

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE
DEPARTMENT OF DEFENSE

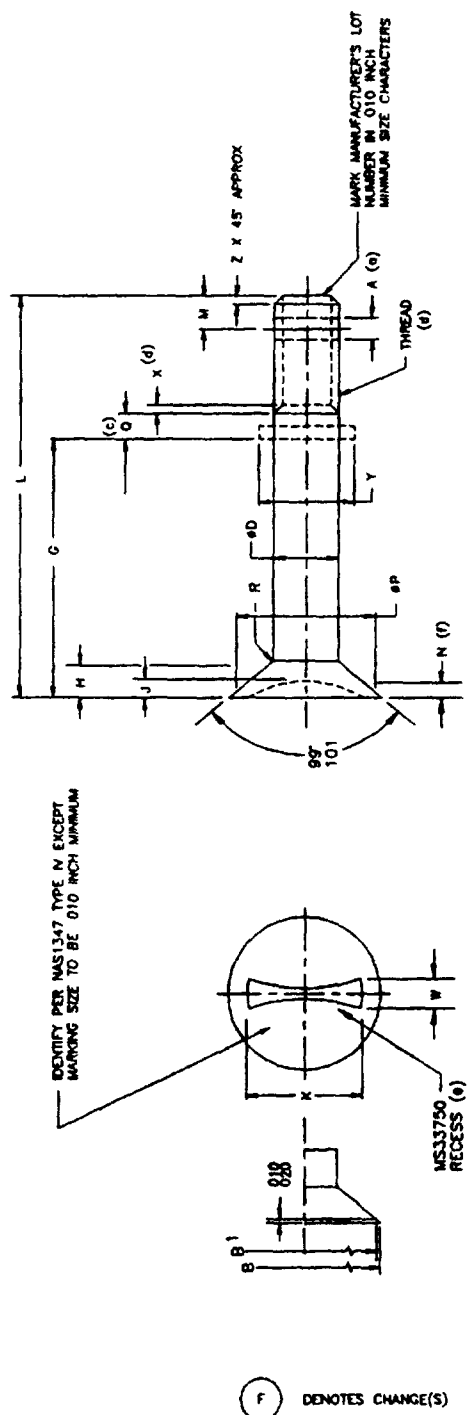


TABLE I

FIRST NOMINAL DASH	NOMINAL DIAMETER	THREAD DESIGNATION (ϕ)	A (ϕ)		B		B'		ϕ D		H (ϕ)		J		K		M + OOD		N		Q		R		Y		Z		RECESS NO NO (ϕ)
			MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	REF	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	
-3	180	180-32 UNF-3A	080	070	345	338	1804	1695	080	043	042	305	083	0290	0285	3147	3143	120	074	020	015	110	275	184	041	021		3	
-4	250	250-24 UNF-3A	086	078	507	448	2482	2443	108	054	051	420	080	0342	0316	4245	4241	120	050	020	015	134	264	254	041	021		4	
-5	3125	3125-24 UNF-3A	086	078	635	577	3112	3108	133	064	061	481	090	0370	0359	5369	5365	151	120	030	020	180	360	370	057	037		5	
-6	375	375-24 UNF-3A	118	108	762	704	3733	3733	160	068	064	639	105	0436	0428	6532	6532	186	120	030	020	220	445	382	057	037		6	
-7	4375	4375-20 UNF-3A	118	108	890	832	4387	4388	188	100	097	715	110	0503	0481	7878	7878	197	120	030	020	274	514	440	057	037		7	
-8	500	500-20 UNF-3A	118	108	1017	959	4982	4982	215	105	101	796	110	0537	0537	8920	8916	228	120	030	020	320	569	569	051	057		8	
-9	5625	5625-16 UNF-3A	118	101	1143	1067	5607	5618	242	118	114	877	115	0592	0592	9964	9960	280	120	030	020	350	671	582	072	052		9	

(a) COTTER PIN HOLE SHALL BE WITHIN 010 INCH OF BOLT DIAMETER CENTERLINE AND SHALL BE PERPENDICULAR TO BOLT SHANK AXIS COUNTERSINK TO DEBURR

(b) REFERENCE DIMENSIONS AND REQUIREMENTS ARE FOR DESIGN INFORMATION AND ARE NOT MANUFACTURING AND INSPECTION REQUIREMENTS

