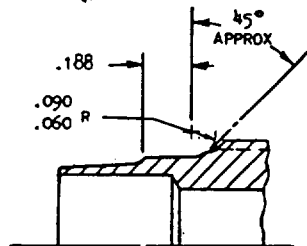
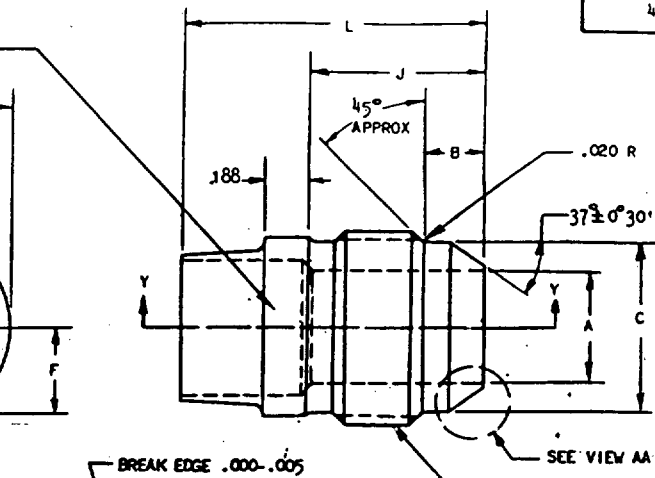
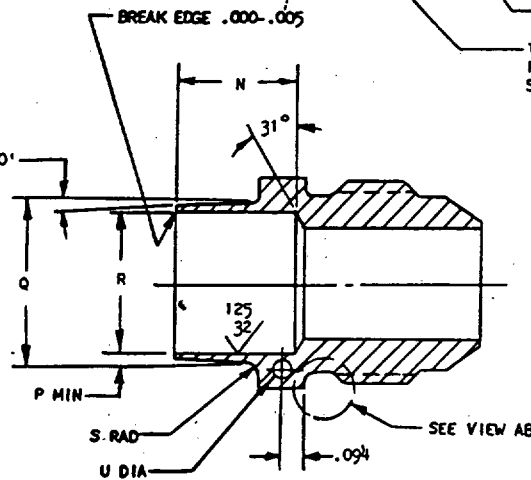
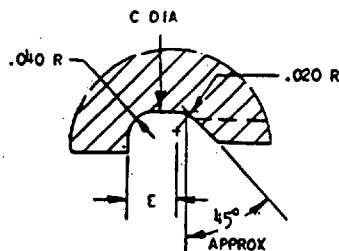
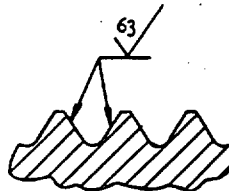
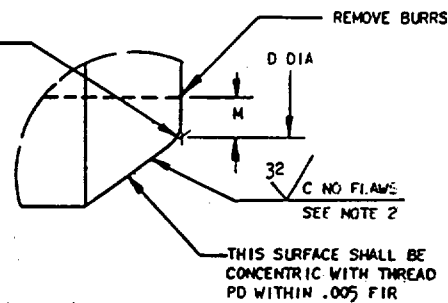


MS9381 (ASG)FED. SUP CLASS
4730MARK PART NUMBER AND MANUFACTURERS
IDENTIFICATION PER AS 478 CLASS CBREAK SHARP EDGE
.005-.015 BOTH ENDSSECTION Z-Z
SIZE -11 AND LARGERTHREAD T
PER MIL-S-8879
SEE NOTE 1

SECTION Y-Y



VIEW AB

BREAK EDGE
.005 RAD MAXSECTION THRU
THREAD PROFILE

VIEW AA

1. THREAD ON SIZES -16 AND SMALLER SHALL BE ROLLED PER AMS7472.
2. CONICAL SURFACE SHALL BE FREE OF NICKS, CHATTER MARKS OR LOW SPOTS. UNBROKEN LINE OF CONTACT TO SHOW ALL AROUND AT OTHER THAN EXTREMITIES OF SURFACE WHEN ROTATED IN CONTACT WITH 74° 0' ± 0° 1' INCLUDED ANGLE GAGE LIGHTLY COATED BY RUBBING WITH CARBON PAPER.
3. ALL DIAMETERS SHALL BE CONCENTRIC WITHIN .010 FIR UNLESS OTHERWISE SPECIFIED.
4. DIMENSIONS ARE TO SHARP CORNERS UNLESS OTHERWISE SPECIFIED.
5. MATERIAL: CORROSION RESISTANT STEEL, AMS 5646.
6. CLEANING: FINISHED PARTS SHALL BE DEGREASED 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.
7. SURFACE ROUGHNESS: AS 291. UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICROINCHES.
8. BREAK SHARP EDGES .003-.015, UNLESS OTHERWISE SPECIFIED.
9. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS ±.010, ANGULAR DIMENSIONS ±5°.
10. DO NOT USE UNASSIGNED PART NUMBERS.

