

This standard is approved by the BUREAU OF NAVAL WEAPONS Department of the NAVY and is mandatory for use by that activity. All other military activities are required to employ this standard where suitable.

NOTE: THE GOVERNMENT HAS A ROYALTY FREE LICENSE UNDER THESE PATENTS FOR THE BENEFIT OF MANUFACTURERS OF THE ITEM EITHER FOR THE GOVERNMENT OR FOR USE IN EQUIPMENT TO BE DELIVERED TO THE GOVERNMENT. (U. S. PATENT NO. 286509)

P.A. Other Cust	TITLE ELBOW, 45° SWIVEL FLANGE, ROSE FITTING AMS 5639 CRES STEEL	MILITARY STANDARD MS18074(WP) SHEET 1 OF 2
PROCUREMENT SPECIFICATION	SUPERSEDES:	

MIN FULL THREAD
H DIA
S RAD.
60°
W
V
C
REF
U
U
J RAD.
K RAD.
L
N DIA REF
RAD. MAX
90°
THREAD T REF
RAD.
DETAIL OF THREAD & SERRATIONS ENLARGED VIEW

SWIVEL FLANGE MS18076
Z
Z
63/C
R
X DIA
X
Y
DETAIL SECTION Y

SECTION Z-Z

THESE SURFACES SHALL BE FLAT AND PARALLEL WITHIN .005 TIR

THESE SURFACES SHALL BE CONCENTRIC WITH EACH OTHER WITHIN .005 TIR.

NOTES:

1. ALL DIAMETERS MUST BE CONCENTRIC WITH EACH OTHER WITHIN .005 TIR.
2. BREAK SHARP EDGES .005-.015 AND REMOVE ALL BURRS.
3. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS ±.010, ANGLES ±1°.
4. SURFACE ROUGHNESS: PER MIL-STD-10, UNLESS OTHERWISE SPECIFIED: MACHINED SURFACES 63, FORGED SURFACES 125.
5. MATERIAL: CORROSION RESISTANT STEEL AMS 5639.
6. PASSIVATION: A.) DEGREASE. B.) IMMERSE FOR NOT LESS THAN 20 MINUTES IN A SOLUTION OF 1 VOLUME OF NITRIC ACID (SP GR 1.42) AND 9 VOLUMES OF WATER AT ROOM TEMPERATURE.

FED. SUP CLASS
4730

PART NO.	A MAX	B MAX	C ±.005	D ±.005	E	F	G	H	J	K	L	M	N	P	R	S	THREAD T MIL-S-8879
MS18074-08	.486	2.098	.875	.750	.578	.094	.875 .870	.437 .432	.010 .005	.210	.094	.354 .348	.435	.4987 .4906	.156 .151	.031	.5000-20 UN JP-3A
MS18074-10	.557	2.471	1.042	.937	.703	.125	1.000 .995	.625 .613	.020 .010	.625	.203	.441 .435	.535	.6063 .6791	.156 .151	.031	.6875-24 UN JP-3A
MS18074-12	.740	2.913	1.042	.937	.703	.125	1.250 .1.245	.686 .675	.020 .010	.625	.203	.568 .562	.670	.7487 .7406	.156 .151	.031	.7500-20 UN JP-3A
MS18074-14	.813	3.089	1.062	.937	.703	.125	1.500 .1.495	.984 .974	.020 .010	.625	.203	.821 .815	.923	1.0611 1.0524	.156 .151	.031	1.0625-18 UN JP-3A
MS18074-20	.813	3.370	1.344	1.187	.953	.125	1.844 1.839	1.234 1.224	.020 .010	1.155	.250	1.018 1.012	1.185	1.3110 1.3023	.156 .151	.031	1.3125-18 UN JP-3A
MS18074-24	.959	3.723	1.344	1.187	.953	.125	2.125 2.120	1.428 1.418	.020 .010	1.155	.250	1.275 1.269	1.426	1.4985 1.4898	.188 .183	.031	1.5000-18 UN JP-3A

PART NO.	U ±.0015	V ±.0015	Y ±.0015	W ±.0005	X MAX	Y MAX	AA MIN	BB MAX	WEIGHT MAX LBS
MS18074-08	.015	.015	.015	.078	.625	.625	.042	.515	.175
MS18074-10	.015	.015	.015	.081	.750	.813	.042	.701	.251
MS18074-12	.015	.015	.015	.081	.938	.938	.042	.765	.330
MS18074-16	.015	.015	.015	.081	1.188	1.188	.042	1.076	.402
MS18074-20	.015	.015	.015	.112	1.500	1.500	.042	1.312	.698
MS18074-24	.015	.015	.015	.112	1.750	1.625	.042	1.498	.920

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P.A.

Other Cost

TITLE

ELBOW, 45° SWIVEL FLANGE, HOSE FITTING
AMS 5639 CRES STEEL

PROCUREMENT SPECIFICATION

MILITARY STANDARD

MS18074 (WP)

SHEET

2 OF 2

APPROVED 26 April 1965 REVISED