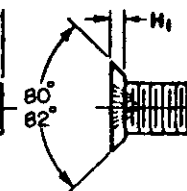
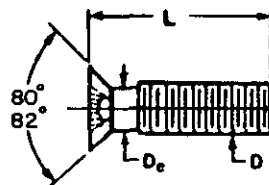
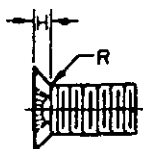


FED. SUP CLASS

5305



FULL HEAD

UNDERCUT HEAD

THREAD		D	2 (.086) - 56UNC-2A	4 (.112) - 40UNC-2A	6 (.138) - 32UNC-2A	8 (.164) - 32UNC-2A			
UNTHREADED DIA		D MAX	.0860	.1120	.1380	.1640			
		D MIN	.0717	.0925	.1141	.1399			
HEAD DIA		A MAX SHARP	.172	.225	.279	.332			
		A MIN SHARP	.156	.207	.257	.308			
		ABS MIN	.150	.200	.249	.300			
RADIUS		R MAX	.035	.050	.062	.082			
FULL HEAD:	HEAD HEIGHT	H MAX	.051	.067	.083	.100			
		MIN	.040	.055	.069	.084			
UNDERCUT HEAD:	HEAD HEIGHT	H MAX	.036	.047	.058	.070			
		H MIN	.028	.039	.048	.059			
DRIVER SIZE			1	1	2	2			
LENGTH			L TOLERANCE	DASH NO. FIN	DASH NO. FIN	DASH NO. FIN			
THREADS SHALL EXTEND TO WITHIN 2 THREADS OF THE BEARING SURFACE OF THE HEAD, OR CLOSER IF PRACTICABLE.	1/8		1		10		21		36
	3/16		2		11		22		37
	1/4		3		12		23		38
	5/16		4		13		24		39
	3/8	+0	5		14		25		40
	7/16	-1/32	6		15		26		41
	1/2		7		16		27		42
	5/8		8		17		28		43
	3/4		9		18		29		44
	7/8				19		30		45
	1				20		31		46
	1-1/4						32		47
	1-1/2	+0					33		48
	1-3/4	-1/16					34		49
	2						35		50

THREADS SHALL EXTEND TO WITHIN 2 THREADS OF THE BEARING SURFACE OF THE HEAD, OR CLOSER IF PRACTICABLE.

MATERIAL: Carbon Steel, FED-STD-66, 55,000 PSI Minimum Ultimate Tensile Strength.

FINISH: Cadmium Plated, Specification QQ-P-416, Type II, Class 3.

THREADS: The Threads shall be in accordance with Screw Threads Standards for Federal Services, Handbook H-28.

EXAMPLE OF PART NUMBER: MS24583-1 = Screw, Carbon Steel, Cadmium plated, 2-56UNC-2A, 1/8 long.
MS24583-51 = Screw, Carbon Steel, Cadmium plated, 10-32UNF-2A, 1/4 long.

- NOTES:** (1) Recess shall conform with Standard MS9006 and Type III, Design I of Procurement Specification. In case of conflict with respect to recess dimensions between Specification FF-S-92 and Standard MS9006, Standard MS9006 shall govern.
(2) Referenced documents shall be of the issue in effect on date of invitations for bid.
(3) This standard takes precedence over documents referenced herein.
(4) Sizes above dotted line have undercut head.
(5) All dimensions are in inches.

INTERCHANGEABILITY RELATIONSHIP - MS24583 screws can universally replace MS35192 and MS35193 screws of like thread and length; but the MS35192 and MS35193 screws cannot replace MS24583 screws.

CANCELLED AFTER 21 Dec 62, USE MS35190 AND MS35191.

- INTERCHANGEABILITY RELATIONSHIP -** MS35190 and MS35191 parts can replace the cancelled MS24583 parts of the same thread size and screw length. The cancelled MS24583 parts cannot always replace the MS35190 and MS35191 parts and should be used until existing stock is depleted. Use only the superseding MS35190 and MS35191 parts of the same thread size and screw length for design and replacement.