(c) RETAINING ELEMENTS SHALL BE LOCATED WITHIN THE LIMITS OF Q DIMENSION

(d) THREAD- IN ACCORDANCE WITH MIL-S-8879 EXCEPT THAT INCOMPLETE THREAD LENGTH X SHALL BE A MAXIMUM OF 1-1/2 AND A MINIMUM OF 1/2 THREAD PITCHES IN LENGTH AND MAJOR DIAMETER SHALL BE AT LEAST .001 BELOW MINIMUM SHANK DIAMETER

(e) RECESS SHALL CONFORM TO MSJ3750 AND BE CONCENTRIC WITHIN 0.16 FIM OF SHANK DIAMETER

(1) REFERENCE NAS 518 AND NAS 519 FOR GAGING DETAILS

(g) THE CONCENTRICITY OF THE THREAD PD IN RELATION TO THE SHANK DIAMETER SHALL BE WITHIN 0.06 FIM

Form Approved
OMB No 0704-0188

PREPARING ACTIVITY DLA-15
CUSTODIANS ARMY- AV NAVY- AS
AIR FORCE- 11 DLA-
REVIEW 99
USER
PROJECT NUMBER S306-1675
DISTRIBUTION STATEMENT

MILITARY SPECIFICATION SHEET

TITLE
F SCREW, CLOSE TOLERANCE.
95 KSI FSU, FLUSH HEAD, 450F

SPECIFICATION SHEET NUMBER
MS27577

30 SEP 93
REV F

SUPERSEDING
MS27577 E 28 AUG 87

AMSC- N/A FSC 5305 F

DISTRIBUTION STATEMENT

A. Approved for public release; distribution is unlimited.

Page 1 of 4

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODISS SPECIFIED IN THE SOLICITATION MIL-B-83050

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Form Approved
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TABLE II

NOMINAL SIZE	SHANK ULTIMATE DOUBLE SHEAR STRENGTH LBS MIN	BOLT ULTIMATE TENSILE STRENGTH LBS MIN
0 190	5 380	2 530
0 250	9,300	4 680
0 3125	14 600	7,510
0 375	21 000	11 540
0 4375	28 600	15 560
0 500	37,300	21 160
0 5625	47,200	26 870
0 625	56,300	34 100
0 750	63,900	38 800
0 875	114 200	55 040
1 000	149 200	74 000

REQUIREMENTS

1 MATERIAL

- (F) SCREW ALLOY STEEL IN ACCORDANCE WITH MIL-S-5000 MIL-S-5626 (UNS G41400) MIL-S-6049 MIL-S-6758 OR MIL-S-8503
- CRES STEEL 17-4PH IN ACCORDANCE WITH AMS5643 EXCEPT THAT AGING TEMPERATURE SHALL NOT BE LESS THAN 1000F OR A-286 IN ACCORDANCE WITH AMS5732
- TITANIUM ALLOY TITANIUM (6AL-4V) PER MIL-T-9047 COMPOSITION 6
- RETAINING ELEMENT 17-4PH IN ACCORDANCE WITH AMS5643 OR 17-7PH IN ACCORDANCE WITH AMS5644 OR AMS5678 (F) OR 440C CRES STEEL IN ACCORDANCE WITH QQ-S-763

2 SURFACE FINISH

UNTHREADED SHANK AND BEARING SURFACE UNDER HEAD 63/ IN ACCORDANCE WITH ANSI/ASME B46 1
ALL OTHER SURFACES 125/ IN ACCORDANCE WITH ANSI/ASME B46 1

3 HEAT TREATMENT

SCREW IN ACCORDANCE WITH MIL-H-6875 TO ROCKWELL C36 TO C41
RETAINING ELEMENT IN ACCORDANCE WITH QUALIFIED MANUFACTURERS REQUIREMENTS

4 PROTECTIVE TREATMENT

ALLOY STEEL CADMIUM PLATE IN ACCORDANCE WITH QQ-P-416 TYPE II CLASS 2
CRES STEEL PASSIVATE IN ACCORDANCE WITH QQ-P-35

5 MATERIALS CODE SYSTEM

CODE LETTER "-" (OR NO CODE) - FOLLOWING BASIC PART NUMBER INDICATES ALLOY STEEL
CODE LETTER "C" FOLLOWING BASIC PART NUMBER INDICATES 17-4PH CRES STEEL
CODE LETTER "P" FOLLOWING BASIC PART NUMBER INDICATES A-286 CRES STEEL
CODE LETTER "V" FOLLOWING BASIC PART NUMBER INDICATES 6AL-4V TITANIUM

