

User activities:

Review activities: ARMY - ME - AV  
NAVY - AS  
DSC - CS

This Military Standard is approved for use by HQ AFCLC CASO/LODS, Federal Center, Bolling Creek, MI 49016, Department of the Air Force, and is available for use by all Departments and agencies of the Department of Defense.

FED. SUP CLASS 4730	
	<p>ACROSS WRENCH PADS</p> <p>DRILL DEPTH Q    THREAD T</p>
<p>TOLERANCE UP TO AND INCLUDING -6 SIZE <math>\pm 2 \frac{1}{2}^\circ</math>, ABOVE -6 SIZE <math>\pm 1 \frac{1}{2}^\circ</math></p> <p>FITTING IN ACCORDANCE WITH MS24385, STYLE G, FOR TUBE SIZE SPECIFIED. 3 ENDS</p>	
<p>(a) MARK EACH WRENCH PAD WITH AN EQUILATERAL TRIANGLE TO DENOTE PRECISION TYPE. MARKING SHALL BE DEPRESSED .025 <math>\pm</math> .010.</p> <p>MATERIAL: STEEL; ALUMINUM ALLOY; CORROSION RESISTANT STEEL (CRES); TITANIUM ALLOY; BARS, SHAPES, OR FORGINGS (SEE PROCUREMENT SPECIFICATION).</p> <p>FINISH: SEE PROCUREMENT SPECIFICATION.</p> <p>NO CODE LETTER IN PART NUMBER FOR STEEL.</p> <p>ADD D IN PLACE OF DASH FOR ALUMINUM ALLOY (EXCEPT 7075-T73).</p> <p>ADD J IN PLACE OF DASH FOR CRES, TYPE 304.</p> <p>ADD K IN PLACE OF DASH FOR CRES, TYPE 316.</p> <p>ADD S IN PLACE OF DASH FOR CRES, TYPE 347.</p> <p>ADD T IN PLACE OF DASH FOR TITANIUM ALLOY.</p> <p>ADD W IN PLACE OF DASH FOR 7075-T73 ALUMINUM ALLOY.</p> <p>TITANIUM IS NOT RECOMMENDED FOR USE IN OXYGEN SYSTEMS.</p> <p>EXAMPLE OF PART NUMBERS:</p> <p>MS24402-8 - TEE, 1/2 TUBING, STEEL.</p> <p>MS24402D8 - TEE, 1/2 TUBING, ALUMINUM ALLOY (EXCEPT 7075-T73).</p> <p>MS24402J8 - TEE, 1/2 TUBING, CRES, TYPE 304.</p> <p>MS24402K8 - TEE, 1/2 TUBING, CRES, TYPE 316.</p> <p>MS24402S8 - TEE, 1/2 TUBING, CRES, TYPE 347.</p> <p>MS24402T8 - TEE, 1/2 TUBING, TITANIUM ALLOY.</p> <p>MS24402W8 - TEE, 1/2 TUBING, 7075-T73 ALUMINUM ALLOY.</p> <p>BREAK ALL SHARP EDGES AND REMOVE ALL HANGING BURRS AND SLIVERS.</p> <p>DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: FRACTIONS <math>\pm 1/64</math>, DECIMALS <math>\pm .005</math>, ANGLES <math>\pm 1/2^\circ</math>.</p> <p>IN ADDITION TO THE SAMPLING REQUIREMENTS OF THE PROCUREMENT SPECIFICATION, THE SURFACE OF THE CONE ENDS ON 100Z OF THE TEES OF A LOT SHALL BE INSPECTED.</p> <p>FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.</p> <p>REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.</p>	
(D) DENOTES CHANGES	
<p>P.A. AIR FORCE-99 (D) TITLE</p> <p>Other Case</p> <p>AIR FORCE-99</p>	<p><b>TEE, TUBE, PRECISION TYPE</b></p>
<p>PROCUREMENT SPECIFICATION</p> <p>MIL-F-5509</p>	<p><b>MILITARY STANDARD</b></p> <p><b>MS 24402</b></p>
<p>SUPERSEDES:</p> <p><del>AN024</del> (D)</p>	<p>SHEET 1 OF 2</p>

APPROVED 6 MAR 58    REVISED (A) 10 FEB 67 (B) 16 JUN 78 (C) 22 MAR 79 (D) 16 APR 22

DASH NO.	TUBING OD	THREAD T (REF)	Q +3/64 -0	II RAD	V ± .015	W APPROX	X APPROX
2	1/8	5/16-24UNJF-3A	47/64	1/16	5/16	5/16	3/16
3	3/16	1/8-24UNJF-3A	51/64		3/8	3/8	1/4
4	1/4	7/16-20UNJF-3A	55/64		7/16		
5	5/16	1/2-20UNJF-3A	59/64		1/2	15/32	5/16
6	3/8	9/16-18UNJF-3A	1- 1/32	3/32	9/16	1/2	
8	1/2	3/4-16UNJF-3A	1- 7/32		3/4	11/16	7/16
10	5/8	7/8-14UNJF-3A	1-27/64	1/8	7/8	25/32	
12	3/4	1-1/16-12UNJ-3A	1- 5/8		1-1/16	29/32	1/2
16	1	1-5/16-12UNJ-3A	1-25/32		1-5/16	1- 3/32	5/8
20	1-1/4	1-5/8-12UNJ-3A	2- 1/32		1-5/8	1- 5/16	3/4
24	1-1/2	1-7/8-12UNJ-3A	2-19/64		1-7/8	1- 1/2	7/8
28	1-3/4	2-1/4-12UNJ-3A	2-25/32		2-1/4	1-25/32	1-1/16
32	2	2-1/2-12UNJ-3A	1- 1/32	3/16	2-9/16	2- 1/32	1-3/16

User activities:  
Review activities: ARMY-ME, AV  
NAVY-AS  
DSC-CS

This Military Standard is approved for use by HQ AFLC, CASO/LODS, Federal Center, Ballis Creek, MI 48016, Department of the Air Force, and is available for use by all Departments and agencies of the Department of Defense.

APPROVED 6 MAR 58 REVISED D FOR CHANGES SEE PAGES 1 & 2. 16 Apr 82

P.A. AIR FORCE-99 Other Code AIR FORCE-99	<b>D</b> TITLE TEE, TUBE, PRECISION TYPE	MILITARY STANDARD <b>MS24402</b>
PROCUREMENT SPECIFICATION MIL-F-5509	SUPERSEDES: <del>AN624</del> <b>D</b>	SHEET 2 OF 2