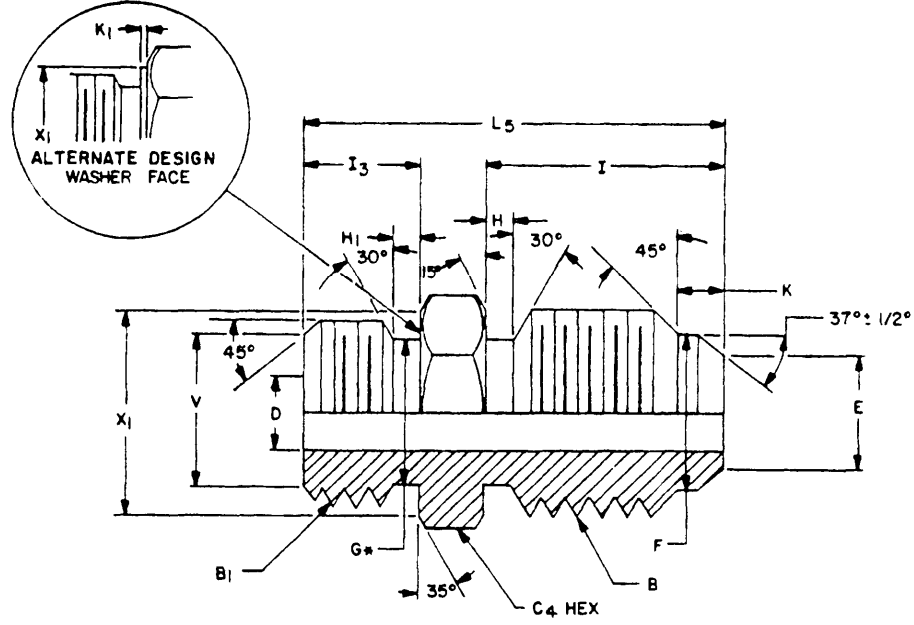


REVIEW ACTIVITIES: CS, AR
USER ACTIVITIES: AT



* "O" RING GROOVE UNDERCUT MUST BE SMOOTH AND FREE FROM TOOL MARKS 100 MICRO INCHES MAXIMUM.

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:
MS39324 - 5 - 4; - 5 INDICATE 37° FLARE FOR 5/16 O.D. TUBE IN 1/16 - INCH INCREMENTS, - 4 INDICATES "O" RING BOSS WITH 7/16-20 STRAIGHT THREAD.
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.
7. DIMENSIONS AND TOLERANCES NOT SHOWN SHALL CONFORM TO SAE J514.

ENTIRE STANDARD REVISED

P.A. ME Other Cust	TITLE ADAPTER: 37- DEGREE FLARE TO "O" RING BOSS	MILITARY STANDARD MS39324 (ME)
PROCUREMENT SPECIFICATIONS: MIL-F-18866	SUPERSEDES:	SHEET 1 OF 3

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

APPROVED 4 MAY 1967 REVISED 9 MAY 80

USER ACTIVITIES

FED. SUP CLASS
47 30

ADAPTER: 37 DEGREE FLARE TO "O" RING BOSS INCHES AND MILLIMETERS														
DASH NO.	B STRAIGHT THREAD NOM SIZE	B ₁ STRAIGHT THREAD NOM SIZE	D		C ₄ HEX	I		G		H ₁		L ₅		I ₃ MM
			IN	MM		IN	MM	IN	MM	IN	MM	IN	MM	
	ISO R725 CLASS A	ISO R725 CLASS A	±.003	±.08	NOM	±.40	±.002	±.05	±.40	±.005	±.40	±.50	±.13	
-4-4	7/16-20	7/16-20	.172	4.40	9/16	.550	14.00	.364	9.25	.075	1.90	1.23	31.20	9.14
-5-4	1/2-20	7/16-20	.172	4.40	9/16	.550	14.00	.364	9.25	.075	1.90	1.23	31.20	9.14
-6-4	9/16-18	7/16-20	.172	4.40	5/8	.556	14.10	.364	9.25	.075	1.90	1.23	31.20	9.14
-8-4	3/4-16	7/16-20	.172	4.40	13/16	.657	16.70	.364	9.25	.075	1.90	1.34	34.00	9.14
-10-4	7/8-14	7/16-20	.172	4.40	15/16	.758	19.30	.364	9.25	.075	1.90	1.47	37.30	9.14
-12-4	1-1/16-12	7/16-20	.172	4.40	1-1/8	.864	21.90	.364	9.25	.075	1.90	1.64	41.60	9.14
-5-5	1/2-20	1/2-20	.234	5.90	5/8	.550	14.00	.427	10.85	.075	1.90	1.23	31.20	9.14
-6-5	9/16-18	1/2-20	.234	5.90	5/8	.556	14.10	.427	10.85	.075	1.90	1.23	31.20	9.14
-8-5	3/4-16	1/2-20	.234	5.90	13/16	.657	16.70	.427	10.85	.075	1.90	1.34	34.00	9.14
-10-5	7/8-14	1/2-20	.234	5.90	15/16	.758	19.30	.427	10.85	.075	1.90	1.47	37.30	9.14
-12-5	1-1/16-12	1/2-20	.234	5.90	1-1/8	.864	21.90	.427	10.85	.075	1.90	1.64	41.60	9.14
-6-6	9/16-18	9/16-18	.297	7.50	11/16	.556	14.10	.482	12.24	.083	2.10	1.29	32.80	9.93
-8-6	3/4-16	9/16-18	.297	7.50	13/16	.657	16.70	.482	12.24	.083	2.10	1.40	35.60	9.93
-10-6	7/8-14	9/16-18	.297	7.50	15/16	.758	19.30	.482	12.24	.083	2.10	1.50	38.00	9.93
-12-6	1-1/16-12	9/16-18	.297	7.50	1-1/8	.864	21.90	.482	12.24	.083	2.10	1.67	42.40	9.93
-8-8	3/4-16	3/4-16	.391	9.90	7/8	.657	16.70	.660	16.76	.094	2.40	1.48	37.60	11.13
-10-8	7/8-14	3/4-16	.391	9.90	1-1/8	.758	19.30	.660	16.76	.094	2.40	1.58	40.10	11.13
-12-8	1-1/16-12	3/4-16	.391	9.90	1-1/4	.864	21.90	.660	16.76	.094	2.40	1.72	44.00	11.13
-10-10	7/8-14	7/8-14	.484	12.30	1	.758	19.30	.773	19.63	.107	2.70	1.70	43.20	5.00
-12-10	1-1/16-12	7/8-14	.484	12.30	1-1/8	.864	21.90	.773	19.63	.107	2.70	1.80	45.70	5.00
-12-12	1-1/16-12	1-1/16-12	.609	15.50	1-1/4	.864	21.90	.945	24.00	.125	3.20	1.97	50.00	5.94
-12-16	1-1/16-12	1-5/16-12	.609	15.50	1-1/2	.864	21.90	1.195	30.35	.125	3.20	2.00	50.80	5.94

