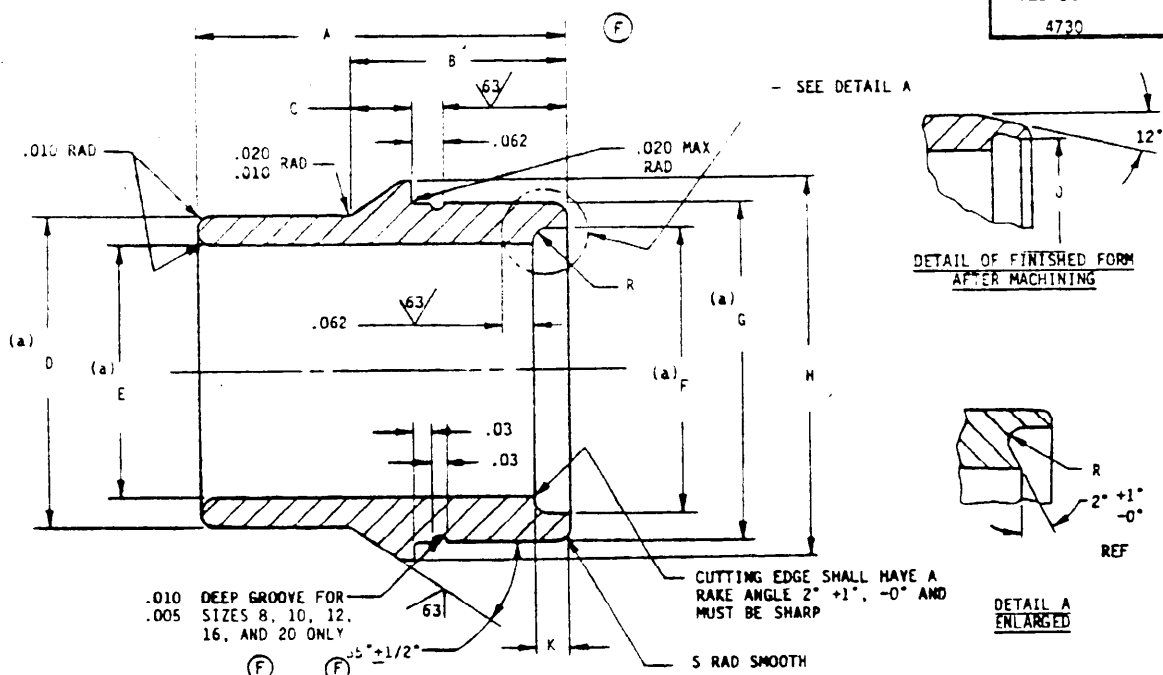


USER SYMBOLS:
ARMY-HE, AT
NAVY-OS

REVIEWER SYMBOLS:
ARMY-AR, MJ, AV
NAVY-AS
USAF-B2, 71
DLA -CS



DASH NO.	STL	CRES	TUBE SIZE	A $\pm .01$	B $\pm .003$	C $+.005$ $-.000$	D	E $+.003$ $-.000$	F $+.006$ $-.000$	G $+.004$ $-.000$	H	J $+.008$ $-.000$	K $+.008$ $-.000$	R		S $+.005$ $-.000$
														MAX	MIN	
-2	-2C	1/8	.41	.316	.098	.164		.129	.154	.175	.256	.148	.024			.010
-3	-3C	3/16	.45	.278		.226		.193	.227	.252	.299	.221	.020			
-4	-4C	1/4	.52		.336	.060	.294	.255	.286	.309	.359	.280		.006	.003	
-5	-5C	5/16	.59				.360	.318	.350	.373	.422	.344				.007
-6	-6C	3/8	.66		.375		.419	.380	.408	.435	.484	.402				
-8	-8C	1/2	.75				.546	.506	.556	.585	.619	.550				
-10	-10C	5/8	.80			.090	.682	.633	.669	.707	.750	.663	.024			
-12	-12C	3/4	.75				.817	.758	.807	.836	.938	.801				
-16	-16C	1		.415	.120		1.065	1.008	1.057	1.086	1.156	1.051		.014	.008	.010
-20	-20C	1-1/4					1.320	1.258	1.310	1.339	1.437	1.304				
-24	-24C	1-1/2					1.570	1.511	1.560	1.589	1.687	1.554				
-32	-32C	2			.150	2.070		2.011	2.063	2.092	2.218	2.057				

(a) CIRCULAR SURFACES OF DIAMETERS D, E, F, AND G SHALL BE CONCENTRIC WITHIN .005 TOTAL INDICATOR READING, AND TRUE WITH CENTERLINE.

