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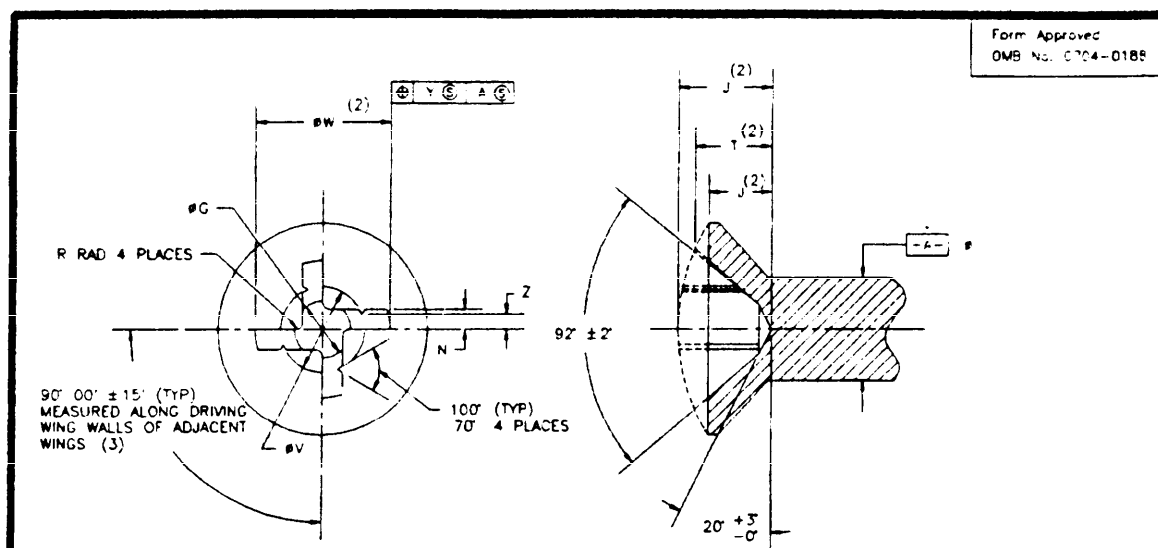


FIGURE 1 RIBBED OFFSET CRUCIFORM RECESS

TABLE 1. RIBBED OFFSET CRUCIFORM RECESS DIMENSIONS

RECESS SIZE	N		G		R		V		Y	Z	
	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN		MAX	MIN
6	.029	.026	.082	.078	0.30	0.16	.106	.094	.012	.0255	.0245
8	.034	.031	.096	.092			.125	.113		.0305	.0295
10	.039	.036	.111	.107			.144	.132		.0355	.0345
1/4	.051	.048	.147	.143	0.40	0.23	.188	.176	.016	.0475	.0465
5/16	.064	.061	.184	.180			.244	.232		.0605	.0595

NOTES

1. DIMENSIONS ARE IN INCHES.
2. THE SPECIFIC PART STANDARD OF DRAWING WHICH SPECIFIES THIS RECESS DRIVE BY REFERENCING THIS DOCUMENT SHALL SPECIFY VALUES FOR DIMENSIONS J, W, T, AND DEPTH OF GAGE PENETRATION, IF THE VALUES SPECIFIED HEREIN ARE NOT COMPATIBLE WITH THE PART CONFIGURATION OR PERFORMANCE REQUIREMENTS.
3. RECESSES SHALL HAVE RIBS ON AT LEAST THE LOWER 75 PERCENT OF THE REMOVAL WALL OF EACH OF THE FOUR WINGS.
4. THE RIBBED RECESSES IN THIS DOCUMENT ARE COVERED UNDER UNITED STATES PATENT 4,084,478, WHICH EXPIRES 18 APRIL 1995. THE GOVERNMENT DOES NOT HAVE A ROYALTY FREE LICENSE. THESE RECESSES ARE ALSO PRODUCED AND MARKETING BY THE LICENSEES OF PHILLIPS SCREW COMPANY UNDER THE DESIGNATION OF ACR® TORQ-SET®.
5. FOR DIMENSIONS OF NON-RIBBED RECESSES, SIZES 0 THROUGH 5/8 INCH, SEE MS33781.
6. CERTAIN PROVISIONS OF THIS DOCUMENT ARE THE SUBJECT OF INTERNATIONAL STANDARDIZATION AGREEMENTS NATO STANAG 3802. WHEN CHANGE NOTICE, REVISION OR CANCELLATION OF THIS DOCUMENT IS PROPOSED WHICH WILL AFFECT OR VIOLATE THE INTERNATIONAL AGREEMENT CONCERNED, THE PREPARING ACTIVITY SHALL TAKE APPROPRIATE RECONCILIATION ACTION THROUGH INTERNATIONAL STANDARDIZATION CHANNELS, INCLUDING DEPARTMENTAL STANDARDIZATION OFFICES, IF REQUIRED.
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(E) ENTIRE SPECIFICATION REVISED

