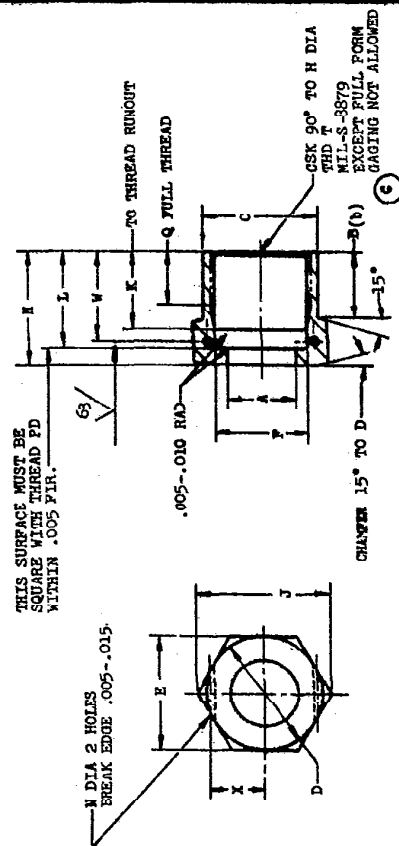


Users activities:
Navy - MC, XHReview activities:
USAF - II

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 for this document.

MS9198



(a) MARK PART NUMBER PER AS 178 CLASS C MANUFACTURER'S IDENTIFICATION REQUIRED

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

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 TEXTURE: ANSI B46.1-1962 UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICROINCHES EXCEPT HEX.

FLUORESCENT PENETRANT INSPECTION PER AMS 2645.

BREAK 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°.

CLEANING: FINISHED PARTS SHALL BE DEGREASED AND IMMERSED FOR NOT LESS THAN 20 MINUTES IN A SOLUTION OF 1 VOLUME OF NITRIC ACID (37 OR 1.42) AND 9 VOLUMES OF WATER AT ROOM TEMPERATURE.

DO NOT USE UNDESIGNED 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

P.A. USAF-82
Other Cont
Navy-AS

TITLE

NUT, TUBE COUPLING - CRES AMS 5646

PROCUREMENT SPECIFICATION
NONE

SUPERSEDES:

MILITARY STANDARD

MS9198

SHEET 1 OF 2

DD FORM 672-1

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

MS9198FED. SUP CLASS
4730Users activities:
Navy - MG, XHReview activities:
USAF - IIThis military standard is approved by the Department of Defense and is
secondary on all activities. Selection for all new engineering design
applications and for repetitive use shall be made from this document.

