

INCH-POUND

MS9483C
w/AMENDMENT 1
14 February 2012
SUPERSEDING
MS9483C
16 February 2010

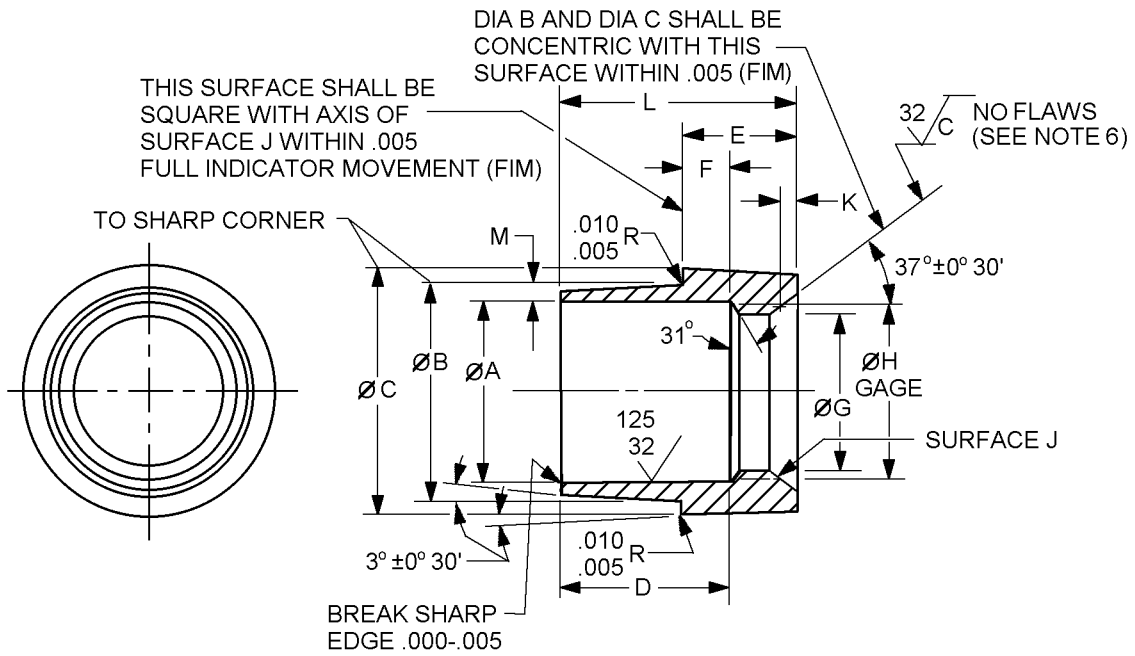
DETAIL SPECIFICATION SHEET

FERRULE, BRAZING, TUBE FITTING - CRES SAE-AMS5646, STRAIGHT

Inactive for new design after 20 September 2000.

This specification is approved for use by all Departments and Agencies
of the Department of Defense.

The requirements for acquiring the product described herein shall consist of this specification sheet and
SAE-AS4841.



Inches	mm
.005	0.13
.010	.025

FIGURE 1. Ferrule, brazing, tube fitting straight.

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Dash number	Tube OD (reference) inches (mm)	A diameter +.002 (0.05) -.000 inches (mm)	B diameter +.000 -.003 (0.08) inches (mm)	C diameter +.000 -.003 (0.08) inches (mm)	D inches (mm)
-02	.125 (3.18)	.115 (2.92)	.172 (4.37)	.267 (6.78)	.346 (8.79)
-03	.188 (4.78)	.178 (4.52)	.234 (5.94)	.329 (8.36)	.358 (9.09)
-04	.250 (6.35)	.240 (6.10)	.297 (7.54)	.383 (9.73)	.376 (9.55)
-05	.313 (7.95)	.302 (7.67)	.366 (9.30)	.445 (11.30)	.376 (9.55)
-06	.375 (9.53)	.365 (9.27)	.432 (10.97)	.502 (12.75)	.376 (9.55)
-07	.438 (11.13)	.428 (10.87)	.494 (12.55)	.564 (14.33)	.403 (10.24)
-08	.500 (12.70)	.489 (12.42)	.562 (14.27)	.682 (17.32)	.432 (10.97)
-09	.562 (14.27)	.551 (14.00)	.626 (15.90)	.743 (18.87)	.451 (11.46)
-10	.625 (15.88)	.614 (15.60)	.690 (17.53)	.797 (20.24)	.479 (12.17)
-11	.688 (17.48)	.677 (17.20)	.762 (19.35)	.908 (23.06)	.510 (12.95)
-12	.750 (19.05)	.739 (18.77)	.826 (20.98)	.972 (24.69)	.510 (12.95)
-14	.875 (22.23)	.864 (21.95)	.953 (24.21)	1.097 (27.86)	.510 (12.95)
-16	1.000 (25.40)	.989 (25.12)	1.081 (27.46)	1.222 (31.04)	.510 (12.95)
-18	1.125 (28.58)	1.114 (28.30)	1.209 (30.71)	1.409 (35.79)	.510 (12.95)
-20	1.250 (31.75)	1.239 (31.47)	1.339 (34.01)	1.534 (38.96)	.510 (12.95)
-24	1.500 (38.10)	1.484 (37.69)	1.609 (40.87)	1.784 (45.31)	.510 (12.95)
-28	1.750 (44.45)	1.734 (44.04)	1.882 (47.80)	2.159 (54.84)	.510 (12.95)
-32	2.000 (50.80)	1.984 (50.39)	2.159 (54.84)	2.409 (61.19)	.510 (12.95)
-40	2.500 (63.50)	2.484 (63.09)	2.659 (67.54)	2.911 (73.94)	.510 (12.95)
-48	3.000 (76.20)	2.984 (75.79)	3.172 (80.57)	3.411 (86.64)	.510 (12.95)

FIGURE 1. Ferrule, brazing, tube fitting straight - Continued.

