

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE ADDRESS SPECIFIED IN THE SOLICITATION NONE

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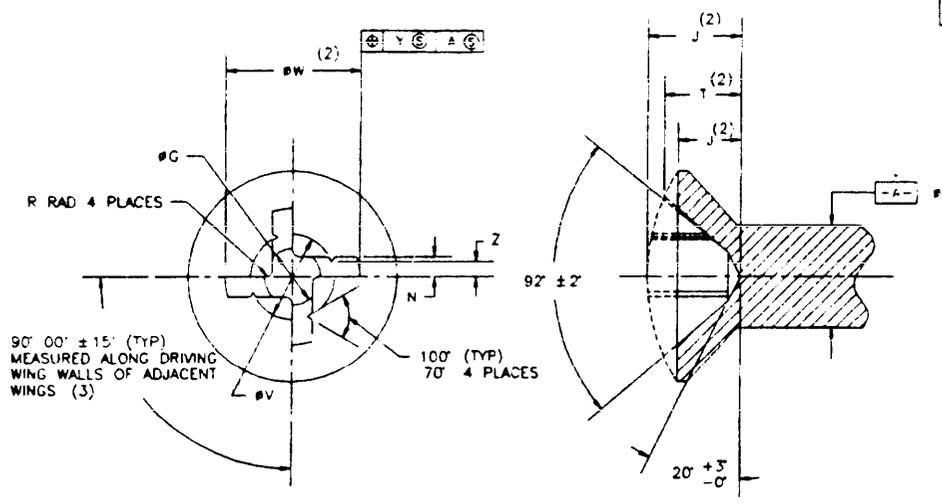


FIGURE 1 RIBBED OFFSET CRUCIFORM RECESS

TABLE 1. RIBBED OFFSET CRUCIFORM RECESS DIMENSIONS											
RECESS SIZE	N		øG		R		øV		Y TOL	Z	
	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN		MAX	MIN
6	.029	.026	.082	.078	.030	.016	.106	.094	.012	.0255	.0245
8	.034	.031	.096	.092			.125	.113		.0305	.0295
10	.039	.036	.111	.107	.040	.023	.144	.132		.0355	.0345
1/4	.051	.048	.147	.143			.188	.176	.016	.0475	.0465
5/16	.064	.061	.184	.180	.052	.031	.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 MARKETED 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.
7. THIS IS A DESIGN SPECIFICATION NOT TO BE USED AS A PART NUMBER.
8. IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS DOCUMENT AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS DOCUMENT SHALL TAKE PRECEDENCE.
9. UNLESS OTHERWISE SPECIFIED, ISSUES OF REFERENCED DOCUMENTS ARE THOSE IN EFFECT AT THE TIME OF SOLICITATION.

(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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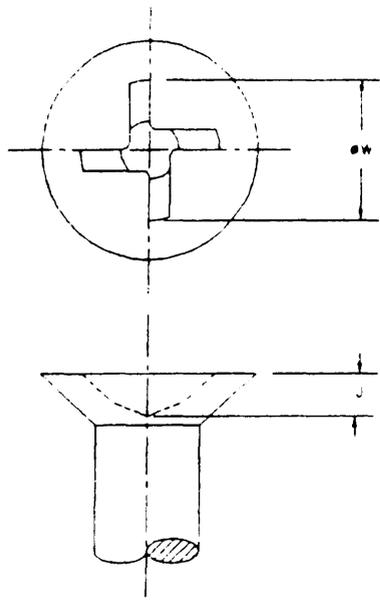


