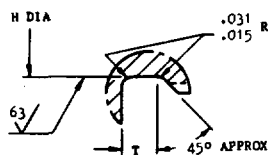
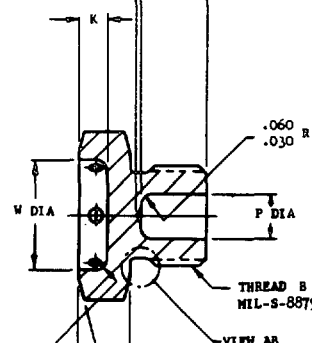


User activities:  
Navy - AS, MC, CGReview activities:  
Air Force - II  
Navy

This standard has been issued by the Department of the Air Force (II) and the Department of the Navy and is mandatory for use by the Department of the Navy. All other military activities are required to employ this standard where suitable.

**MS9954**CHAMFER U  
= 45° APPROXVIEW AB  
ENLARGED.065-.075 DIA  
CSK .005 TO .100 DIA  
6 HOLES EQUALLY SPACED  
AS SHOWNMARK PART NUMBER AND  
MANUFACTURER'S IDENTIFICATION,  
PER AS 478, CLASS ACHAMFER 15° TO  
V DIA BOTH SIDESDRILL POINT PERMISSIBLE  
.057 DEPTH MAXTHIS SURFACE SHALL BE  
SQUARE WITH PD OF  
THREAD B WITHIN 5  
FIR.

PART NO.	THREAD B	E	H +.002 -.003	J MIN	K	L	M	P	Q	S	T +.015 -.000	U	V	W	APPROX WEIGHT LB/100
MS9954-01	.250-28 UNJF-3A	.560	.196	.482	.150	.430-.439	.320	-	-	.003	.063	.020-.050	.438	.250	.421
MS9954-02	.3125-24 UNJF-3A	.600	.250	.622	.150	.553-.564	.360	-	-	.003	.063	.020-.050	.562	.312	.731
MS9954-03	.375-24 UNJF-3A	.600	.312	.694	.150	.616-.627	.360	-	-	.003	.063	.020-.050	.625	.375	.942
MS9954-04	.4375-20 UNJF-3A	.660	.364	.766	.150	.679-.690	.400	-	-	.003	.075	.030-.060	.688	.438	1.301
MS9954-05	.500-20 UNJF-3A	.670	.426	.837	.150	.741-.752	.400	-	-	.003	.075	.030-.060	.750	.500	1.654
MS9954-06	.5625-18 UNJF-3A	.680	.481	.907	.150	.803-.814	.400	-	-	.003	.083	.040-.070	.812	.562	2.021
MS9954-07	.625-18 UNJF-3A	.730	.544	.978	.160	.865-.877	.440	-	-	.003	.083	.040-.070	.875	.625	2.554
MS9954-08	.750-16 UNJF-3A	.730	.660	1.121	.160	.990-1.002	.440	.250	.400	.003	.094	.040-.070	1.000	.750	3.265
MS9954-09	.8125-16 UNJF-3A	.740	.722	1.191	.160	1.052-1.064	.440	.312	.400	.003	.094	.040-.070	1.062	.812	3.769
MS9954-10	.875-14 UNJF-3A	.740	.773	1.263	.160	1.115-1.127	.440	.375	.400	.003	.107	.050-.080	1.125	.875	4.122
MS9954-11	1.000-12 UNJF-3A	.780	.882	1.475	.190	1.301-1.314	.440	.500	.400	.003	.125	.050-.080	1.312	1.000	5.792
MS9954-12	1.0625-12 UNJF-3A	.830	.945	1.475	.200	1.301-1.314	.480	.562	.400	.003	.125	.050-.080	1.312	1.000	6.307
MS9954-14	1.1875-12 UNJF-3A	.830	1.070	1.619	.200	1.427-1.440	.480	.688	.400	.003	.125	.050-.080	1.438	1.125	7.388
MS9954-16	1.3125-12 UNJF-3A	.840	1.195	1.833	.200	1.614-1.627	.480	.812	.400	.003	.125	.050-.080	1.625	1.312	9.243
MS9954-18	1.500-12 UNJF-3A	.840	1.382	1.974	.200	1.738-1.752	.480	1.000	.400	.003	.125	.050-.080	1.750	1.438	10.841
MS9954-20	1.625-12 UNJF-3A	.850	1.507	2.117	.200	1.863-1.877	.480	1.125	.400	.003	.125	.050-.080	1.875	1.562	12.556
MS9954-24	1.875-12 UNJF-3A	.860	1.756	2.402	.200	2.113-2.127	.480	1.375	.400	.003	.125	.050-.080	2.125	1.812	16.059
MS9954-28	2.250-12 UNJF-3A	.870	2.131	2.830	.200	2.488-2.502	.480	1.750	.400	.003	.125	.050-.080	2.500	2.188	21.965
MS9954-32	2.500-12 UNJF-3A	.870	2.381	3.115	.200	2.738-2.752	.480	2.000	.400	.003	.125	.050-.080	2.750	2.438	26.026

1. HEXAGON AND DIAMETER V SHALL BE CONCENTRIC WITH THREAD PD WITHIN .010 FIR.
2. DIAMETER H SHALL BE CONCENTRIC WITH THREAD PD WITHIN .005 FIR AND FREE FROM THREAD TOOL MARKS.
3. MATERIAL: ALUMINUM AMS 4121
4. FINISH: ANODIC TREATMENT AMS 2470. DO NOT DYE
5. SURFACE TEXTURE: USAS B46.1 - 1962, UNLESS OTHERWISE SPECIFIED SURFACES TO BE 125 MICROINCHES.
6. FLUORESCENT PENETRANT INSPECTION PER AMS 2645.
7. BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED.
8. DIMENSION IN INCHES. UNLESS OTHERWISE SPECIFIED: TOLERANCES; LINEAR DIMENSIONS  $\pm .010$ , ANGULAR DIMENSIONS  $\pm .0^\circ$
9. DO NOT USE UNASSIGNED PART NUMBERS.

INTERNATIONAL STANDARDIZATION: CERTAIN PROVISIONS OF THIS STANDARD ARE THE SUBJECT OF INTERNATIONAL STANDARDIZATION AGREEMENTS ASOC 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.

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THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE MILITARY SERVICES BY THE SAE AEROSPACE PART STANDARDS DIVISION.

P.A. AIR FORCE-11	INTERNATIONAL INTEREST	TITLE PLUG, MACHINE THREAD-DRILLED, AMS 4121, PREFORMED PACKING, MIL-S-8879 THREAD	MILITARY STANDARD
Other Cust NAVY - AS	SEE NOTE 9		<b>MS9954</b>
PROCUREMENT SPECIFICATION	SUPERSEDES:	MS9015-08 Thru -32	SHEET 1 OF 1

DD FORM 672-1 (Limited coordination)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

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