

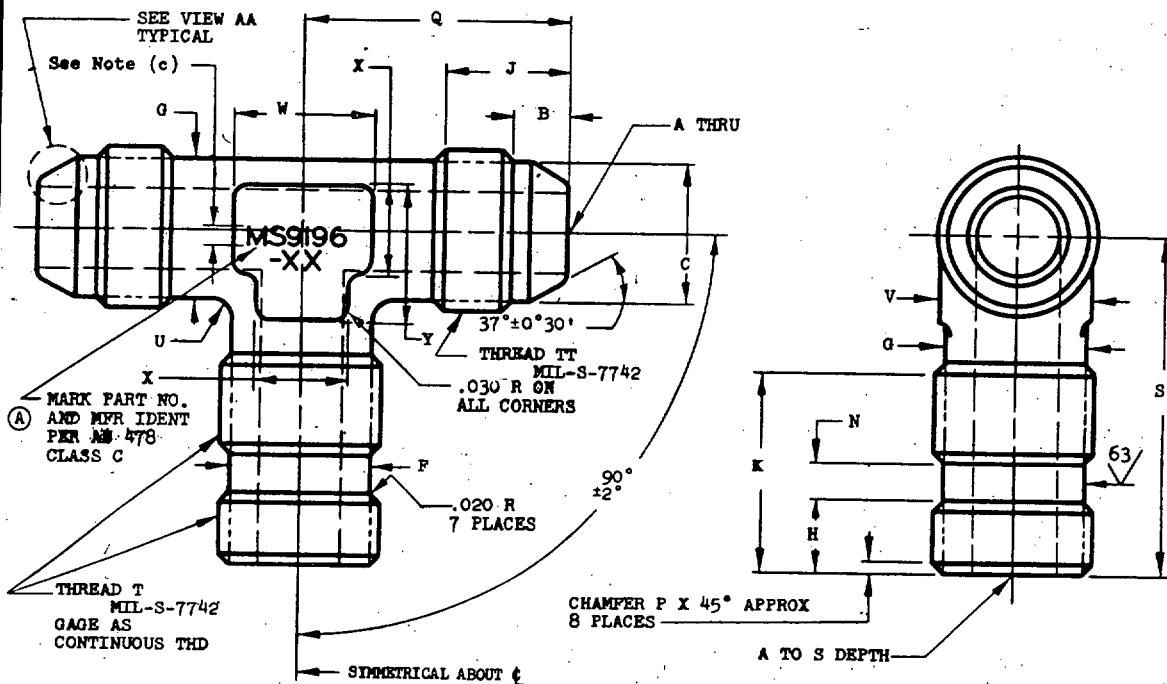
FED. SUP CLASS.
4730**MS9196(ASG)**THIS SURFACE SHALL BE CONCENTRIC
WITH THD PD WITHIN .005 FIR.

32° C NO FLAWS

BREAK EDGE
.005 MAX RAD

REMOVE BURRS

VIEW AA

SECTION THRU
THD PROFILE

- (a) DIAMETER F SHALL BE FREE OF THREAD MARKS.
 (b) DIAMETER F SHALL BE CONCENTRIC WITH PD OF THREAD WITHIN .0025 FIR.
 (c) .020-.040 FOR -.02, -.03, AND -.04 SIZES; .040-.060 FOR -.05 THRU -.16 SIZES; .090-.150 FOR -.18 AND LARGER SIZES.
 (d) ALL DIAMETERS SHALL BE CONCENTRIC WITHIN .010 FIR UNLESS OTHERWISE SPECIFIED.
 (e) PARTING LINE MISMATCH .015 MAX.
 (f) E MIN WALL THICKNESS BETWEEN FORGED SURFACE AND HOLE A.

THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE ENGINE AND PROPELLER UTILITY PARTS COMMITTEE OF THE SAE.

