

FED. SUP CLASS
5305

SHEET METAL*

SCREW SIZE	METAL THICKNESS	STEEL, CRES, MONEL, BRASS			ALUMINUM ALLOY		
		PIERCED OR EXTRUDED HOLE	DRILLED OR CLEAN-PUNCHED HOLE		PIERCED OR EXTRUDED HOLE	DRILLED OR CLEAN-PUNCHED HOLE	
			HOLE DIA	DRILL SIZE		HOLE DIA	DRILL SIZE
2	.015	----	.064	52	----	----	--
	.018	----	.064	52	----	----	--
	.024	----	.067	51	----	.064	52
	.030	----	.070	50	----	.064	52
	.036	----	.073	49	----	.064	52
	.048	----	.073	49	----	.067	51
	.060	----	.076	48	----	.070	50
4	.015	.086	.086	44	----	----	--
	.018	.086	.086	44	----	----	--
	.024	.086	.089	43	.086	----	--
	.030	.086	.094	42	.086	.086	44
	.036	.086	.094	42	.086	.086	44
	.048	----	.096	41	.086	.086	44
	.060	----	.100	39	----	.080	43
	.075	----	.102	38	----	.080	43
	.105	----	----	--	----	.094	42
6	.015	.111	.104	37	----	----	--
	.018	.111	.104	37	----	----	--
	.024	.111	.106	36	.111	----	--
	.030	.111	.106	36	.111	.104	37
	.036	.111	.110	35	.111	.104	37
	.048	----	.111	34	.111	.104	37
	.060	----	.116	32	----	.106	36
	.075	----	.120	31	----	.110	35
	.105	----	.128	30	----	.111	34
	.128 to .250	----	----	--	----	.120	31
8	.018	.136	----	--	----	----	--
	.024	.136	.125	1/8	.136	----	--
	.030	.136	.125	1/8	.136	.116	32
	.036	.136	.125	1/8	.136	.120	31
	.048	.136	.128	30	.136	.128	30
	.060	----	.136	29	----	.136	29
	.075	----	.140	28	----	.140	28
	.105	----	.150	25	----	.147	26
	.125	----	.150	25	----	.147	26
	.135	----	.152	24	----	.149	25
	.162 to .375	----	----	--	----	.152	24
10	.018	.157	----	--	----	----	--
	.024	.157	.144	27	.157	----	--
	.030	.157	.144	27	.157	----	--
	.036	.157	.147	26	.157	.144	27
	.048	.157	.152	24	.157	.144	27
	.060	----	.152	24	----	.144	27
	.075	----	.157	22	----	.147	26
	.105	----	.161	20	----	.147	26
	.125	----	.170	18	----	.154	23
	.135	----	.170	18	----	.154	23
	.164	----	.173	17	----	.159	21
	.200 to .375	----	----	--	----	.166	19
1/4	.030	.209	.194	10	----	----	--
	.036	.209	.194	10	----	----	--
	.048	.209	.194	10	----	----	--
	.060	----	.199	8	----	.199	8
	.075	----	.204	6	----	.201	7
	.105	----	.209	4	----	.204	6
	.125	----	.228	1	----	.209	4
	.135	----	.228	1	----	.209	4
	.164	----	.234	15/64	----	.213	3
	.187	----	.234	15/64	----	.213	3
	.194	----	.234	15/64	----	.221	2
	.200 to .375	----	----	--	----	.228	1

(B) * Note: Hole sizes for metal thicknesses .105 and above apply to Types B and BP only.

(B) THIS IS A DESIGN STANDARD AND SHALL NOT BE USED AS A PART NUMBER.

(B) For changes see sheets 1 and 2.

P.A. WC Other Cust R2	TITLE SCREW, TAPPING, THREAD FORMING - TYPES AB, B AND BP, APPROXIMATE HOLE SIZES FOR	MILITARY STANDARD MS24632
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 1 OF 2

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

This military standard is mandatory 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: AT, AV, EL, IS, MI, MU, NSA, SS
(USER: AS, CL, ME, OS, SH)

APPROVED 5 OCT 59 REVISED (A) 7 JUN 61 (B) 8 NOV 68

REVISIONS: A, V, EL, IS, MI, ML, NS, SS
 DELETIONS: U, ME, OS, SH

FED SUP CLASS 5305											
PLYWOOD (RESIN IMPREGNATED)						ASBESTOS COMPOSITION					
COMPREG, PREGWOOD, ETC.						TRANSITE, EBONY ASBESTOS, ETC.					
SCREW SIZE	HOLE DIA	DRILL SIZE	MATERIAL THICKNESS	PENETRATION IN BLIND HOLES		SCREW SIZE	HOLE DIA	DRILL SIZE	MATERIAL THICKNESS	PENETRATION IN BLIND HOLES	
			MIN	MIN	MAX				MIN	MIN	MAX
2	.073	49	.125	.188	.500	2	.076	48	.125	.188	.500
4	.100	39	.188	.250	.625	4	.101	38	.188	.250	.625
6	.125	1/8	.188	.250	.625	6	.120	31	.188	.250	.625
8	.144	27	.188	.250	.750	8	.147	26	.312	.375	.750
10	.173	17	.250	.312	1.000	10	.166	19	.312	.375	1.000
1/4	.228	1	.312	.375	1.000	1/4	.228	1	.438	.500	1.000

** CAST METALS					** PLASTICS								
ALUMINUM, MAGNESIUM, ZINC, BRASS, BRONZE				SCREW SIZE	HOLE DIA	DRILL SIZE	PHENOL FORMALDEHYDE		CELLULOSE ACETATE, CELLULOSE NITRATE, ACRYLIC RESIN, STYRENE RESIN				
SCREW SIZE	HOLE DIA	DRILL SIZE	PENETRATION IN BLIND HOLES				SCREW SIZE	HOLE DIA	DRILL SIZE	PENETRATION IN BLIND HOLES	HOLE DIA	DRILL SIZE	PENETRATION IN BLIND HOLES
			MIN							MIN			MIN
2	.078	47	.125	2	.078	47	.188	.078	47	.188			
4	.104	37	.188	4	.100	39	.250	.094	42	.250			
6	.128	30	.250	6	.128	30	.250	.120	31	.250			
8	.152	24	.250	8	.150	25	.312	.144	27	.312			
10	.177	16	.250	10	.177	16	.312	.170	18	.312			
1/4	.234	15/64	.312	1/4	.234	15/64	.375	.221	2	.375			

NOTES:

1. Because conditions differ widely, it may be necessary to vary the hole size to suit a particular application.
- (B) 2. All dimensions are in inches. Hole diameters are standard drill sizes rounded to the nearest .001 inch.
3. For aeronautical applications, more definitive hole dimensions are contained in AND10325.
4. For design feature purposes, this standard takes precedence over procurement documents referenced herein.
5. Referenced documents shall be of the issue in effect on date of invitations for bid.
- (B) ** 6. These tables apply to types B and BP only.

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APPROVED 5 OCT 59 REVISED (A) 7 JUN 61 (B) FOR CHANGES SEE SHEETS 1 AND 2

P.A. NO Other Cont #2	TITLE (B) SCREW, TAPPING, THREAD FORMING- TYPES AB, B AND BP, APPROXIMATE HOLE SIZES FOR	MILITARY STANDARD MS 24632
PROCUREMENT SPECIFICATION NONE	SUPERSEDES	SHEET 2 OF

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE