

User: Army - GL

Reviewers: Army - EL, MI, MO, NI, WC
USAF - 69

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

FED. SUP CLASS 325									
				Thread Per Handbook H 28 Screw Thread Standards for Federal Services 1957					
THREAD	D DIA MAX	F		Y		SELF-LOCKING DESIGN DATA		T HEX DEPTH MIN	
				118° ± 2° FOR LENGTHS AND UNDER	90° ± 2° FOR LENGTHS AND OVER	P(d) MAX			
		MAX	MIN	116°	88°				
#4-40NC-3A #6-32NC-3A	.112 .138	.0510 .0635	.0500 .0625	1/8 1/8	5/32 3/16	.060 .075	.083 .104	.040 .050	
#8-32NC-3A #10-32NF-3A 1/4-28UNF-3A	.164 .190 .250	.0791 .0947 .1270	.0781 .0937 .1250	3/16 3/16 1/4	1/4 1/4 5/16	.084 .092 .114	.117 .131 .166	.082 .075 .100	
5/16-24UNF-3A 3/8-24UNF-3A 1/2-20UNF-3A	.3125 .375 .500	.1582 .1895 .2520	.1562 .1875 .2500	5/16 3/8 1/2	3/8 7/16 9/16	.137 .159 .206	.204 .236 .309	.125 .150 .200	
L LENGTH TOLERANCE		DASH NUMBERS (a)							
		#4-40	#6-32	#8-32	#10-32	1/4-28	5/16-24	3/8-24	1/2-20
1/8 3/16	±.010	1 5	2 6	3 7	4 8	9			
1/4 5/16		10 16	11 17	12 18	13 19	14 20	15 21		
3/8		22 29	23 30	24 31	25 32	26 33	27 34	28 35	29 36
7/16 1/2		41 33	42 34	43 35	44 36	45 37	46 38	47 39	48 40
9/16		49 41	50 42	51 43	52 44	53 45	54 46	55 47	56 48
5/8 3/4 7/8	±.015	61 46	62 47	63 48	64 49	65 50	66 51	67 52	68 53
1 1-1/4 1-1/2		69 54	70 55	71 56	72 57	73 58	74 59	75 60	76 61
1-3/4		77 62	78 63	79 64	80 65	81 66	82 67	83 68	84 69
2		85 70	86 71	87 72	88 73	89 74	90 75	91 76	92 77
2-1/2 3		93 78	94 79	95 80	96 81	97 82	98 83	99 84	100 85
		For lengths above heavy line see note (g)							
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 Other Cust Army - WC USAF - 69		TITLE SETScrew, HEXAGON SOCKET, CONE POINT, 250° SELF LOCKING ELEMENT, CORROSION RESISTING STEEL, PASSIVATED				MILITARY STANDARD MS18068			
PROCUREMENT SPECIFICATION FF-S-200 & MM-F-18240		SUPERSEDES:				SHEET 1 OF 2			

APPROVED 4 Jun 63
REVISED 22 Dec 64