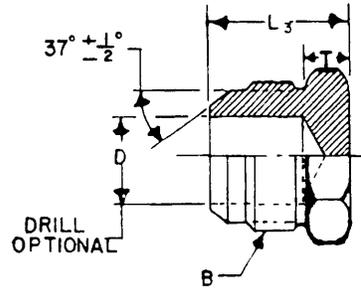
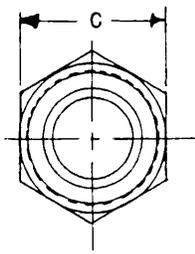


FED. SUP CLASS  
4730



REVIEWER: CS-EL-ME  
USER: AT-PC-YD

DASH NUMBER	TUBE OD NOM	B STRAIGHT THREAD	C HEX FLAT: NOM	D DIAMETER		L <sub>3</sub> ±.020	T REF
				BASIC	TOLERANCE		
B2	1/8	5/16-24UNF-2A	7/16	.062	±.003	.700	.220
B3	3/16	3/8--24UNF-2A	7/16	.125		.730	.220
B4	1/4	7/16-20UNF-2A	1/2	.172		.800	.220
B5	5/16	1/2 -20UNF-2A	9/16	.234		.800	.220
B6	3/8	9/16-18UNF-2A	5/8	.297		.840	.250
B8	1/2	3/4 -16UNF-2A	13/16	.391		±.004	.940
B10	5/8	7/8 -14UNF-2A	15/16	.484	±.005	1.100	.310
B12	3/4	1-1/16-12UN-2A	1-1/8	.609		1.280	.380
B14	7/8	1-3/16-12UN-2A	1-1/4	.718		1.310	.380
B16	1	1-5/16-12UN-2A	1-3/8	.844		+0.007 -0.005	1.330
B20	1-1/4	1-5/8 -12UN-2A	1-11/16	1.078	+0.008 -0.005	1.450	.460
B24	1-1/2	1-7/8 -12UN-2A	2	1.312		1.650	.530
B32	2	2-1/2 -12UN-2A	2-5/8	1.781		+0.010 -0.005	2.050

NOTES:

- MATERIAL:** Steel, carbon in accordance with procurement specification.  
Steel, corrosion-resisting in accordance with procurement specification.
- PROTECTIVE COATING:** Cadmium plated in accordance with procurement specification.  
Zinc plated in accordance with procurement specification.  
Phosphate coating in accordance with procurement specification.  
Passivation treatment in accordance with procurement specification.
- DIMENSIONS AND TOLERANCES:** Dimensions and tolerances not shown shall be in accordance with the SAE Standard for 37 Degree Flared Fittings (SAE J514).
- THREADS:** Threads shall be in accordance with Screw-Thread Standards for Federal Services, Handbook H28.
- PART NUMBER:** The MS part number consists of the MS number plus the dash number.
  - For cadmium plating use the MS number, plus the dash number. Example: MS51518B2.
  - For zinc plating add (Z) to the dash number. Example: MS51518B2Z.
  - For phosphate coating add (P) to the dash number. Example: MS51518B2P.
  - For corrosion-resisting steel, add (S) to the dash number. Example: MS51518B2S.
- For design feature purposes, this standard takes precedence over procurement documents referenced herein.
- Reference documents shall be of the issue in effect on date of invitations for bid.
- The illustration is for identification purpose only and is not intended to restrict designs on shapes not dimensioned.
- After 17 January 1979 bodies will be used for production only and SHALL NOT be stocked for maintenance. Existing stock of bodies should be used until depleted.

This military standard is approved 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 when applicable.

APPROVED 20 DEC 1971 REVISED 17 JANUARY 1979

P.A. AR Other Cust OS	TITLE PLUG, MACHINE THREAD, 37° FLARED	MILITARY STANDARD <b>MS51518</b>
PROCUREMENT SPECIFICATION MIL-F-18866	SUPERSEDES:	SHEET 1 OF 1

