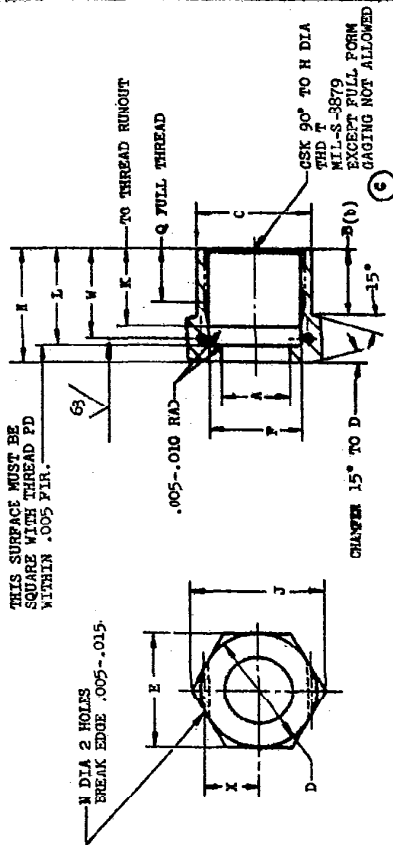


MS9198

Users activities:
Navy - MC, XH

Review 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.



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

(a) MULTIPLE MARKING PERMISSIBLE PROVIDED POSITIVE IDENTIFICATION IS SHOWN. PARTS MUST BE MARKED BEFORE THREADING.

(b) TO THEORETICAL SHARP CORNER.

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.

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 (57 OR 1.42) AND 9 VOLUMES OF WATER AT ROOM TEMPERATURE.

DO NOT USE UNASSIGNED PART NUMBERS

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

FED. SUP CLASS
4730

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

P.A. USAF-82 Other Code Navy-AS	TITLE NUT, TUBE COUPLING - CRES AMS 5646	MILITARY STANDARD MS9198
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	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

MS9198

FED. SUP CLASS
4730

Users activities:
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PART NO.	ION SIZE OD RET		THREAD T	C						F DIA
	A DIA +.003 - .000	B ±.015 (b)		C DIA ±.005	D DIA	E	F 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	.700	-16UNJF-3B	.270	.425	.605	.615	.605-.617	.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	.920	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	2.237-3.252	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	

ION SIZE OD 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	.460	.607	.682	.057-.062	.332	.567	1.930
.312	.500	.703	.482	.610	.690	.065-.075	.332	.565	2.600
.375	.562	.775	.535	.674	.742	.065-.075	.337	.592	2.920
.438	.625	.846	.535	.683	.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	.777	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	.916	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	1.955	.800	.990	1.120	.065-.075	.550	.945	19.830
1.250	1.625	2.094	.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 DIVISION

P.A. USAF-82 Other Cust Navy-AS	(C) TITLE NUT, TUBE COUPLING - GRES AMS 5646	MILITARY STANDARD MS9198
PROCUREMENT SPECIFICATION NONE	SUPSEDES:	SHEET 2 OF

DD FORM 672-1

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