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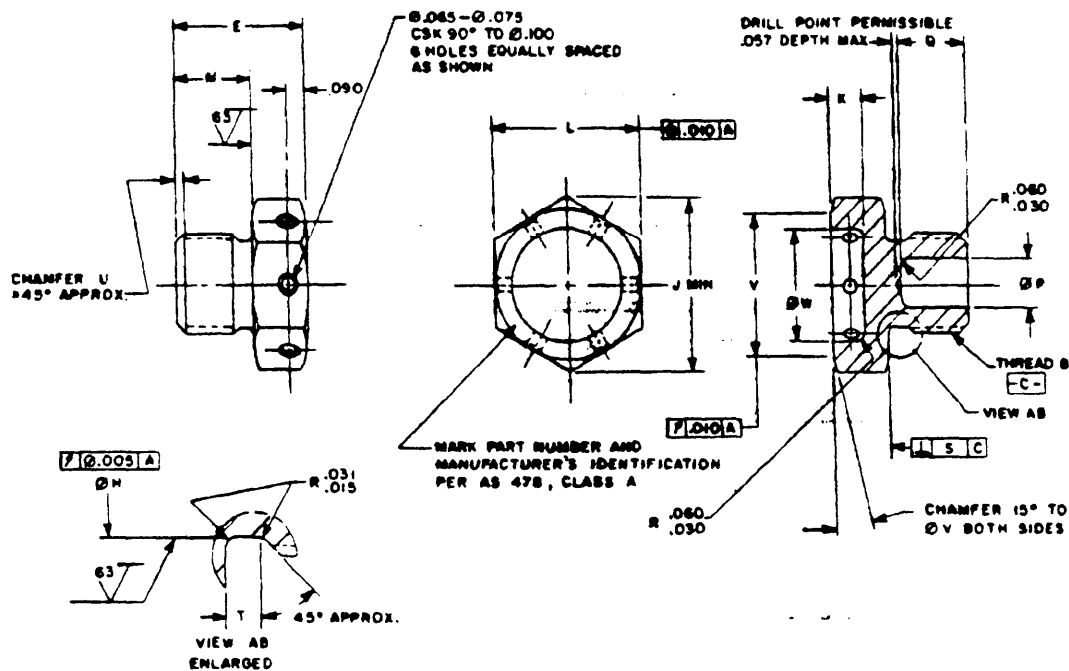
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TABLE 1. DASH NUMBERS AND DIMENSIONS

DASH NUMBER	THREAD B	E	ØH +.002 -.003	J MIN	E	L	H	ØP	Ø	S	T +.015 -.000	U	V	ØW	APPROX WEIGHT LB/100
01	.250-28 UNJF-3A	.560	.196	.482	.150	.430-.439	.320	-	-	.003	.063	.020-.050	.438	.250	1.183
02	.3125-24 UNJF-3A	.600	.250	.622	.150	.553-.564	.360	-	-	.003	.063	.020-.050	.562	.312	2.055
03	.375-24 UNJF-3A	.600	.312	.694	.150	.616-.627	.360	-	-	.003	.063	.020-.050	.625	.375	2.644
04	.4375-20 UNJF-3A	.660	.364	.766	.150	.679-.690	.400	-	-	.003	.075	.030-.060	.688	.438	3.657
05	.500-20 UNJF-3A	.670	.426	.837	.150	.741-.752	.400	.219	.360	.003	.075	.030-.060	.750	.500	4.277
06	.5625-18 UNJF-3A	.680	.481	.907	.150	.803-.814	.400	.219	.360	.003	.083	.040-.070	.812	.562	5.307
07	.625-18 UNJF-3A	.730	.544	.978	.160	.865-.877	.440	.312	.380	.003	.083	.040-.070	.875	.625	6.334
08	.750-16 UNJF-3A	.730	.660	1.121	.160	.990-1.002	.440	.438	.480	.003	.094	.040-.070	1.000	.750	7.995
09	.8125-16 UNJF-3A	.740	.722	1.191	.160	1.052-1.064	.440	.500	.480	.003	.094	.040-.070	1.062	.812	9.199
10	.875-14 UNJF-3A	.740	.733	1.263	.160	1.115-1.127	.440	.548	.400	.003	.107	.050-.080	1.125	.875	10.122
11	1.000-12 UNJF-3A	.780	.882	1.475	.190	1.301-1.314	.440	.657	.400	.005	.125	.050-.080	1.312	1.000	14.608
12	1.0625-12 UNJF-3A	.830	.945	1.475	.200	1.301-1.314	.480	.719	.400	.005	.125	.050-.080	1.312	1.000	15.891
14	1.1875-12 UNJF-3A	.830	1.070	1.619	.200	1.427-1.440	.480	.844	.400	.005	.125	.050-.080	1.438	1.125	18.582
16	1.3125-12 UNJF-3A	.840	1.195	1.833	.200	1.614-1.627	.480	.969	.400	.005	.125	.050-.080	1.625	1.312	23.436
18	1.500-12 UNJF-3A	.840	1.382	1.974	.200	1.738-1.752	.480	1.156	.400	.005	.125	.050-.080	1.750	1.438	27.369
20	1.625-12 UNJF-3A	.850	1.507	2.117	.200	1.863-1.877	.480	1.281	.400	.005	.125	.050-.080	1.875	1.562	31.827
24	1.875-12 UNJF-3A	.860	1.756	2.402	.200	2.113-2.127	.480	1.531	.400	.005	.125	.050-.080	2.124	1.812	40.949
28	2.250-12 UNJF-3A	.870	2.131	2.830	.200	2.488-2.502	.480	1.906	.400	.005	.125	.050-.080	2.500	2.188	56.454
32	2.500-12 UNJF-3A	.870	2.381	3.115	.200	2.738-2.752	.480	2.156	.400	.005	.125	.050-.080	2.750	2.438	67.139

