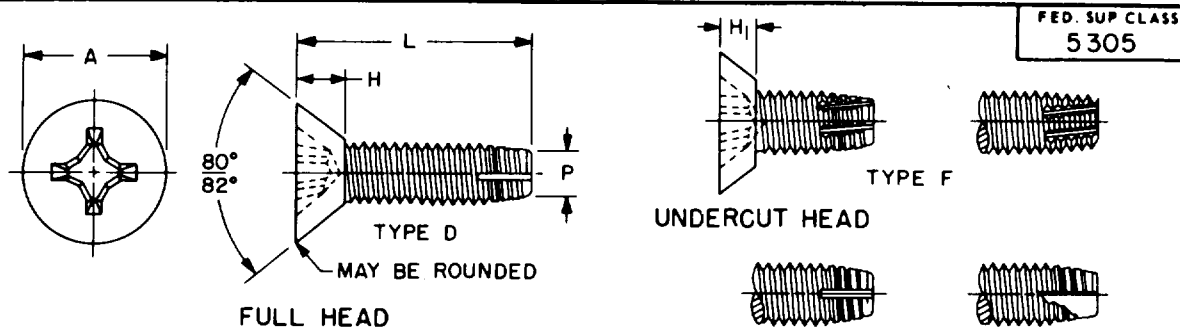


REVIEWER: ELIS, MI, NS, PA, WV
USER: AT, EL, GL, MC, ME, MU, OS, YD



FED. SUP CLASS
5305

TABLE I

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
H ₁ 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	.095	.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:** Corrosion-resisting steel shall be AISI 410 (hardened) in accordance with Fed. Std. No. 66.
2. **PROTECTIVE COATING:** Corrosion-resisting steel shall be passivated in accordance with QQ-P-35.
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: MS24628-1.
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.

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.

P.A. WC Other Cust 82	TITLE SCREW, TAPPING-THREAD CUTTING, TYPES D, F, G OR T, FLAT 82° COUNTERSUNK HEAD, CROSS-RECESSED, CORROSION-RESISTING STEEL	MILITARY STANDARD MS24628
PROCUREMENT SPECIFICATION FF-S-107	SUPERSEDES: MS24624, MS24644, MS24648, BCXX2 in part and BCXX4 in part.	SHEET 1 OF 2

FED. SUP CLASS
5305

(C)

INTERCHANGEABILITY TABLE

The screws covered by the following dash numbers of MS24644 and MS24648 are cancelled after 25 February 1963. The screws covered by the following dash numbers of MS24624 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 should be in accordance with this table.

DASH NUMBERS			
CANCELLED			SUPERSEDING
MS24624	MS24644	MS24648	MS24628
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 Cust 82	TITLE SCREW, TAPPING- THREAD CUTTING, TYPES D, F, G OR T, FLAT 82° COUNTERSUNK HEAD, CROSS-RECESSED, CORROSION-RESISTING STEEL	MILITARY STANDARD MS24628
PROCUREMENT SPECIFICATION FF-S-107	SUPERSEDES: MS24624, MS24644, MS24648, BCXX2 in part and BCXX4 in part.	SHEET 2 OF

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

☆ U. S. GOVERNMENT PRINTING OFFICE: 1975 - 603-119 4872

REVIEWER:EAJS,MI,NS,PA,WV
USER:AT,EL,GL,MC,ME,MU,OS,YD

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.

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