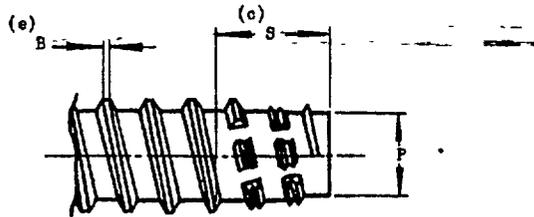
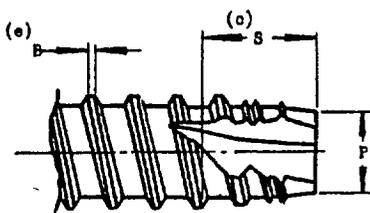


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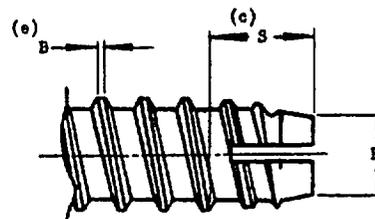
This drawing was approved by joint action of the Air Force and Navy Departments as the Air Force-Navy standard for this product. The drawing supersedes all antecedent standard drawings for the same product and shall become effective for the procurement of aeronautical equipment, or for use in new designs, not later than 6 months after the latest date of approval thereon.



TYPE BF OR FZ



TYPE BT OR 25



TYPE BO OR H

(d) OPTIONAL TYPES OF ENDS FOR THREAD CUTTING SCREWS

① CARBON STEEL, SLOTTED HEAD SCREWS, THREAD FORMING, DASH NUMBERS FOR:

LENGTH	NO. 4		NO. 6		NO. 8		NO. 10		1/4	
	DASH NO.	GRIP MIN								
1/4		.115								
3/8	+0	.240	6-6	.219	8-6	.205				
1/2	-1/32	.365	6-8	.344	8-8	.330	10-8	.313		
5/8			6-10	.469	8-10	.455	10-10	.438	14-10	.415
3/4										
7/8	+0		6-12	.578	8-12	.564	10-12	.547	14-12	.524
1	-3/64		6-14	.703	8-14	.689	10-14	.672	14-14	.649
1 1/4			6-16	.828	8-16	.814	10-16	.797	14-16	.774
1 1/2			6-20	1.078	8-20	1.203	10-20	1.047	14-20	1.024
			6-24	1.328	8-24	1.314	10-24	1.297	14-24	1.274
1 3/4										
2	+0				8-28	1.549	10-28	1.532	14-28	1.509
2 1/4	-1/16				8-32	1.800	10-32	1.782	14-32	1.759
2 1/2					8-36	2.049	10-36	2.032	14-36	2.009
					8-40	2.300	10-40	2.282	14-40	2.259

APPROVED 10 Jan 55 REVISED 12 Jul 55

PROCUREMENT SPECIFICATION MIL-B-6033	AIR FORCE-NAVY AERONAUTICAL STANDARD	AN531 SHEET 2
	SCREW, TAPPING, THREAD FORMING OR THREAD CUTTING, 82-DEGREE FLAT HEAD, SPACED THREAD	

NOTICE: This drawing was approved by joint action of the Air Force and Navy Department in accordance with the provisions of the Joint Air Force-Navy Standardization Agreement. It is the responsibility of the user to determine the applicability of this drawing to his own design and to determine the effect of any change in the drawing on his own design. It is the responsibility of the user to determine the effect of any change in the drawing on his own design. It is the responsibility of the user to determine the effect of any change in the drawing on his own design.

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- (a) MARKING FOR CORROSION-RESISTANT STEEL SCREWS. ONLY ONE DASH NEED BE VISIBLE, POSITION OPTIONAL. NO MARKING REQUIRED ON HEADS OF NO. 4 SCREWS.
- (b) THE GRIP LENGTH IS MEASURED FROM THE TOP OF THE HEAD TO THE END OF THE FULL-THREADED PORTION OF THE SHANK. THE MINIMUM GRIP DIMENSIONS SHOWN IN THE DASH NUMBER TABLE ARE FOR DESIGN PURPOSES ONLY AND ARE NOT AN INSPECTION REQUIREMENT.
- (c) TAPER LENGTH, S, IS 2 TO 2-1/2 TIMES THE PITCH OF THE THREAD.
- (d) SCREWS DESIGNATED AS THREAD FORMING HAVE PLAIN ENDS (NOT FLUTED OR SLOTTED). SCREWS DESIGNATED AS THREAD CUTTING HAVE FLUTED OR SLOTTED ENDS.
- (e) MAXIMUM CREST OF THREAD, B, UP TO AND INCLUDING SIZE NO. 8 EQUALS 0.004 INCH; MAXIMUM CREST OF THREAD OVER SIZE NO. 8 EQUALS 0.006 INCH. TAPERED THREADS HAVE UNFINISHED CRESTS.

