



(a) DIMENSIONS A, F, AND T TO BE CONCENTRIC WITHIN .005 FULL INDICATOR READING.

MATERIAL: STEEL; BARS OR SHAPES. TITANIUM ALLOY - BARS, SHAPES OR FORGINGS. ALUMINUM ALLOY; BARS OR SHAPES. CORROSION RESISTANT STEEL; BARS, SHAPES, OR FORGINGS. SEE PROCUREMENT SPECIFICATION.

FINISH: SEE PROCUREMENT SPECIFICATION. TITANIUM NOT TO BE USED IN OXYGEN SYSTEMS. ADD L TO DASH NUMBER TO INDICATE PLUG WITH LOCKWIRE HOLES. NO CODE LETTER IN PART NUMBER FOR STEEL. ADD D AFTER DASH NUMBER FOR ALUMINUM ALLOY (EXCEPT 7075-T73). ADD J AFTER DASH NUMBER FOR CORROSION RESISTANT STEEL, TYPE 304. ADD K AFTER DASH NUMBER FOR CORROSION RESISTANT STEEL, TYPE 316. ADD S AFTER DASH NUMBER FOR CORROSION RESISTANT STEEL, TYPE 347. ADD W AFTER DASH NUMBER FOR 7075-T73 ALUMINUM. ADD T AFTER DASH NUMBER FOR TITANIUM.

EXAMPLE OF PART NUMBERS:

- AN814-6 - PLUG AND BLEEDER; 3/8 (6/16) TUBING OD; STEEL, WITHOUT LOCKWIRE HOLES.
- AN814-6L - PLUG AND BLEEDER; 3/8 (6/16) TUBING OD; STEEL WITH LOCKWIRE HOLES.
- AN814-6D - PLUG AND BLEEDER; 3/8 (6/16) TUBING OD; AL. ALLOY, WITHOUT LOCKWIRE HOLES (EXCEPT 7075-T73).
- AN814-6DL - PLUG AND BLEEDER; 3/8 (6/16) TUBING OD; AL. ALLOY, WITH LOCKWIRE HOLES, (EXCEPT 7075-T73).
- AN814-8J - PLUG AND BLEEDER; 1/2 (8/16) TUBING OD; CORROSION RESISTANT STEEL, TYPE 304, WITHOUT LOCKWIRE HOLES.
- AN814-8K - PLUG AND BLEEDER; 1/2 (8/16) TUBING OD; CORROSION RESISTANT STEEL, TYPE 316, WITHOUT LOCKWIRE HOLES.
- AN814-8S - PLUG AND BLEEDER; 1/2 (8/16) TUBING OD; CORROSION RESISTANT STEEL, TYPE 347, WITHOUT LOCKWIRE HOLES.
- AN814-8W - PLUG AND BLEEDER; 1/2 TUBING, 7075-T73 WITHOUT LOCKWIRE HOLES.
- AN814-8WL - PLUG AND BLEEDER; 1/2 TUBING, 7075-T73 WITH LOCKWIRE HOLES.
- AN814-8T - PLUG AND BLEEDER; 1/2 TUBING, TITANIUM WITHOUT LOCKWIRE HOLES.
- AN814-8TL - PLUG AND BLEEDER; 1/2 TUBING, TITANIUM 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, TOLERANCE: FRACTIONS  $\pm 1/64$ , DECIMALS  $\pm .005$ , ANGLES  $\pm 1/2^\circ$ . TOLERANCE FOR DRILL DIAMETER A SHALL BE IN ACCORDANCE WITH AND10387.

P. A. AIR FORCE -82 Other Cust	INTERNATIONAL INTEREST	AIR FORCE-NAVY AERONAUTICAL STANDARD		AN814
NAVY - AS AIR FORCE -99		PLUG AND BLEEDER - SCREW THREAD		
PROCUREMENT SPECIFICATION MIL-F-5509	SUPERSEDES:			SHEET 1 OF 2

USER ACTIVITIES:

REVIEWER ACTIVITIES: DLA-CS

This military 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.

DASH NO.	TUBING OD	THREAD T (REF)	A DIA	B DIA	C +0 -1/64	D
		14				
AN814-2	1/8	5/16-24UNF -3A	.062	7/32	17/64	35/64
AN814-3	3/16	3/8 -24UNF -3A	.125	9/32		9/16
AN814-4	1/4	7/16-20UNF -3A	.171	11/32	5/16	5/8
AN814-5	5/16	1/2 -20UNF -3A	.234	13/32	9/32	
AN814-6	3/8	9/16-18UNF -3A	.296	15/32	23/64	23/32
AN814-8	1/2	3/4 -16UNF -3A	.390	5/8		25/32
AN814-10	5/8	7/8 -14UNF -3A	.484	3/4	21/64	
AN814-12	3/4	1-1/16-12UN -3A	.609	15/16	31/64	1
AN814-16	1 "	1-5/16-12UN -3A	.843	1- 3/16	27/64	
AN814-20	1-1/4	1-5/8 -12UN -3A	1.078	1- 1/2	39/64	
AN814-24	1-1/2	1-7/8 -12UN -3A	1.312	1-23/32		
AN814-28	1-3/4	2-1/4 -12UN -3A	1.546	2- 3/32	17/32	
AN814-32	2	2-1/2 -12UN -3A	1.781	2-11/32	33/64	

DASH NO.	E	F +.002 -.003 DIA	G MIN REF	H +1/32	K	L	S +.015 -.000
AN814-2	.563	+.004	.250	5/32	5/16	5/16	.063
AN814-3	.625		.313		21/64	3/8	
AN814-4	.688		.364	3/16	3/8	7/16	.075
AN814-5	.750		.427			1/2	
AN814-6	.813	+.005	.482	7/32	27/64	9/16	.083
AN814-8	1.000		.660	1/4	15/32	3/4	.094
AN814-10	1.125		.773	5/16	17/32	7/8	.107
AN814-12	1.375		.945			1-1/8	.125
AN814-16	1.625	+.016	1.195	11/32	19/32	1-3/8	
AN814-20	1.875		1.507			1-5/8	
AN814-24	2.125	+.020	1.756			1-7/8	
AN814-28	2.500		2.131			2-1/4	
AN814-32	2.750		2.381	21/64		2-1/2	

P. A.  
AIR FORCE -82  
Other CustINTERNATIONAL  
INTEREST

AIR FORCE-NAVY AERONAUTICAL STANDARD

NAVY - AS

AIR FORCE -99

PLUG AND BLEEDER - SCREW THREAD

AN814

PROCUREMENT SPECIFICATION  
MIL-F-5509

SUPERSEDES:

SHEET 2 OF 2

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE