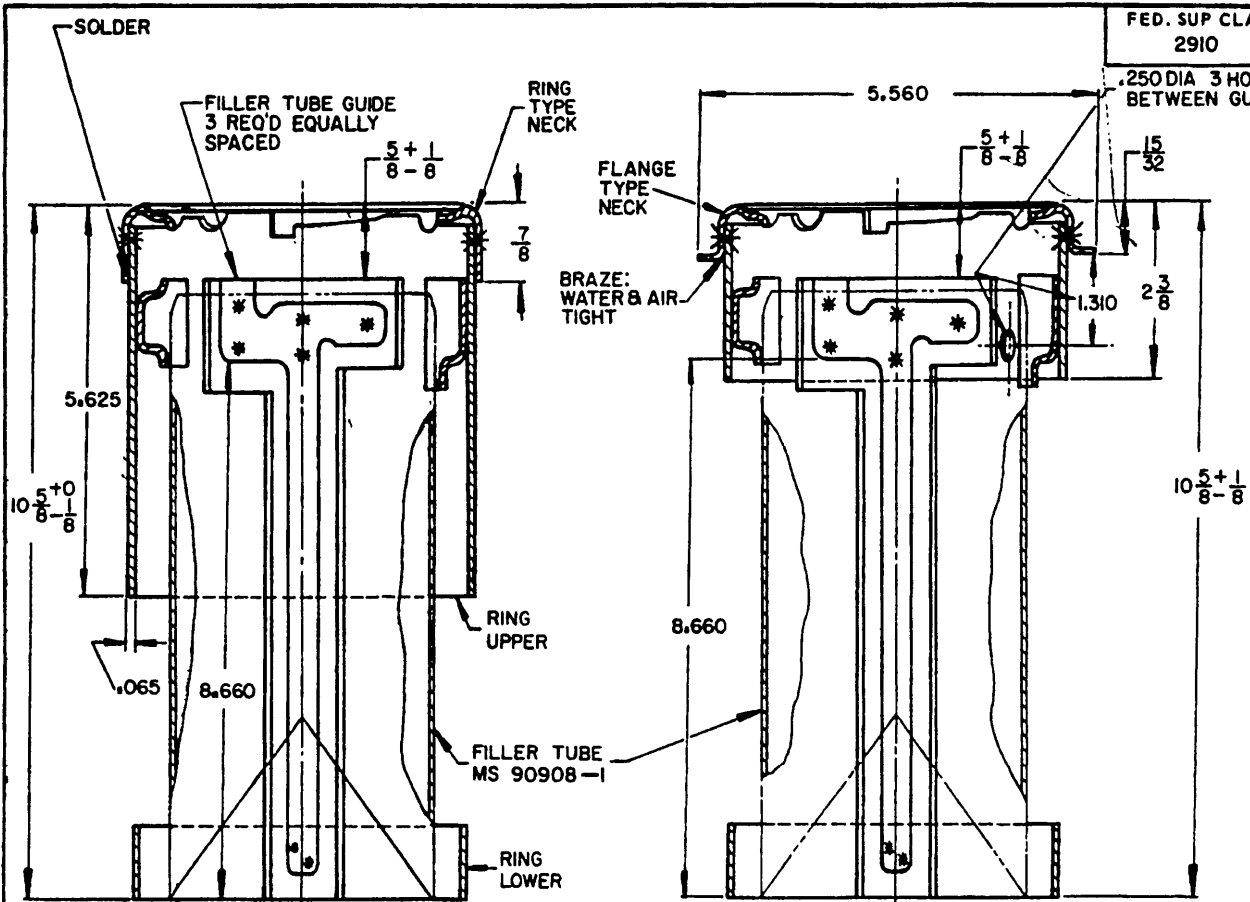
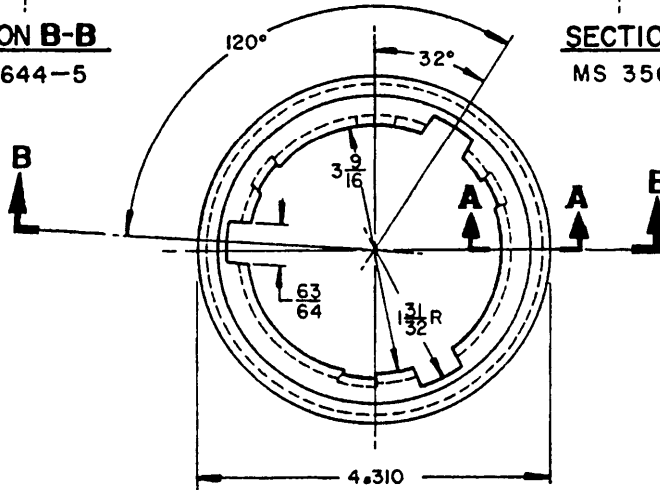