FIGURE 2

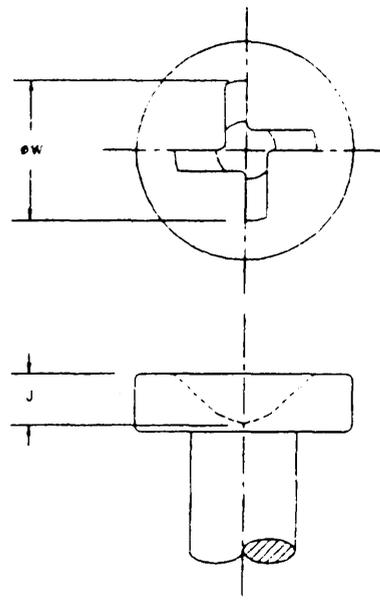


FIGURE 3

TABLE II 100° FLUSH HEAD				
SCREW SIZE	RECESS AND DRIVER SIZE	ØW WING	J RECESS DEPTH	GAGE PENET
6	6	182	066	0500
		172	056	0395
8	8	215	078	.0595
		205	.068	.0480
10	10	248	.090	.0685
		238	080	0560
1/4	1/4	325	118	0890
		315	108	0750
5/16	5/16	357	.122	.0860
		347	112	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	072	0555
		183	.062	.0450
8	8	.228	085	.0660
		.218	.075	0545
10	10	.263	.098	.0760
		253	088	0635
1/4	1/4	345	128	0990
		.335	118	.0850
5/16	5/16	382	.134	.0985
		372	124	.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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PREPARING ACTIVITY: NAVY - AS
 CUSTODIANS: ARMY - AV NAVY -
 AIR FORCE - 99 DLA -
 REVIEW IS, 82
 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 1994
 REV E
 SUPERSEDING
 MS14191D 31 JULY 1987
 AMSC- N/A FSC 53GP

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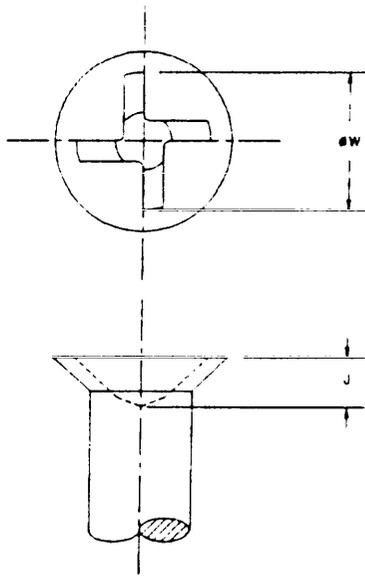


FIGURE 4

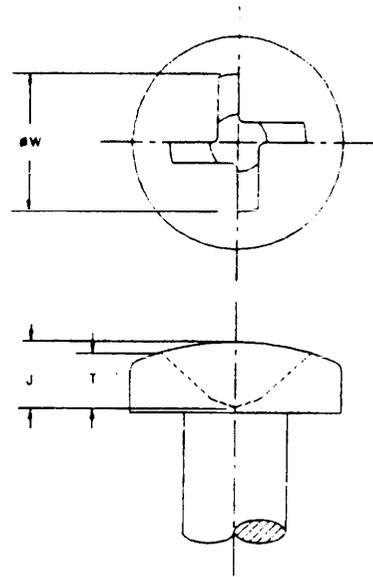


FIGURE 5

TABLE IV (3)				
100° REDUCED FLUSH HEAD				
SCREW SIZE	RECESS AND DRIVER SIZE	ØW 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
		ØW 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

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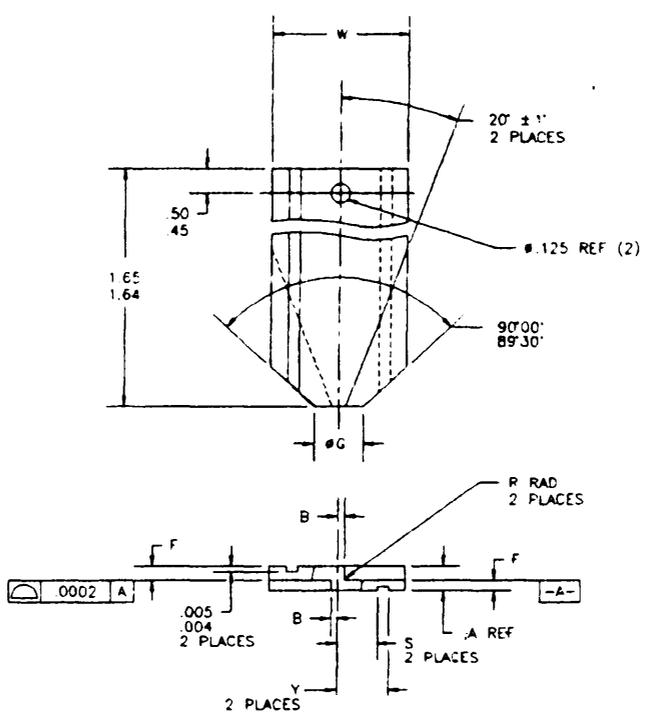


FIGURE 6 GAGE POINT

TABLE VI. GAGE POINT DIMENSIONS

RECESS SIZE	A REF		F + .0001		B MAX	.0G ± .001		R MAX	S -.002	W ± .010		Y + .002
	GO	NOT GO	GO	NOT GO		GO	NOT GO			GC	NOT GO	
6	.0519	.0581	.0259	.0290	.006	.083	.134	.015	.034	.250	.438	.054
8	.0619	.0681	.0309	.0340	.009	.097	.159					.042
10	.0719	.0781	.0359	.0390	.014	.112	.171	.022	.050	.438	.625	.089
1/4	.0959	.1021	.0479	.0510		.148	.225					.069
5/16	.1219	.1281	.0609	.0640		.186	.282	.030	.091			

