INCH-POUND

MS24672B
2 June 2006
SUPERSEDING
MS24672A
27 March 1961

DETAIL SPECIFICATION SHEET

SCREW, CAP, SOCKET HEAD, FLAT COUNTERSUNK, CORROSION RESISTING STEEL, UNF-3A

Inactive for new design after 27 March 1961

This specification is approved for use by all Departments and Agencies of the Department of Defense.

The requirements for acquiring the product described herein shall consist of this specification sheet and FF-S-86.

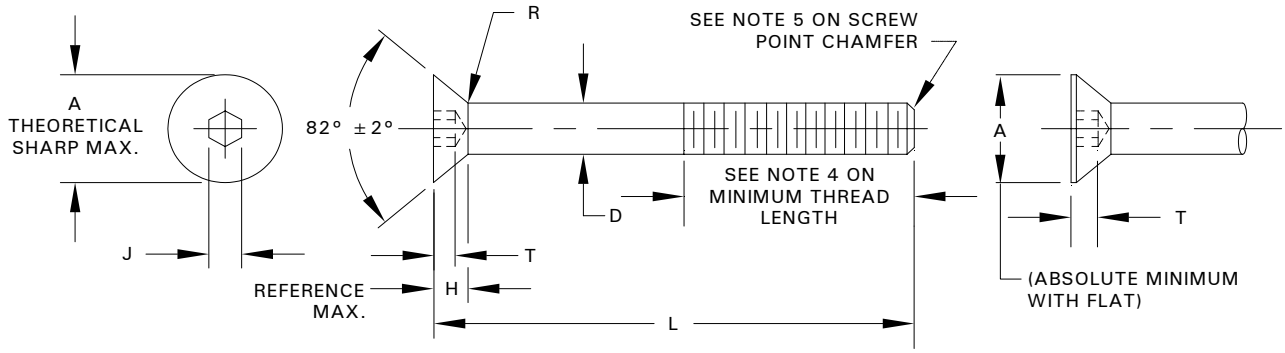

FIGURE 1. Screw

TABLE I. Screw Dash Numbers and Dimensions

NOMINAL SIZE			#10 (.190)	.250	.313	.375	.500
THREADS PER INCH			32UNF-3A	28UNF-3A	24UNF-3A	24UNF-3A	20UNF-3A
D BODY DIAMETER		MAX	.190	.250	.3125	.375	.500
		MIN	.1867	.2464	.3084	.3705	.4948
A HEAD DIAMETER	THEO. SHARP	MAX	.411	.531	.656	.781	.937
	ABS.	MIN	.359	.480	.600	.720	.872
H HEAD HEIGHT	REFERENCE	MAX	.127	.161	.198	.234	.251
J SOCKET WIDTH ACROSS FLATS		MAX	.1270	.1582	.1895	.2207	.3155
		MIN	.1250	.1562	.1875	.2187	.3125
T KEY ENGAGEMENT		MIN	.087	.111	.135	.159	.172
R RADIUS		MAX	.019	.025	.031	.037	.050
MINIMUM BREAKING STRENGTH		LBS.	1400	2550	4060	6150	11200
L LENGTH	TOL.		DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.
.375	+.016 - .016		1	9	17		
.500			2	10	18	25	
.625			3	11	19	26	
.750			4	12	20	27	32
1.000			5	13	21	28	33
1.250	+.031 - .016		6	14	22	29	34
1.500			7	15	23	30	35
1.750							36
2.000							37

NOTES:

1. MATERIAL: STEEL, CORROSION RESISTANT, IN ACCORDANCE WITH FF-S-86. ULTIMATE LOAD – 70,000 PSI MIN TENSILE STRENGTH; PROOF LOAD – 30,000 PSI MIN YIELD STRENGTH; ELONGATION – 35 PERCENT MIN.

2. PROTECTIVE COATING: PASSIVATED IN ACCORDANCE WITH FF-S-86.

3. THREADS: THE THREADS SHALL BE IN ACCORDANCE WITH FED-STD- H28.

4. MINIMUM THREAD LENGTH: THE MINIMUM USABLE THREAD LENGTH SHALL BE EQUAL TO 2D PLUS .500. THE THREAD LENGTH TOLERANCE SHALL BE EQUAL TO THE NOMINAL DIAMETER. SCREWS TOO SHORT FOR APPLICATION OF THE FORMULA SHALL BE THREADED AS CLOSE TO THE HEAD AS PRACTICABLE.

5. POINT CHAMFER: THE POINTS SHALL BE FLAT AND CHAMFERED. THE FLAT SHALL BE NORMAL TO THE AXIS OF THE SCREW. THE CHAMFER SHALL EXTEND SLIGHTLY BELOW THE ROOT OF THE THREAD AND THE EDGE BETWEEN THE FLAT AND THE CHAMFER MAY BE ROUNDED. THE INCLUDED ANGLE OF THE THREADED POINT SHALL BE APPROXIMATELY 90°. CHAMFERING OF SCREW SIZES UP TO AND INCLUDING NO. 8 SHALL BE AT THE OPTION OF THE MANUFACTURER.

6. DIMENSIONS: ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.

7. PART NUMBER: THE MS PART NUMBER CONSISTS OF THE MS NUMBER, PLUS THE DASH NUMBER.
   EXAMPLE: MS24672-1

8. THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.

9. CHANGES FROM PREVIOUS ISSUE. MARGINAL NOTATIONS ARE NOT USED IN THIS REVISION TO IDENTIFY CHANGES WITH RESPECT TO THE PREVIOUS ISSUE DUE TO THE EXTENT OF THE CHANGES.

Custodians:
Navy – SH

Review Activities:
Navy – AS

Preparing activity:
DLA – IS

(Project 5305-2006-003)

NOTE: The activities listed above were interested in this document as of the date of this document. Since organizations and responsibilities can change, you should verify the currency of the information above using the ASSIST Online database at http://assist.daps.dla.mil