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Dash number	E inches (mm)	F inches (mm)	G diameter inches (mm)	H diameter gage inches (mm)	K inches (mm)
-02	.235 (5.97)	.100 (2.54)	.090 (2.29)	.124 (3.15)	.041 (1.04)
-03	.235 (5.97)	.100 (2.54)	.150 (3.81)	.185 (4.70)	.040 (1.02)
-04	.235 (5.97)	.100 (2.54)	.200 (5.08)	.242 (6.15)	.036 (0.91)
-05	.235 (5.97)	.100 (2.54)	.260 (6.60)	.302 (7.67)	.035 (0.89)
-06	.228 (5.79)	.100 (2.54)	.320 (8.13)	.358 (9.09)	.031 (0.79)
-07	.255 (6.48)	.120 (3.05)	.385 (9.78)	.430 (10.92)	.036 (0.91)
-08	.285 (7.24)	.120 (3.05)	.438 (11.13)	.504 (12.80)	.044 (1.12)
-09	.295 (7.49)	.150 (3.81)	.500 (12.70)	.555 (14.10)	.036 (0.91)
-10	.302 (7.67)	.150 (3.81)	.562 (14.27)	.621 (15.77)	.039 (0.99)
-11	.305 (7.75)	.120 (3.05)	.625 (15.88)	.698 (17.73)	.048 (1.22)
-12	.306 (7.77)	.120 (3.05)	.688 (17.48)	.769 (19.53)	.054 (1.37)
-14	.325 (8.26)	.130 (3.30)	.812 (20.62)	.894 (22.71)	.054 (1.37)
-16	.342 (8.69)	.140 (3.56)	.938 (23.83)	1.021 (25.93)	.055 (1.40)
-18	.370 (9.40)	.140 (3.56)	1.062 (26.97)	1.174 (29.82)	.074 (1.88)
-20	.397 (10.08)	.160 (4.06)	1.188 (30.18)	1.299 (32.99)	.074 (1.88)
-24	.405 (10.29)	.180 (4.57)	1.438 (36.53)	1.532 (38.91)	.062 (1.57)
-28	.405 (10.29)	.100 (2.54)	1.688 (42.88)	1.839 (46.71)	.100 (2.54)
-32	.405 (10.29)	.100 (2.54)	1.938 (49.23)	2.099 (53.31)	.107 (2.72)
-40	.405 (10.29)	.100 (2.54)	2.438 (61.93)	2.594 (65.89)	.117 (2.97)
-48	.405 (10.29)	.100 (2.54)	2.938 (74.63)	3.099 (78.71)	.107 (2.72)

FIGURE 1. Ferrule, brazing, tube fitting straight - Continued.

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Dash number	L reference inches (mm)	M minimum inches (mm)	Approx weight lb/100 (kg/100)
-02	.481 (12.22)	.023 (.58)	.356 (0.16)
-03	.493 (12.52)	.023 (.58)	.488 (0.22)
-04	.511 (12.98)	.023 (.58)	.615 (0.28)
-05	.511 (12.98)	.027 (.69)	.783 (0.36)
-06	.504 (12.80)	.028 (.71)	.894 (0.41)
-07	.538 (13.67)	.028 (.71)	1.090 (0.49)
-08	.597 (15.16)	.031 (.79)	1.910 (0.87)
-09	.596 (15.14)	.032 (.81)	2.140 (0.97)
-10	.631 (16.03)	.033 (.84)	2.340 (1.06)
-11	.695 (17.65)	.037 (.94)	3.350 (1.52)
-12	.696 (17.68)	.038 (.97)	3.670 (1.66)
-14	.705 (17.91)	.039 (.99)	4.430 (2.01)
-16	.712 (18.08)	.041 (1.04)	5.220 (2.37)
-18	.740 (18.80)	.042 (1.07)	7.410 (3.36)
-20	.747 (18.97)	.045 (1.14)	6.670 (3.03)
-24	.735 (18.67)	.057 (1.45)	11.020 (5.00)
-28	.815 (20.70)	.069 (1.75)	18.360 (8.33)
-32	.815 (20.70)	.082 (2.08)	21.840 (9.91)
-40	.815 (20.70)	.082 (2.08)	29.900 (13.56)
-48	.815 (20.70)	.089 (2.26)	32.920 (14.93)

NOTES:

1. Dimensions are in inches.
2. Metric equivalents are given for information only.
3. Unless otherwise specified tolerances for linear dimensions are ± 0.010 inch (0.25 mm) and angular dimensions are $\pm 5^\circ$, all diameters concentric within .010 inch (0.25 mm) FIM.
4. Unless otherwise specified machined surfaces to be 125μ inches (3.18 μ m) in accordance with ASME B46.1
5. Unless otherwise specified break sharp edges .003 - .015 inches (0.08 - 0.38 mm).
6. Surface J shall be free of nicks, chatter marks, or low spots. Unbroken line of contact to show all around at other than extremities of surface J when rotated in contact with $74^\circ 0' \pm 0^\circ 1'$ included angle gage lightly coated by rubbing with carbon paper.

FIGURE 1. Ferrule, brazing, tube fitting straight - Continued.

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CONCLUDING MATERIAL

Custodians:

Navy - AS
DLA - CC

Preparing activity:

DLA - CC

(Project 4730-2011-103)

Review activity:

Navy - SA

NOTE: The activities listed above were interested in this document as of the date of this document. Since organizations and responsibilities can change, you should verify the currency of the information above using the ASSIST Online database at <https://assist.daps.dla.mil>.