



REINSTATED AS OF 15 JUN 83

THE CONICAL SEAL SURFACE SHALL BE FREE OF FLAWS, NICKS AND CHATTER MARKS WHEN VIEWED WITH THE UNAIDED EYE. THE CENTER 80% OF THE CONICAL SURFACE (SEE DETAIL A) SHALL ALSO 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 AN EQUIVALENT BLUEING METHOD.

L AS LISTED PROVIDES FOR A WASHER TO FORM BACKING FACE AGAINST BULKHEAD PLUS 1/32 LAND FOR POSITIONING IN BULKHEAD. WHEN DESIGN OF FITTING INCLUDES A HEX OR FACE EQUAL TO OR GREATER THAN E, NO WASHER IS REQUIRED AND THIS DIMENSION WILL BE .031 AS IN STYLE E.

TOLERANCE ON F MAY BE $+.002$ $-.003$ PROVIDED NO THREAD MARKS ARE PRESENT.

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

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

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.

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 TO THE EXTENT SPECIFIED HEREIN.

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

FOR CHANGES SEE SHEET 1

THIS IS A DESIGN STANDARD, NOT TO BE USED AS PART NUMBER. (G) DFNOTES CHANGES

P.A. AIR FORCE - 82 Other Cases AIR FORCE - 99	TITLE FITTING END, BULKHEAD FLARED TUBE CONNECTION PRECISION TYPE, STANDARD DIMENSIONS	MILITARY STANDARD
		MS24386(USAF)
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 1 OF 2

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

THIS MILITARY STANDARD IS APPROVED FOR USE BY THE
SAN ANTONIO ALC (CODE 82), AND IS AVAILABLE FOR
USE BY ALL DEPARTMENTS AND AGENCIES OF THE
DEPARTMENT OF DEFENSE.

Review activities:

ARMY - MI
DLA - CS

TABLE OF DIMENSIONS

SIZE TUBING NO.	③ THREAD T MIL-S-8879	A DIA	B +.015 -.000	C +.009 -.005 DIA	D +.003 -.001 DIA	E	F +.000 -.003 DIA	H MAX.	K	L	③ H +.010 -.000 DIA	N +.010 -.000	P +.005 -.000	Q +.015 -.000	R	S DIA	V MIN	Y MAX MIN
2	1/8 3125-24 UNJF-3A	.062	.177	.245 .003 .563	.250		.312		.922		.549	.125	.385	.063	.109	.438		.3125 .3053
3	3/16 3750-24 UNJF-3A	.125 +.003		.307 .146 .625						.094	.611	.131				.500		.3750 .3678
4	1/4 4375-20 UNJF-3A	.172 -.004	.193	.359 .193 .688	.364			1.016			.674	.140	.443	.075	.125	.562	.005	.4375 .4294
5	5/16 5000-20 UNJF-3A	.234		.421 .255 .750	.426	+.003					.736	.156				.625		.5000 .4919
6	3/8 5625-18 UNJF-3A	.297	.198	.476 .318 .813	.481	-.004			1.094		.799	.187	.476	.083	.141	.688		.5625 .5538
8	1/2 7500-16 UNJF-3A	.391 +.004	.253	.654 .426 1.000	.660			1.250			.986	.219	.565	.094	.156	.875	.012	.7500 .7406
10	5/8 8750-14 UNJF-3A	.484	.266	.767 .539 1.125	.773			1.391			1.111		.623	.107	.172	1.000	.022	.8750 .8647
12	3/4 10625-12 UNJ-3A	.609 +.005	.315	.938 .664 1.375	.945			1.562			1.361		.732			1.188		1.0625 1.0511
16	1 13125-12 UNJ-3A	.844 +.007 -.005		1.188 .913 1.625	1.195	+.016				.125	1.599					1.438		1.3125 1.3011
20	1-1/4 16250-12 UNJ-3A	1.078 +.008	.367	1.501 1.147 1.875	1.507			1.609			1.849	.234	.784	.125		1.750	.029	1.6250 1.6136
24	1-1/2 18750-12 UNJ-3A	1.312 -.005	.378	1.750 1.381 2.125	1.756			1.625			2.095		.795		.188	2.000		1.8750 1.8636
28	1-3/4 22500-12 UNJ-3A	1.547	.451	2.125 1.646 2.500	2.131			1.781			2.470		.868			2.375		2.2500 2.2386
32	2 25000-12 UNJ-3A	1.781	.461	2.375 1.880 2.750	2.381	+.020		1.906			2.720		.878			2.625	.044	2.5000 2.4886
40	2-1/2 30000-12 UNJ-3A	2.281 +.010 -.005	.395	2.882 2.380 3.250	2.881			1.719			3.220		.895			3.125		3.0000 2.9886
48	3 35000-12 UNJ-3A	2.781		3.382 2.880 3.750	3.381			1.812			3.720		.978			3.625		3.5000 3.4886

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PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 2 OF 2