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USER ACTIVITIES

REVIEWER ACTIVITIES:  
AIR FORCE-99  
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PA NAVY - AS Other Cost	INTERNATIONAL INTEREST	TITLE PLUG, MACHINE THREAD DRILLED, PREFORMED PACKING MIL-S-8879 THREAD	MILITARY STANDARD
AIR FORCE-II			MS9902
PROCUREMENT SPECIFICATION NONE	SUPERSEDES	MS 9404	PAGE 1 OF 2

AMSC N/A

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5365-0120

APPROVED 11 MAR 70  
REVISED 30 SEPT 87

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## REQUIREMENTS:

1. MATERIAL: CORROSION AND HEAT RESISTANT STEEL AMS 5446.
2. THREADS: THREADS IN ACCORDANCE WITH MIL-S-8879.
3. SURFACE TEXTURE: SURFACE TEXTURE, UNLESS OTHERWISE SPECIFIED, SHALL BE 125 MICROINCHES IN ACCORDANCE WITH ANSI B46.1.
4. FLUORESCENT PENETRANT INSPECTION: FLUORESCENT PENETRANT INSPECTION PER AMS 2645.
5. TOLERANCES: UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE FOR LINEAR DIMENSIONS  $\pm .010$ , ANGULAR DIMENSIONS  $\pm 5^\circ$ .
6. DIAMETER "B" SHALL BE FREE FROM TOOL MARKS.
7. EDGES: BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
8. PART NUMBER: THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER FROM TABLE 1.

EXAMPLE: MS9902-01

└── DASH NUMBER

└── BASIC MS NUMBER

MS9902-01 INDICATES - PLUG, MACHINE THREAD - DRILLED, PREFORMED PACKING, MIL-S-8879 THREAD;  
.250-28 UNUT-3A.

## NOTES:

1. ALL DIMENSIONS ARE IN INCHES.
2. DO NOT USE UNASSIGNED PART NUMBERS.
3. IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS STANDARD AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE.
4. REFERENCED GOVERNMENT (OR NON-GOVERNMENT) DOCUMENTS OF THE ISSUE LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION FORM A PART THIS STANDARD TO THE EXTENT SPECIFIED HEREIN.
5. THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE GAO AEROSPACE PRODUCTION DIVISION.
6. AS AND AMS ARE SAE PUBLICATIONS.

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APPROVED 11 MAR 70 REVISED 11 MAR 70 FOR CHANGES SEE PAGES 1 AND 2

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