PART NO.	TOM TIME OF RET	THREAD T	A		B		C		D		E		F	
			DIA + .003 - .000	± .015 (b)	DIA + .005 - .005	DIA	DIA	DIA	DIA	DIA	DIA	DIA	DIA	DIA
MS9198-02	.125	.3125-24UNJF-3B	.180	.435	.425	.438	.430-.439	.272-.280						
MS9198-03	.188	.375-24UNJF-3B	.242	.452	.490	.500	.492-.502	.334-.342						
MS9198-04	.250	.4375-20UNJF-3B	.305	.467	.550	.562	.553-.564	.388-.397						
MS9198-05	.312	.500-20UNJF-3B	.374	.440	.615	.625	.616-.627	.451-.459						
MS9198-06	.375	.5625-18UNJF-3B	.440	.467	.678	.688	.679-.690	.508-.517						
MS9198-07	.438	.625-18UNJF-3B	.502	.493	.740	.750	.741-.752	.570-.579						
MS9198-08	.500	.750-16UNJF-3B	.570	.493	.862	.872	.863-.877	.689-.698						
MS9198-09	.562	.8125-16UNJF-3B	.634	.493	.927	.937	.928-.940	.751-.760						
MS9198-10	.625	.875-14UNJF-3B	.698	.617	.990	1.000	.990-1.002	.805-.815						
MS9198-11	.688	1.000-12UNJF-3B	.770	.588	1.115	1.125	1.114-1.127	.918-.930						
MS9198-12	.750	1.0625-12UNJF-3B	.834	.588	1.180	1.250	1.239-1.252	.981-.991						
MS9198-14	.875	1.1875-12UNJF-3B	.961	.615	1.320	1.375	1.364-1.377	1.106-1.116						
MS9198-16	1.000	1.3125-12UNJF-3B	1.089	.652	1.433	1.500	1.489-1.502	1.231-1.241						
MS9198-18	1.125	1.500-12UNJF-3B	1.217	.680	1.620	1.750	1.735-1.752	1.419-1.429						
MS9198-20	1.250	1.625-12UNJF-3B	1.347	.727	1.745	1.812	1.800-1.814	1.544-1.554						
MS9198-24	1.500	1.875-12UNJF-3B	1.617	.880	1.995	2.125	2.113-2.127	1.794-1.804						
MS9198-28	1.750	2.250-12UNJF-3B	1.890	.930	2.410	2.500	2.487-2.502	2.169-2.179						
MS9198-32	2.000	2.500-12UNJF-3B	2.167	1.060	2.660	2.750	2.737-2.752	2.419-2.429						
MS9198-40	2.500	3.000-12UNJF-3B	2.667	.860	3.200	3.250	2.237-2.252	2.919-2.929						
MS9198-42	3.000	3.500-12UNJF-3B	3.180	.910	3.700	3.812	3.793-3.814	3.419-3.429						

TOM TIME OF RET	H + .030 - .000	J MIN	K MAX	L ± .005	M	N	Q MIN	X	APPROX WEIGHT LB/100
.125	.312	.491	.425	.575	.650	.045-.050	.300	.535	1.210
.188	.375	.541	.441	.592	.667	.057-.062	.316	.552	1.475
.250	.438	.591	.462	.607	.682	.057-.062	.332	.567	1.530
.312	.500	.703	.482	.610	.690	.065-.075	.332	.565	2.600
.375	.562	.775	.535	.637	.742	.065-.075	.337	.592	2.920
.438	.625	.846	.535	.663	.768	.065-.075	.368	.618	3.422
.500	.750	.907	.569	.723	.828	.065-.075	.383	.648	4.680
.562	.812	1.059	.569	.723	.828	.065-.075	.383	.668	5.314
.625	.875	1.130	.667	.817	.927	.065-.075	.453	.717	6.310
.688	1.000	1.271	.738	.868	.968	.065-.075	.488	.818	7.859
.750	1.062	1.414	.738	.868	.968	.065-.075	.488	.818	9.907
.875	1.188	1.554	.765	.915	1.015	.065-.075	.515	.865	12.164
1.000	1.312	1.699	.786	.962	1.062	.065-.075	.536	.912	13.637
1.125	1.500	1.935	.800	.990	1.120	.065-.075	.550	.945	19.830
1.250	1.625	2.054	.810	1.017	1.167	.065-.075	.560	.967	20.016
1.500	1.875	2.411	.937	1.170	1.320	.065-.075	.687	1.100	27.903
1.750	2.250	2.838	.945	1.170	1.370	.065-.075	.695	1.170	41.710
2.000	2.500	3.123	1.050	1.300	1.500	.065-.075	.800	1.300	49.000
2.500	3.000	3.693	.850	1.100	1.300	.065-.075	.600	1.100	60.621
3.000	3.500	4.334	.900	1.150	1.350	.065-.075	.650	1.150	78.529

THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AEROSPACE PART
STANDARDS DIVISIONP.A. USAF-82
Other Cuts
Navy-AS

C

TITLE

NUT, TUBE COUPLING - CRES AMS 5646

MILITARY STANDARD

MS9198PROCUREMENT SPECIFICATION
NONE

SUPERSEDES:

SHEET 2 OF

DD FORM 672-1

APPROVED 28 May 62 REVISED C FOR CHANGES SEE SHEETS 1 AND 2.