CUSTODIAN

USAF - AFSC
Navy - BuNepsPROCUREMENT SPECIFICATION
NONE**MILITARY STANDARD**

TEE, TUBE - AMS-5646, BOSS

MS9196(ASG)

SHEET 1 OF 2

NOTICE: When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility, nor any obligation whatsoever; and the fact that the Government may have furnished, furnished, or in any way supplied the said drawings, specifications, or other data is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

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MS9196(ASG)

CORROSION RESISTANT STEEL AMS 5646, FORGING.

CLEANING: FINISHED PARTS SHALL BE DECREASED AND IMMERSED FOR NOT LESS THAN 20 MINUTES IN A SOLUTION OF 1 VOLUME OF NITRIC ACID (SP GR 1.42) AND 9 VOLUMES OF WATER AT ROOM TEMPERATURE.

SURFACE ROUGHNESS: AS 291. UNLESS OTHERWISE SPECIFIED MACHINED SURFACES TO BE 125 MICROINCHES.

PARTS SUBJECT TO FLOURESCENT PENETRANT INSPECTION PER AMS 2645.

BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.

DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED: TOLERANCES; LINEAR DIMENSIONS ±.015.

DIMENSIONS TO SHARP CORNERS UNLESS OTHERWISE SPECIFIED.

DO NOT USE UNASSIGNED PART NUMBERS. AS & AMS ARE SAE PUBLICATIONS.

