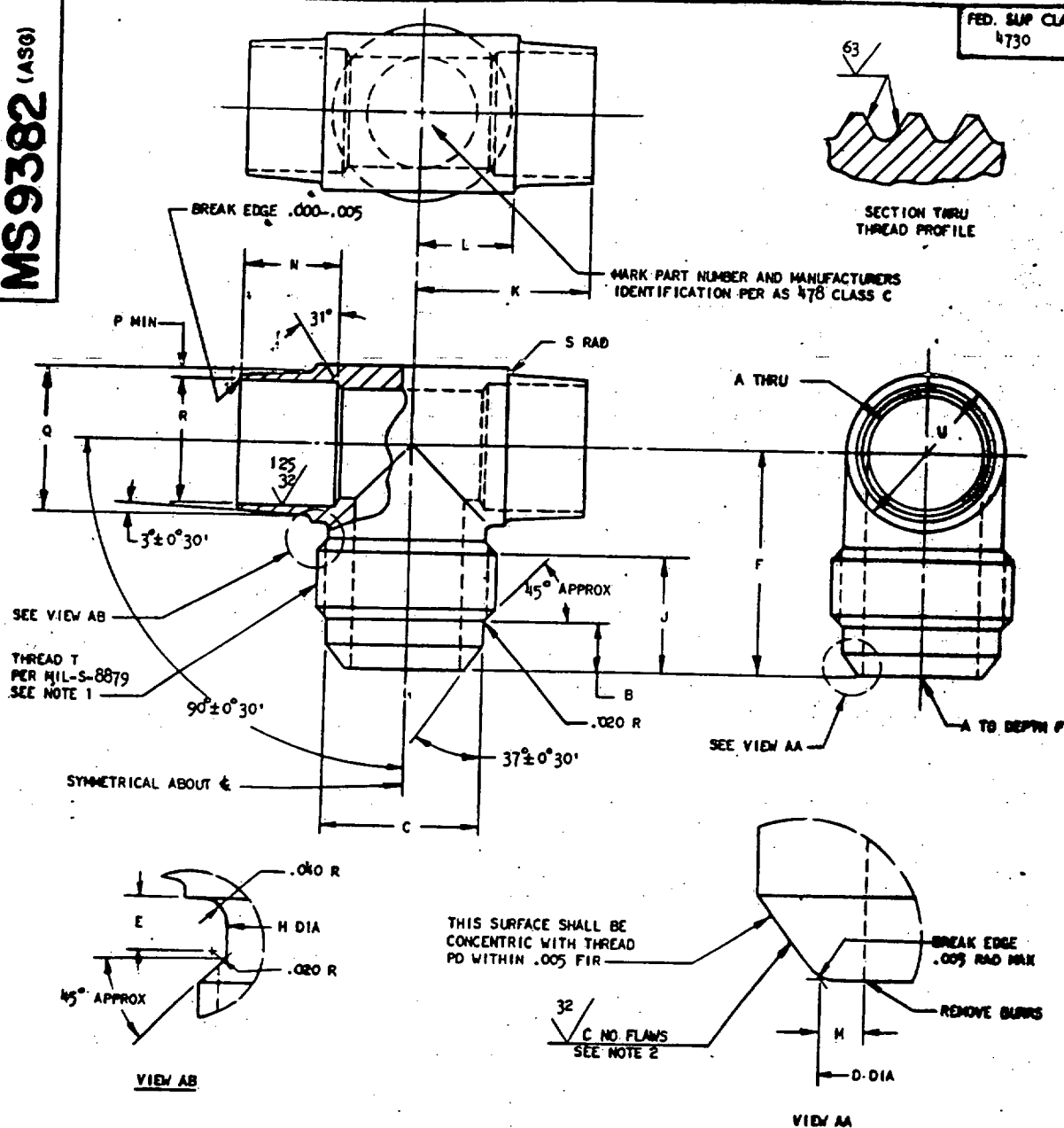


MS9382 (ASG)FED. SUP CLASS
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1. THREAD ON SIZES -16 AND SMALLER SHALL BE ROLLED PER AMS7472.
2. CONICAL SURFACE SHALL BE FREE OF NICKS, CHATTER MARKS OR LOW SPOTS. UNBROKEN LINE OF CONTACT TO SHOW ALL AROUND AT OTHER THAN EXTREMITIES OF SURFACE WHEN ROTATED IN CONTACT WITH 74° 0' ± 0° 1'. INCLUDED ANGLE GAGE LIGHTLY COATED BY RUBBING WITH CARBON PAPER.
3. WITH THE EXCEPTION OF DIAMETER U, ALL DIAMETERS ABOUT THEIR RESPECTIVE AXES SHALL BE CONCENTRIC WITHIN .010 FIR. DIAMETER U SHALL BE CONCENTRIC WITH DIAMETER R WITHIN .020 FIR.
4. DIMENSIONS ARE TO SHARP CORNERS UNLESS OTHERWISE SPECIFIED.
5. MATERIAL: CORROSION RESISTANT STEEL, AMS 5646, FORGING.
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. FORGING MISMATCH OF .015 PERMISSIBLE.
8. SURFACE ROUGHNESS: AS 291. UNLESS OTHERWISE SPECIFIED MACHINED SURFACES TO BE 125 MICROINCHES.
9. PARTS SUBJECT TO FLUORESCENT PENETRANT INSPECTION PER AMS 2645.
10. BREAK SHARP EDGES .003-.015, UNLESS OTHERWISE SPECIFIED.
11. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR DIMENSIONS ±.010, ANGULAR DIMENSIONS ±5°.
12. 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.

PA USAF - 11	TITLE TEE, TUBE - BRAZING, AMS 5646	MILITARY STANDARD MS9382 (ASG)
Other Cust Navy - AS		
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 1 OF 2

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.

Review activities:

Navy - AS
USAF - 11APPROVED 3 Oct 66
REVISED

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

Review activities:

NAVY - AS
USAF - 11

MS9382 (ASG)

PART NO.	NOM TUBE OD	THREAD T					A	B	C DIA	D DIA	E	F
		SIZE	MAJOR DIA	PITCH DIA	MINOR DIA	ROOT RAD						
MS9382-02	.125	3125-24UNF-3A	.3053	.2827-.2854	.2591-.2644	.0063-.0075	.058-.065	.144	.245	.132	+.015 -.000	.567
MS9382-03	.188	3175-24UNF-3A	.3678	.3450-.3479	.3214-.3268	.0075-.0075	.121-.128	.144	.307	.195	.063	.625
