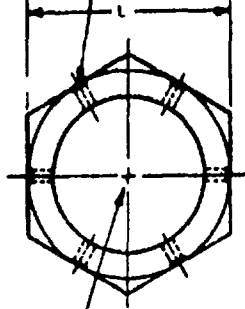
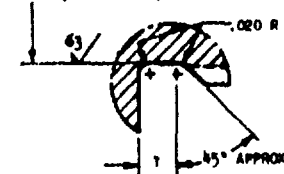


MS9404

.064-.075 DIA
CSH 90° TO .100 DIA
6 HOLES SPACED AS
SHOWN



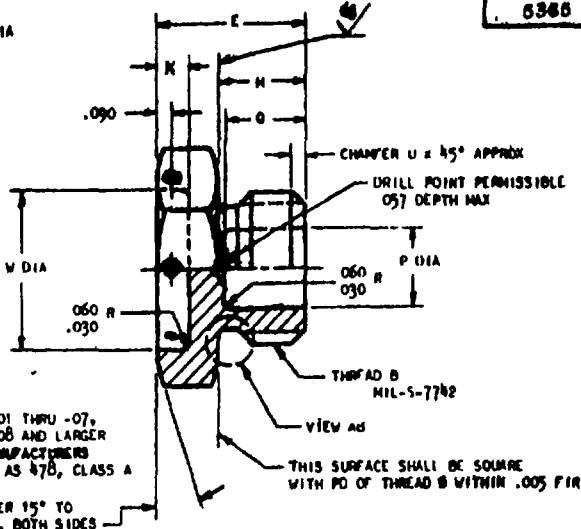
H 1/16 (SEE NOTE 2)



VIEW AB

MARK ENDS ON SIZES -.01 THRU -.07,
PART NO. ON SIZES -.08 AND LARGER
AND ON ALL SIZES MANUFACTURERS
IDENTIFICATION, PER AS 478, CLASS A

CHAMFER 15° TO
V DIA, BOTH SIDES



THIS SURFACE SHALL BE SQUARE
WITH PD OF THREAD B WITHIN .005 FIR

FED SUP CLASS
6366 (A)

PART NO	THREAD B	L	H + .002 - .003	J (1)	K	L	M	P	O	T + .015 - .000	U	V	W	APPROX WEIGHT LB/100
MS9404-01	250-28 UNF-3A	560	.196	.013	150	430-439	320	—	—	.063	.020-.050	.438	.250	1.05
MS9404-02	3125-24 UNF-3A	600	.250	.017	150	553-564	360	—	—	.063	.020-.050	.562	.312	1.84
MS9404-03	375-24 UNF-3A	600	.312	.019	150	616-627	360	—	—	.063	.020-.050	.625	.375	2.35
MS9404-04	4375-20 UNF-3A	660	.364	.021	150	679-690	400	—	—	.075	.070-.060	.688	.438	3.28
MS9404-05	500-20 UNF-3A	670	.426	.023	150	741-752	400	.219	.340	.075	.070-.060	.750	.500	3.51
MS9404-06	5625-18 UNF-3A	680	.481	.024	150	802-814	400	.219	.340	.083	.080-.070	.812	.562	9.02
MS9404-07	625-16 UNF-3A	730	.544	.026	.160	865-877	440	—	—	.094	.080-.070	.875	.625	5.63
MS9404-08	750-16 UNF-3A	730	.660	.030	.160	990-1002	440	.438	.400	.094	.080-.070	1.000	.750	7.60
MS9404-09	8125-16 UNF-3A	740	.722	.030	.160	1052-1064	440	.500	.400	.094	.080-.070	1.062	.812	8.46
MS9404-10	875-14 UNF-3A	740	.773	.030	.160	1114-1127	440	.438	.400	.107	.050-.080	1.125	.875	10.24
MS9404-11	1000-12 UNF-3A	780	.882	.030	.180	1301-1314	440	.657	.400	.125	.050-.080	1.312	1.000	13.36
MS9404-12	10625-12 UNF-3A	830	.945	.030	.200	1364-1377	480	.719	.400	.125	.050-.080	1.375	1.062	15.12
MS9404-13	1125-12 UNF-3A	830	1.009	.030	.200	1427-1440	480	.741	.400	1.125	.050-.080	1.438	1.125	16.15
MS9404-14	11875-12 UNF-3A	840	1.070	.030	.200	1489-1502	480	.844	.400	.125	.050-.080	1.500	1.188	17.18
MS9404-16	13125-12 UNF-3A	840	1.195	.030	.200	1614-1627	480	.969	.400	.125	.050-.080	1.625	1.312	19.86
MS9404-18	1500-12 UNF-3A	890	1.382	.030	.200	1738-1752	480	1.156	.400	.125	.050-.080	1.750	1.438	26.50
MS9404-20	1625-12 UNF-3A	890	1.507	.050	.200	1926-1940	480	1.281	.400	.125	.050-.080	1.938	1.625	26.67
MS9404-24	1875-12 UNF-3A	860	1.756	.050	.200	2176-2190	480	1.531	.400	.125	.050-.080	2.188	1.875	32.70
MS9404-28	2250-12 UNF-3A	870	2.131	.050	.200	2550-2564	480	1.906	.400	.125	.050-.080	2.562	2.250	43.43
MS9404-32	2500-12 UNF-3A	870	2.381	.050	.200	2800-2814	480	2.156	.400	.125	.050-.080	2.812	2.500	51.70

1. HEXAGON SHALL BE CONCENTRIC WITH THREAD PD WITHIN J FIR
2. DIAMETER H SHALL BE CONCENTRIC WITH THREAD PD WITHIN .005 FIR AND FREE FROM THREAD TOOL MARKS
3. MATERIAL CORROSION AND HEAT RESISTANT STEEL AMS 5646
4. MATERIAL CODE FMS PER AS 269.
5. SURFACE ROUGHNESS AS 291 UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICRONS.
6. PARTS SUBJECT TO FLUORESCENT PENETRANT INSPECTION PER AMS 2695.
7. BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED
8. DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED TOLERANCES, LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 5^\circ$
9. DO NOT USE UNASSIGNED PART NUMBERS

**INACTIVE FOR DESIGN AFTER 9 JUNE 1972. FOR PARTS WITH MIL-S-8879
SCREW THREADS SEE MS9902**

AS AND AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS PUBLICATION
THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE ENGINE PROPELLER UTILITY PARTS COMMITTEE OF THE SAE.

P.A. Air Force - 82 Other Civil Navy - AS	INTERNATIONAL INTERESTS ASCO AIRSTD 17/15 (A)	TITLE PLUG, MACHINE THREAD - AMS 8646, PREFORMED PACKING	MILITARY STANDARD MS9404
PROCUREMENT SPECIFICATION NONE	SUPERSEDES	SHEET 1 OF 1	

DD FORM 672-1 (Limited coordination)

EDITION OF 1 SEP 67 MAY BE USED

Review Activities
Air Cycle -

This standard has been approved by the Department of the Air Force (82) and the Department of the Navy (AS) and is mandatory for use by all military departments. All other military departments are required to comply with this standard where applicable.

REVISION 1 9 June 72
APPROVED 5 June 72