INCH-POUND

PREPARING ACTIVITY: NAVY - AS CUSTODIANS: ARMY - AV NAVY - AIR FORCE - 99 DLA- REVIEW IS, B2 USER PROJECT NUMBER 53GP-0270 DISTRIBUTION STATEMENT	MILITARY SPECIFICATION SHEET TITLE RECESS, OFFSET CRUCIFORM, RIBBED DIMENSIONS OF RECESS, GAGE AND DRIVER FOR	SPECIFICATION SHEET NUMBER MS14191 20 SEPT 1994 REV E SUPERSEDING MS14191D 31 JULY 1987 AMSC - N/A FSC 53GP
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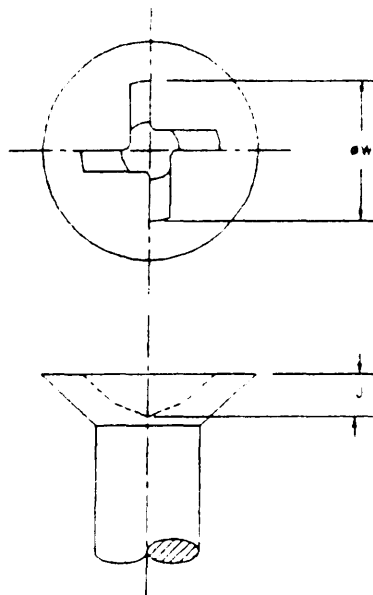


FIGURE 2

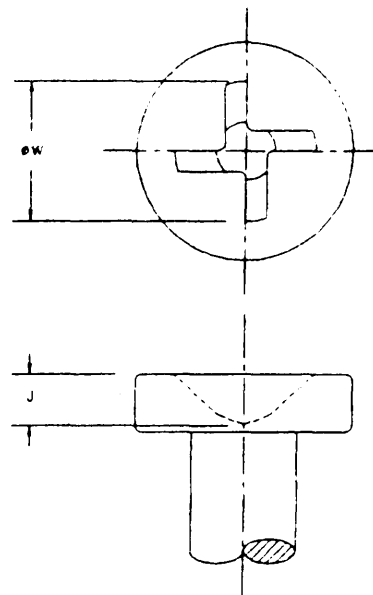


FIGURE 3

TABLE II
100° FLUSH HEAD

SCREW SIZE	RECESS AND DRIVER SIZE	ØW WING	J RECESS DEPTH	GAGE PENET
6	6	.182 .172	.066 .056	.0500 .0395
8	8	.215 .205	.078 .068	.0595 .0480
10	10	.248 .238	.090 .080	.0685 .0560
1/4	1/4	.325 .315	.118 .108	.0890 .0750
5/16	5/16	.357 .347	.122 .112	.0860 .0700

TABLE III
RECESSED HEXAGON HEAD
FLAT PAN HEAD
FLAT FILLISTER HEAD

SCREW SIZE	RECESS AND DRIVER SIZE	ØW WING	J RECESS DEPTH	GAGE PENET
6	6	.193 .183	.072 .062	.0555 .0450
8	8	.228 .218	.085 .075	.0660 .0545
10	10	.263 .253	.098 .088	.0760 .0635
1/4	1/4	.345 .335	.128 .118	.0990 .0850
5/16	5/16	.382 .372	.134 .124	.0985 .0825

