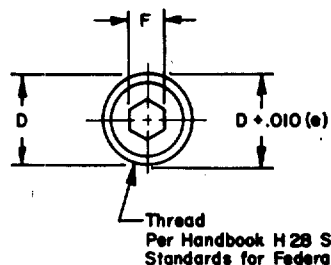
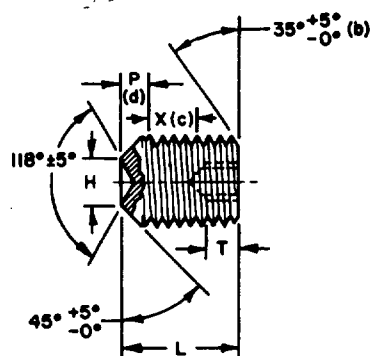


FED. SUP CLASS  
5305

USAR: ARMY - 3L, ML, MU, WC  
USAF - 69  
NAVY - WP

THREAD	D DIA MAX	F		H DIA		SELF-LOCKING DESIGN DATA	T HEX DEPTH
						P(d)	
		MAX	MIN	MAX	MIN	50° MAX	MIN
#4-40NC-3A	.112	.0510	.0500	.061	.051	.062	.040
#6-32NC-3A	.138	.0635	.0625	.074	.064	.076	.050
#8-32NC-3A	.164	.0791	.0781	.087	.076	.085	.062
#10-32NF-3A	.190	.0947	.0937	.102	.088	.093	.075
1/4-28UNF-3A	.250	.1270	.1250	.132	.118	.116	.100
5/16-24UNF-3A	.3125	.1582	.1562	.172	.156	.136	.125
3/8-24UNF-3A	.375	.1895	.1875	.212	.194	.151	.150
1/2-20UNF-3A	.500	.2520	.2500	.291	.270	.188	.200

L LENGTH		DASH NUMBERS (a)							
		#4-40	#6-32	#8-32	#10-32	1/4-28	5/16-24	3/8-24	1/2-20
TOLERANCE									
1/8	± .010	1	2	3	4				
3/16		5	6	7	8	9			
1/4		10	11	12	13	14	15		
5/16		16	17	18	19	20	21		
3/8		22	23	24	25	26	27	28	29
7/16	± .015	30	31	32	33	34	35	36	37
1/2		38	39	40	41	42	43	44	45
9/16		46	47	48	49	50	51	52	53
5/8			54	55	56	57	58	59	60
3/4			61	62	63	64	65	66	67
7/8	± .020			67	68	69	70	71	72
1						73	74	75	76
1-1/4						77	78	79	80
1-1/2							81	82	83
1-3/4							84	85	86
2	± .031	For lengths above heavy line see note (g)							87
2-1/2									88
3									89

This Standard takes precedence over documents referenced herein.  
Reference documents shall be of the issue in effect on the date of invitation for bid.

P.A. Navy - WP	TITLE	MILITARY STANDARD
Other Cust	SETSCREW, HEXAGON SOCKET, CUP POINT, 250°F SELF LOCKING ELEMENT, ALLOY STEEL, CADMIUM PLATED	MS18063
Army - WC USAF - 69	SUPERSEDES:	SHEET 1 OF 2
PROCUREMENT SPECIFICATION 77-S-200 & MIL-F-18240		

DD FORM 672-1

coordination.

REVISED 22 Dec 64  
APPROVED 4 Jun 63

This military standard is approved by the Department of Defense and is mandatory on all activities. Selection for all engineering and design applications and for repetitive use shall be made from this document.

FED. SUP CLASS  
5303

User: Army - OL

Reviewers: Army - EL, MI, MO, MU, WC  
USAF - 69  
Navy - WP

- (a) Unassigned dash numbers shall not be used
- (b) Socket end of screw shall be flat and chamfered. The chamfer shall extend to the minor diameter of the thread and the edge between flat and chamfer shall be slightly rounded.
- (c) Location of effective locking area "X" shall be in accordance with MS 15981 except as noted herein.
- (d) <sup>P</sup>Max. = Maximum point plus minimum of 1 thread pitch. For ease in starting, locking element shall not be effective within this area.
- (e) Maximum major thread diameter plus .010 = Maximum ring gage diameter that locking region of part must pass through freely or with finger pressure.
- (f) See MS51963 and MS51964 For Set Screws without self-locking feature.
- (g) As MIL-F-18240 doesn't establish torque requirements for items above heavy line, only a positive indication of torque is required.

**MATERIAL:** Steel, alloy (See Procurement Specification). Hardened by quenching in oil from the hardening temperature and tempered to a Rockwell Hardness of C33-40 or equivalent.

**LOCKING ELEMENT:** In accordance with Specification MIL-F-18240.

**DESIGN AND USAGE LIMITATIONS:** See MS 15981.

**FINISH:** Steel: Cadmium plate Specification QQ-P-416, Type II, Class 3. Except that paragraph 4.4.5 is not applicable.

**EXAMPLE OF PART NUMBER:** MS-18063 -57 = 1/4-28UNF-3A x 3/4 long cadmium plated steel cup point self-locking set screw.

APPROVED 14 Jun 63  
REVISED 4 22 Dec 64

P.A. Navy - WP Other Cost Army - WC USAF - 69	TITLE SETSCREW, HEXAGON SOCKET, CUP POINT, 250 P SELF LOCKING ELEMENT, ALLOY STEEL, CADMIUM PLATED	MILITARY STANDARD <b>MS18063</b>
PROCUREMENT SPECIFICATION FF-S-200 & MIL-F-18240	SUPERSEDES:	SHEET 2 OF 2

DD FORM 672-1

coordination