6 PART NUMBER

THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER, FOLLOWED BY A MATERIAL CODE LETTER FOLLOWED BY A NOMINAL DIAMETER SIZE IN SIXTEENTHS OF AN INCH TAKEN FROM TABLE I, FOLLOWED BY A GRIP IN SIXTEENTHS OF AN INCH TAKEN FROM TABLE III

EXAMPLES OF PART NUMBER

MS27577-4-24

250-28 UNJF-3A ALLOY STEEL SCREW 250 INCH NOMINAL DIAMETER
1 50 NOMINAL GRIP

GRIP IN SIXTEENTHS OF AN INCH

NOMINAL DIAMETER SIZE IN SIXTEENTHS OF AN INCH

ALLOY STEEL

SCREW CLOSE TOLERANCE. (F)

MS27577C4-24

250-28 UNJF-3A CORROSION-RESISTANT STEEL SCREW, 250 INCH
NOMINAL DIAMETER, 1 50 NOMINAL GRIP

GRIP IN SIXTEENTHS OF AN INCH

NOMINAL DIAMETER SIZE IN SIXTEENTHS OF AN INCH

CORROSION-RESISTANT STEEL

SCREW CLOSE TOLERANCE. (F)

NOTES

- 1 SCREWS SHALL BE FREE FROM ALL BURRS AND SLIVERS BREAK ALL SHARP EDGES
- 2 DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED TOLERANCES LINEAR ± 0.10 , ANGULAR $\pm 2^\circ$
- 3 IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS STANDARD AND THE REFERENCES CITED HEREIN THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE
- 4 REFERENCED GOVERNMENT (OR NON-GOVERNMENT) DOCUMENTS OF THE ISSUE LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (DODISS) SPECIFIED IN THE SOLICITATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN

PREPARING ACTIVITY DLA-B

CUSTODIANS ARMY- AV NAVY- AS

AIR FORCE- 11

DLA-

REVIEW 99

USER

PROJECT NUMBER 5306-1675

MILITARY SPECIFICATION SHEET

TITLE

(F) SCREW, CLOSE TOLERANCE,
95 KSI FSU, FLUSH HEAD, 450F

SPECIFICATION SHEET NUMBER

MS27577

30 SEP 83

REV F

SUPERSEDING

MS27577 E 28 AUG 87

AMSC-

N/A

FSC 5305

(F)

DISTRIBUTION STATEMENT

A Approved for public release distribution is unlimited

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Form Approved
OMB No 0704-0188

TABLE 18

2ND DASH NO	FIRST DASH NO		-3 L ± 010	-4 L ± 010	-5 L ± 010	-6 L ± 010	-7 L ± 010	-8 L ± 010	-9 L ± 010	-10 L ± 010	-12 L ± 010	-14 L ± 010	-16 L ± 010
	G-GRIP LENGTH												
	MAX	MIN											
03	204	188	570	616									
04	266	250	632	678	738	799							
05	328	312	695	741	800	861							
06	390	375	757	803	863	924	968	1 031					
07	454	438	820	866	925	986	1 030	1 093	1 234	1 296			
08	516	500	882	928	988	1 049	1 093	1 156	1 296	1 359	1 523	1 630	1 742
09	578	562	945	991	1 050	1 111	1 155	1 218	1 359	1 421	1 585	1 692	1 804
10	641	625	1 007	1 053	1 113	1 174	1 218	1 281	1 421	1 484	1 647	1 755	1 867
11	704	688	1 070	1 116	1 175	1 236	1 280	1 343	1 484	1 546	1 710	1 818	1 930
12	766	750	1 132	1 178	1 238	1 299	1 343	1 406	1 546	1 609	1 772	1 880	1 992
13	828	812	1 195	1 241	1 300	1 361	1 405	1 468	1 609	1 671	1 835	1 942	2 054
14	891	875	1 257	1 303	1 363	1 424	1 468	1 531	1 671	1 734	1 897	2 005	2 117
15	954	938	1 320	1 366	1 425	1 486	1 530	1 593	1 734	1 796	1 960	2 068	2 180
16	1 016	1 000	1 382	1 428	1 488	1 549	1 593	1 656	1 796	1 859	2 023	2 130	2 242
17	1 078	1 062	1 445	1 491	1 550	1 611	1 655	1 718	1 859	1 921	2 085	2 192	2 304
18	1 141	1 125	1 507	1 553	1 613	1 674	1 718	1 781	1 921	1 984	2 147	2 255	2 367
19	1 204	1 188	1 570	1 616	1 675	1 736	1 780	1 843	1 984	2 046	2 209	2 316	2 430
20	1 266	1 250	1 632	1 678	1 738	1 799	1 843	1 906	2 046	2 109	2 272	2 380	2 492
21	1 328	1 312	1 695	1 741	1 800	1 861	1 905	1 968	2 109	2 171	2 335	2 442	2 554
22	1 391	1 375	1 757	1 803	1 863	1 924	1 968	2 031	2 171	2 234	2 397	2 505	2 617
23	1 454	1 438	1 820	1 866	1 925	1 986	2 030	2 093	2 234	2 296	2 459	2 568	2 680
24	1 516	1 500	1 882	1 928	1 988	2 049	2 093	2 156	2 296	2 369	2 532	2 640	2 742
25	1 578	1 562	1 945	1 991	2 050	2 111	2 155	2 218	2 359	2 421	2 585	2 692	2 804
26	1 641	1 625	2 007	2 053	2 113	2 174	2 218	2 281	2 421	2 484	2 647	2 755	2 867
27	1 704	1 688	2 070	2 116	2 175	2 236	2 280	2 343	2 484	2 546	2 710	2 818	2 930
28	1 766	1 750	2 132	2 178	2 238	2 299	2 343	2 406	2 546	2 609	2 772	2 880	2 992
29	1 828	1 812	2 195	2 241	2 300	2 361	2 405	2 468	2 609	2 671	2 835	2 942	3 054
30	1 891	1 875	2 257	2 303	2 365	2 424	2 468	2 531	2 671	2 734	2 897	3 005	3 117
31	1 954	1 938	2 320	2 366	2 425	2 486	2 530	2 593	2 734	2 796	2 960	3 068	3 180
32	2 016	2 000	2 382	2 428	2 488	2 549	2 593	2 656	2 796	2 859	3 023	3 130	3 242
