

Dear activities: Navy - US
Army - UL, FR, HT, AT
USAF - 11
Army - AB, M
DIA - CS

This military standard is approved by the Department of Defense and is mandatory on all activities. Substitution for all engineering and design applications and for repetitive use shall be made from this document.

FED. SUP CLASS
L730

DRILL DEPTH Q
THREAD T
X
X
DRILL DEPTH R
FITTING END IN ACCORDANCE WITH MS33515, STYLE S, EXCEPT AS SHOWN
PERFECT THREAD TO THIS DEPTH
BOSS IN ACCORDANCE WITH MS33649 FOR APPLICABLE TUBE SIZE, EXCEPT AS SHOWN
90°
TOLERANCE UP TO AND INCLUDING
-6 SIZE $\pm 2-1/2$; ABOVE
-6 SIZE $\pm 1-1/2$
FITTING END IN ACCORDANCE WITH MS33514, STYLE F, EXCEPT AS SHOWN
ACROSS WRENCH FLAT
V DIA
K
1/8 MINIMUM WHEN 2 IS GREATER THAN V

DASH NO.	TUBE OD	THREAD T MIL-S-8879	R MIN	K $+3/64$ -0	Q $+3/64$ -0	R $+3/64$ -0	U RAD	V	W APPROX	X APPROX	2 DIA	WT STEEL	LN AL	MAX T ALLOY
-2	1/8	.3125-24 UNJF-3A	.375	5/8	27/32	3/8	1/16	1/2	15/32	5/16	9/16	.051	.018	.029
-3	3/16	.3750-24 UNJF-3A	.406	11/16	29/32	1-29/64	3/32	9/16	1/2	5/16	5/8	.104	.039	.060
-4	1/4	.4375-20 UNJF-3A	.438	3/4	1-3/32	1-43/64	3/32	3/4	11/16	7/16	3/4	.233	.083	.134
-5	5/16	.5000-20 UNJF-3A	.464	13/16	1-5/32	1-57/64	1/8	7/8	25/32	7/16	7/8	.278	.099	.160
-6	3/8	.5625-18 UNJF-3A	.562	1	1-11/32	2-1/32	1/8	1-1/16	29/32	1/2	1-1/16	.326	.116	.188
-8	1/2	.7500-16 UNJF-3A	.625	1-5/32	1-1/2	2-1/4	1/8	1-1/16	29/32	1/2	1-3/16	.554	.206	.334
-10	5/8	.8750-14 UNJF-3A	.688	1-11/32	1-41/64	2-1/16	1/8	1-5/16	1-3/32	5/8	1-7/16	1.012	.360	.583
-12	3/4	1.0625-12 UNJ-3A	.750	1-17/32	1-27/32	2-21/32	1/8	1-5/8	1-5/16	3/4	1-11/16	1.340	.455	.773
-16	1	1.3125-12 UNJ-3A	.875	1-23/32	1-63/64	2-51/64	1/8	1-7/8	1-1/2	7/8	2	1.950	.672	1.125
-20	1-1/4	1.6250-12 UNJ-3A												