NOTES:

1. DIMENSIONS ARE IN INCHES
2. GAGE PENETRATION IS DEFINED AS THE DISTANCE TO WHICH THE GAGE, SHOWN ON SHEET 5, WILL ENTER THE RECESS
3. THIS IS A DESIGN SPECIFICATION NOT TO BE USED AS A PART NUMBER
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CUSTODIANS: ARMY - AV NAVY -
AIR FORCE - 99 DLA -
REVIEW IS, 82
USER:
PROJECT NUMBER: 53GP-0270
DISTRIBUTION STATEMENT:

MILITARY SPECIFICATION SHEET
TITLE
RECESS, OFFSET CRUCIFORM, RIBBED
DIMENSIONS OF
RECESS, GAGE AND DRIVER FOR

SPECIFICATION SHEET NUMBER
MS14191 20 SEPT 1994
REV E
SUPERSEDING
MS14191D 31 JULY 1987
AMSC- N/A FSC 53GP

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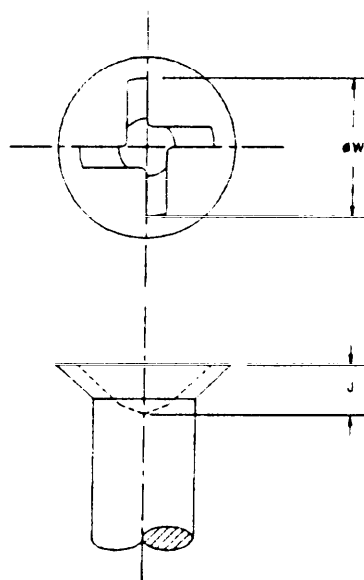


FIGURE 4

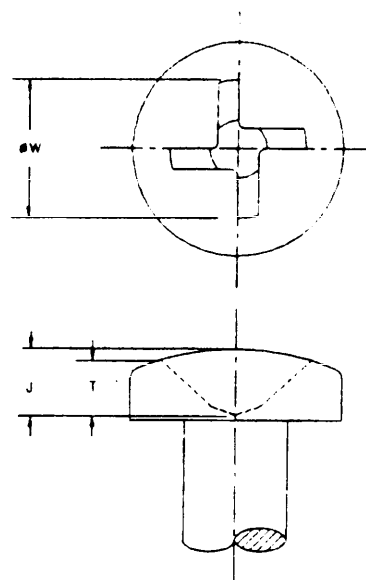


FIGURE 5

TABLE IV (3)
100° REDUCED FLUSH HEAD

SCREW SIZE	RECESS AND DRIVER SIZE	W WING	J RECESS DEPTH	GAGE PENET
8	6	.182 .172	.066 .056	.0500 .0395
10	8	.215 .205	.078 .068	.0595 .0480
1/4	10	.248 .238	.090 .080	.0685 .0560
5/16	1/4	.325 .315	.118 .108	.0890 .0750
3/8	5/16	.357 .347	.122 .112	.0860 .0700

TABLE V (3)

SCREW SIZE	RECESS AND DRIVER SIZE	HEAD				
		PAN AND BRAZIER			PAN	BRAZIER
		W WING	T RECESS DEPTH	GAGE PENET	J RECESS DEPTH	J RECESS DEPTH
6	6	.160 .150	.055 .045	.0390 .0285	.070 .060	.072 .062
8	8	.190 .180	.065 .055	.0470 .0355	.083 .073	.085 .075
10	10	.219 .209	.075 .065	.0540 .0415	.096 .086	.098 .088
1/4	1/4	.286 .276	.098 .088	.0695 .0555	.126 .116	.130 .120
5/16	5/16	.357 .347	.122 .112	.0860 .0700	.153 .143	.164 .154