33	2 078	2 062	2 445	2 491	2 550	2 611	2 655	2 718	2 859	2 921	3 085	3 192	3 304
34	2 141	2 125	2 507	2 553	2 613	2 674	2 718	2 781	2 921	2 984	3 147	3 255	3 367
35	2 204	2 188	2 570	2 616	2 675	2 736	2 780	2 843	2 984	3 046	3 209	3 316	3 430
36	2 266	2 250	2 632	2 678	2 738	2 799	2 843	2 906	3 046	3 109	3 272	3 380	3 492
37	2 328	2 312	2 695	2 741	2 800	2 861	2 905	2 968	3 109	3 171	3 335	3 442	3 554
38	2 391	2 375	2 757	2 803	2 863	2 924	2 968	3 031	3 171	3 234	3 397	3 505	3 617
39	2 454	2 438	2 820	2 866	2 925	2 986	3 030	3 093	3 234	3 296	3 460	3 568	3 680
40	2 516	2 500	2 882	2 928	2 988	3 049	3 093	3 156	3 296	3 359	3 523	3 630	3 742
41	2 578	2 562	2 945	2 991	3 050	3 111	3 155	3 218	3 359	3 421	3 585	3 692	3 804
42	2 641	2 625	3 007	3 053	3 113	3 174	3 218	3 281	3 421	3 484	3 647	3 755	3 867
43	2 704	2 688	3 070	3 116	3 175	3 236	3 280	3 343	3 484	3 546	3 710	3 818	3 930
44	2 766	2 750	3 132	3 178	3 238	3 299	3 343	3 406	3 546	3 609	3 772	3 880	3 992
45	2 828	2 812	3 195	3 241	3 300	3 361	3 405	3 468	3 609	3 671	3 835	3 942	4 054
46	2 891	2 875	3 257	3 303	3 363	3 424	3 468	3 531	3 671	3 734	3 897	4 005	4 117
47	2 954	2 938	3 320	3 366	3 425	3 486	3 530	3 593	3 734	3 796	3 960	4 068	4 180
48	3 016	3 000	3 382	3 428	3 488	3 549	3 593	3 656	3 796	3 859	4 023	4 130	4 242
49	3 078	3 062	3 445	3 491	3 550	3 611	3 655	3 718	3 859	3 921	4 085	4 192	4 304
50	3 141	3 125	3 507	3 553	3 613	3 674	3 718	3 781	3 921	3 984	4 147	4 255	4 367
51	3 204	3 188	3 570	3 616	3 675	3 736	3 780	3 843	3 984	4 046	4 209	4 316	4 430
52	3 266	3 250	3 632	3 678	3 738	3 799	3 843	3 906	4 046	4 109	4 272	4 380	4 492
53	3 328	3 312	3 695	3 741	3 800	3 861	3 905	3 968	4 109	4 171	4 335	4 442	4 554
54	3 391	3 375	3 757	3 803	3 863	3 924	3 968	4 031	4 171	4 234	4 397	4 505	4 617
55	3 454	3 438	3 820	3 866	3 925	3 986	4 030	4 093	4 234	4 296	4 460	4 568	4 680
56	3 516	3 500	3 882	3 928	3 988	4 049	4 093	4 156	4 296	4 359	4 523	4 630	4 742
57	3 578	3 562	3 945	3 991	4 050	4 111	4 155	4 218	4 359	4 421	4 585	4 692	4 804
58	3 641	3 625	4 007	4 053	4 113	4 174	4 218	4 281	4 421	4 484	4 647	4 755	4 867
59	3 704	3 688	4 070	4 116	4 175	4 236	4 280	4 343	4 484	4 546	4 710	4 818	4 930
60	3 766	3 750	4 132	4 178	4 238	4 299	4 343	4 406	4 546	4 609	4 772	4 880	4 992
61	3 828	3 812	4 195	4 241	4 300	4 361	4 405	4 468	4 609	4 671	4 835	4 942	5 054
62	3 891	3 875	4 257	4 303	4 363	4 424	4 468	4 531	4 671	4 734	4 897	5 005	5 117

