

REVIEW ACTIVITIES: C.S.A.R
USER ACTIVITIES AT

THIS MILITARY STANDARD IS MANDATORY FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE
DEPARTMENT OF DEFENSE. SELECTION FOR ALL NEW ENGINEERING AND DESIGN APPLICATIONS
AND FOR REPETITIVE USE SHALL BE MADE FROM THIS DOCUMENT.

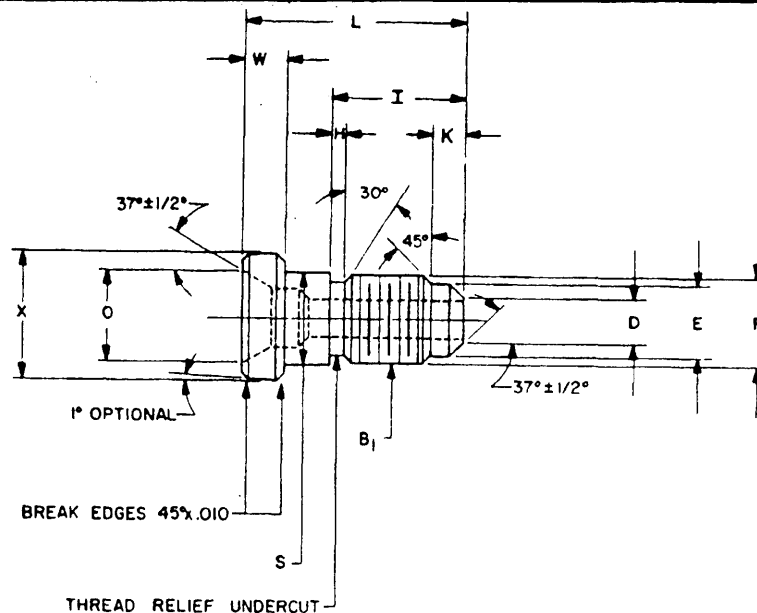
TUBE - REDUCER : 37 DEGREE FLARE - INCHES AND MILLIMETERS													
DASH NO.	A, STRAIGHT THREAD	MINOR DIA		A ₁ , STRAIGHT THREAD	C	F		U		K		J ₁	
	NOM SIZE CLASS A	IN	MM	NOM SIZE CLASS B	HEX	IN	MM	IN	MM	IN	MM	IN	MM
		+0.005 -0.000	+ .13 - .00		NOM	+0.003 -0.005	+0.8 -1.30	+0.000 -0.130	+0.000 -0.130	+0.015 -0.000	+0.40 -0.00	FULL	THREAD
5-4	1/2 - 20	.451	11.46	7/16 - 20	5/8	.193	4.90	.359	9.120	.193	4.90	.261	6.63
6-5	9/16 - 18	.508	12.90	1/2 - 20	11/16	.255	6.48	.421	10.690	.193	4.90	.261	6.63
10-8	7/8 - 14	.804	20.42	3/4 - 16	1	.426	10.82	.654	16.610	.253	6.43	.354	8.99
12-10	1-1/16 - 12	.979	24.86	7/8 - 14	1-1/4	.539	13.70	.767	19.480	.266	6.80	.370	9.40

DASH NO.	I ₁		J		I		L		D		V	
	IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	IN	MM
	+0.005 -0.000	+0.015 -0.000	+0.013 -0.00	+0.40 -0.00	+0.015 -0.00	+0.40 -0.00	+0.010 -0.00	+0.25 -0.00	DRILL		+0.015 -0.000	+0.40 -0.00
5-4	.344	8.740	.075	1.90	.550	14.00	1.156	29.30	.172	4.40	.505	12.80
6-5	.344	8.740	.075	1.90	.550	14.00	1.188	30.20	.234	5.94	.567	14.40
10-8	.469	11.910	.094	2.40	.657	16.70	1.437	36.50	.391	9.93	.880	22.35
12-10	.500	12.700	.107	2.72	.758	19.30	1.656	42.00	.484	12.29	1.067	27.10

NOTES: 1. MATERIAL SHALL BE CARBON STEEL WITH PROTECTIVE PLATING IN ACCORDANCE WITH MIL-F-18866.
2. BREAK ALL SHARP EDGES AND REMOVE ALL BURRS AND SLIVERS.
3. UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES (MILLIMETERS).
4. PART NUMBER EXAMPLE:
MS39323 - 5-4, -5 INDICATES 5/16-INCH O.D. TUBE IN 1/16-INCH INCREMENTS,
-4 INDICATES 1/4-INCH O.D. TUBE IN 1/16-INCH INCREMENTS.
5. REFERENCE DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BIDS,
OR REQUEST FOR PROPOSAL.
6. FOR DESIGN FEATURE PURPOSES THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT
DOCUMENTS REFERENCED HEREIN.