(F) PART WITH THREAD IN ACCORDANCE WITH MIL-STD-8837, TYPE A, THREAD 1/2, 3/4, 1, 1-1/4, 1-1/2, 2, 2-1/2, 3, 3-1/2, 4, 4-1/2, 5, 5-1/2, 6, 6-1/2, 7, 7-1/2, 8, 8-1/2, 9, 9-1/2, 10, 10-1/2, 11, 11-1/2, 12, 12-1/2, 13, 13-1/2, 14, 14-1/2, 15, 15-1/2, 16, 16-1/2, 17, 17-1/2, 18, 18-1/2, 19, 19-1/2, 20, 20-1/2, 21, 21-1/2, 22, 22-1/2, 23, 23-1/2, 24, 24-1/2, 25, 25-1/2, 26, 26-1/2, 27, 27-1/2, 28, 28-1/2, 29, 29-1/2, 30, 30-1/2, 31, 31-1/2, 32, 32-1/2, 33, 33-1/2, 34, 34-1/2, 35, 35-1/2, 36, 36-1/2, 37, 37-1/2, 38, 38-1/2, 39, 39-1/2, 40, 40-1/2, 41, 41-1/2, 42, 42-1/2, 43, 43-1/2, 44, 44-1/2, 45, 45-1/2, 46, 46-1/2, 47, 47-1/2, 48, 48-1/2, 49, 49-1/2, 50, 50-1/2, 51, 51-1/2, 52, 52-1/2, 53, 53-1/2, 54, 54-1/2, 55, 55-1/2, 56, 56-1/2, 57, 57-1/2, 58, 58-1/2, 59, 59-1/2, 60, 60-1/2, 61, 61-1/2, 62, 62-1/2, 63, 63-1/2, 64, 64-1/2, 65, 65-1/2, 66, 66-1/2, 67, 67-1/2, 68, 68-1/2, 69, 69-1/2, 70, 70-1/2, 71, 71-1/2, 72, 72-1/2, 73, 73-1/2, 74, 74-1/2, 75, 75-1/2, 76, 76-1/2, 77, 77-1/2, 78, 78-1/2, 79, 79-1/2, 80, 80-1/2, 81, 81-1/2, 82, 82-1/2, 83, 83-1/2, 84, 84-1/2, 85, 85-1/2, 86, 86-1/2, 87, 87-1/2, 88, 88-1/2, 89, 89-1/2, 90, 90-1/2, 91, 91-1/2, 92, 92-1/2, 93, 93-1/2, 94, 94-1/2, 95, 95-1/2, 96, 96-1/2, 97, 97-1/2, 98, 98-1/2, 99, 99-1/2, 100, 100-1/2, 101, 101-1/2, 102, 102-1/2, 103, 103-1/2, 104, 104-1/2, 105, 105-1/2, 106, 106-1/2, 107, 107-1/2, 108, 108-1/2, 109, 109-1/2, 110, 110-1/2, 111, 111-1/2, 112, 112-1/2, 113, 113-1/2, 114, 114-1/2, 115, 115-1/2, 116, 116-1/2, 117, 117-1/2, 118, 118-1/2, 119, 119-1/2, 120, 120-1/2, 121, 121-1/2, 122, 122-1/2, 123, 123-1/2, 124, 124-1/2, 125, 125-1/2, 126, 126-1/2, 127, 127-1/2, 128, 128-1/2, 129, 129-1/2, 130, 130-1/2, 131, 131-1/2, 132, 132-1/2, 133, 133-1/2, 134, 134-1/2, 135, 135-1/2, 136, 136-1/2, 137, 137-1/2, 138, 138-1/2, 139, 139-1/2, 140, 140-1/2, 141, 141-1/2, 142, 142-1/2, 143, 143-1/2, 144, 144-1/2, 145, 145-1/2, 146, 146-1/2, 147, 147-1/2, 148, 148-1/2, 149, 149-1/2, 150, 150-1/2, 151, 151-1/2, 152, 152-1/2, 153, 153-1/2, 154, 154-1/2, 155, 155-1/2, 156, 156-1/2, 157, 157-1/2, 158, 158-1/2, 159, 159-1/2, 160, 160-1/2, 161, 161-1/2, 162, 162-1/2, 163, 163-1/2, 164, 164-1/2, 165, 165-1/2, 166, 166-1/2, 167, 167-1/2, 168, 168-1/2, 169, 169-1/2, 170, 170-1/2, 171, 171-1/2, 172, 172-1/2, 173, 173-1/2, 174, 174-1/2, 175, 175-1/2, 176, 176-1/2, 177, 177-1/2, 178, 178-1/2, 179, 179-1/2, 180, 180-1/2, 181, 181-1/2, 182, 182-1/2, 183, 183-1/2, 184, 184-1/2, 185, 185-1/2, 186, 186-1/2, 187, 187-1/2, 188, 188-1/2, 189, 189-1/2, 190, 190-1/2, 191, 191-1/2, 192, 192-1/2, 193, 193-1/2, 194, 194-1/2, 195, 195-1/2, 196, 196-1/2, 197, 197-1/2, 198, 198-1/2, 199, 199-1/2, 200, 200-1/2, 201, 201-1/2, 202, 202-1/2, 203, 203-1/2, 204, 204-1/2, 205, 205-1/2, 206, 206-1/2, 207, 207-1/2, 208, 208-1/2, 209, 209-1/2, 210, 210-1/2, 211, 211-1/2, 212, 212-1/2, 213, 213-1/2, 214, 214-1/2, 215, 215-1/2, 216, 216-1/2, 217, 217-1/2, 218, 218-1/2, 219, 219-1/2, 220, 220-1/2, 221, 221-1/2, 222, 222-1/2, 223, 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578-1/2, 579, 579-1/2, 580, 580-1/2, 581, 581-1/2, 582, 582-1/2, 583, 583-1/2, 584, 584-1/2, 585, 585-1/2, 586, 586-1/2, 587, 587-1/2, 588, 588-1/2, 589, 589-1/2, 590, 590-1/2, 591, 591-1/2, 592, 592-1/2, 593, 593-1/2, 594, 594-1/2, 595, 595-1/2, 596, 596-1/2, 597, 597-1/2, 598, 598-1/2, 599, 599-1/2, 600, 600-1/2, 601, 601-1/2, 602, 602-1/2, 603, 603-1/2, 604, 604-1/2, 605, 605-1/2, 606, 606-1/2, 607, 607-1/2, 608, 608-1/2, 609, 609-1/2, 610, 610-1/2, 611, 611-1/2, 612, 612-1/2, 613, 613-1/2, 614, 614-1/2, 615, 615-1/2, 616, 616-1/2, 617, 617-1/2, 618, 618-1/2, 619, 619-1/2, 620, 620-1/2, 621, 621-1/2, 622, 622-1/2, 623, 623-1/2, 624, 624-1/2, 625, 625-1/2, 626, 626-1/2, 627, 627-1/2, 628, 628-1/2, 629, 629-1/2, 630, 630-1/2, 631, 631-1/2, 632, 632-1/2, 633, 633-1/2, 634, 634-1/2, 635, 635-1/2, 636, 636-1/2, 637, 637-1/2, 638, 638-1/2, 639, 639-1/2, 640, 640-1/2, 641, 641-1/2, 642, 642-1/2, 643, 643-1/2, 644, 644-1/2, 645, 645-1/2, 646, 646-1/2, 647, 647-1/2, 648, 648-1/2, 649, 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720-1/2, 721, 721-1/2, 722, 722-1/2, 723, 723-1/2, 724, 724-1/2, 725, 725-1/2, 726, 726-1/2, 727, 727-1/2, 728, 728-1/2, 729, 729-1/2, 730, 730-1/2, 731, 731-1/2, 732, 732-1/2, 733, 733-