PART NO.	④ (f) E	NOM TUBE OD	THREAD T	SIZE	THREAD TT			A DIA	B +.015 -.000	C DIA +.000 -.010	D DIA ±.003	F DIA +.002 -.003 (a)(b)
					MAJOR DIA	PD	MINOR DIA MAX					
MS9196-02	.060	.125	.3125-24UNF-3A	.3125-24NS	.3023- 3028	.2797- 2824	.2584	.058-.065	.144	.245	.132	.250
MS9196-03	.060	.188	.375-24UNF-3A	.375-24NS	.3448- 3458	.3430- 3449	.3209	.121-.128	.144	.307	.195	.312
MS9196-04	.060	.250	.4375-20UNF-3A	.4375-20NS	.4264- 4269	.3989- 4020	.3732	.168-.175	.160	.359	.242	.364
MS9196-05	.060	.312	.500-20UNF-3A	.500-20NS	.4889- 4899	.4613- 4645	.4357	.230-.237	.160	.421	.304	.426
MS9196-06	.060	.375	.5625-18UNF-3A	.5625-18NS	.5508- 5518	.5200- 5234	.4913	.293-.301	.165	.476	.358	.481
MS9196-07	.060	.438	.625-18UNF-3A	.625-18NS	.6133- 6138	.5824- 5859	.5538	.355-.363	.165	.539	.430	.544
MS9196-08	.100	.500	.750-16UNF-3A	.750-16NS	.7376- 7376	.7026- 7064	.6703	.387-.395	.229	.654	.462	.660
MS9196-09	.100	.562	.8125-16UNF-3A	.8125-16NS	.8001- 8001	.7653- 7689	.7328	.434-.442	.229	.716	.509	.722
MS9196-10	.100	.625	.875-14UNF-3A	.875-14NS	.8617- 8617	.8215- 8256	.7844	.480-.488	.255	.767	.555	.773
MS9196-11	.130	.688	1.000-12UNF-3A	1.000-12NS	.9856- 9856	.9385- 9429	.8948	.542-.552	.304	.875	.619	.882
MS9196-12	.130	.750	1.0625-12UN-3A	1.0625-12NS	1.0481- 1.0481	1.0012- 1.0054	.9573	.604-.614	.304	.938	.681	.945
MS9196-13	.130	.875	1.1875-12UN-3A	1.1875-12NS	1.1731- 1.1731	1.1261- 1.1304	1.0823	.729-.739	.304	1.062	.806	1.070
MS9196-14	.130	1.000	1.3125-12UN-3A	1.3125-12NS	1.2981- 1.2981	1.2511- 1.2554	1.2073	.839-.851	.312	1.188	.918	1.195
MS9196-15	.130	1.125	1.500-12UNF-3A	1.500-12NS	1.4856- 1.4856	1.4381- 1.4429	1.3948	.948-.960	.312	1.375	1.027	1.382
MS9196-16	.175	1.250	1.625-12UN-3A	1.625-12NS	1.6106- 1.6106	1.5635- 1.5679	1.5198	1.073-1.086	.363	1.500	1.153	1.507
MS9196-17	.185	1.500	1.875-12UN-3A	1.875-12NS	1.8606- 1.8606	1.8134- 1.8179	1.7698	1.307-1.320	.374	1.750	1.387	1.756
MS9196-18	.225	1.750	2.250-12UN-3A	2.250-12NS	2.2356- 2.2356	2.1884- 2.1929	2.1448	1.542-1.557	.447	2.125	1.652	2.131
MS9196-19	.255	2.000	2.500-12UN-3A	2.500-12NS	2.4856- 2.4856	2.4429- 2.4383	2.3948	1.776-1.791	.457	2.375	1.886	2.381
MS9196-02	.240	.208	.317	.682	.020-.050	.707	1.000	.062	.400	.200	.300	.033
MS9196-03	.300	.208	.346	.682	.020-.050	.764	1.000	.062	.400	.220	.310	.047
MS9196-04	.350	.250	.398	.748	.030-.060	.826	1.115	.062	.500	.260	.360	.066
MS9196-05	.415	.250	.398	.748	.030-.060	.889	1.140	.062	.580	.300	.420	.085
MS9196-06	.470	.278	.398	.813	.040-.070	.998	1.270	.094	.650	.330	.490	.108
MS9196-07	.535	.278	.398	.813	.040-.070	.998	1.305	.094	.650	.330	.490	.124
MS9196-08	.650	.312	.489	.903	.040-.070	1.195	1.460	.094	.850	.430	.640	.239
MS9196-09	.710	.312	.489	.903	.050-.080	1.195	1.490	.094	.880	.440	.660	.272
MS9196-10	.765	.357	.585	1.018	.050-.080	1.411	1.680	.125	1.000	.500	.750	.361
MS9196-11	.870	.417	.663	1.122	.050-.080	1.614	1.855	.125	1.000	.500	.750	.528
MS9196-12	.935	.417	.663	1.122	.050-.080	1.614	1.855	.125	1.000	.500	.750	.569
MS9196-13	1.055	.417	.710	1.122	.050-.080	1.768	1.945	.125	1.000	.500	.750	.691
MS9196-14	1.185	.417	.720	1.122	.050-.080	1.778	2.010	.125	1.000	.500	.750	.811
MS9196-15	1.495	.417	.767	1.122	.050-.080	2.027	2.100	.125	1.200	.600	.900	1.207
MS9196-16	1.745	.417	.889	1.122	.050-.080	2.293	2.165	.125	1.625	.900	.900	1.347
MS9196-17	2.120	.417	1.017	1.205	.050-.080	2.777	2.625	.188	1.812	.600	.900	1.780
MS9196-18	2.370	.417	1.142	1.300	.050-.080	3.027	2.975	.250	2.438	.750	1.125	4.166

FED. SUP CLASS.
4730

APPROX
WEIGHT
LBS/EA

X

Y

W

V

U

S

Q

P

M

K

J

H

G DIA

MIN

MAX

MIN

MAX

MIN

MAX

MIN

MAX

MIN

MAX

MIN

MAX

MIN

MAX

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CUSTODIANS
Navy - BuWeps
USAF - AFSC

OTHER INT.
AF

MILITARY STANDARD

TUBE - AMS 5646, BOSS

MS9196(ASG)

PROCUREMENT SPECIFICATION
NONE

SUPERSEDES:

SHEET

2

OF

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