ENTIRE STANDARD REVISED

P.A. ME Other Cust	TITLE TUBE-REDUCER: 37 DEGREE FLARE	MILITARY STANDARD MS39323 (ME)
PROCUREMENT SPECIFICATIONS MIL-F-18866	SUPERSEDES:	SHEET 1 OF 3

FED. SUP CLASS
4730

TUBE - REDUCER : 37 DEGREE FLARE - INCHES AND MILLIMETERS

DASH NO.	B ₁ , STRAIGHT THREAD NOM SIZE CLASS 2A	PITCH DIA IN		PITCH DIA MM		E		F		K		H	
		MAX	MIN	MAX	MIN	IN	MM	IN	MM	IN	MM	IN	MM
						.003	.08	.000	.00	.015	.40	.015	.40
								.005	.13	.000	.00	.000	.00
6-4	7/16-20	.4037	.3995	10.25	10.47	.193	4.90	.359	9.12	.193	4.90	.075	1.90
8-4	7/16-20	.4037	.3995	10.25	10.47	.193	4.90	.359	9.12	.193	4.90	.075	1.90
10-4	7/16-20	.4037	.3995	10.25	10.47	.193	4.90	.359	9.12	.193	4.90	.075	1.90
12-4	7/16-20	.4037	.3995	10.25	10.47	.193	4.90	.359	9.12	.193	4.90	.075	1.90
8-5	1/2-20	.4037	.3995	10.25	10.47	.255	6.48	.421	10.69	.193	4.90	.075	1.90
10-5	1/2-20	.4662	.4619	11.84	11.73	.255	6.48	.421	10.69	.193	4.90	.075	1.90
12-5	1/2-20	.4662	.4619	11.84	11.73	.255	6.48	.421	10.69	.193	4.90	.075	1.90
8-6	9/16-18	.5250	.5205	13.33	13.22	.318	8.08	.476	12.09	.198	5.02	.083	2.10
10-6	9/16-18	.5250	.5205	13.33	13.22	.318	8.08	.476	12.09	.198	5.02	.083	2.10
12-6	9/16-18	.5250	.5205	13.33	13.22	.318	8.08	.476	12.09	.198	5.02	.083	2.10
12-8	3/4-16	.7079	.7029	17.98	17.85	.426	10.82	.654	16.61	.253	6.40	.094	2.40

REVIEW ACTIVITIES:
USER ACTIVITIES

APPROVED 4 MAY 1967 REVISED (A) 9 MAY 80

P.A. ME Other Cust	TITLE TUBE-REDUCER : 37 DEGREE FLARE	MILITARY STANDARD MS39323(ME)
PROCUREMENT SPECIFICATIONS MIL-F-18866	SUPERSEDES:	SHEET 2 OF 3

REVIEW ACTIVITIES
USER ACTIVITIES

FED. SUP CLASS
47 30

TUBE-REDUCER: 37 DEGREE FLARE-INCHES AND MILLIMETERS (CONT)													
DASH NO	I		L		W		D		X		S		O
	IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	
	1.015	2.40	1.02	2.55	1.02	2.55	1.03	2.60	1.000	2.54	1.000	2.54	1.13
									-.003	-.008	-.003	-.008	-.40
6-4	5.50	14.00	.97	24.60	.17	4.32	.172	4.40	.502	12.750	.432	10.970	11.20
8-4	5.50	14.00	1.00	25.40	.22	5.60	.172	4.40	.682	17.320	.562	14.270	14.96
10-4	5.50	14.00	1.03	26.20	.23	5.80	.172	4.40	.797	20.240	.690	17.530	17.90
12-4	5.50	14.00	1.09	27.60	.27	6.90	.172	4.40	.972	24.690	.826	20.980	22.35
8-5	5.50	14.00	1.00	25.40	.22	5.60	.234	5.94	.682	17.320	.562	14.270	14.96
10-5	5.50	14.00	1.03	26.20	.23	5.80	.234	5.94	.797	20.240	.690	17.530	17.90
12-5	5.50	14.00	1.09	27.60	.27	6.90	.234	5.94	.972	24.690	.826	20.980	22.35
8-6	5.56	14.12	1.00	25.40	.22	5.60	.297	7.54	.682	17.320	.562	14.270	14.96
10-6	5.56	14.12	1.03	26.20	.23	5.80	.297	7.54	.797	20.340	.690	17.530	17.90
12-6	5.56	14.12	1.09	27.60	.27	6.90	.297	7.54	.972	24.690	.826	20.980	22.35
12-8	6.57	16.70	1.19	30.20	.27	6.90	.391	9.90	.972	24.690	.826	20.980	22.35

☆U.S. GOVERNMENT PRINTING OFFICE: 1980 — 603-121/2417

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PROCUREMENT SPECIFICATIONS MIL-F-18866	SUPERSEDES:	SHEET 3 OF 3

DD FORM 672-1
1 SEP 57

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

APPROVED 4 MAY 1967 REVISED (A) 9 MAY 90

