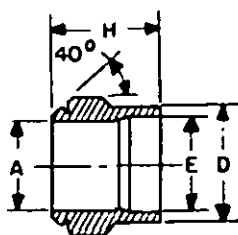
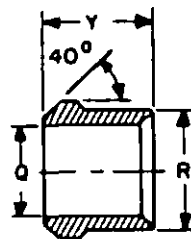
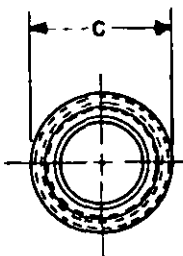


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STYLE A

(C)



STYLE B

(C)

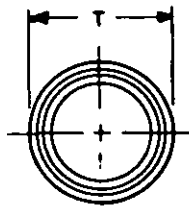


TABLE I

* DASH NO.	TUBE O.D. NOM	A DIA +.003 -.000	C DIA +.005 -.000	D DIA +.000 -.003	E DIA +.003 -.000	H DIA +.003 -.000	Q DIA +.003 -.000	R DIA		T DIA ± .005	Y ± .003
								MIN	MAX		
1	1/8	0.130	0.237	0.178	0.140	.288	0.129	0.175	0.178	0.203	.278
2	3/16	0.193	0.307	0.249	0.205	.329	0.193	0.252	0.256	0.312	.278
3	1/4	0.255	0.367	0.312	0.268	.363	0.255	0.309	0.313	0.359	.336
4	5/16	0.318	0.430	0.375	0.330	.367	0.318	0.373	0.377	0.422	.336
5	3/8	0.380	0.492	0.440	0.393	.393	0.380	0.431	0.435	0.484	.375
6	1/2	0.505	0.663	0.587	0.521	.429	0.506	0.585	0.589	0.625	.375
7	5/8	0.631	0.780	0.713	0.647	.442	0.633	0.698	0.702	0.750	.415
8	3/4	0.756	0.925	0.838	0.772	.475	0.758	0.836	0.840	0.875	.415
9	7/8	0.881	1.040	0.963	0.897	.475	0.883	0.961	0.965	1.000	.415
10	1	1.006	1.187	1.088	1.022	.475	1.008	1.086	1.090	1.125	.415
11	1-1/4	1.260	1.446	1.341	1.275	.475	1.260	1.339	1.343	1.406	.415
12	1-1/2	1.510	1.694	1.590	1.524	.475	1.511	1.589	1.593	1.656	.415
13	2	2.014	2.210	2.094	2.026	.509	2.014	2.092	2.096	2.188	.450

For notes see sheet 2.

(C) Denotes change

P.A. AR Other Cust 99	TITLE SLEEVE, CLINCH, TUBE FITTING, FLARELESS TYPE, HYDRAULIC	MILITARY STANDARD MS51825
PROCUREMENT SPECIFICATION MIL-F-18866	SUPERSEDES CNH18 in part	PAGE 1 OF 2

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

4730-0890

User Activities:  
Army - AV  
Navy - OS, MCReview Activities:  
Army - AT, CL, ME  
Air Force - 82  
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APPROVED 29 DEC 67 REVISED (F) 2 JULY 1984 (C) 30 JULY 1987

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## NOTES:

1. **MATERIAL:** Steel, carbon in accordance with procurement specification.  
Steel, corrosion-resisting in accordance with procurement specification.
2. **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.
3. **DIMENSIONS AND TOLERANCES:** Dimensions and tolerances not shown shall be in accordance with the SAE Standard for Flareless Tube Fittings (SAE J514).
4. **THREADS:** Threads shall be in accordance with Screw-Thread Standards for Federal Services, FED-STD-428.
5. **PART NUMBER:** The MS part number consists of the MS number, plus the dash number and the style designator.
  - A. For cadmium plated sleeves use the MS number, plus the dash number and the style designator. Example: MS51825-1A or MS51825-1B.
  - B. For zinc plated sleeves add (Z) and the style designator to the dash number. Example: MS51825-1ZA or MS51825-1ZB.
  - C. For phosphate coated sleeves add (P) and the style designator to the dash number. Example: MS51825-1PA or MS51825-1PB.
  - D. For corrosion-resisting steel sleeves add (SS) and the style designator to the dash number. Example: MS51825-1SSA or MS51825-1SSB.
6. For design feature purposes, this standard takes precedence over procurement documents referenced herein.
7. Reference documents shall be of the issue in effect on date of invitations for bid.
8. The illustration is for identification and is not intended to restrict designs or shapes not dimensioned.
9. After 22 NOV 1974 , sleeves will be used for production only and SHALL NOT be stocked for maintenance. Existing stock of sleeves should be used until depleted.
10. CAUTION: The following data is furnished for the purpose of new design only and is not intended to imply interchangeability.

MS51825 will replace MS39212 for new design after approval date on this document. Table II below gives reference data for coordination of equivalent tube sizes, in both compression and hydraulic type sleeves. Assembly replacement is authorized.

TABLE II (FOR INFORMATION ONLY)  
ASSEMBLY EQUIVALENCY

PART NUMBER		PART NUMBER		PART NUMBER	
COMPRESSION	HYDRAULIC	COMPRESSION	HYDRAULIC	COMPRESSION	HYDRAULIC
MS39212-1	MS51825-1	MS39212-5	MS51825-5	MS39212-9	MS51825-9
-2	-2	-6	-6	-10	-10
-3	-3	-7	-7	-11	-11
-4	-4	-8	-8	-12	-12

P.A. Other Cost 99	AR	TITLE SLEEVE, CLINCH, TUBE FITTING, FLARELESS TYPE, HYDRAULIC	MILITARY STANDARD MS51825
PROCUREMENT SPECIFICATION MIL-F-18866	SUPERSEDES:	CNH18 in part	PAGE 2 OF 2

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

4730-0890

Use Activities:  
Army - AV  
Navy - OS, MC

Review Activities:  
Army - AI, CL, HZ  
Air Force - 82  
DLA - CS

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 29 DEC 1967  
F FOR CHANGES SEE SHEET 1  
G 30 July 1987