USER SYMBOLS:
NAVY - OS
ARMY - GL, CR, ME, AT

REVIEWER SYMBOLS:
NAVY -
USAF - II
ARMY - AR, MT
DLA - CS

"Review/user information is current as of the date of this document.
For future coordination of changes in this document, draft circulation
should be based on the information in the current DODISS."

This military standard is approved for use by all Departments
in the Department of Defense. Selection for all new
engineering and design applications and for repetitive use shall
be made from this document.

FED. SUP CLASS
4730

- (F) 6. ~~PARTS CODED C ARE INACTIVE FOR DESIGN AFTER 27 JUNE 1969. PARTS CODED C MAY BE USED UNTIL STOCKS ARE
EXHAUSTED. PARTS CODED J OR K MAY BE USED IN LIEU OF PARTS CODED C.~~
- (F) 7. ITEMS CODED "C" ON PREVIOUS ISSUES OF THIS STANDARD ARE NO LONGER TO BE FURNISHED. UNLESS OTHERWISE
SPECIFIED, PARTS CODED J, K, OR S (AT SUPPLIER'S OPTION) SHALL BE FURNISHED IN LIEU OF "C" CODED PARTS.
CERTAIN PROVISIONS (SCREW THREADS, BOSS DIMENSIONS AND UNDERCUT DIMENSIONS) OF THIS STANDARD ARE THE
SUBJECT OF INTERNATIONAL STANDARDIZATION AGREEMENT ASCC AIR STD 17/15. WHEN REVISION OR CANCELLATION
OF THIS STANDARD IS PROPOSED WHICH WILL AFFECT OR VIOLATE THE INTERNATIONAL AGREEMENT CONCERNED, THE
PREPARING ACTIVITY WILL TAKE APPROPRIATE RECONCILIATION ACTION THROUGH INTERNATIONAL STANDARDIZATION
CHANNELS, INCLUDING DEPARTMENTAL STANDARDIZATION OFFICES, IF REQUIRED.
- (F) 8. TITANIUM NOT RECOMMENDED FOR USE IN OXYGEN SYSTEMS.
9. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.
10. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.

APPROVED 4 OCT 51 REVISED F FOR CHANGES SEE SHEETS 1 AND 2

P.A. NAVY - AS Other Cust IISAP-99 Army-AV	INTERNATIONAL INTEREST SEE NOTE 7	TITLE TEE, BULKHEAD, FLARELESS TUBE, INTERNAL THREAD ON SIDE	MILITARY STANDARD MS21910
PROCUREMENT SPECIFICATION MIL-F-18280	SUPERSEDES		SHEET 2 OF 2

DD FORM 672-1 (Coordinated)
1 MAR 77

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

PLATE NO. 2384