

Form approved
OMB No. 0704-0188

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODISS SPECIFIED IN THE SOLICITATION: NONE

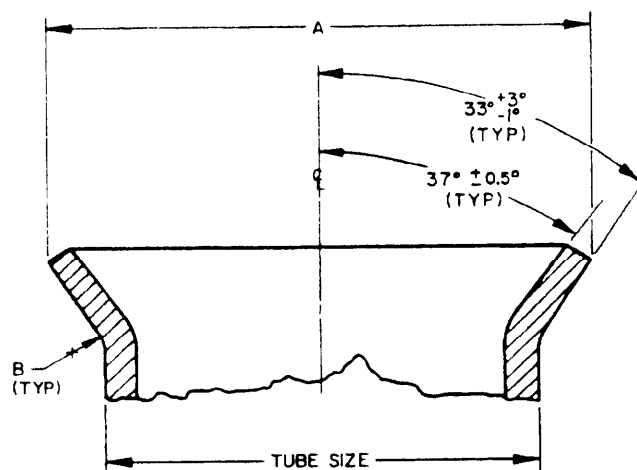


TABLE 1. DIMENSIONS DATA.

TUBE SIZE NOMINAL OD	A DIA	B RAD ± .010
0.125	.200	.032
0.188	.302	
0.250	.359	
0.313	.421	
0.375	.484	
0.500	.656	
0.625	.781	
0.750	.937	
1.000	1.187	.093
1.250	1.500	
1.500	1.721	
1.750	2.106	
2.000	2.356	
2.500	2.856	
3.000	3.356	

(C) ENTIRE STANDARD REVISED

DESIGN STANDARD

PREPARING ACTIVITY NAVY - AS

CUSTODIANS ARMY - AV NAVY -

AIR FORCE - 99

REVIEW AF - 71, 82, ARMY - AR, ME, MI, DLA - CS

USER ARMY - AT, MAR CORPS - MC

PROJECT NUMBER 4730-0020

MILITARY SPECIFICATION SHEET

TITLE

TUBING END
STANDARD DIMENSIONS FOR FLARED

SPECIFICATION SHEET NUMBER

MS33584C 17 DEC 90

SUPERSEDING
MS33584B

9 DEC 1960

AMSC - N/A

FSC
4730

SPECIFICATION IS APPROVED FOR USE
BY THE DEPARTMENT OF DEFENSE

11/11/90/MS33584C

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OMB No. 0704-0188NOTES:

1. DIMENSIONS ARE IN INCHES.
2. FLARE SHALL BE SQUARE WITH CENTERLINE OF TUBE WITHIN 0.5° FOR THE DISTANCE COVERED BY THE LENGTH OF THE MS20819 SLEEVE.
3. THE CIRCULAR RUNOUT BETWEEN THE INNER AND OUTER SURFACES OF THE FLARE SHALL NOT EXCEED .005 FULL INDICATOR MOVEMENT (F.I.M.) WITH THE TUBING O.D.
4. THE SEALING SURFACE SHALL BE FREE OF PII MARKS, RADIAL OR LONGITUDINAL SCRATCHES AND INDENTATIONS. FLARE SEALING SURFACE SHALL NOT EXCEED 32 MICROINCHES R_a PER ANSI/ASME B46.1.
5. THIS STANDARD IS FOR USE WITH FLARED TUBE FITTINGS SPECIFICATION MIL-F-5509.
6. 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.
7. REFERENCED GOVERNMENT (OR NON-GOVERNMENT) DOCUMENTS OF THIS 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.
8. THIS IS A DESIGN STANDARD, NOT TO BE USED AS A PART NUMBER.
9. RECOMMENDED BURNISHING THE FLARED END OF THE TUBE DURING INSTALLATION IF NECESSARY.

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SPECIFICATION IS APPROVED FOR USE
BY ALL DEPARTMENTS AND AGENCIES OF THE
DEPARTMENT OF DEFENSE.

(C) ENTIRE STANDARD REVISED

PREPARING ACTIVITY: NAVY-AS

CUSTODIANS: ARMY-AV NAVY-

AIR FORCE-99

REVIEW USAF-71, 82 ARMY-AR, ME, MI, DLA-CS
USER ARMY-AT, MAR CORPS-MC
PROJECT NUMBER 4730-0020

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FSC 4730