

This military standard is approved by the Department of Defense and is mandatory on all activities. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

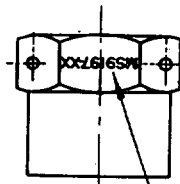
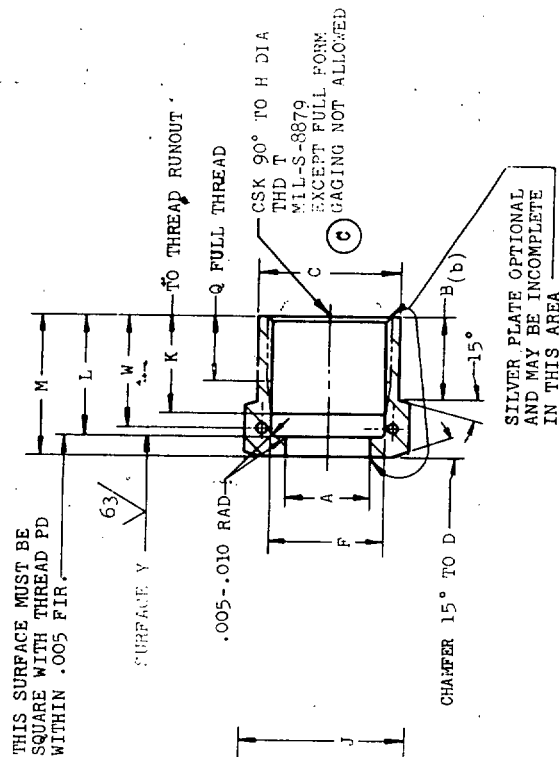
Review activities:

USAF - I

Users activities:

Novy - MC, XH

MS9197



(a) MARK PART NUMBER PER AS 478 CLASS C MANUFACTURER'S IDENTIFICATION REQUIRED

DIAMETERS A AND F SHALL BE CONCENTRIC TO THREAD PD WITHIN .004 FIR. DIAMETER C AND HEXAGON E SHALL BE CONCENTRIC TO THREAD PD WITHIN .010 FIR.

(a) MULTIPLE MARKING PERMISSIBLE PROVIDED POSITIVE IDENTIFICATION IS SHOWN. PARTS MUST BE MARKED BEFORE THREADING.
(b) TO THEORETICAL SHARP CORNER.

MATERIAL: CORROSION AND HEAT RESISTANT STEEL AMS 5646

SURFACE FINISH: SILVER PLATE AMS 2410 .0003-.0006 THICK ON THREAD AT PD AND SURFACE Y. DIMENSIONS SPECIFIED ARE AFTER PLATING.

(c) SURFACE TEXTURE: ANSI B46.1-1962 UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICROINCHES EXCEPT HEX. BRASK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED. FILLETS .005-.020 RAD OR CHAMFER. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED: TOLERANCES: LINEAR DIMENSIONS ±.010, ANGULAR DIMENSIONS ±5°.

DO NOT USE UNASSIGNED PART NUMBERS.

AS & AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS, INC. PUBLICATIONS

REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.

FED. SUP CLASS
4730

THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AEROSPACE PART STANDARDS DIVISION (c) FOR CHANGES SEE SHEETS 1 & 2

P.A. USAF - 82 Other Cust Navy - AS	TITLE NUT, TUBE COUPLING-CRES AMS 5646, SILVER PLATE	MILITARY STANDARD MS9197
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 1 OF 2