FED. SUP CLASS  
2910  
.250 DIA 3 HOLES  
BETWEEN GUIDES

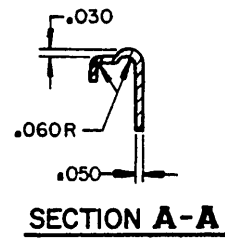


**SECTION B-B**  
MS 35644-5

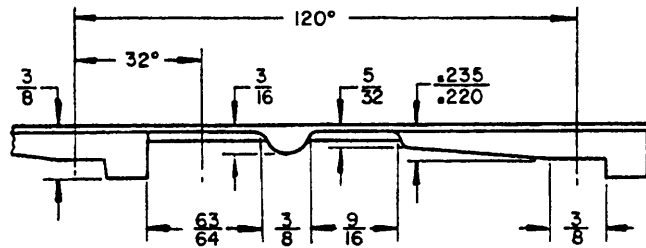
**SECTION B-B**  
MS 35644-1



**PLAN VIEW**



**SECTION A-A**



**CAM DEVELOPMENT**

(F) DENOTES CHANGE

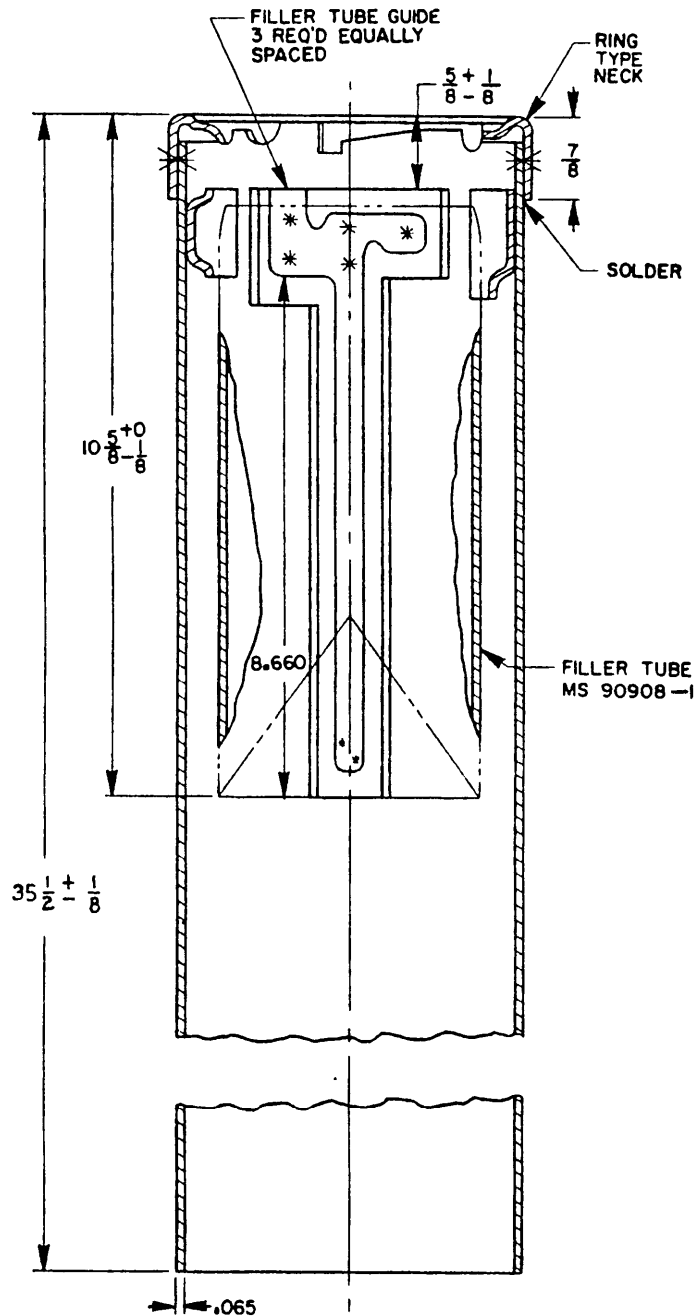
REVIEW ACTIVITIES: ARMY-ME; AF-82  
USER ACTIVITY: DLA-CS

AMSC N/A  
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P.A. ARMY-AT Other Cust AF-99	TITLE <b>FILLER NECK: FUEL TANK- MILITARY VEHICLES</b>	MILITARY STANDARD <b>MS35644</b>
PROCUREMENT SPECIFICATION NONE	SUPERSEDES: MS 35644-2 THRU 4 AND 6 THRU 8	SHEET 1 OF 3