AS & AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS, INC. PUBLICATIONS.
THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE SAE AEROSPACE PROPULSION DIVISION.

P.A. USAP - 11

TITLE

Other Cust
Navy - AS

COUPLING, TUBE - BRAZING, AMS 5646

MILITARY STANDARD**MS9381 (ASG)**PROCUREMENT SPECIFICATION
NONE

SUPERSEDES:

SHEET 1 OF 2

Review activities:
Navy - AS
USAF - 11

This military standard is approved by the Department of the Air Force and the Naval Air Systems Command and is mandatory for use by these activities. All other military activities are required to employ this standard where suitable.

REVISED
APPROVED 3 Oct 66

MS 9381 (ASG)

FED. SUP CLASS
4730

PART NO.	NOM TUBE OD	THREAD T					A	B	C DIA	D DIA	E	F	G
		SIZE	MAJOR DIA	PITCH DIA	MINOR DIA	ROOT RAD							
M9381-02	.125	.3125-24UNF-3A	.3053-.3125	.2827-.2854	.2591-.2644	.0063-.0075	.058-.065	.144	.245	.132	.063	.125	.250
M9381-03	.188	.375-24 UNF-3A	.3678-.3750	.3479-.3509	.3214-.3268	.0063-.0075	.121-.128	.144	.359	.195	.063	.156	.312
M9381-04	.250	.4375-20UNF-3A	.4294-.4375	.4109-.4150	.3736-.3797	.0075-.0090	.168-.175	.160	.359	.242	.075	.188	.375
M9381-05	.312	.500-20UNF-3A	.4919-.5000	.4643-.4675	.4360-.4422	.0075-.0090	.230-.237	.160	.421	.304	.075	.219	.438
M9381-06	.375	.5625-18UNF-3A	.5538-.5625	.5230-.5264	.4916-.4963	.0083-.0100	.293-.301	.165	.476	.368	.083	.250	.500
M9381-07	.438	.625-18UNF-3A	.6163-.6250	.5854-.5889	.5540-.5608	.0083-.0100	.355-.363	.165	.539	.430	.083	.281	.562
M9381-08	.500	.750-16UNF-3A	.7406-.7500	.7056-.7094	.6702-.6778	.0094-.0113	.387-.395	.229	.654	.462	.094	.344	.688
M9381-09	.562	.875-16UNF-3A	.8631-.8725	.8285-.8323	.7929-.7995	.0107-.0129	.444-.452	.229	.716	.509	.094	.375	.750
M9381-10	.625	.875-16UNF-3A	.8647-.8750	.8295-.8333	.7941-.7995	.0107-.0129	.480-.488	.255	.767	.555	.107	.391	.761
M9381-11	.688	1.000-12UNF-3A	.9886-1.0000	.9415-.9459	.8944-.9038	.0125-.0150	.542-.552	.304	.875	.619	.125	.438	.875
M9381-12	.750	1.0625-12UNF-3A	1.0511-1.0625	1.0042-1.0084	.9570-.9663	.0125-.0150	.604-.614	.304	.938	.681	.125	.469	.938
M9381-14	.875	1.1875-12UNF-3A	1.1761-1.1875	1.1291-1.1334	1.0820-1.0913	.0125-.0150	.729-.739	.304	1.062	.806	.125	.531	1.062
M9381-16	1.000	1.3125-12UNF-3A	1.3011-1.3125	1.2541-1.2584	1.2070-1.2163	.0125-.0150	.839-.851	.312	1.188	.918	.125	.594	1.188
M9381-18	1.125	1.500-12UNF-3A	1.4886-1.5000	1.4411-1.4459	1.3940-1.4038	.0125-.0150	.948-.960	.312	1.375	1.027	.125	.656	1.312
M9381-20	1.250	1.625-12UNF-3A	1.6136-1.6250	1.5665-1.5709	1.5193-1.5288	.0125-.0150	1.073-1.086	.363	1.501	1.153	.125	.719	1.438
M9381-24	1.500	1.875-12UNF-3A	1.8636-1.8750	1.8164-1.8209	1.7692-1.7788	.0125-.0150	1.307-1.320	.374	1.750	1.281	.125	.844	1.688
M9381-28	1.750	2.250-12UNF-3A	2.2386-2.2500	2.1914-2.1959	2.1442-2.1538	.0125-.0150	1.542-1.557	.447	2.125	1.592	.125	1.000	2.000
M9381-32	2.000	2.500-12UNF-3A	2.4886-2.5000	2.4413-2.4459	2.3941-2.4038	.0125-.0150	1.776-1.791	.457	2.375	1.886	.125	1.125	2.250
M9381-40	2.500	3.000-12UNF-3A	2.9886-3.0000	2.9412-2.9459	2.8940-2.9038	.0125-.0150	2.276-2.291	.391	2.882	2.386	.125	1.375	2.750
M9381-48	3.000	3.500-12UNF-3A	3.4886-3.5000	3.4413-3.4459	3.3940-3.4038	.0125-.0150	2.776-2.791	.391	3.382	2.886	.125	1.625	3.250

