


 FED. SUP CLASS
5305

TABLE 1

NOMINAL SIZE		2(.086)	4(.112)	6(.138)	8(.164)	10(.190)	1/4(.250)
THREADS PER INCH		56	40	32	32	24	20
A HEAD DIA	MAX SHARP	.172	.225	.279	.332	.385	.507
	MIN FLAT	.147	.195	.244	.292	.340	.452
H HEAD HEIGHT - REF		.051	.067	.083	.100	.116	.153
H1 UNDERCUT HEAD HEIGHT	MAX	.036	.047	.059	.070	.081	.107
	MIN	.028	.038	.048	.058	.068	.092
P POINT DIA	MAX	.067	.086	.106	.132	.147	.198
	MIN	.061	.077	.093	.121	.133	.181
L LENGTH	TOL	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.
.250		1	10	20	30		
.312		2	11	21	31	45	
.375	+0	3	12	22	32	46	
.438	-.031		13	23			
.500		5	14	24	34	48	62
.625			15	25	35	49	63
.750			16	26	36	50	64
.875				27	37	51	65
1.000	+0			28	38	52	66
1.250	-.047				39	53	67
1.500					40	54	68
1.750	+0				41	55	69
2.000	-.062					56	70

NOTES:

1. **MATERIAL:** Carbon steel shall be AISI 1016, 1018, 1019, 1021, 1022 or 1024 (hardened) in accordance with Fed. Std. 66.
2. **PROTECTIVE COATING:** Carbon steel shall be cadmium plated in accordance with QQ-P-416, Type II, Class 3.
3. **THREADS:** The threads shall be in accordance with procurement specification.
4. **RECESS:** The recess shall be in accordance with MS9006.
5. **SHORT LENGTHS:** Lengths above dotted lines shall have undercut heads.
6. **HOLE SIZES:** For approximate hole sizes see MS24634.
7. **DIMENSIONS:** All dimensions are in inches, unless otherwise specified.
8. **PART NUMBER:** The MS part number consists of the MS number, plus the dash number.
Example: MS24627-1.
9. Referenced documents shall be of the issue in effect on date of invitations for bid.
10. For design feature purposes, this standard takes precedence over procurement documents referenced herein.

P.A. 6C Other Code 82	TITLE SCREW, TAPPING-THREAD CUTTING, TYPES D, F, G OR T, FLAT 82° COUNTERSUNK HEAD, CROSS-RECESSED, CARBON STEEL	MILITARY STANDARD MS 24627
PROCUREMENT SPECIFICATION 77-3-107	SUPERSEDES, MS24623, MS24643, and MS24647; BCL12 in part, BCL14 in part and BCL11.1.	SHEET 1 OF 2

FED. SUP CLASS
5305

C

INTERCHANGEABILITY TABLE

The screws covered by the following dash numbers of MS24643 and MS24647 are cancelled after 25 February 1963. The screws covered by the following dash numbers of MS24623 are cancelled after 15 May 1975. The cancelled screws cannot always replace the superseding screws and should be used until existing stocks are depleted. Use only the superseding screws for design and engineering. Replacement shall be in accordance with this table.

DASH NUMBERS			
CANCELLED			SUPERSEDING
MS24623	MS24643	MS24647	MS24627
1	--	--	1
2	--	--	2
3	--	--	3
9	1	1	10
10	2	2	11
11	3	3	12
12	4	4	14
--	--	5	15
--	--	6	16
20	9	9	20
21	10	10	21
22	11	11	22
23	12	12	24
25	13	13	25
26	14	14	26
27	--	15	27
28	--	16	28
29	--	--	--
30	--	--	--
33	20	21	32
34	21	22	34
35	22	23	35
36	23	24	36
37	24	25	37
38	25	26	38
39	26	--	39
40	--	--	40
41	--	--	41
42	--	--	--
43	--	--	--
44	--	--	--
--	--	30	46
47	30	31	48
48	31	32	49
49	32	33	50
50	33	34	51
51	34	35	52
52	35	36	53
53	36	37	54
54	37	--	55
55	38	--	56
56	--	--	--
57	--	--	--
--	--	40	62
60	--	41	63
61	42	42	64
62	43	43	65
63	44	44	66
64	45	45	67
65	46	46	68
66	47	--	69
67	48	--	70
68	--	--	--
69	--	--	--

** NO REPLACEMENT

P.A. WC Other Cast 82	TITLE SCREW, TAPPING-THREAD CUTTING, TYPES D, F, G OR T, FLAT 82° COUNTERSUNK HEAD, CROSS-RECESSED, CARBON STEEL	MILITARY STANDARD MS24627
PROCUREMENT SPECIFICATION FF-S-107	SUPERSEDES MS24623, MS24643, and MS24647; BCX12 in part, BCX14 in part and BQX1-1.	SHEET 2 OF

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

☆ U. S. GOVERNMENT PRINTING OFFICE: 1975 - 603-119/4863

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

REVIEWER: EAJSMI NSPA WV
USER: ATELGL NC ME NJU OSYD

APPROVED 5 OCT 1959 REVISED A 25 FEB 1963 B 27 AUG 1969 C FOR CHANGES SEE SHEET 1