- ① MATERIAL: CARBON STEEL, CASE HARDENED, OR CORROSION-RESISTANT STEEL, TYPE 410, HARDENED.
- ① FINISH: CARBON STEEL, CADMIUM PLATE, SPECIFICATION QQ-P-416, TYPE I, CLASS C. CORROSION-RESISTANT STEEL, NONE.

ADD C BEFORE FIRST DASH NUMBER FOR CORROSION-RESISTANT STEEL SCREWS.

ADD F BETWEEN FIRST AND SECOND DASH NUMBERS FOR SCREWS WITH FLUTED OR SLOTTED ENDS, (THREAD CUTTING). IF R APPEARS IN THE CODING, ADD THE F IMMEDIATELY FOLLOWING THE R.

ADD R BETWEEN FIRST AND SECOND DASH NUMBERS FOR RECESSED HEAD SCREWS.

① EXAMPLES OF PART NUMBERS:

- AN531-6-8 - NO. 6, CARBON STEEL, SLOTTED HEAD, THREAD FORMING SCREW, 8/16 IN LENGTH.
- AN531-6P8 - NO. 6, CARBON STEEL, RECESSED HEAD, THREAD FORMING SCREW, 8/16 IN LENGTH.
- AN531-6RFB - NO. 6, CARBON STEEL, RECESSED HEAD, FLUTED OR THREAD CUTTING SCREW, 8/16 IN LENGTH.
- AN531C6-F - NO. 6, CORROSION-RESISTANT STEEL, SLOTTED HEAD, THREAD FORMING SCREW, 8/16 IN LENGTH.
- AN531C6R8 - NO. 6, CORROSION-RESISTANT STEEL, RECESSED HEAD, THREAD FORMING SCREW, 8/16 IN LENGTH.
- AN531C6RFB - NO. 6, CORROSION-RESISTANT STEEL, RECESSED HEAD, FLUTED OR THREAD CUTTING SCREW, 8/16 IN LENGTH.

SCREWS HAVING FIVE THREADS OR LESS MAY HAVE FINER PITCH THREADS, OR SHORTER POINTS, OR FINER PITCH THREADS AND SHORTER POINTS, AT THE OPTION OF THE PRODUCER.

SCREW MANUFACTURER'S DESIGNATION MAY BE INCLUDED ON THE SCREWS.

SCREWS SHALL BE FREE OF ALL LOOSE OR HANGING BURRS OR SLIVERS WHICH MIGHT BECOME DISLODGED UNDER USAGE.

DIMENSIONS IN INCHES.

SUBJECT TO AND10087 LIMITATIONS, THE THREAD FORMING SCREWS SHOWN ON THIS DRAWING MAY BE USED WITH SPECIFICATION MIL-N-3337 SHEET SPACING NUTS.

SUBJECT TO AND10087 LIMITATIONS, THE SCREWS MAY BE USED AS TAPPING SCREWS WITH AND10325 HOLE SIZES AND AND10387 HOLE TOLERANCES.

APPROVED 10 Jan 55 REVISED ① 12 Jul 55

PROCUREMENT SPECIFICATION MIL-S-6033	AIR FORCE-NAVY AERONAUTICAL STANDARD SCREW, TAPPING, THREAD FORMING OR THREAD CUTTING, 82- DEGREE FLAT HEAD, SPACED THREAD	AN531 SHEET 3
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INCH-POUND

AN531 REV. 5
AMENDMENT 1
20 May 1996

AIR FORCE - NAVY AERONAUTICAL STANDARD

SCREW, TAPPING, THREAD FORMING OR THREAD
CUTTING, 82 DEGREE, FLAT HEAD, SPACED THREAD

This amendment forms a part of AN531 REV. 5, dated , 17 February 1959 and is approved for use by all Departments and Agencies of the Department of Defense.

PAGES 1, 2 and 3

In Procurement Specification Block delete: "MIL-S-6033" and substitute: "FF-S-107".

PAGE 3

The fifth and sixth sentences under part number examples "Subject to AND10087 limitations...." delete: "AND10087" and substitute: "MS33749".

Custodians:

Navy - AS
Air Force - 99

Preparing Activity:
DLA-IS

(Project 5305-2133)

AMSC N/A

FSC 5405

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