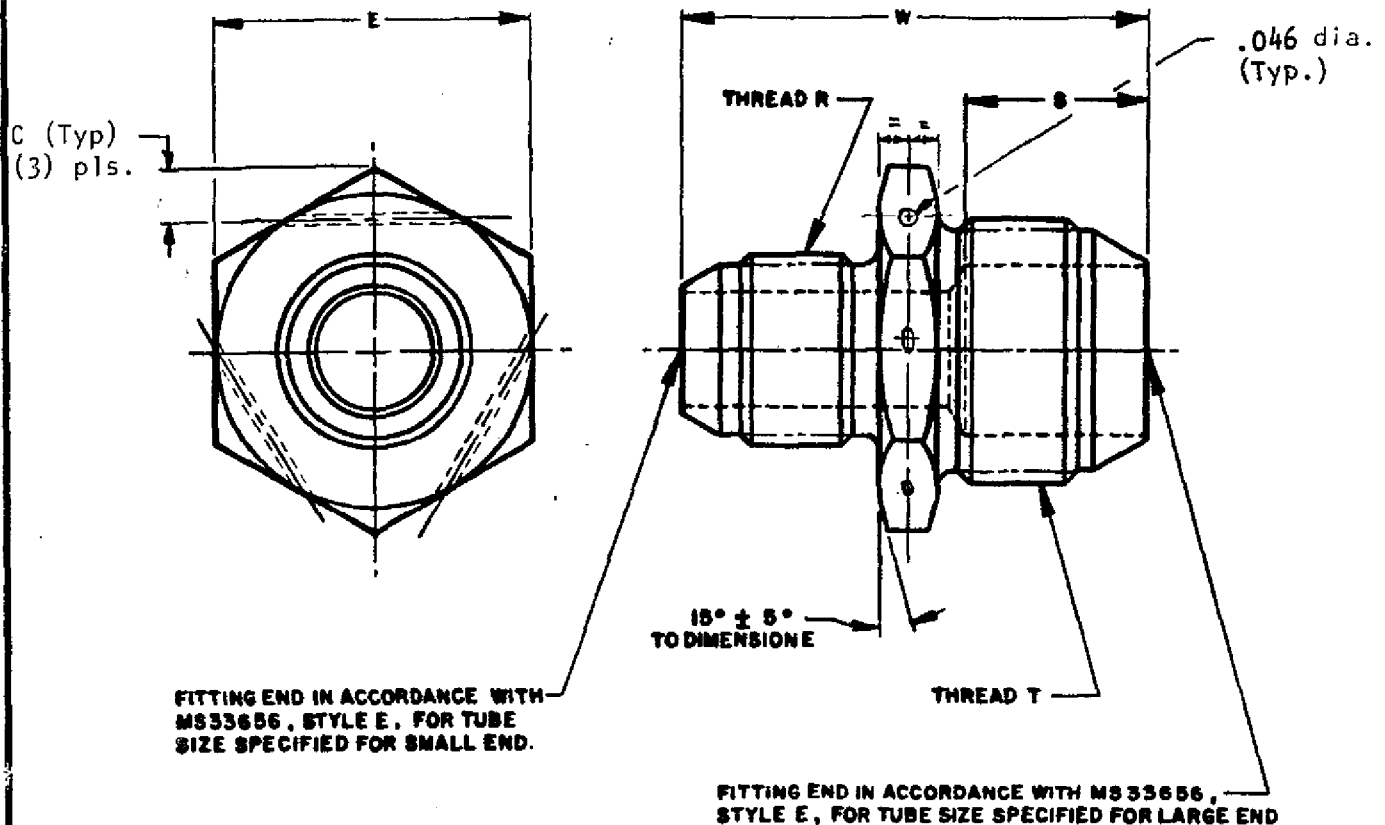




## STANDARDS SHEET



(a) Tolerances on hex dimensions shall be in accordance with MS33656. Titanium not for use in oxygen systems.

Material: Aluminum alloy; bars, shapes or forgings.

Steel; bars, shapes, or forgings. Titanium alloy-bars, shapes or forgings.

Corrosion resistant steel - bars, shapes, or forgings.

Finish: See Procurement Specification.

