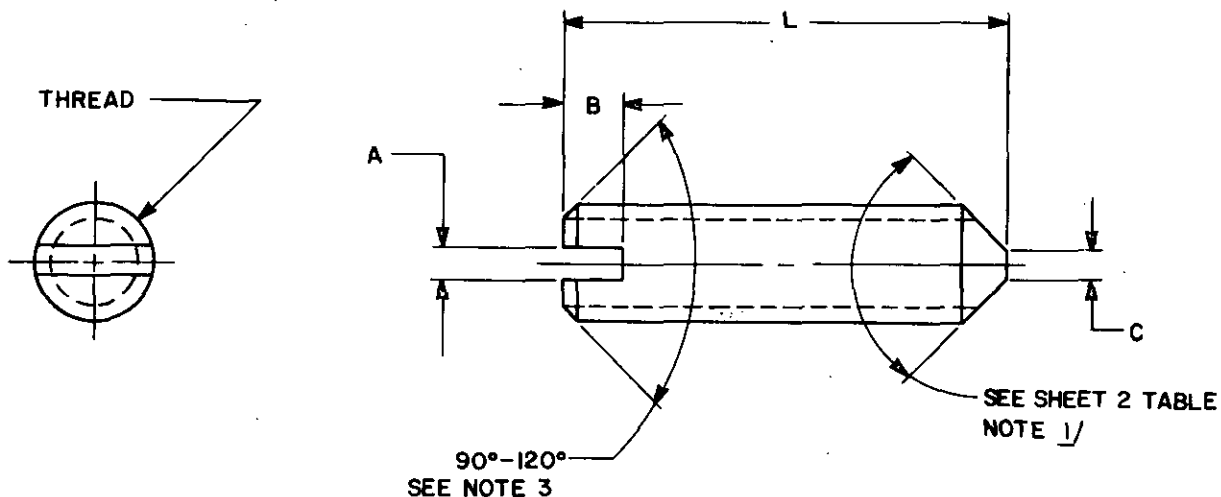


User ac

ARMY - CE, ER, ME  
NAVY - MC, OS, SH

Review activities:

ARMY - AV, MI  
DLA - IS  
NSA - NS

## REQUIREMENTS:

1. MATERIAL. STEEL, LOW OR MEDIUM CARBON IN ACCORDANCE WITH FF-S-210.
2. FINISH. CADMIUM PLATE IN ACCORDANCE WITH QQ-P-416, TYPE II, CLASS 3 (5.1  $\mu$ m THICK).
3. THREADS. IN ACCORDANCE WITH FED-STD-H28/21, TOLERANCE CLASS - 6g, BEFORE PLATING.
4. HARDNESS. 30-37HRC OR SURFACE HARDENED TO 64HR30N, MINIMUM.
5. PART NUMBER. THE PART NUMBER CONSISTS OF THE DS NUMBER PLUS THE DASH NUMBER. EXAMPLE: DS51409-1.

## NOTES:

1. DIMENSIONS. UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN MILLIMETERS (mm).
2. TOLERANCES. ANGLES  $\pm 5^\circ$  UNLESS OTHERWISE SPECIFIED.
3. CHAMFER ON FACE SHALL EXTEND SLIGHTLY BELOW THE THREAD ROOT. THE EDGE BETWEEN THE FACE AND CHAMFER MAY BE SLIGHTLY ROUNDED.
4. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BIDS, OR REQUEST FOR PROPOSAL, EXCEPT THAT REFERENCED ADOPTED INDUSTRY DOCUMENTS SHALL GIVE THE DATE OF THE ISSUE ADOPTED.
5. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.

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.

P. A. Other Cust. 99	AR International interest	TITLE SETSCREW, SLOTTED HEADLESS, CONE POINT CARBON STEEL, CADMIUM PLATED, METRIC	MILITARY STANDARD DS51409
PROCUREMENT SPECIFICATION FF-S-210	SUPERSEDES:	PAGE 1	OF 2

METRIC

User activities:  
 ARMY - CE, ER, ME  
 NAVY - MC, OS, SH  
 DLA - IS  
 NSA - NS  
 Revision activities:  
 ARMY - AV, MI  
 DLA - IS  
 NSA - NS

Thread designation			M1.6x0.35	M2x0.4	M2.5x0.45	M3x0.5	M4x0.7	M5x0.8	M6x1	M8x1.25	M10x1.5
C	max...		0.15	0.20	0.25	0.30	0.40	0.50	1.50	2.00	2.50
	min...		0	0	0	0	0	0	1.20	1.60	2.00
A	min...		0.31	0.31	0.46	0.46	0.66	0.86	1.06	1.26	1.66
	max...		0.45	0.45	0.60	0.60	0.80	1.00	1.20	1.51	1.91
B	min...		0.88	1.00	1.10	1.25	1.75	2.00	2.50	3.10	3.75
	max...		1.06	1.20	1.33	1.50	2.05	2.35	2.90	3.60	4.25
L			Dash numbers								
nom	min	max									
2.0	1.7	2.3	-1	-8							
2.5	2.2	2.8	-2	-9	-16						
3.0	2.7	3.3	-3 <u>1/</u>	-10 <u>1/</u>	-17	-24					
4.0	3.7	4.3	-4	-11	-18 <u>1/</u>	-25 <u>1/</u>	-33				
5.0	4.7	5.3	-5	-12	-19	-26	-34 <u>1/</u>	-42			
6.0	5.7	6.3	-6	-13	-20	-27	-35	-43 <u>1/</u>	-51		
8.0	7.7	8.3	-7	-14	-21	-28	-36	-44	-52 <u>1/</u>	-60	
10.0	9.7	10.3		-15	-22	-29	-37	-45	-53	-61 <u>1/</u>	-70
12.0	11.7	12.3			-23	-30	-38	-46	-54	-62	-71 <u>1/</u>
14.0	13.5	14.5				-31	-39	-47	-55	-63	-72
16.0	15.5	16.5				-32	-40	-48	-56	-64	-73
20.0	19.5	20.5					-41	-49	-57	-65	-74
25.0	24.5	25.5						-50	-58	-66	-75
30.0	29.5	30.5							-59	-67	-76
35.0	34.5	35.5								-68	-77
40.0	39.5	40.5								-69	-78
45.0	44.5	45.5									-79
50.0	49.5	50.5									-80

1/ INDICATES CONE POINT ANGLE FOR THESE AND LONGER LENGTHS IS 90°, FOR SHORTER LENGTHS 118°

**METRIC**

APPROVED 26 APRIL 1982 REVISED

P. A. AR Other Cust. 99	International ..interest	TITLE SET SCREW, SLOTTED HEADLESS, CONE POINT, CARBON STEEL, CADMIUM PLATED, METRIC	MILITARY STANDARD DS51409
PROCUREMENT SPECIFICATION FF-S-210	SUPERSEDES:	PAGE 2 OF 2	