APPROVED 28 May 62 REVISED (A) 31 Jul 64 (B) 4 May 70 (C) 13 Dec 72

MS9197

FED. SUP CLASS
4730Users activities:
Navy - MC, XHReview activities:
USAF - II

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PART NO.		NOM TUBE OD REF	THREAD T			A DIA +.003 -.000	B ±.015 (b)	C DIA ±.005	D DIA	E	F DIA
MS9197-02	.125	.3125-24UNJF-3B	.180	.435	.425	.438	.430-.439	.272-.280			
MS9197-03	.188	.375-24UNJF-3B	.242	.452	.490	.500	.492-.502	.334-.342			
MS9197-04	.250	.4375-20UNJF-3B	.305	.467	.550	.562	.553-.564	.388-.397			
MS9197-05	.312	.500-20UNJF-3B	.374	.440	.615	.625	.616-.627	.451-.459			
MS9197-06	.375	.5625-18UNJF-3B	.440	.467	.678	.688	.679-.690	.508-.517			
MS9197-07	.438	.625-18UNJF-3B	.502	.493	.740	.750	.741-.752	.570-.579			
MS9197-08	.500	.750-16UNJF-3B	.570	.493	.865	.875	.865-.877	.689-.698			
MS9197-09	.562	.8125-16UNJ-3B	.634	.493	.927	.937	.928-.940	.751-.760			
MS9197-10	.625	.875-14UNJF-3B	.698	.617	.990	1.000	.990-1.002	.805-.815			
MS9197-11	.688	1.000-12UNJF-3B	.770	.588	1.115	1.125	1.114-1.127	.918-.930			
MS9197-12	.750	1.0625-12UNJ-3B	.834	.588	1.180	1.250	1.239-1.252	.981-.991			
MS9197-14	.875	1.1875-12UNJ-3B	.961	.615	1.320	1.375	1.364-1.377	1.106-1.116			
MS9197-16	1.000	1.3125-12UNJ-3B	1.089	.652	1.433	1.500	1.489-1.502	1.231-1.241			
MS9197-18	1.125	1.500-12UNJF-3B	1.217	.680	1.620	1.750	1.738-1.752	1.419-1.429			
MS9197-20	1.250	1.625-12UNJ-3B	1.347	.727	1.745	1.812	1.800-1.814	1.544-1.554			
MS9197-24	1.500	1.875-12UNJ-3B	1.617	.880	1.995	2.125	2.113-2.127	1.794-1.804			
MS9197-28	1.750	2.250-12UNJ-3B	1.890	.930	2.410	2.500	2.487-2.502	2.169-2.179			
MS9197-32	2.000	2.500-12UNJ-3B	2.167	1.060	2.660	2.750	2.737-2.752	2.419-2.429			
MS9197-40	2.500	3.000-12UNJ-3B	2.667	.860	3.200	3.250	3.237-3.252	2.919-2.929			
MS9197-48	3.000	3.500-12UNJ-3B	3.180	.910	3.700	3.812	3.798-3.814	3.419-3.429			

NOM TUBE OD REF	H +.030 -.000	J MIN	K MAX	L ±.005	M	N	Q MIN	W	X	APPROX WEIGHT LB/100
.125	.312	.491	.425	.575	.650	.045-.050	.300	.535	.180-.190	1.210
.188	.375	.561	.441	.592	.667	.057-.062	.316	.552	.210-.220	1.475
.250	.438	.631	.482	.607	.682	.057-.062	.332	.567	.245-.255	1.830
.312	.500	.703	.482	.610	.690	.065-.075	.332	.565	.280-.290	2.600
.375	.562	.775	.535	.637	.742	.065-.075	.367	.592	.310-.320	2.920
.438	.625	.846	.536	.663	.768	.065-.075	.368	.618	.336-.356	3.422
.500	.750	.987	.569	.723	.828	.065-.075	.383	.648	.400-.420	4.680
.562	.812	1.059	.569	.723	.828	.065-.075	.383	.668	.427-.447	5.314
.625	.875	1.130	.667	.817	.927	.065-.075	.453	.777	.465-.485	6.310
.688	1.000	1.271	.738	.868	.968	.065-.075	.488	.818	.520-.540	7.859
.750	1.062	1.414	.738	.868	.968	.065-.075	.488	.818	.580-.600	9.907
.875	1.188	1.556	.765	.915	1.015	.065-.075	.515	.865	.645-.665	12.164
1.000	1.312	1.699	.786	.962	1.062	.065-.075	.536	.912	.715-.735	13.637
1.125	1.500	1.935	.800	.990	1.120	.065-.075	.550	.945	.840-.860	19.830
1.250	1.625	2.054	.810	1.017	1.167	.065-.075	.560	.967	.890-.910	20.016
1.500	1.875	2.411	.937	1.170	1.320	.065-.075	.687	1.100	1.040-1.060	27.903
1.750	2.250	2.838	.945	1.170	1.370	.065-.075	.695	1.170	1.255-1.275	41.710
2.000	2.500	3.123	1.050	1.300	1.500	.065-.075	.800	1.300	1.395-1.415	49.000
2.500	3.000	3.693	.850	1.100	1.300	.065-.075	.600	1.100	1.680-1.700	60.621
3.000	3.500	4.334	.900	1.150	1.350	.065-.075	.650	1.150	2.000-2.020	78.529

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

P.A. USAF-82 Other Cust Navy-AS	TITLE NUT, TUBE COUPLING-CRES AMS 5646, SILVER PLATE	MILITARY STANDARD MS9197
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 2 OF