



THE CONICAL SEAL SURFACE SHALL BE FREE OF FLAWS, NICKS AND CHATTER MARKS WHEN VIEWED WITH THE UNAIDED EYE. THE CENTER 90° OF THE SURFACE (SEE DETAIL A) SHALL A 90 HAVE NO LOW SPOTS AND SHALL HAVE AN UNBROKEN LINE OF CONTACT TO SHOW ALL AROUND WHEN ROTATED IN CONTACT WITH A 74° 0' ± 1' INCLUDED ANGLE GAGE LIGHTLY COATED BY RUBBING WITH CARBON PAPER OR BY EQUIVALENT BLUEING METHOD.

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

DIMENSIONS D, C, F AND T (PITCH DIA) SHALL HAVE CIRCULAR RUNOUT TO EACH OTHER AND WITH THE 37° ANGLE, MEASURED AND CALCULATED AS AN INCLUDED ANGLE, WITHIN .005 FULL INDICATOR MOVEMENT. OTHER DIAMETERS SHALL HAVE CIRCULAR RUNOUT TO EACH OTHER WITHIN .010 FIM.

ALL MACHINED SURFACES SHALL BE SMOOTH TO 125 MICROINCHES Ra PER ANSI B46.1 UNLESS NOTED.

DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: $\pm 1/2^\circ$, DECIMALS $\pm .016$

NOTES:
REFERENCED GOVERNMENT (OR NONGOVERNMENT) 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 OF THE EXTENT SPECIFIED HEREIN.

FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER ACQUISITION DOCUMENTS REFERENCED HEREIN.

THIS IS A DESIGN STANDARD NOT TO BE USED AS A PART NUMBER.

(E) ENTIRE STANDARD REVISED

P.A. AIR FORCE - 82 Other Cost AIR FORCE - 99	TITLE FITTING END, FLARED TUBE CONNECTION, PRECISION TYPE, STANDARD DIMENSIONS	MILITARY STANDARD
		MS24385(USAF)
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 1 OF 2

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Review activities:
DLA-C3

This military standard is approved by the San Antonio ALC (Code 82).
Department of the Air Force and shall be used by that activity. All
other military activities are required to employ this standard where
suitable.

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Review activities:
DLA-CS

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EQUIV- TUBE SIZE DASH NO	TUBING OD	THREAD T MIL-S-8879	A DIA	B +.015 -.000	C +.000 -.005 DIA	D +.003 -.004 DIA	E	F +.002 -.003	H MAX	J +.015 -.010 DIA	K +.010 -.010 DIA	M +.010 -.010 DIA	Q +.015 -.000	W MT/H
-2	1/8	.3125-24UNJF-3A	.062	.177	.245	.083	.563	.250		.448	.500	.549	.063	
-3	3/16	.3750-24UNJF-3A	.125		.307	.146	.625	.312		.479	.562	.611		
-4	1/4	.4375-20UNJF-3A	.172	.193	.359	.193	.688	.364	.005	.550	.625	.674	.075	.005
-5	5/16	.5000-20UNJF-3A	.234		.421	.255	.750	.426			.687	.736		
-6	3/8	.5625-18UNJF-3A	.297	.198	.476	.318	.813	.481		.556	.750	.799	.083	
-8	1/2	.7500-16UNJF-3A	.391	.253	.654	.426	1.000	.660		.657	.937	.986	.094	.012
-10	5/8	.8750-14UNJF-3A	.484	.266	.767	.539	1.125	.773		.759	1.062	1.111	.107	.012
-12	3/4	1.0625-12UNJ-3A	.603	.315	.938	.664	1.375	.945		.864	1.274	1.361		
-16	1	1.3125-12UNJ-3A	.844		1.188	.913	1.625	1.195		.911	1.524	1.599	.125	
-20	1-1/4	1.6250-12UNJ-3A	1.078	.367	1.501	1.147	1.875	1.507		.956	1.838	1.849		
-24	1-1/2	1.8750-12UNJ-3A	1.312		1.750	1.381	2.125	1.756	.008	1.063	2.053	2.095		
-28	1-3/4	2.2500-12UNJ-3A	1.547	.451	2.125	1.646	2.500	2.131		1.208	2.468	2.470		
-32	2	2.5000-12UNJ-3A	1.781	.461	2.375	1.880	2.750	2.381		1.333	2.718	2.720		.014

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AIR FORCE 99		MS24385(USAF)
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 2 OF 2