

MIL-P-39228
 AMENDMENT 3
 4 May 1976
~~AMENDMENT 2~~
 1 June 1973

MILITARY SPECIFICATION
 FLANGES, WAVEGUIDE, GENERAL PURPOSE,
 GENERAL SPECIFICATION FOR

This amendment forms a part of Military Specification MIL-P-39228, dated 20 September 1963, and is approved for use by all Departments and Agencies of the Department of Defense.

PAGE 1

1.1, under "SPECIFICATIONS, FEDERAL" add:

"QQ-A-200/9 - Aluminum Alloy, Bar, Rod, Shapes, Tube, and Wire, Extruded 6063.
 QQ-P-416 - Plating, Cadmium (Electrodeposited)."

2.1, under "STANDARDS, MILITARY": Delete "MIL-STD-10 - Surface Roughness Waviness and Lay."

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*2.2, under (Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia 3, Pa) add:

"AMERICAN NATIONAL STANDARDS INSTITUTE

846.1-1962 - Surface Texture.
 Y14.5-1963 - Dimensioning and Tolerancing for Engineering Drawings.

(Application for copies should be addressed to the American National Standards Institute, 1430 Broadway, New York, N.Y., 10018).

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*3.1, delete and substitute:

"3.1 Specification sheets. The individual item requirements shall be as specified herein and in accordance with the applicable specification sheets. In the event of any conflict between the requirements of this specification and the specification sheets, the latter shall govern."

3.2.2.1, delete and substitute:

"3.2.2.1 Bar stock and forging. When fabricated from bar stock or by forging, flanges shall be of an aluminum alloy conforming to alloy 6061 of Publication B221-62 or B211-62, or aluminum alloy 6063 conforming to QQ-A-200/9. Bar stock shall be tempered T6."

*3.3, delete and substitute:

"3.3 Design and construction. Waveguide flanges shall be of the design, construction, and physical dimensions specified (see 3.1). Dimensions and tolerances shall be interpreted in accordance with ANSI Y14.5 - 1973."

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3.3.3, 3.3.4, and 3.3.5, delete and substitute:

3.3.3 Cap screws. Cap screws shall be type II, style 10P, steel alloy, in accordance with FF-S-85 or type I, style 11, steel alloy in accordance with FF-S-36, whichever is applicable.

3.3.4 Hexagon nuts. Hexagon nuts shall be group B, type 1, steel, in accordance with FF-N-836.

3.3.5 Lock washers. Lock washers shall be class A, steel, in accordance with FF-W-84. The thickness shall be as specified (see 3.1)."

Following 3.3.5, add new paragraph:

3.3.6 Plating. Cap screws, nuts, and lock washers shall have a class 2, type II plating as specified in QQ-P-316."

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3.5 Marking. First sentence, delete "type designation" and substitute "part number." Second sentence, delete "1/16 of an inch" and substitute "1/32 of an inch."

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TABLE I, add:

<u>Material</u>	<u>Requirement paragraph</u>	<u>Applicable specifications</u>
Cap screws	3.3.3	FF-S-85 or FF-S-86
Hexagon nuts	3.3.4	FF-N-836
Lock washers	3.3.5	FF-W-84"

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4.6.2 Surface roughness. Delete reference to "STANDARD MIL-STD-10" and substitute: "ANSI B46.1 1962."

The margins of this amendment are marked with an asterisk to indicate where change (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous amendment.

Custodians:

Army - EL
Navy - EC
Air Force - 85

Preparing activity:

Navy - EC

Agent:

DSA - ES

Review activities:

Army - MI, MU, SG, SM
Air Force - 11, 85
NSA - PS

(Project 5085-OBIR)

User activities:

Army - AV
Navy - MC, AS, OS, SI, CG
Air Force - 14, 19

MIL-F-3922B
 SUPPLEMENT 1F
 4 April 1977
 SUPERSEDING 1E
 24 June 1976

MILITARY SPECIFICATION

FLANGES WAVEGUIDE, GENERAL PURPOSE,

GENERAL SPECIFICATION FOR

This supplement forms a part of Military Specification MIL-F-3922B, dated 20 September 1963.

SPECIFICATION SHEETS

MIL-F-3922/52	- Flanges, Waveguide (Pressurizable Contact).
MIL-F-3922/53	- Flanges, Waveguide (Cover) (Square 4 Hole) (Circular Back).
MIL-F-3922/54	- Flanges, Waveguide (Cover) (Square, 4 Hole).
MIL-F-3922/55	- Flanges, Waveguide (Cover) (Round, 6 Hole).
MIL-F-3922/56	- Flanges, Waveguide (Cover) (Round, 8 Hole).
MIL-F-3922/57	- Flanges, Waveguide (Cover) (Round, 8 Hole) (2 Holes Centered Horizontally, 2 Holes Centered Vertically).
MIL-F-3922/58	- Flanges, Waveguide (Contact) (Rectangular, 10 Hole).
MIL-F-3922/59	- Flanges, Waveguide (Choke) (Square, 4 Hole).
MIL-F-3922/60	- Flanges, Waveguide, (Choke) (Round, 6 Hole).
MIL-F-3922/61	- Flanges, Waveguide (Choke) (Round, 8 Hole).
MIL-F-3922/62	- Flanges, Waveguide (Choke) (Round, 8 Hole (2 Holes Centered Horizontally, 2 Holes Centered Vertically)).
MIL-F-3922/63	- Flanges, Waveguide (Minature, Unpressurized Contact) (8 Hole).
MIL-F-3922/64	- Flanges, Waveguide (Minature, Unpressurized Contact) (6 through Hole, 6 Tapped Hole).
MIL-F-3922/65	- Flanges, Waveguide (Contact) (Round, 4 Hole).
MIL-F-3922/66	- Flanges, Waveguide (Contact) (Round, 8 Hole).
MIL-F-3922/67	- Flanges, Waveguide (Cover) (Round, 4 Hole).
MIL-F-3922/68	- Flanges, Waveguide (Cover) (Butt Mount) (Square, 4 Hole).
MIL-F-3922/69	- Flanges, Waveguide (Choke) (Square, 4 Hole).
MIL-F-3922/70	- Flanges, Waveguide (Cover) (Square, 4 Hole, Butt Mount).
MIL-F-3922/71(EC)	- Flanges, Waveguide (Contact) (With Pressurization Fitting).
MIL-F-3922/72(EC)	- Flanges, Waveguide (Cover) (With Pressurization Fitting).
MIL-F-3922/73(EC)	- Flanges, Waveguide (Choke) (With Pressurization Fitting).
MIL-F-3922/74	- Flanges, Waveguide (Contact) (Round, 4 Hole) (Submillimeter).
MIL-F-3922/75(EC)	- Flanges, Waveguide, Reduced Height.
MIL-F-3922/76	- Flanges, Waveguide, General Purpose, Large (Unpressurized Contact).

Preparing activity:
 Navy - EC

Agent:
 DLA - ES

FSC 5985