

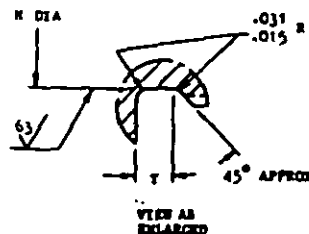
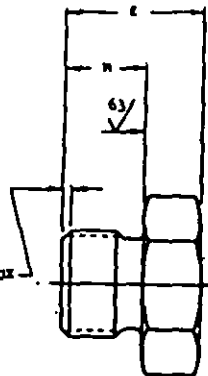
User activities:
Navy - AS, MC, CO,

Revision activities:
Air Force - 92
Navy - AS

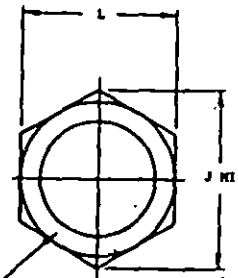
This standard has been approved by the Department of the Air Force (11) and the Department of the Navy and is mandatory for use by their activities. All other military activities are required to comply with this standard when adopted.

MS9953

CHAMFER U
= 45° APPROX

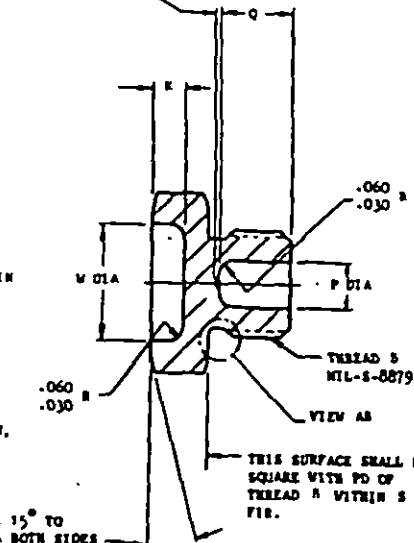


MARK PART NUMBER AND
MANUFACTURER'S IDENTIFICATION,
PER AS 478, CLASS A



CHAMFER 15° TO
V DIA BOTH SIDES

DRILL POINT PERMISSIBLE
.057 DEPTH MAX



FED. SUP CLASS
4730

PART NO.	THREAD S	E	H +.002 -.003	J MIN	K	L	M	P	Q	R	T +.015 -.005	U	V	W	APPROX WEIGHT LB/100
MS9953-01	.250-28 UNJF-3A	.480	.196	.482	.070	.430-.439	.320	-	-	.003	.063	.020-.050	.438	.250	.349
MS9953-02	.3125-24 UNJF-3A	.550	.250	.662	.100	.553-.564	.360	-	-	.003	.063	.020-.050	.562	.312	.660
MS9953-03	.375-24 UNJF-3A	.550	.312	.694	.100	.616-.627	.360	-	-	.003	.063	.020-.050	.625	.375	.855
MS9953-04	.4375-20 UNJF-3A	.620	.364	.766	.110	.679-.690	.400	-	-	.003	.075	.030-.060	.688	.438	1.226
MS9953-05	.500-20 UNJF-3A	.620	.426	.837	.100	.741-.752	.400	-	-	.003	.075	.030-.060	.750	.500	1.536
MS9953-06	.5625-18 UNJF-3A	.650	.481	.907	.120	.803-.814	.400	-	-	.003	.083	.040-.070	.812	.562	1.952
MS9953-07	.625-18 UNJF-3A	.690	.544	.978	.120	.865-.877	.440	-	-	.003	.083	.040-.070	.875	.625	2.439
MS9953-08	.750-16 UNJF-3A	.690	.660	1.121	.120	.990-1.002	.440	.250	.400	.003	.094	.040-.070	1.000	.750	3.122
MS9953-09	.8125-16 UNJ-3A	.690	.722	1.191	.110	1.052-1.064	.440	.312	.400	.003	.094	.040-.070	1.062	.812	3.565
MS9953-10	.875-14 UNJF-3A	.740	.773	1.263	.160	1.115-1.127	.440	.375	.400	.003	.107	.050-.080	1.125	.875	4.749
MS9953-11	1.000-12 UNJF-3A	.750	.882	1.475	.160	1.301-1.314	.440	.500	.400	.005	.125	.050-.080	1.312	1.000	5.690
MS9953-12	1.0625-12 UNJ-3A	.790	.945	1.475	.160	1.301-1.314	.480	.562	.400	.005	.125	.050-.080	1.312	1.000	6.057
MS9953-14	1.1875-12 UNJ-3A	.790	1.070	1.619	.160	1.427-1.440	.480	.688	.400	.005	.125	.050-.080	1.438	1.125	7.100
MS9953-16	1.3125-12 UNJ-3A	.840	1.195	1.833	.200	1.614-1.627	.480	.812	.400	.005	.125	.050-.080	1.625	1.312	9.277
MS9953-18	1.500-12 UNJF-3A	.840	1.382	1.974	.200	1.738-1.752	.480	1.000	.400	.005	.125	.050-.080	1.750	1.438	10.867
MS9953-20	1.625-12 UNJ-3A	.840	1.507	2.117	.190	1.863-1.877	.480	1.125	.400	.005	.125	.050-.080	1.875	1.562	12.465
MS9953-24	1.875-12 UNJ-3A	.840	1.756	2.402	.180	2.113-2.127	.480	1.375	.400	.005	.125	.050-.080	2.125	1.812	15.808
MS9953-28	2.250-12 UNJ-3A	.870	2.131	2.830	.200	2.488-2.502	.480	1.750	.400	.005	.125	.050-.080	2.500	2.188	21.620
MS9953-32	2.500-12 UNJ-3A	.870	2.381	3.115	.200	2.738-2.752	.480	2.000	.400	.005	.125	.050-.080	2.750	2.438	26.032

- HEXAGON AND DIAMETER V SHALL BE CONCENTRIC WITH THREAD PD WITHIN .010 FIR.
 - DIAMETER H SHALL BE CONCENTRIC WITH THREAD PD WITHIN .005 FIR AND FREE FROM THREAD TOOL MARKS.
 - MATERIAL: ALUMINUM AMS 4121.
 - FINISH: ANODIC TREATMENT AMS 2470. DO NOT DYE.
 - SURFACE TEXTURE: USAS B46.1 - 1962. UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICROINCHES.
 - FLUORESCENT PERMEANT INSPECTION PER AMS 2645.
 - BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
 - DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED: TOLERANCES; LINEAR DIMENSIONS $\pm .010$, ANGULAR DIMENSIONS $\pm 30^\circ$.
 - DO NOT USE UNASSIGNED PART NUMBERS.
 - INTERNATIONAL STANDARDIZATION: CERTAIN PROVISIONS OF THIS STANDARD ARE THE SUBJECT OF INTERNATIONAL STANDARDIZATION AGREEMENTS ASSC AIR STD 17/15. WHEN REVISION OR CANCELLATION OF THIS STANDARD IS PROPOSED, THE DEPARTMENTAL CUSTODIANS WILL INFORM THEIR RESPECTIVE DEPARTMENTAL STANDARDIZATION OFFICE SO THAT APPROPRIATE ACTION MAY BE TAKEN RESPECTING THE INTERNATIONAL AGREEMENT CONCERNED.
- AS AND AMS ARE SOCIETY OF AUTOMOTIVE ENGINEERS, INC., PUBLICATIONS.
THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AEROSPACE PART STANDARDS DIVISION.

P.A. AIR FORCE-11 Other Comd NAVY - AS	INTERNATIONAL INTEREST	TITLE PLUG, MACHINE THREAD - AMS 4121, PREFORMED PACKING, MIL-S-8879 THREAD	MILITARY STANDARD MS9953
PROCUREMENT SPECIFICATION	SUPERSEDES		SHEET 1 OF 1

DD FORM 672-1 (Limited circulation)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

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APPROVED 7 Dec 70