NOTES

1. DIMENSIONS ARE IN INCHES
2. GAGE PENETRATION IS DEFINED AS THE DISTANCE TO WHICH THE GAGE, SHOWN ON SHEET 5, WILL ENTER THE RECESS
3. SEE MIL-STD-1515 FOR AIRCRAFT USAGE LIMITATIONS.
4. THIS IS A DESIGN SPECIFICATION NOT TO BE USED AS A PART NUMBER
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CUSTODIANS: ARMY- AV NAVY-
AIR FORCE- 99 DLA-
REVIEW: IS, B2
USER:
PROJECT NUMBER: 53GP-0270

MILITARY SPECIFICATION SHEET
TITLE
RECESS, OFFSET CRUCIFORM, RIBBED
DIMENSIONS OF
RECESS, GAGE AND DRIVER FOR

SPECIFICATION SHEET NUMBER
MS14191 20 SEPT 1934
REV E
SUPERSEDING
MS14191D 31 JULY 1987
AMSC- N/A FSC 53GP

DISTRIBUTION STATEMENT

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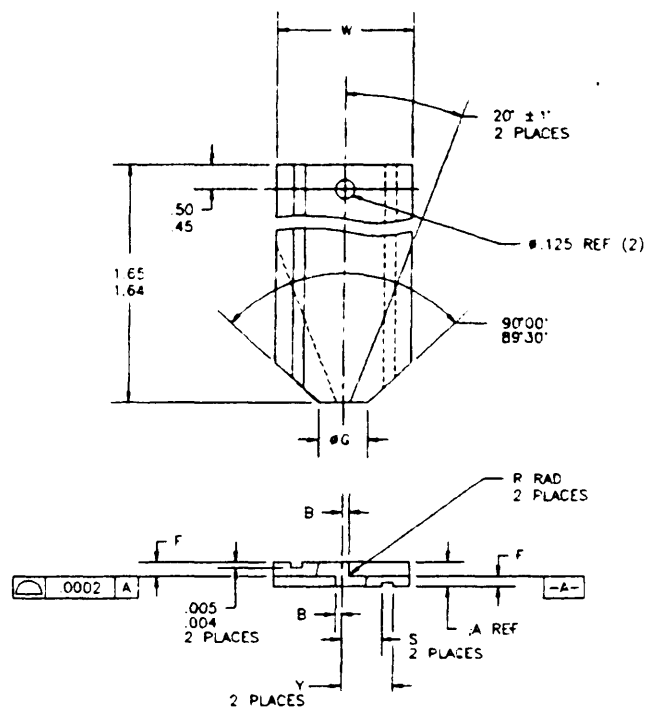


FIGURE 6 GAGE POINT

TABLE VI. GAGE POINT DIMENSIONS

RECESS SIZE	A REF		F + .0001		B MAX	ØG ± .001		R MAX	S -.002	W ± .010		Y + .002
	GO	NOT GO	GO	NOT GO		GO	NOT GO			GO	NOT GO	
6	.0519	.0581	.0259	.0290	.006	.083	.134	.015	.034	.250	.438	.054
8	.0619	.0681	.0309	.0340	.009	.097	.159		.042			.062
10	.0719	.0781	.0359	.0390		.112	.171	.022	.050			.070
1/4	.0959	.1021	.0479	.0510	.014	.148	.225		.069	.438	.625	.089
5/16	.1219	.1281	.0609	.0640		.186	.282	.030	.091			.116

