

User Activities: Army-ME, AV
Navy-AS
Air Force-99

Review activities: Army-ME, AV
Navy-AS
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DLA-CS

This standard is approved for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document when applicable.

FED. SUP. CLASS 4730		
	CONCENTRICITY: F AND T (PITCH DIAMETER) SHALL BE CONCENTRIC WITHIN .005 TOTAL INDICATOR READING. SQUARENESS BETWEEN THREAD T AND FACE OF HEX SHALL NOT EXCEED .005 WHEN MEASURED AT DIAMETER E. MATERIAL: STEEL, ALUMINUM ALLOY; BARS OR SHAPES. TITANIUM ALLOY; BARS, SHAPES, OR FORGINGS. SEE PROCUREMENT SPECIFICATION. FINISH: SEE PROCUREMENT SPECIFICATION. ADD L TO PART NUMBER TO INDICATE NIPPLE WITH LOCKWIRE HOLES. NO CODE LETTER IN PART NUMBER FOR STEEL. Ⓒ ADD D IN PLACE OF DASH FOR ALUMINUM ALLOY (EXCEPT 7075-T73). Ⓒ ADD T IN PLACE OF DASH FOR TITANIUM ALLOY. TITANIUM IS NOT RECOMMENDED FOR USE IN OXYGEN SYSTEMS. Ⓒ ADD W IN PLACE OF DASH FOR 7075-T73 ALUMINUM ALLOY. EXAMPLE OF PART NUMBERS: MS24487-4 - NIPPLE, 1/4 TUBING, STEEL, WITHOUT LOCKWIRE HOLES. Ⓒ MS24487DAL - NIPPLE, 1/4 TUBING, ALUMINUM ALLOY (EXCEPT 7075-T73), WITH LOCKWIRE HOLES. MS24487TBL - NIPPLE, 1/2 TUBING, TITANIUM ALLOY, WITH LOCKWIRE HOLES. Ⓒ MS24487WBL - NIPPLE, 1/2 TUBING, 7075-T73 ALUMINUM ALLOY, WITH LOCKWIRE HOLES. BREAK ALL SHARP EDGES AND REMOVE ALL HANGING BURRS AND SLIVERS WHICH MIGHT BECOME DISLODGED UNDER USAGE. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: FRACTIONS $\pm 1/64$, DECIMALS $\pm .005$, ANGLES $\pm 1/2^\circ$. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID. Ⓒ denotes changes	
P.A. Air Force-99 Other Cust	International Interest	TITLE NIPPLE, TUBE, 37° TO 45° SEAT
Procurement Specification MIL-F-5509		SUPERSEDES:
MILITARY STANDARD MS24487		PAGE 1 OF 2

APPROVED 11 APR 58 REVISED (A) 10 FEB 67 (B) 16 JUN 78 (C) 22 MAR 79

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DD FORM 672
1 MAY 73

(Coordinate) with the provisions of the present and subsequent.

4730-1013

P.A. Air Force-99 Other Cust	Intentional Intersect	TITLE NIPPLE, TUBE, 3/8 TO 4.5" DIA	MILITARY STANDARD
Prescription Specification MIL-F-5509		SUPERSEDES	MS24487 PAGE 2 OF 2

DASH NO.	TUBING OD	THREAD T (REF)	A DIA (REF)	E (REF)	F +.002 -.003 DIA	J (REF)	K	M	O +.015 -.000	P DIA	WEIGHT MAX (LBS.)			
											STEEL	AL ALLOY	CRES	TI ALLOY
2	1/8	5/16-24UNJF-3A	.062	.563	.250	.448	5/16	63/64	.063	7/32				
3	3/16	3/8-24UNJF-3A	.125	.625	.312	.479	21/64	1-1/32	.063	9/32				
4	1/4	7/16-20UNJF-3A	.172	.688	.364	.550	3/8	1-7/32	.075	11/32				
5	5/16	1/2-20UNJF-3A	.234	.750	.426	.550	3/8	1-7/32	.075	13/32				
6	3/8	9/16-18UNJF-3A	.297	.813	.481	.556	27/64	1-5/16	.083	15/32				
8	1/2	3/4-16UNJF-3A	.391	1.000	.660	.657	15/32	1-1/2	.094	5/8				
10	5/8	7/8-14UNJF-3A	.484	1.125	.773	.758	17/32	1-13/64	.107	3/4				
12	3/4	1-1/16-12UNJ-3A	.509	1.375	.945	.864	19/32	1-29/32	.125	15/16				
16	1	1-5/16-12UNJ-3A	.844	1.625	1.195	.911		1-61/64		1-3/16				

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REVISED For changes see page 1. 22 MAR 79

FED. SUP CLASS
4730