APPROVED 17 AUGUST 1955 REVISED (A) 21 JANUARY 1959 (B) 7 JUNE 1963 (C) 22 FEBRUARY 1974 (D) 20 DEC 82 (E) 17 APR 84 (F) 25 NOV 86



**SECTION B-B**  
MS 35644-9

APPROVED 17 AUG 55 REVISED (F) FOR CHANGES SEE SHEET 3

P.A. ARMY - AT  
Other Cust  
AF-99

TITLE  
**FILLER NECK: FUEL TANK-  
MILITARY VEHICLES**

**MILITARY STANDARD**  
**MS 35644**

PROCUREMENT SPECIFICATION

SUPERSEDES: MS 35644-2 THRU 4 & 6 THRU 8

SHEET 2 OF 3

FED. SUP CLASS  
2910

MS PART N <sup>o</sup>	TYPE OF GUIDE	TYPE OF NECK
MS35644-1	OPEN	FLANGE
MS35644-5	OPEN	RING
MS35644-9	OPEN	RING

## REQUIREMENTS.

1. THIS NECK SHALL MATE WITH CAP, FUEL TANK-TACTICAL VEHICLE, FORDING SHOWN ON MS35645. SPECIFIED TEST DEPICTED IN PROCUREMENT SPECIFICATION REFERENCED THEREIN SHALL APPLY.
- (F) 2. MATERIAL: STEEL SHEET OR STRIP HOT ROLLED PICKLED AND OILED OR COLD ROLLED OILED, DRAWING QUALITY ASTM-A507, STEEL SHEET OR STRIP, CARBON, HOT ROLLED DRAWING QUALITY ASTM-A621; STEEL SHEET CARBON COLD ROLLED DRAWING QUALITY ASTM-A619, STEEL CARBON COLD ROLLED STRIP TEMPER 4 OR 5 ASTM-A109.
3. JOINT AT FILLER NECK AND UPPER RING SHALL BE AIR AND WATER TIGHT.
- (F) 4. WELD IN ACCORDANCE WITH MIL-STD-1261, CLASS 1; USE ELECTRODE MIL-70S-1 THRU 3 OF MIL-E-23765/1. SPOT WELDING SHALL BE IN ACCORDANCE WITH MIL-W-12332. SOLDER SHALL BE COMPOSITION SN 40 OR SN 50 OF QQ-S-571 AND SHALL BE IN ACCORDANCE WITH DOD-STD-1866, METHOD OPTIONAL. BRAZING SHALL CONFORM TO APPLICABLE METHOD OF MIL-B-7883.
5. PARTS SHALL BE FREE FROM BURRS AND SHARP EDGES.
- (F) 6. ALL PARTS SHALL BE PROTECTED WITH LEAD PLATING TYPE II, CLASS 2 OF MIL-L-13808 OR BY HOT DIP LEAD COATING, TYPE II OR TYPE III OF MIL-L-13762.
7. GUIDE SHALL PROPERLY POSITION AND SUPPORT FILLER TUBE MS90908-1 WITHOUT BINDING.

## NOTES:

1. FILLER TUBE MS90908-1 IS INCLUDED AS A PART OF FILLER NECK ASSEMBLY MS35644-1, -5 OR -9.
2. UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE  $\pm 1/64$  ON FRACTIONS,  $\pm .010$  ON DECIMALS,  $\pm 1^{\circ}$  ON ANGLES.
- (F) 3. REFERENCED GOVERNMENT DOCUMENTS OF THE ISSUE LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN.
- (F) 4. IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS STANDARD AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE.
5. THIS STANDARD IS NOT INTENDED TO LIMIT CONSTRUCTION TO FEATURES OTHER THAN AS SHOWN HEREON BY DIMENSIONS, NOTATIONS, OR REFERENCED DOCUMENTS.

APPROVED 17 AUGUST 1955 (F) FOR CHANGES SEE SHEET 3

P.A. ARMY - AT Other Cust AF-99	TITLE	FILLER NECK: FUEL TANK- MILITARY VEHICLES	MILITARY STANDARD MS35644
	PROCUREMENT SPECIFICATION NONE	SUPERSEDES MS 35644 -2 THRU 4 AND 6 THRU 8	SHEET 3 OF 3