

Review activities: USA - 11
ARMY - AF, MI
DIA - CS

User activities: NAVY - DS
ARMY - CI, CR, MI, AT

FED. SUP CLASS
17*

TOLERANCES UP TO AND INCLUDING
-6 SIZE $\pm 2-1/2$, ABOVE -6 SIZE $\pm 1-1/2$

DASH NO.	TUBE SIZE	THREAD T MIL-STD-1875	MIN FULL THD	M	C	F	U	V	X APPROX	Y APPROX	Z	L	W			T
													STKTH	ALIM	ALLOY	
-1	1/2"	1/2"-20 UNF-3A	1/4"	1.75	1.94	1.82	1/4"	1.31	1.25	1.25	1.25	1.25	1.08	1.03	1.04	1.04
-2	3/4"	3/4"-20 UNF-3A	1/2"	2.00	2.19	2.07	1/2"	1.56	1.50	1.50	1.50	1.50	1.24	1.05	1.06	1.06
-3	1"	1"-20 UNF-3A	3/4"	2.25	2.44	2.32	3/4"	1.75	1.67	1.67	1.67	1.67	1.39	1.10	1.11	1.11
-4	1 1/4"	1 1/4"-20 UNF-3A	1"	2.50	2.69	2.57	1"	2.00	1.92	1.92	1.92	1.92	1.54	1.25	1.26	1.26
-5	2"	2"-20 UNF-3A	1 1/4"	3.00	3.19	3.07	1 1/4"	2.25	2.17	2.17	2.17	2.17	1.76	1.47	1.48	1.48
-6	2 1/2"	2 1/2"-20 UNF-3A	1 3/4"	3.25	3.44	3.32	1 3/4"	2.50	2.42	2.42	2.42	2.42	1.91	1.62	1.63	1.63
-7	3"	3"-20 UNF-3A	2"	3.50	3.69	3.57	2"	2.75	2.67	2.67	2.67	2.67	2.10	1.81	1.82	1.82
-8	3 1/2"	3 1/2"-20 UNF-3A	2 1/4"	3.75	3.94	3.82	2 1/4"	3.00	2.92	2.92	2.92	2.92	2.25	1.96	1.97	1.97
-9	4"	4"-20 UNF-3A	2 3/4"	4.00	4.19	4.07	2 3/4"	3.25	3.17	3.17	3.17	3.17	2.40	2.11	2.12	2.12
-10	4 1/2"	4 1/2"-20 UNF-3A	3"	4.25	4.44	4.32	3"	3.50	3.42	3.42	3.42	3.42	2.55	2.26	2.27	2.27
-11	5"	5"-20 UNF-3A	3 1/4"	4.50	4.69	4.57	3 1/4"	3.75	3.67	3.67	3.67	3.67	2.70	2.41	2.42	2.42
-12	5 1/2"	5 1/2"-20 UNF-3A	3 3/4"	4.75	4.94	4.82	3 3/4"	4.00	3.92	3.92	3.92	3.92	2.85	2.56	2.57	2.57
-13	6"	6"-20 UNF-3A	4"	5.00	5.19	5.07	4"	4.25	4.17	4.17	4.17	4.17	3.00	2.71	2.72	2.72
-14	6 1/2"	6 1/2"-20 UNF-3A	4 1/4"	5.25	5.44	5.32	4 1/4"	4.50	4.42	4.42	4.42	4.42	3.15	2.86	2.87	2.87
-15	7"	7"-20 UNF-3A	4 3/4"	5.50	5.69	5.57	4 3/4"	4.75	4.67	4.67	4.67	4.67	3.30	3.01	3.02	3.02
-16	7 1/2"	7 1/2"-20 UNF-3A	5"	5.75	5.94	5.82	5"	5.00	4.92	4.92	4.92	4.92	3.45	3.16	3.17	3.17
-17	8"	8"-20 UNF-3A	5 1/4"	6.00	6.19	6.07	5 1/4"	5.25	5.17	5.17	5.17	5.17	3.60	3.31	3.32	3.32
-18	8 1/2"	8 1/2"-20 UNF-3A	5 3/4"	6.25	6.44	6.32	5 3/4"	5.50	5.42	5.42	5.42	5.42	3.75	3.46	3.47	3.47
-19	9"	9"-20 UNF-3A	6"	6.50	6.69	6.57	6"	5.75	5.67	5.67	5.67	5.67	3.90	3.61	3.62	3.62
-20	9 1/2"	9 1/2"-20 UNF-3A	6 1/4"	6.75	6.94	6.82	6 1/4"	6.00	5.92	5.92	5.92	5.92	4.05	3.76	3.77	3.77