P.A. USAF

Other Cust

TITLE:

SCREW, MACHINE-FLAT COUNTERSUNK HEAD, CROSS-RECESSED, CARBON STEEL, CADMIUM PLATED

MILITARY STANDARD

MS24583(USAF)

PROCUREMENT SPECIFICATION
FF-S-92

SUPERSEDES:

SHEET 1 OF 2

THIS LIMITED COORDINATION MILITARY STANDARD DRAWING HAS BEEN PREPARED BY THE AIR FORCE BASED UPON CURRENTLY AVAILABLE TECHNICAL INFORMATION, BUT IT HAS NOT BEEN APPROVED FOR PROMULGATION AS A REVISION OF MILITARY STANDARD SHEETS. IT IS SUBJECT TO MODIFICATION, HOWEVER, PENDING ITS PROMULGATION AS A COORDINATED MILITARY STANDARD DRAWING. IT MAY BE USED IN PROCUREMENT.

NOTICE—When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility, nor any obligation whatsoever; and the fact that the Government may have furnished, or in any way supplied the said drawings, specifications, or other data is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

NOTICE.—When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility, nor any obligation whatsoever, and the fact that the Government may have furnished, limited, or in any way supplied the said drawings, specifications, or other data is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

THIS LIMITED COORDINATED MILITARY STANDARD DRAWING HAS BEEN PREPARED BY THE AIR FORCE BASED UPON CURRENTLY AVAILABLE TECHNICAL INFORMATION, BUT IT HAS NOT BEEN APPROVED FOR PROMULGATION AS A REVISION OF MILITARY STANDARD SHEETS. IT IS SUBJECT TO MODIFICATION, HOWEVER, PENDING ITS PROMULGATION AS A COORDINATED MILITARY STANDARD DRAWING. IT MAY BE USED IN PROCUREMENT.

FED. SUP CLASS

5305

THREAD		D	10 (.190) - 32UNF-2A	1/4- 28UNF-2A	5/16- 24UNF-2A	3/8- 24UNF-2A			
UNTHREADED DIA	D	MAX	.1900	.2500	.3125	.3750			
		MIN	.1850	.2225	.2800	.3430			
HEAD DIA	A	MAX SHARP	.385	.507	.635	.762			
		MIN SHARP	.359	.477	.600	.722			
		ABS MIN	.348	.462	.581	.700			
FULL HEAD:	RADIUS	R MAX	.062	.071	.083	.083			
	HEAD HEIGHT	H MAX	.116	.153	.191	.230			
		MIN	.098	.131	.165	.200			
UNDERCUT HEAD:	HEAD HEIGHT	H MAX	.081	.107	.134	.161			
		MIN	.069	.092	.116	.140			
DRIVER SIZE			2	3	4	4			
LENGTH		L	TOLERANCE	DASH NO.	FIN	DASH NO.	FIN	DASH NO.	FIN
THREADS SHALL EXTEND TO WITHIN 2 THREADS OF THE BEARING SURFACE OF THE HEAD, OR CLOSER IF PRACTICABLE.	1/4	+0 -1/32	51						
	5/16		52		66				
	3/8		53		67		80		
	7/16		54		68		81		
	1/2		55		69		82		93
	5/8		56		70		83		94
	3/4	+0 -1/16	57		71		84		95
	7/8		58		72		85		96
	1		59		73		86		97
	1-1/4		60		74		87		98
1-1/2	+0 -3/32	61		75		88		99	
1-3/4		62		76		89		100	
2		63		77		90		101	
2-1/4		64		78		91		102	
2-1/2		65		79		92		103	
2-3/4								104	
1-3/4								105	

P.A. USAF

Other Cust

TITLE:

SCREW, MACHINE-FLAT COUNTERSUNK HEAD, CROSS-
PROCESSED, CARBON STEEL, CADMIUM PLATED

MILITARY STANDARD

MS24583(USAF)

PROCUREMENT SPECIFICATION

FF-S-92

SUPERSEDES:

SHEET 2 OF 2

DD FORM 672-1 (Limited coordination)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

GPO 826641

APPROVED 5 Feb 60 REVISED 21 Dec 62