



Form approved  
OMB No. 0704-0188

NOTES:

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 Ra 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 (DDISS) 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.

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 DDISS SPECIFIED IN THE SOLICITATION NONE

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

© 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

MILITARY SPECIFICATION SHEET  
 TITLE  
 TUBING END  
 STANDARD DIMENSIONS FOR FLARED

SPECIFICATION SHEET NUMBER  
**MS33584C** 17 DEC 90  
 SUPERSEDING  
 MS33584B      9 DEC 1967  
 AMSQC    N/A      FSC 4730