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. A HOLE OF SUITABLE SIZE TO BE DRILLED THROUGH GAGE FOR RING.
3. PERMANENTLY MARK MANUFACTURER'S PART NUMBER AND SERIAL NUMBER.
4. THE REMOVAL WALL OF BOTH WINGS ON GAGE POINTS TO HAVE RIB CLEARANCE RELIEF AS SHOWN.
5. THIS IS A DESIGN SPECIFICATION NOT TO BE USED AS A PART NUMBER.
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CUSTODIANS: ARMY - AV NAVY -	TITLE	MS14191
AIR FORCE - 99 DLA -	RECESS, OFFSET CRUCIFORM, RIBBED	20 SEPT 1994
REVIEW: IS, B2	DIMENSIONS OF	REV E
USER	RECESS, GAGE AND DRIVER FOR	SUPERSEDING
PROJECT NUMBER: 53GP-0270		MS14191D 31 JULY 1987
DISTRIBUTION STATEMENT		AMSC - N/A FSC 53GP
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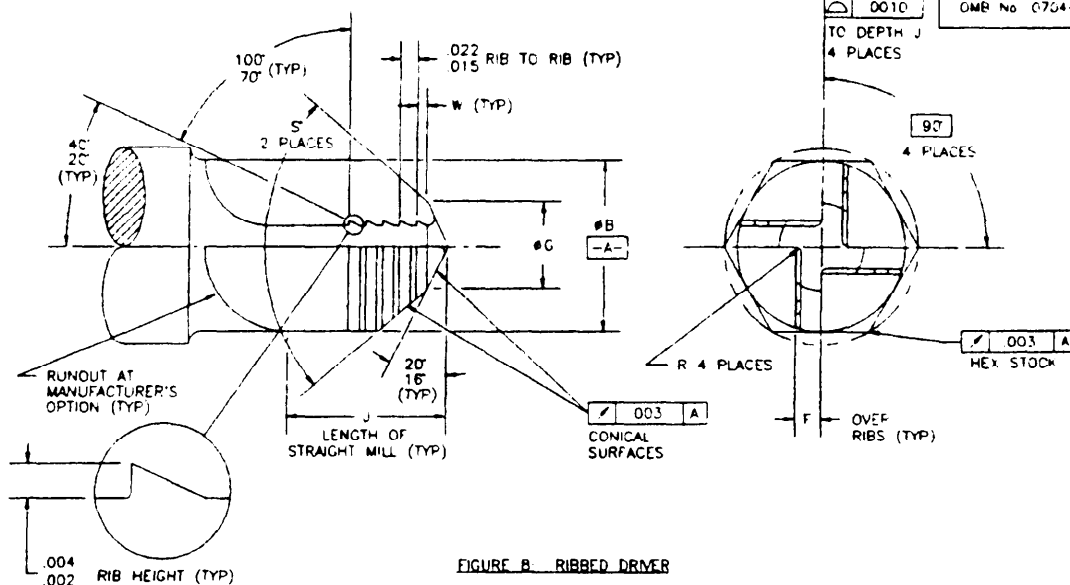


FIGURE B. RIBBED DRIVER

ENLARGED VIEW OF RIB

TABLE VIII RIBBED DRIVER DIMENSIONS											
DRIVER SIZE	#B	F OVER RIBS		#G		J	R		S	W	MIN NO OF RIBS
		MAX	MIN	MAX	MIN	MIN	MAX	MIN		MAX	
E	185 180	0245	0230	084	082	094	016	013	94°30' 92°30'	015	4
B	247 242	0295	0280	098	096						
10		0345	0330	113	111						
1/4	434 429	0465	0435	149	147	125	023	020	91°30' 90°30'	030	5
5/16		0595	0565	187	185	141	028	023		035	

NOTES

1. DIMENSIONS ARE IN INCHES
2. DRIVERS SHALL HAVE RIBS ON THE REMOVAL WALL OF EACH WING.
3. SEE MIL-B-85643 FOR BIT PROCUREMENT.
4. THE RIBBED DRIVERS IN THIS DOCUMENT ARE COVERED UNDER UNITED STATES PATENT 4,187,892, WHICH EXPIRES 12 FEBRUARY 1997. THE GOVERNMENT DOES NOT HAVE A ROYALTY FREE LICENSE. THESE DRIVERS ARE ALSO PRODUCED AND MARKETING BY THE LICENSEES OF PHILLIPS SCREW COMPANY UNDER THE DESIGNATION OF ACR® MULTI-RIBBED TORQ-SET®
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CUSTODIANS: ARMY - AV NAVY -
AIR FORCE - 99 DLA -
REVIEW IS. 82
USER
PROJECT NUMBER 53GP-0270

MILITARY SPECIFICATION SHEET
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RECESS, OFFSET CRUCIFORM, RIBBED
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