MS9382-04	.250	3375-20UNF-3A	.4294	.4019-.4050	.3736-.3797	.0075-.0090	.168-.175	.160	.359	.242	.075	.726
MS9382-05	.312	500-20UNF-3A	.4919	.4643-.4675	.4360-.4422	.0075-.0090	.230-.237	.160	.421	.304	.075	.766
MS9382-06	.375	5625-18UNF-3A	.5538	.5230-.5264	.4916-.4983	.0083-.0100	.293-.301	.165	.476	.368	.083	.799
MS9382-07	.438	.625-16UNF-3A	.6163	.5854-.5889	.5510-.5608	.0083-.0100	.355-.363	.165	.539	.430	.083	.833
MS9382-08	.500	.750-16UNF-3A	.7106	.6706-.7094	.6702-.6778	.0094-.0113	.367-.395	.229	.654	.462	.094	.993
MS9382-09	.562	.8125-16UNF-3A	.8031	.7683-.7712	.7329-.7403	.0094-.0113	.434-.442	.229	.716	.509	.094	1.028
MS9382-10	.625	.875-14UNF-3A	.8647	.8245-.8286	.7841-.7925	.0107-.0129	.480-.488	.255	.787	.555	.107	1.163
MS9382-11	.688	1.000-12UNF-3A	.9886	.9415-.9459	.8944-.9038	.0125-.0150	.542-.552	.304	.875	.619	.125	1.323
MS9382-12	.750	1.0625-12UNF-3A	1.0511	1.0042-1.0084	.9570-.9663	.0125-.0150	.604-.614	.304	.938	.687	.125	1.354
MS9382-14	.875	1.1875-12UNF-3A	1.1761	1.1291-1.1334	1.0800-1.0913	.0125-.0150	.729-.739	.304	1.082	.806	.125	1.462
MS9382-16	1.000	1.3125-12UNF-3A	1.3011	1.2541-1.2584	1.2070-1.2163	.0125-.0150	.839-.851	.312	1.188	.918	.125	1.537
MS9382-18	1.125	1.500-12UNF-3A	1.4886	1.4411-1.4459	1.3940-1.4038	.0125-.0150	.948-.960	.312	1.375	1.027	.125	1.674
MS9382-20	1.250	1.625-12UNF-3A	1.6136	1.5665-1.5709	1.5193-1.5288	.0125-.0150	1.073-1.086	.363	1.501	1.153	.125	1.739
MS9382-24	1.500	1.875-12UNF-3A	1.8636	1.8164-1.8209	1.7692-1.7788	.0125-.0150	1.307-1.320	.374	1.750	1.387	.125	1.993
MS9382-28	1.750	2.250-12UNF-3A	2.2386	2.1914-2.1959	2.1442-2.1538	.0125-.0150	1.542-1.557	.447	2.125	1.652	.125	2.292
MS9382-32	2.000	2.500-12UNF-3A	2.4886	2.4413-2.4459	2.3941-2.4038	.0125-.0150	1.776-1.791	.457	2.375	1.886	.125	2.552
MS9382-40	2.500	3.000-12UNF-3A	2.9886	2.9412-2.9459	2.8940-2.9038	.0125-.0150	2.276-2.291	.391	2.882	2.386	.125	2.578
MS9382-48	3.000	3.500-12UNF-3A	3.4886	3.4411-3.4459	3.3940-3.4038	.0125-.0150	2.776-2.791	.391	3.382	2.886	.125	2.906