PART NO.	H DIA + .010 - .000	J	L	M MIN	N	P MIN	Q DIA + .010 - .000	R DIA + .002 - .000	S	U	V	APPROX WEIGHT LB/100
MS9381-02	.344	.415	.811	.030	.316	.022	.170	.115	.031-.062	.045-.050	.102-.112	1.17
MS9381-03	.348	.446	.884	.030	.358	.023	.234	.178	.031-.062	.051-.062	.139-.149	2.05
MS9381-04	.500	.517	.973	.030	.376	.026	.303	.240	.047-.078	.051-.062	.170-.180	
MS9381-05	.593	.517	.973	.030	.376	.029	.370	.302	.047-.078	.055-.075	.207-.217	2.64
MS9381-06	.656	.523	.973	.030	.376	.029	.433	.365	.047-.078	.065-.075	.238-.258	3.12
MS9381-07	.719	.523	1.006	.030	.403	.033	.504	.428	.047-.078	.065-.075	.270-.290	3.96
MS9381-08	.781	.633	1.145	.030	.432	.034	.568	.489	.047-.078	.065-.075	.300-.320	5.82
MS9381-09	.844	.643	1.164	.030	.451	.038	.637	.551	.047-.078	.065-.075	.331-.351	8.46
MS9381-10	.904	.737	1.306	.030	.479	.039	.703	.614	.047-.078	.065-.075	.362-.382	11.80
MS9381-11	1.000	.853	1.443	.030	.510	.041	.769	.677	.047-.078	.065-.075	.410-.430	13.13
MS9381-12	1.094	.853	1.443	.030	.510	.041	.831	.739	.047-.078	.065-.075	.440-.460	15.96
MS9381-14	1.188	.898	1.488	.030	.510	.041	.956	.864	.047-.078	.065-.075	.503-.523	
MS9381-16	1.312	.908	1.498	.030	.510	.046	1.091	.989	.078-.109	.065-.075	.565-.585	18.27
MS9381-18	1.500	.908	1.548	.030	.510	.046	1.216	1.114	.078-.109	.065-.075	.644-.664	22.33
MS9381-20	1.625	.954	1.544	.030	.510	.051	1.351	1.239	.078-.109	.065-.075	.706-.726	27.38
MS9381-24	1.875	1.079	1.669	.030	.510	.061	1.616	1.484	.078-.109	.065-.075	.890-.890	38.13
MS9381-28	2.250	1.204	1.794	.044	.510	.071	1.886	1.734	.078-.109	.065-.075	.986-1.006	61.64
MS9381-32	2.500	1.329	1.919	.044	.510	.086	2.166	1.984	.078-.109	.065-.075	1.111-1.131	79.22
MS9381-40	3.000	1.105	1.695	.044	.510	.086	2.666	2.484	.094-.125	.065-.075	1.361-1.381	82.11
MS9381-48	3.500	1.183	1.773	.044	.510	.091	3.176	2.984	.094-.125	.065-.075	1.611-1.631	105.85

APPROVED 3 Oct 66
REVISED

THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE SAE AEROSPACE PROPULSION DIVISION.

P.A. USAF - 11	TITLE	MILITARY STANDARD
Other Cust Navy - AS	COUPLING, TUBE - BRAZING, AMS 5646	MS 9381 (ASG)
PROCUREMENT SPECIFICATION NOTE	SUPERSEDES:	SHEET 2 OF 2