(B) PARTS WITH THREADS IN ACCORDANCE WITH MIL-STD-1875 OF THE SAME THREAD SIZE, PITCH AND TOLERANCE CLASS ARE ACCEPTABLE FOR PROCUREMENT UNTIL 1 JULY 1991. THE PARTS WITH MIL-STD-1875 THREADS WILL NOT BE SUPPLIED HEREAFTER. EXISTING STOCKS ARE TO BE USED UNTIL EXHAUSTED.

1. MATERIAL: CARBON STEEL - FORGING;
ALUMINUM ALLOY - FORGING;
CORROSION RESISTANT STEEL - FORGING;
TITANIUM ALLOY - FORGING

2. FINISH: SEE PROCUREMENT SPECIFICATION.

3. BREAK ALL SHARP EDGES AND REMOVE ALL BURRS AND SLIVERS.

4. DIMENSIONS IN INCHES, UNLESS OTHERWISE SPECIFIED. TOLERANCES: DRYMIL 1.016.

(B) SEE PROCUREMENT SPECIFICATION.
NOTE: PARTS MADE FROM 1137 OR 1141 WIRINGS QUALIFIED TO MIL-F-18280C SHALL NOT BE SUPPLIED AFTER 30 JUNE 1981.

(B) DENOTES CHANGES

P.A. Navy - AC Other Code	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
USAF - 99 Army-AV	SEE NOTE	ELBOW, 90° UNIVERSAL, FLARELESS TUBE, HIGH PROFILE	MS21925
PROCUREMENT SPECIFICATION MIL-F-18280	SUPERSEDES		SHEET 1 OF 2

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

FED. SUP CLASS

5. PART NUMBERS:

NO MORE LETTER IN PART NUMBER FOR CARBON STEEL.

ADD B AFTER DASH NUMBER FOR ALUMINUM ALLOY (2014).

ADD W IN PLACE OF DASH FOR ALUMINUM ALLOY (7075).

~~ADD C AFTER DASH NUMBER FOR CORROSION RESISTANT STEEL, TYPE 304, 304L, 316, 316L, OR 317.~~

ADD J IN PLACE OF DASH FOR CORROSION RESISTANT STEEL, TYPE 304.

ADD K IN PLACE OF DASH FOR CORROSION RESISTANT STEEL, TYPE 316.

ADD S AFTER DASH NUMBER FOR CORROSION RESISTANT STEEL, TYPE ~~304 AND 316~~. PARTS ARE NOT TO BE MANUFACTURED

FROM TYPE 304L STEEL AFTER 27 JUNE 1969.

ADD T AFTER DASH NUMBER FOR TITANIUM ALLOY (6AL-4V).

EXAMPLES OF PART NUMBERS:

MS21925-L - ELBOW, 1/4 TUBING, CARBON STEEL.

MS21925-LB - ELBOW, 1/4 TUBING, ALUMINUM ALLOY (2014).

MS21925-WL - ELBOW, 1/4 TUBING, ALUMINUM ALLOY (7075).

MS21925-JL - ELBOW, 1/4 TUBING, CORROSION RESISTANT STEEL, TYPE 304L.

MS21925-KL - ELBOW, 1/4 TUBING, CORROSION RESISTANT STEEL, TYPE 316L.

MS21925-LC - ELBOW, 1/4 TUBING, CORROSION RESISTANT STEEL, TYPE 316.

MS21925-LT - ELBOW, 1/4 TUBING, TITANIUM ALLOY (6AL-4V).

~~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.~~

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.

7. CERTAIN PROVISIONS (SCREW THREADS) 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.

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.

Review activities: NAVY - OS
ARMY - CL, CR, HP, AT

User activities: USAF - 11
ARMY - AR, MI
DLA - CS

APPROVED 29 Nov 57 REVISED (B) FOR CHANGES SEE SHEETS 1 AND 2.

P.A. Navy - AS Other Com USAF - 99 Army - AV	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
	SEE NOTE 7	ELBOW, 90° UNIVERSAL, FLARELESS TUBE, HIGH PROFILE	MS21925
PROCUREMENT SPECIFICATION MIL-V-18280	SUPERSEDES:	SHEET 2 OF 2	

DD FORM 672-1 (Coordinated)
ASG use only

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

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