REQUIREMENTS:

1. MATERIAL: CARBON STEEL AND CORROSION RESISTANT STEEL, BARS. SEE PROCUREMENT SPECIFICATION.
2. FINISH: SEE PROCUREMENT SPECIFICATION.

(F) REVISED AND REDRAWN

P.A. NAVY - AS Other Cost USAF - 99 ARMY - AV	INTERNATIONAL INTEREST	TITLE SLEEVE, COUPLING, FLARELESS	MILITARY STANDARD MS21922
PROCUREMENT SPECIFICATION MIL-F-18280	SUPERSEDES: MS21918	SHEET 1 OF 2	

DISTRIBUTION STATEMENT A: APPROVED FOR PUBLIC RELEASE. DISTRIBUTION IS UNLIMITED

AMSIC N/A

NOTES:

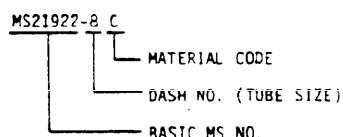
1. FOR SURFACE ROUGHNESS, SEE ANSI B46.1.
2. BREAK ALL SHARP EDGES AND REMOVE ALL HANGING BURRS AND SLIVERS.
3. DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS $\pm .005$, ANGLES $\pm 1/2^\circ$.
4. PART NO.: ADD C AFTER DASH NUMBER FOR CORROSION RESISTANT STEEL, AMS5643 (17-4-PH).
5. EXAMPLE OF PART NO.:

MS21922-8 C

MATERIAL CODE

DASH NO. (TUBE SIZE)

BASIC MS NO.
6. LETTERS MS NOT TO BE MARKED ON THIS PART.
7. INTERCHANGEABILITY RELATIONSHIP: MS21918 AND MS21922 PARTS IDENTIFIED BY THE SAME DASH NUMBER ARE FUNCTIONALLY INTERCHANGEABLE. USE MS21921 AND MS21922 AS AN ASSEMBLY WHEN SUBSTITUTING FOR MS21917 AND MS21918.
8. F DIAMETER, K LENGTH, R RADIUS, S RADIUS AND 2° EDGE ANGLE ARE NON-INSPECTABLE AFTER PRODUCTION OF 12° PILOT ANGLE.
9. PARTS CODED C ARE INACTIVE FOR DESIGN AFTER 27 SEPTEMBER 1974. USE ONLY FOR REPLACEMENT OF IDENTICAL ITEMS IN EXISTING MILITARY EQUIPMENT.
10. IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS STANDARD AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE.
11. REFERENCED GOVERNMENT (OR NON-GOVERNMENT) DOCUMENTS OF THE ISSUE LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN.
12. OVALITY: THE INCREASE OR DECREASE OF DIMENSIONS D, E, F, OR G DUE TO WARPAGE CAUSED BY HEAT TREATMENT SHALL NOT EXCEED THE SPECIFIED DIMENSIONS, INCLUDING TOLERANCES, BY MORE THAN .004 FOR SIZES -2 THROUGH -12, NOR MORE THAN .006 FOR SIZES -16 THROUGH -32 WHEN MEASURED AFTER HEAT TREATMENT.



P.A.
NAVY — AS
Other Cust
USAF - 99
ARMY - AV

INTERNATIONAL
INTEREST

TITLE

SLEEVE, COUPLING, FLARELESS

MILITARY STANDARD

MS21922

PROCUREMENT SPECIFICATION
MIL E-18280

SUPERSEDES: MS21210

GARST

ESTD. 1910 IN ALA

4730

APPROVED 27 Feb: 56 REVISED (F) FOR CHANGES SEE SHEETS 1 AND 2