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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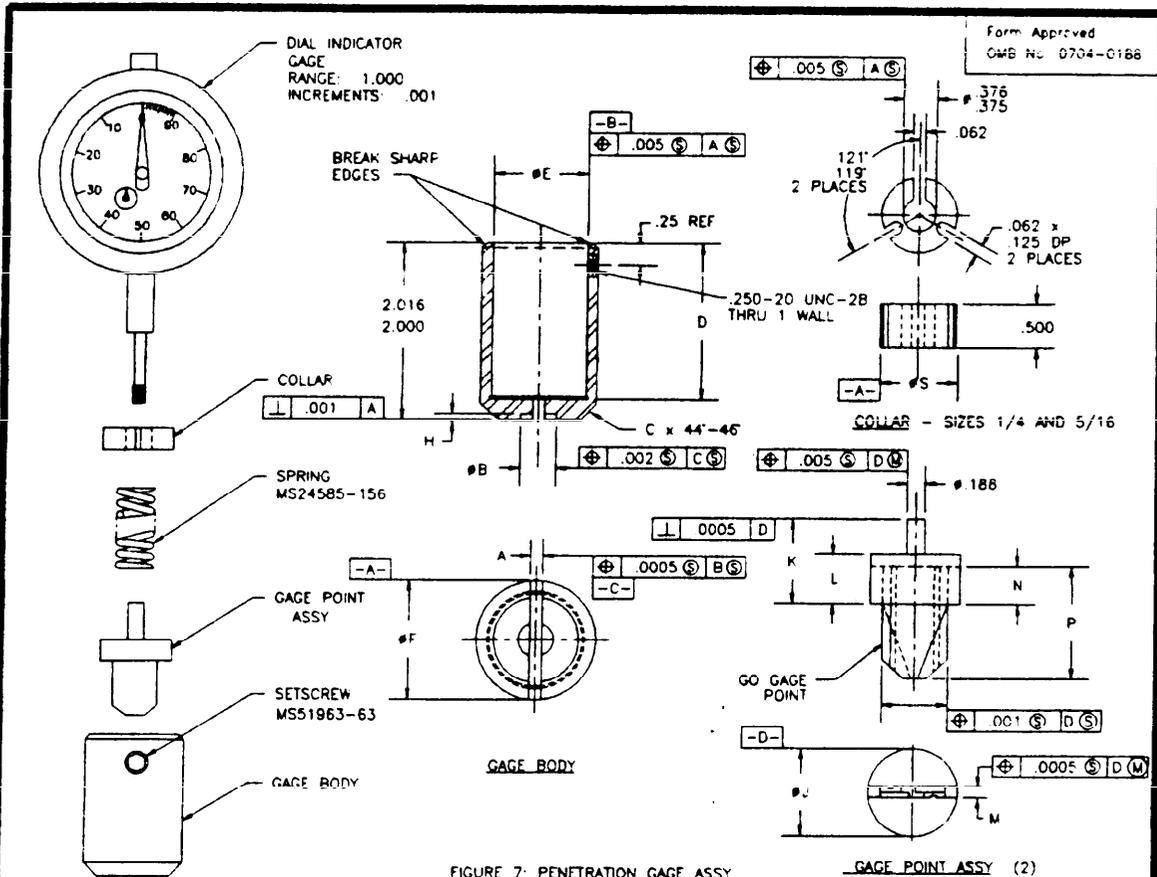


FIGURE 7: PENETRATION GAGE ASSY.

GAGE POINT ASSY (2)

RECESS SIZE	A	#B	C	#D		#E		#F	H	#J		K	L	M	N	P	#S
				MAX	MIN	MAX	MIN			MAX	MIN						
6	+.002 .053	+.002 160	.125	1.880	1.875	.376	.375	.875	.031	.3745	.3740	.844	.500	±.001 .054	.188	.510	N/A
8	.063	190		.074													
10	.073	219		.098													
1/4	.097	286	.250	1.755	1.750	.751	.750	1.250	.062	.7495	.7490	.719	.375	±.001 .098	.312	.800	.7495
5/16	.123	.357		124													

NOTES:

1. DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCE: DECIMALS ± .016.
2. COMPONENT BONDING AT MANUFACTURER'S OPTION.
3. MARKING SHALL INCLUDE MANUFACTURER'S NAME, PART NUMBER, AND RECESS SIZE.
4. THIS IS A DESIGN SPECIFICATION NOT TO BE USED AS A PART NUMBER.
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