

REVIEWER: IS, MI, MU, NSA, AV, BS
USER: AT, ME, SH, MC, CC

HEAD MARKING		LENGTH		M X 45° APPROX.		FED. SUP. CLASS			
99° TO 101°		H REF.		D		5305			
A		R		GRIP		ABS A MIN WITH MAX F			
		1/32, AN		MAX-TWO IMPERFECT THREADS		EDGES OF HEAD MAY BE ROUNDED OR STRAIGHT-SIDED			
INCREASE OF .001 OVER D DIAMETER FROM THE POINT OF TANGENCY OF R AND THE SHANK WILL BE PERMISSIBLE									
TABLE I									
NOMINAL SIZE		#8	#10	1/4	5/16	3/8	7/16	1/2	9/16
THREADS PER INCH		32UNC-3A	32UNF-3A	28UNF-3A	24UNF-3A	24UNF-3A	20UNF-3A	20UNF-3A	18UNF-3A
D SCREW DIAMETER	MAX MIN	.164 .161	.189 .186	.249 .246	.3115 .3085	.374 .371	.4365 .4325	.499 .495	.5615 .5575
A HEAD DIAMETER	MAX SHARP MIN SHARP ABS MIN	.332 .319 .283	.385 .371 .327	.507 .491 .447	.635 .617 .569	.762 .742 .666	.890 .868 .805	1.017 .992 .919	1.145 1.118 1.036
F FLAT	MAX	.015	.016	.018	.020	.023	.026	.030	.034
H HEAD HEIGHT	REF	.068	.080	.106	.133	.159	.186	.213	.240
M POINT	MAX	.031	.031	.031	.047	.047	.047	.047	.047
R FILLET RADIUS	MAX MIN	.015 .005	.015 .005	.015 .005	.020 .010	.020 .010	.020 .010	.020 .010	.020 .010
TABLE II									
*MINIMUM TENSILE STRENGTH LOAD POUNDS									
NOMINAL SIZE	LOW-ALLOY STEEL	ALUMINUM ALLOY	CORROSION RESISTING STEEL						
Nr. 8-32UNC-3A	1750	870	1190						
Nr. 10-32UNF-3A	2500	1240	1700						
1/4-28UNF-3A	4550	2250	3090						
5/16-24UNF-3A	7250	3600	4930						
3/8-24UNF-3A	10950	5440	7460						
7/16-20UNF-3A	14640	7360	10090						
1/2-20UNF-3A	19990	9910	13590						
9/16-18UNF-3A	25350	12590	17260						
<p>* Based on 125,000 PSI minimum tensile strength for low-alloy steel, 62,000 PSI for aluminum alloy and 85,000 PSI for corrosion resisting steel. Load pounds are calculated by the stress areas indicated in Screw-Thread Standards for Federal Services, Handbook H28.</p> <p>MATERIAL: Steel, Low-Alloy - Rockwell Hardness C26 to C32; MIL-S-6049 OR MIL-S-6050. Aluminum Alloy - Alloy 2024 of QQ-A-430 or alloy 2024, T4 temper of QQ-A-225. Steel, Corrosion Resisting - Fed. Std. No. 66, steel no. 302, 303, 304, 305 or 316 or equal to or interchangeable with 16-18 or 18-8 chromium nickel alloy steel (developed for cold heading).</p> <p>PROTECTIVE COATING OR TREATMENT: Cadmium Plated - QQ-P-416, Type II, Class 3. Anodize - MIL-A-8625, Type I or II. Passivate - QQ-P-35.</p> <p>MAGNETIC PERMEABILITY: These fasteners have a magnetic permeability of 2.0 maximum (air=1.0) for a field strength of H-200 oersteds using a magnetic indicator per MIL-1-17214.</p> <p>HEAT TREATMENT: For Steel, Low-Alloy - 125,000 PSI to 145,000 PSI tensile strength, MIL-H-6875. For QQ-A-430 Aluminum Alloy - 62,000 PSI tensile strength (min), MIL-H-6065.</p> <p>RECESS: The recess shall be in accordance with MS9006.</p> <p>THREADS: The threads shall be in accordance with MIL-S-7742.</p> <p>ECCENTRICITY: The conical surface of the head shall not be eccentric with the body more than a total runout of .005.</p> <p>LENGTH TOLERANCE: Tolerance on the lengths for Nr. 8-32, Nr. 10-32, 1/4-28 and 3/8-24 screws = +1/32, -1/64; for 5/16-24 and 9/16-18 screws = +3/64, -0; for 7/16-20 and 1/2-20 screws = +1/64, -1/32.</p> <p>HEAD MARKING: Low-Alloy Steel - One "X" required. Corrosion Resisting Steel - One "-" required. Aluminum Alloy - None required.</p> <p>DIMENSIONS: All dimensions are in inches unless otherwise specified.</p> <p>PART NUMBER: The MS part number consists of the MS number, plus the coded dash number. See sheet 2 and 3.</p> <p>NOTES: (1) For design feature purposes, this standard takes precedence over procurement documents referenced herein. (2) Referenced documents shall be of the issue in effect on date of invitations for bid.</p>									
© FOR CHANGE SEE SHEET 1.									
P.A. WC	TITLE		MILITARY STANDARD						
Other Cust	SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°		MS24694						
82	STRUCTURAL, CROSS RECESSED, UNC-3A AND UNF-3A								
PROCUREMENT SPECIFICATION	SUPERSEDES	AN509	SHEET 1 OF 4						
MIL-S-7839									

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DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

APPROVED 5 AUG 60 REVISED (A) 21 APR 67 (B) 6 NOV 68 (C) 17 FEB 69

TABLE III DASH NUMBERS AND CODES**												FED. SUP. CLASS 5305	
NOMINAL SIZE	#8-32UNC-3A			#10-32UNF-3A			1/4-28UNF-3A			5/16-24UNF-3A			
LENGTH	GRIP	TOL.	DASH NR.	GRIP	TOL.	DASH NR.	GRIP	TOL.	DASH NR.	GRIP	TOL.	DASH NR.	
9/32	3/32		1	7/64		46	9/64		92	11/64		137	
11/32	3/32		2	7/64		47	9/64		93	11/64		138	
13/32	3/32	+1/32	3	7/64	+1/32	48	9/64	+1/32	94	11/64	+1/32	139	
15/32	3/32	-0	4	7/64	-0	49	9/64	-0	95	11/64	-0	140	
17/32	3/32		5	7/64		50	9/64		96	11/64		141	
19/32	5/32		6	7/64		51	9/64		97	11/64		142	
21/32	7/32		7	3/16		52	9/64		98	11/64		143	
23/32	9/32		8	1/4		53	3/16		99	7/32		144	
25/32	11/32		9	5/16		54	1/4		100	9/32		145	
27/32	13/32		10	3/8		55	5/16		101	11/32		146	
29/32	15/32		11	7/16		56	3/8		102	13/32		147	
31/32	17/32		12	1/2		57	7/16		103	15/32		148	
1-1/32	19/32		13	9/16		58	1/2		104	17/32		149	
1-3/32	21/32		14	5/8		59	9/16		105	19/32		150	
1-5/32	23/32		15	11/16		60	5/8		106	21/32		151	
1-7/32	25/32		16	3/4		61	11/16		107	23/32		152	
1-9/32	27/32		17	13/16		62	3/4		108	25/32		153	
1-11/32	29/32		18	7/8		63	13/16		109	27/32		154	
1-13/32	31/32		19	15/16		64	7/8		110	29/32		155	
1-15/32	1-1/32	+1/64	20	1		65	15/16		111	31/32		156	
1-17/32	1-3/32	-1/64	21	1-1/16		66	1		112	1-1/32		157	
1-19/32	1-5/32		22	1-1/8		67	1-1/16		113	1-3/32		158	
1-21/32	1-7/32		23	1-3/16	+1/64	68	1-1/8	+1/64	114	1-5/32		159	
1-23/32	1-9/32		24	1-1/4	-1/64	69	1-3/16	-1/64	115	1-7/32	+1/64	160	
1-25/32	1-11/32		25	1-5/16		70	1-1/4		116	1-9/32	-1/64	161	
1-27/32	1-13/32		26	1-3/8		71	1-5/16		117	1-11/32		162	
1-29/32	1-15/32		27	1-7/16		72	1-3/8		118	1-13/32		163	
1-31/32	1-17/32		28	1-1/2		73	1-7/16		119	1-15/32		164	
2-1/32	1-19/32		29	1-9/16		74	1-1/2		120	1-17/32		165	
2-3/32	1-21/32		30	1-5/8		75	1-9/16		121	1-19/32		166	
2-5/32	1-23/32		31	1-11/16		76	1-5/8		122	1-21/32		167	
2-7/32	1-25/32		32	1-3/4		77	1-11/16		123	1-23/32		168	
2-9/32	1-27/32		33	1-13/16		78	1-3/4		124	1-25/32		169	
2-11/32	1-29/32		34	1-7/8		79	1-13/16		125	1-27/32		170	
2-13/32	1-31/32		35	1-15/16		80	1-7/8		126	1-29/32		171	
2-15/32				2		81	1-15/16		127	1-31/32		172	
2-17/32				2-1/16		82	2		128	2-1/32		173	
2-19/32				2-1/8		83	2-1/16		129	2-3/32		174	
2-21/32				2-3/16		84	2-1/8		130	2-5/32		175	
2-23/32				2-1/4		85	2-3/16		131	2-7/32		176	
2-25/32				2-5/16		86	2-1/4		132	2-9/32		177	
2-27/32				2-3/8		87	2-5/16		133	2-11/32		178	
2-29/32				2-7/16		88	2-3/8		134	2-13/32		179	
2-31/32				2-1/2		89	2-7/16		135	2-15/32		180	
3-1/32				2-9/16		90	2-1/2						

NOTE: For illustration, material, protective coating and other pertinent data, see sheet 1.

** DASH NUMBER CODE:
Add "S" before dash number for Cadmium Plated, Low-Alloy Steel Screw.
Add "A" before dash number for Anodized, Aluminum Alloy Screw.
Add "C" before dash number for Passivated, Corrosion Resisting Steel Screw.

EXAMPLES OF MS PART NUMBERS:
MS24694-S1 = #8-32UNC-3A Cadmium Plated, Low-Alloy Steel Screw, 9/32 inch long.
MS24694-A100 = 1/4-28UNF-3A Anodized, Aluminum Alloy Screw, 27/32 inch long.
MS24694-C250 = 7/16-20UNF-3A Passivated, Corrosion Resisting Steel Screw, 2-1/32 inches long.

P.A.	WC	TITLE	MILITARY STANDARD
Other Cust	82	SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, STRUCTURAL, CROSS RECESSED, UNC-3A AND UNF-3A	MS24694
PROCUREMENT SPECIFICATION MIL-S-7839	SUPERSEDES	AN509	SHEET 2 OF

REVIEWER: IS, MI, MU, NSA, AV, 85
USER: AT, ME, SH, MC, CC

This military standard has been approved by the Department of Defense and 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.

APPROVED 5 AUG 60 REVISED 21 APR 67 6 NOV 68 FOR CHANGE SEE SHEET 1

REVIEWER: JS, MI, ME, NSA, AV, BS
USER: AT, ME, SH, MC, CG

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TABLE 111 (Cont) DASH NUMBERS AND CODES **											FED. SUP CLASS 5305	
NOMINAL SIZE	3/8-24UNF-3A			7/16-20UNF-3A			1/2-20UNF-3A			9/16-18UNF-3A		
LENGTH	GRIP	TOL	DASH NR.	GRIP	TOL	DASH NR.	GRIP	TOL	DASH NR.	GRIP	TOL	DASH NR.
13/32	3/16		181									
15/32	3/16	+1/32	182	7/32		225	1/4		270			
17/32	3/16	-0	183	7/32		226	1/4		271	9/32		330
19/32	3/16		184	7/32		227	1/4		272	9/32		331
21/32	3/16		185	7/32	+1/32	228	1/4		273	9/32		332
23/32	3/16		186	7/32	-0	229	1/4		274	9/32		333
25/32	3/16		187	7/32		230	1/4	+1/32	275	9/32	+1/32	334
27/32	3/16		188	7/32		231	1/4	-0	276	9/32	-0	335
9/32	7/32		189	7/32		232	1/4		277	9/32		336
11/32	9/32		190	1/4		233	1/4		278	9/32		337
1-1/32	11/32		191	5/16		234	1/4		279	9/32		338
1-3/32	13/32		192	3/8		235	1/4		280	9/32		339
1-5/32	15/32		193	7/16		236	5/16		281	9/32		340
1-7/32	17/32		194	1/2		237	3/8		282	9/32		341
1-9/32	19/32		195	9/16		238	7/16		283	11/32		342
1-11/32	21/32		196	5/8		239	1/2		284	13/32		343
1-13/32	23/32		197	11/16		240	9/16		285	15/32		344
1-15/32	25/32		198	3/4		241	5/8		286	17/32		345
1-17/32	27/32		199	13/16		242	11/16		287	19/32		346
1-19/32	29/32		200	7/8		243	3/4		288	21/32		347
1-21/32	31/32		201	15/16		244	15/16		289	23/32		348
1-23/32	1-1/32		202	1		245	1		290	25/32		349
1-25/32	1-3/32	+1/64	203	1-1/16	+1/64	246	15/16		291	27/32		350
1-27/32	1-5/32	-1/64	204	1-1/8	-1/64	247	1		292	29/32		351
1-29/32	1-7/32		205	1-3/16		248	1-1/16		293	31/32		352
1-31/32	1-9/32		206	1-1/4		249	1-1/8		294	1-1/32		353
2-1/32	1-11/32		207	1-5/16		250	1-3/16		295	1-3/32		354
2-3/32	1-13/32		208	1-3/8		251	1-1/4		296	1-5/32		355
2-5/32	1-15/32		209	1-7/16		252	1-5/16		297	1-7/32		356
2-7/32	1-17/32		210	1-1/2		253	1-3/8		298	1-9/32		357
2-9/32	1-19/32		211	1-9/16		254	1-7/16	+1/64	299	1-11/32	+1/64	358
2-11/32	1-21/32		212	1-5/8		255	1-1/2	-1/64	300	1-13/32	-1/64	359
2-13/32	1-23/32		213	1-11/16		256	1-9/16		301	1-15/32		360
2-15/32	1-25/32		214	1-3/4		257	1-5/8		302	1-17/32		361
2-17/32	1-27/32		215	1-13/16		258	1-11/16		303	1-19/32		362
2-19/32	1-29/32		216	1-7/8		259	1-3/4		304	1-21/32		363
2-21/32	1-31/32		217	1-15/16		260	1-15/16		305	1-23/32		364
2-23/32	2-1/32		218	2		261	1-7/8		306	1-25/32		365
2-25/32	2-3/32		219	2-1/16		262	1-15/16		307	1-27/32		366
2-27/32	2-5/32		220	2-1/8		263	2		308	1-29/32		367
2-29/32	2-7/32		221	2-3/16		264	2-1/16		309	1-31/32		368
2-31/32	2-9/32		222	2-1/4		265	2-1/8		310	2-1/32		369
3-1/32	2-11/32		223	2-5/16		266	2-3/16		311	2-3/32		370
3-3/32	2-13/32		224	2-3/8		267	2-1/4		312	2-5/32		371
3-5/32							2-5/16		313	2-7/32		372
3-7/32							2-3/8		314	2-9/32		373
3-9/32							2-7/16		315	2-11/32		374
3-11/32							2-1/2		316	2-13/32		375
3-13/32							2-9/16		317	2-15/32		376
3-15/32							2-5/8		318	2-17/32		377
3-17/32							2-11/16		319	2-19/32		378
3-19/32							2-3/4		320	2-21/32		379
3-21/32							2-13/16		321	2-23/32		380
3-23/32							2-7/8		322	2-25/32		381
3-25/32							2-15/16		323	2-27/32		382
3-27/32							3		324	2-29/32		383
3-29/32							3-1/16		325	2-31/32		384
3-31/32							3-1/8		326	3-1/32		385
4-1/32							3-3/16		327	3-3/32		386
4-3/32							3-1/4		328	3-5/32		387

NOTE: FOR ILLUSTRATION, MATERIAL, PROTECTIVE COATING AND OTHER PERTINENT DATA, SEE SHEET 1.
** FOR DASH NUMBER CODES, SEE SHEET 2.

P.A. WC
Other Cust
82

TITLE
SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°,
STRUCTURAL, CROSS RECESSED,
UNC-3A AND UNF-3A

MILITARY STANDARD
MS24694
SHEET 3 OF

PROCUREMENT SPECIFICATION
MIL-S-7839

SUPERSEDES
AN509

APPROVED 5 AUG 60
REVISED (A) 21 APR 67 (B) 6 NOV 68 (C) FOR CHANGE SEE SHEET 1.

NOTE: FOR ILLUSTRATION, MATERIAL, PROTECTIVE COATING AND OTHER PERTINENT DATA, SEE SHEET 1.
** FOR DASH NUMBER CODES, SEE SHEET 2.

P.A.	WC	TITLE	MILITARY STANDARD
Other Cust	B2	SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, STRUCTURAL, CROSS RECESSED, UNC-3A AND UNF-3A	MS24694
PROCUREMENT SPECIFICATION MIL-S-7839	SUPERSEDES ANSO9	SHEET	3 OF

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

APPROVED 5 AUG 60 REVISED 21 APR 67 6 NOV 68 (C) FOR CHANGE SEE SHEET 1.

REVIEWER: IS, MI, MU, NSA, AV, BS
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TABLE IV
 INTERCHANGEABILITY - (Using Coded Dash Numbers)

FED. SUP. CLASS
 5305

After 21 April 1967 screws given on AN509 are canceled, but their existing stock should be used for maintenance purposes until depleted. USE ONLY THE NEW MS24694 SCREWS FOR NEW DESIGN AND ENGINEERING.

Codes for canceled and new dash numbers:

- (1) For cadmium plated, carbon steel screws: The following AN509 dash numbers are superseded by the following MS dash numbers with a prefix "S" added. Example: AN509-8R4 superseded by MS24694-S1.
- (2) For anodized, aluminum alloy screws: AN dash numbers with a prefix "DD" superseded by MS dash numbers with a prefix "A". Example: AN509DD8R4 superseded by MS24694-A1.
- (3) For passivated, corrosion resisting steel screws: AN dash numbers with a prefix "C" superseded by MS dash numbers with a prefix "C". Example: AN509C8R4 superseded by MS24694-C1.
- (4) For AN509 part numbers inactive for design after 31 January 1952: Bronze screws, uncoated ("Z" before first dash number) and cadmium plated ("P" before first dash number) are canceled but have no replacements.
- (5) For AN509 part numbers inactive for design after 17 February 1959: Optional design II cross recessed ("R" between first and second dash numbers) and slotted head screws ("-" between first and second dash numbers) are canceled and superseded by the appropriately coded MS dash number. Example: AN509-8R4 or AN509-8-4 superseded by MS24694-S1.

CANCELED AN509 DASH NO	NEW MS24694 DASH NO	CANCELED AN509 DASH NO	NEW MS24694 DASH NO	CANCELED AN509 DASH NO	NEW MS24694 DASH NO	CANCELED AN509 DASH NO	NEW MS24694 DASH NO	CANCELED AN509 DASH NO	NEW MS24694 DASH NO	CANCELED AN509 DASH NO	NEW MS24694 DASH NO
8R4	1	10R31	73	516R5	137	616R23	199	716R42	261	816R61	325
8R5	2	10R32	74	516R6	138	616R24	200	716R43	262	816R62	326
8R6	3	10R33	75	516R7	139	616R25	201	716R44	263	816R63	327
8R7	4	10R34	76	516R8	140	616R26	202	716R45	264	816R64	328
8R8	5	10R35	77	516R9	141	616R27	203	716R46	265	816R65	329
8R9	6	10R36	78	516R10	142	616R28	204	716R47	266	816R66	330
8R10	7	10R37	79	516R11	143	616R29	205	716R48	267	816R67	331
8R11	8	10R38	80	516R12	144	616R30	206	816R68	270	816R68	332
8R12	9	10R39	81	516R13	145	616R31	207	816R69	271	816R69	333
8R13	10	10R40	82	516R14	146	616R32	208	816R70	272	816R70	334
8R14	11	10R41	83	516R15	147	616R33	209	816R71	273	816R71	335
8R15	12	10R42	84	516R16	148	616R34	210	816R72	274	816R72	336
8R16	13	10R43	85	516R17	149	616R35	211	816R73	275	816R73	337
8R17	14	10R44	86	516R18	150	616R36	212	816R74	276	816R74	338
8R18	15	10R45	87	516R19	151	616R37	213	816R75	277	816R75	339
8R19	16	10R46	88	516R20	152	616R38	214	816R76	278	816R76	340
8R20	17	10R47	89	516R21	153	616R39	215	816R77	279	816R77	341
8R21	18	10R48	90	516R22	154	616R40	216	816R78	280	816R78	342
8R22	19	416R5	92	516R23	155	616R41	217	816R79	281	816R79	343
8R23	20	416R6	93	516R24	156	616R42	218	816R80	282	816R80	344
8R24	21	416R7	94	516R25	157	616R43	219	816R81	283	816R81	345
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P.A. WC	TITLE	MILITARY STANDARD
Other Code	SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, STRUCTURAL, CROSS RECESSED, UNC-3A AND UNF-3A	MS24694
PROCURMENT SPECIFICATION MIL-S-7839	SUPERSEDES AN509	SHEET 4 OF

DD FORM 672-1 (Continued)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

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