

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

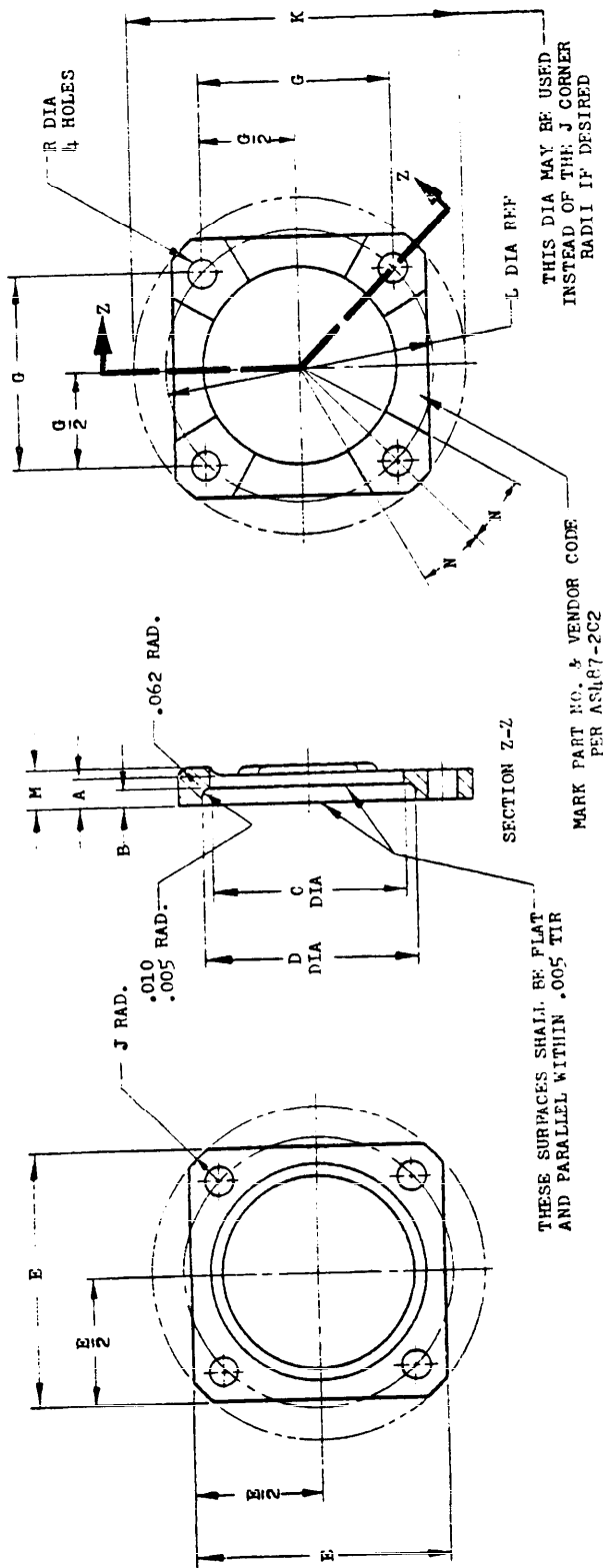
P.A.
Other Cust
PROCUREMENT SPECIFICATION

TITLE
FLANGE, SWIVEL, HOSE FITTING
AMS 5639 CRES STEEL

SUPERSEDES:

MILITARY STANDARD
MS18076 (WP)

SHEET 1 OF 1



PART NO.	A	B	C	D	E	G	H	J	K	L	M	N	WEIGHT MAX LBS
MS18076-08	+.015 -.005	+.005 -.000	+.010 -.000	+.005 -.000	1.390	.950	+.010 -.000	+.010	1.782	1.344	+.010	20°	.074
MS18076-10			.880	1.010	1.468	1.038	.205	.219	1.906	1.468	.297	18°	.070
MS18076-12	.234	.136	1.125	1.260	1.594	1.156			2.094	1.635		16°	.085
MS18076-16			1.375	1.510	1.750	1.312		.266	2.312	1.855		12°	.089
MS18076-20			1.688	1.834	2.188	1.656	.266	.281	2.875	2.342	.359		.148
MS18076-24	.297	.168	1.938	2.135	2.375	1.812	.328	.312	3.094	2.562			.179
MS18076-32			2.562	2.760	3.000	2.375			3.953	3.359			.288

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 $\pm .005$, ANGLES $\pm 1/2^\circ$.

4. REDUCTION BY FORGING DRAFT ANGLE OF 7° MAXIMUM IS PERMISSIBLE.

5. SURFACE ROUGHNESS: PER MIL-STD-10. UNLESS OTHERWISE SPECIFIED: MACHINED SURFACES 63, FORGED SURFACES 125.

6. MATERIAL: CORROSION RESISTANT STEEL AMS 5639.

7. PASSIVATION: A.) DECREASE. 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.

APPROVED 26 April 1965 REVISED

FED. SUP CLASS
E730