Break all sharp edges and remove all hanging burrs and slivers which might become dislodged under usage.

Dimensions in inches. Unless otherwise specified, tolerances: Fraction  $\pm 1/64$ , Decimals  $\pm .005$ , Angles  $\pm 1/2$ .

MAKE FROM AN919 REDUCER AND REWORK BY ADDING WIRE LOCKING HOLES TO AN919 REDUCER OF CORRESPONDING DASH NO.

Procurement Specification: MIL-F-5509.

| DRAWN    | GILCHRIST        | CLASSIFICATION                      | STANDARD |
|----------|------------------|-------------------------------------|----------|
| CHECKED  | <i>P. L. H.</i>  | REDUCER-EXTERNAL THREAD FLARED TUBE | CSP 430  |
| STRESSED | <i>M. Hood</i>   |                                     |          |
| APPROVED | <i>SCHREIBER</i> |                                     |          |

## STANDARDS SHEET

| DASH NO. | LARGE END |                | SMALL END |               | E     | W       | S     | C    |
|----------|-----------|----------------|-----------|---------------|-------|---------|-------|------|
|          | TUBE OD   | THREAD T REF   | TUBE OD   | THREAD R REF  |       |         |       |      |
| -0       | 3/16      | 3/8 -24UNJF-3A | 1/8       | 5/16-24UNF-3A | .625  | 1-11/64 | 5/8   | .080 |
| -1       | 1/4       | 7/16-20UNJF-3A |           |               | .688  | 1- 1/4  | 11/16 | .080 |
| -2       |           |                | 3/16      | 3/8 -24UNF-3A |       | 1- 9/32 | 37/64 |      |
| -3       | 5/16      | 1/2 -20UNJF-3A | 1/4       | 7/16-20UNF-3A | .750  | 1-23/64 | 39/64 | .100 |
| -4       |           |                | 1/8       | 5/16-24UNF-3A | .813  | 1-19/64 | 5/8   | .100 |
| -5       | 3/8       | 9/16-18UNJF-3A | 3/16      | 3/8-24UNF-3A  |       | 1-21/64 |       |      |
| -6       |           |                | 1/4       | 7/16-20UNF-3A |       | 1-13/32 |       |      |
| -7       |           |                | 5/16      | 1/2 -20UNF-3A |       |         |       |      |
| -8       |           |                | 1/8       | 5/16-24UNF-3A | 1.000 | 1-27/64 | 22/32 | .100 |
| -9       | 1/2       | 3/4 -16UNJF-3A | 3/16      | 3/8 -24UNF-3A |       | 1-29/64 |       |      |
| -10      |           |                | 1/4       | 7/16-20UNF-3A |       |         |       |      |
| -11      |           |                | 5/16      | 1/2 -20UNF-3A |       | 1-17/32 |       |      |
| -12      |           |                | 3/8       | 9/16-18UNF-3A |       |         |       |      |

No code letter in part number for steel.

Add D after dash number for aluminum alloy (except alloy 7075-T73).

Add J after dash number for corrosion resistant steel, type 304.

Add K after dash number for corrosion resistant steel, type 316.

Example of part numbers:

CSP430-8 - Reducer, 1/2 Tubing, Steel.

CSP430-8D - Reducer, 1/2 Tubing, Aluminum Alloy (except 7075-T73).

CSP430-8J - Reducer, 1/2 Tubing, Corrosion Resistant Steel, Type 304.

CSP430-8K - Reducer, 1/2 Tubing, Corrosion Resistant Steel, Type 316.

MAKE FROM AN919 REDUCER AND REWORK BY ADDING WIRE LOCKING HOLES TO AN919 REDUCER OF CORRESPONDING DASH NO.

|          |                     |                                     |          |
|----------|---------------------|-------------------------------------|----------|
| DRAWN    | GILCHRIST           | CLASSIFICATION                      | STANDARD |
| CHECKED  | <i>P. JAM</i>       | REDUCER-EXTERNAL THREAD FLARED TUBE | CSP 430  |
| STRESSED | <i>W. McLeod</i>    |                                     |          |
| APPROVED | <i>S. B. BATTEN</i> |                                     |          |

27 MAY 87