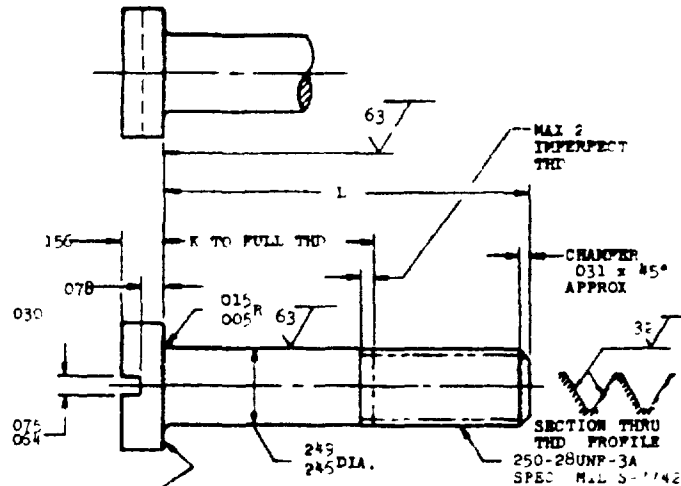
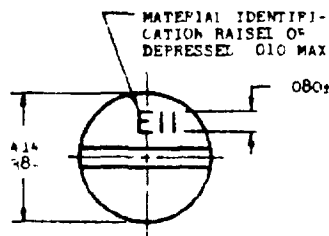


OPTIONAL METHOD OF SLOPPING



THIS SURFACE MUST BE SQUARE WITH SHANK WITHIN .003 FULL INDICATOR READING

L	K + .000 - .060	PART NO	L	K + .000 - .060	PART NO	L	K + .000 - .060	PART NO
500	(A)	AN115455	1 250	625	AN115467	2 250	1 625	AN115479
562	(A)	AN115456	1 312	688	AN115468	2 375	1 750	AN115480
525	(A)	AN115457	1 375	750	AN115469	2 500	1 875	AN115481
688	(A)	AN115458	1 438	812	AN115470	2 525	2 000	AN115482
750	125	AN115459	1 500	875	AN115471	2 750	2 125	AN115483
812	188	AN115460	1 562	938	AN115472	2 875	2 250	AN115484
875	250	AN115461	1 625	1 000	AN115473	3 000	2 375	AN115485
938	312	AN115462	1 688	1 062	AN115474			
1 000	375	AN115463	1 750	1 125	AN115475			
1 062	438	AN115464	1 812	1 250	AN115476			
1 125	500	AN115465	2 000	1 375	AN115477			
1 188	562	AN115466	2 125	1 500	AN115478			

(A) THREAD TO HEAD MAXIMUM TWO IMPERFECT THREADS

NOTE (1) THE RUNOUT FOR STRAIGHTNESS OF SHANK SHALL NOT EXCEED .001 PER INCH OF SCREW LENGTH  
(2) THE CONCENTRICITY OF THREAD PD IN RELATION TO THE SHANK SHALL BE WITHIN .006 PER INCH  
(3) THE CONCENTRICITY OF THE SHANK IN RELATION TO THE HEAD SHALL BE WITHIN .010 PER INCH

MATERIAL STEEL AMS 6320

HARDNESS ROCKWELL C75-3

FINISH CADMIUM PLATE AMS 7433

SURFACE ROUNDED TO .005

MANUFACTURING SPECIFICATION AMS 7457

(3) INSPECTION ALL PARTS SHALL UNDERGO MAGNETIC INSPECTION IN ACCORDANCE WITH AMS2640

BREAK SHARP EDGES .003-.015 UNLESS OTHERWISE SPECIFIED TOLERANCES UNLESS DIMENSIONS + .010

DO NOT USE UNASSIGNED PART NUMBERS

THIS STANDARD WAS DEVELOPED COOPERATIVELY WITH THE ENGINE AND PROPELLER STANDARD PARTS COMMITTEE OF THE SAE

P A  
USAF - 11  
Other Govt  
Navy - 45  
Army - 47

AIR FORCE-NAVY AERONAUTICAL STANDARD

SCREW MACHINE - STEEL FLAT FILLISTER HEAD 250 2P

AN115451  
THRU  
AN115500

DISTRIBUTION STATEMENT A Approved for public release distribution is unlimited

APPROVED 8 Jun 49 REVISED 1 4 Oct 54 2 Jul 61 3 10 June 1986