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PART NO.	H DIA	J	K	L	M	N	P	Q DIA	R DIA	S	U DIA	APPROX LB/100
MS9382-02	.240	.317	.411	.188	.030	.346	.022	.171	.115	.031-.062	.240	1.02
MS9382-03	.300	.346	.444	.219	.030	.358	.024	.236	.178	.031-.062	.300	1.62
MS9382-04	.350	.398	.502	.250	.030	.376	.027	.304	.240	.047-.078	.350	2.33
MS9382-05	.415	.398	.533	.281	.030	.376	.030	.372	.302	.047-.078	.415	3.05
MS9382-06	.470	.398	.564	.312	.030	.376	.030	.435	.363	.047-.078	.470	3.64
MS9382-07	.535	.398	.622	.344	.030	.403	.034	.506	.428	.047-.078	.535	5.54
MS9382-08	.650	.489	.705	.406	.030	.432	.035	.569	.489	.047-.078	.650	9.20
MS9382-09	.710	.489	.748	.438	.030	.451	.038	.637	.551	.047-.078	.710	11.25
MS9382-10	.765	.585	.799	.469	.030	.479	.039	.702	.614	.047-.078	.765	12.97
MS9382-11	.870	.663	.892	.531	.030	.510	.041	.768	.677	.047-.078	.870	19.20
MS9382-12	.935	.663	.923	.562	.030	.510	.041	.830	.739	.047-.078	.935	21.46
MS9382-14	1.055	.710	.966	.625	.030	.510	.041	.955	.884	.047-.078	1.055	27.03
MS9382-16	1.185	.720	1.041	.688	.030	.510	.045	1.089	.989	.078-.109	1.185	33.13
MS9382-18	1.365	.767	1.126	.781	.030	.510	.045	1.213	1.114	.078-.109	1.365	49.28
MS9382-20	1.495	.767	1.189	.844	.030	.510	.050	1.348	1.239	.078-.109	1.495	61.99
MS9382-24	1.745	.889	1.306	.969	.030	.510	.059	1.612	1.484	.078-.109	1.745	104.32
MS9382-28	2.120	1.017	1.485	1.156	.044	.510	.069	1.882	1.734	.078-.109	2.120	146.78
MS9382-32	2.370	1.142	1.602	1.281	.044	.510	.083	2.161	1.984	.078-.109	2.370	189.18
MS9382-40	2.870	.918	2.102	1.531	.044	.510	.083	2.661	2.484	.094-.125	2.870	242.80
MS9382-48	3.370	.996	2.102	1.781	.044	.510	.088	3.171	2.904	.094-.125	3.370	327.65

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

P.A. USAF - 11	TITLE	MILITARY STANDARD
Other Cust NAVY - AS	TEE, TUBE - BRAZING, AMS 5646	MS 9382 (ASG)
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 2 OF 2

APPROVED 3 Oct 66

REVISED