APPROVED 4 MAY 1967 REVISED (A) 9 MAY 80

P.A. Other Cust	TITLE ADAPTER: 37- DEGREE FLARE TO "O" RING BOSS	MILITARY STANDARD MS39324(ME)
PROCUREMENT SPECHICATIONS MIL-F-18866	SUPERSEDES:	SHEET 2 OF 3

REPAIR ACTIVITIES: CS
USER ACTIVITIES

FED. SUP CLASS
47 30

ADAPTER: 37 DEGREE FLARE TO "O" RING BOSS INCHES AND MILLIMETERS (CONT)

DASH NO	V		X ₁		E		F		K		H		K ₁	
	IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	IN	MM
	±.005	±.13	±.005	±.13	±.003	±.08	±.005	±.13	±.015	±.40	±.015	±.40	±.015	±.40
-4-4	.365	.927	.563	14.30	.193	4.90	.359	.912	.193	4.90	.075	1.90		
-5-4	.365	.927	.563	14.30	.255	6.48	.421	10.69	.193	4.90	.075	1.90		
-6-4	.365	.927	.563	14.30	.318	8.08	.476	12.09	.198	5.00	.083	2.10	.062	1.60
-8-4	.365	.927	.563	14.30	.426	10.82	.654	16.61	.253	6.42	.094	2.40	.062	1.60
-10-4	.365	.927	.563	14.30	.539	13.70	.767	19.48	.266	6.80	.107	2.70	.062	1.60
-12-4	.365	.927	.563	14.30	.664	16.80	.938	23.82	.315	8.00	.125	3.20	.062	1.60
-5-5	4.25	10.80	6.25	15.88	2.55	64.8	4.21	10.67	.193	4.90	.075	1.90		
-6-5	4.25	10.80	6.25	15.88	3.18	80.8	4.76	12.09	.198	4.90	.083	2.10		
-8-5	4.25	10.80	6.25	15.88	4.26	10.82	6.54	16.61	.253	6.42	.094	2.40	.062	1.60
10-5	4.25	10.80	6.25	15.88	5.39	13.70	7.67	19.48	.266	6.80	.107	2.70	.062	1.60
-12-5	4.25	10.80	6.25	15.88	6.64	16.80	9.38	23.82	.315	8.00	.125	3.20	.062	1.60
-6-6	4.80	12.19	6.88	17.48	3.18	80.8	4.76	12.09	.198	5.03	.083	2.10		
-8-6	4.80	12.19	6.88	17.48	4.26	10.82	6.54	16.61	.253	6.42	.094	2.40	.062	1.60
-10-6	4.80	12.19	6.88	17.48	5.39	13.70	7.67	19.48	.266	6.80	.107	2.70	.062	1.60
-12-6	4.80	12.19	6.88	17.48	6.64	16.80	9.38	23.32	.315	2.00	.125	3.20	.062	1.60
-8-8	6.60	16.76	8.75	22.22	4.26	10.82	6.54	16.61	.253	6.42	.094	2.40		
-10-8	6.60	16.76	8.75	22.22	5.39	13.70	7.67	19.48	.266	6.80	.107	2.70	.094	2.40
-12-8	6.60	16.76	8.75	22.22	6.64	16.80	9.38	23.82	.315	8.00	.125	3.20	.094	2.40
-10-10	7.75	19.68	10.00	25.40	5.39	13.70	7.67	19.48	.266	6.80	.107	2.70		
-12-10	7.75	19.68	10.00	25.40	6.64	16.80	9.38	23.82	.315	8.00	.125	3.20		
-12-12	9.45	24.00	12.50	31.75	6.64	16.80	9.38	23.82	.315	8.00	.125	3.20		
-12-16	11.95	30.35	15.00	38.10	6.64	16.80	9.38	23.82	.315	8.00	.125	3.20		

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

DD FORM 1 SEP 57 672-1

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.