500	.7500 16 UNJF 3B	.875	.714	.391	.769		1.040	.834	.005	
09	.562	.8125 16 UNJ 3B	.938	.730	.436	.832	.107	1.102	.850		
10	.625	.8750 14 UNJF 3B	1.000	.802	.484	.896		1.165	.930		
11	.688	1.0000 12 UNJF 3B	1.156	.877	.547	1.023	.125	1.352	1.064	.008	
12	.750	1.0625 12 UNJ 3B	1.234		.609	1.086		1.415			
14	.875	1.1875 12 UNJ 3B	1.362		.734	1.211		1.540			
16	1.000	1.3125 12 UNJ 3B	1.487		.844	1.336		1.665	1.116		
18	1.125	1.5000 12 UNJF 3B	1.675		.953	1.524		1.790			
20	1.250	1.6250 12 UNJ 3B	1.800		1.078	1.648		1.978			
24	1.500	1.8750 12 UNJ 3B	2.050		1.312	1.898		2.228	1.127	.010	
28	1.750	2.2500 12 UNJ 3B	2.425		1.547	2.273		2.602	1.243		
32	2.000	2.5000 12 UNJ 3B	2.675	.907	1.781	2.524		2.852	1.368		

- DIMENSIONS IN INCHES
- SURFACE TEXTURE ANSI B46.1 1978
- REMOVE ALL BURRS AND SLIVERS AND BREAK SHARP EDGES
- MINIMUM DIAMETER FLAT SURFACE CLEARANCE PROVISIONS FOR FITTING WRENCH FITTING INSTALLATION AND TOOL FILLET RADIUS MUST BE ADDED AS REQUIRED. G MIN DIAMETER MAY BE REDUCED BY .040 WHEN IT DEFINES THE LIMITS OF A RAISED SURFACE AND WHEN STRENGTH REQUIREMENTS PERMIT
- CERTAIN PROVISIONS OF THIS STANDARD ARE THE SUBJECT OF INTERNATIONAL STANDARDIZATION AGREEMENT ASCAIR STD 17718 WHEN REVISION OR CANCELLATION OF THIS STANDARD IS PROPOSED. THE DEPARTMENTAL CUSTODIANS WILL INFORM THEIR RESPECTIVE STANDARDIZATION OFFICE SO THAT APPROPRIATE ACTION MAY BE TAKEN RESPECTING THE INTERNATIONAL AGREEMENT CONCERNED
- THRU THREAD DESIGN SHALL HAVE SUFFICIENT THREADS TO MEET STRENGTH REQUIREMENTS OF MATERIAL USED
- B MIN IS THE FULL THREAD DEPTH REQUIREMENT FOR BLIND TAP DESIGN
- REFERENCE CLEARANCE ENVELOPE PROVIDES MINIMUM CLEARANCE FOR THE LONGEST STANDARD FITTING

THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES
BY THE SAE AEROSPACE PROPULSION DIVISION AND PART STANDARDS DIVISION

THIS IS A DESIGN STANDARD. NOT TO BE USED AS A PART NUMBER

PA Air Force 11 Other Cust Army AV Navy AS	INTERNATIONAL INTEREST	TITLE BOSS: FLUID CONNECTION INTERNAL STRAIGHT THREAD	MILITARY STANDARD MS 33649
PROCUREMENT SPECIFICATION NONE	SUPERSEDES	AND 1004 AND 10050	SHEET 1 OF 1

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