PREPARING ACTIVITY DLA-15 CUSTODIANS ARMY- AV NAVY- AS AIR FORCE- 11 DLA-	MILITARY SPECIFICATION SHEET TITLE F SCREW, CLOSE TOLERANCE, 95 KSI FSU, FLUSH HEAD, 450°F	SPECIFICATION SHEET NUMBER MS27577 30 SEP 83 REV F
REVIEW 99 USER PROJECT NUMBER 5306-1875	AMSC- N/A FSC 5305 F	SUPERSEDING MS27577 E 28 AUG 87
DISTRIBUTION STATEMENT A. Approved for public release distribution is unlimited	Page 1 of 1	

DD Form 672, MAY 88

PREVIOUS EDITIONS ARE OBSOLETE

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODDS SPECIFIED IN THE SOLICITATION MIL-B-83050

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TABLE III CONT

2ND DASH NO	FIRST DASH NO		-3 L ± 010	-4 L ± 010	-5 L ± 010	-6 L ± 010	-7 L ± 010	-8 L ± 010	-9 L ± 010	-10 L ± 010	-12 L ± 010	-14 L ± 010	-16 L ± 010
	G-GRIP LENGTH												
	MAX	MIN											
63	3 953	3 937	4 320	4 366	4 425	4 488	4 530	4 593	4 734	4 796	4 860	5 068	5 180
64	4 016	4 000	4 382	4 428	4 488	4 549	4 593	4 656	4 796	4 859	5 023	5 130	5 242
65	4 078	4 062	4 445	4 491	4 550	4 611	4 655	4 718	4 859	4 921	5 085	5 192	5 304
66	4 141	4 125	4 507	4 553	4 613	4 674	4 718	4 781	4 921	4 984	5 147	5 255	5 367
67	4 203	4 188	4 570	4 616	4 675	4 736	4 780	4 843	4 904	5 046	5 209	5 318	5 430
68	4 266	4 250	4 632	4 678	4 738	4 799	4 843	4 906	5 046	5 109	5 272	5 380	5 492
69	4 328	4 312	4 695	4 741	4 800	4 861	4 905	4 968	5 108	5 171	5 335	5 442	5 554
70	4 391	4 375	4 757	4 803	4 863	4 924	4 968	5 031	5 171	5 234	5 397	5 505	5 617
71	4 454	4 438	4 820	4 866	4 925	4 986	5 030	5 093	5 234	5 296	5 460	5 568	5 680
72	4 516	4 500	4 882	4 928	4 988	5 049	5 093	5 156	5 296	5 359	5 522	5 630	5 742
73	4 578	4 562	4 945	4 991	5 050	5 111	5 155	5 218	5 359	5 421	5 585	5 692	5 804
74	4 641	4 625	5 007	5 053	5 113	5 174	5 218	5 281	5 421	5 484	5 647	5 755	5 867
75	4 704	4 688	5 070	5 116	5 175	5 236	5 280	5 343	5 484	5 546	5 710	5 818	5 930
76	4 766	4 750	5 132	5 178	5 238	5 299	5 343	5 406	5 546	5 609	5 772	5 880	5 992
77	4 828	4 812	5 195	5 241	5 300	5 361	5 405	5 468	5 609	5 671	5 835	5 942	6 054
78	4 891	4 875	5 257	5 303	5 367	5 424	5 468	5 531	5 671	5 734	5 897	6 005	6 117
79	4 953	4 937	5 320	5 366	5 425	5 486	5 530	5 593	5 734	5 796	5 960	6 068	6 180
80	5 016	5 000	5 382	5 428	5 488	5 549	5 593	5 656	5 796	5 859	6 023	6 130	6 242
81	5 078	5 062	5 445	5 491	5 550	5 611	5 655	5 718	5 859	5 921	6 085	6 192	6 304
82	5 141	5 125	5 507	5 553	5 613	5 674	5 718	5 781	5 921	5 984	6 147	6 255	6 367
83	5 203	5 188	5 570	5 616	5 675	5 736	5 780	5 843	5 984	6 046	6 209	6 318	6 430
84	5 266	5 250	5 632	5 678	5 738	5 799	5 843	5 906	6 046	6 109	6 272	6 380	6 492
85	5 328	5 312	5 695	5 741	5 800	5 861	5 905	5 968	6 109	6 171	6 335	6 442	6 554
86	5 391	5 375	5 757	5 803	5 863	5 924	5 968	6 031	6 171	6 234	6 397	6 505	6 617
87	5 454	5 438	5 820	5 866	5 925	5 986	6 030	6 093	6 234	6 296	6 460	6 568	6 680
88	5 516	5 500	5 882	5 928	5 988	6 049	6 093	6 156	6 296	6 359	6 522	6 630	6 742
89	5 578	5 562	5 945	5 991	6 050	6 111	6 155	6 218	6 359	6 421	6 585	6 692	6 804
90	5 641	5 625	6 007	6 053	6 113	6 174	6 218	6 281	6 421	6 484	6 647	6 755	6 867
91	5 704	5 688	6 070	6 116	6 175	6 236	6 280	6 343	6 484	6 546	6 710	6 818	6 930
92	5 766	5 750	6 132	6 178	6 238	6 299	6 343	6 406	6 546	6 609	6 772	6 880	6 992
93	5 828	5 812	6 195	6 241	6 300	6 361	6 405	6 468	6 609	6 671	6 835	6 942	7 054
94	5 891	5 875	6 257	6 303	6 363	6 424	6 468	6 531	6 671	6 734	6 897	7 005	7 117
95	5 953	5 938	6 320	6 366	6 425	6 486	6 530	6 593	6 734	6 796	6 960	7 068	7 180
96	6 016	6 000	6 382	6 428	6 488	6 549	6 593	6 656	6 796	6 859	7 023	7 130	7 242
97	6 078	6 062	6 445	6 491	6 550	6 611	6 655	6 718	6 859	6 921	7 085	7 192	7 304
98	6 141	6 125	6 507	6 553	6 613	6 674	6 718	6 781	6 921	6 984	7 147	7 255	7 367
99	6 204	6 188	6 570	6 616	6 675	6 736	6 780	6 843	6 984	7 046	7 209	7 318	7 430
100	6 266	6 250	6 632	6 678	6 738	6 799	6 843	6 906	7 046	7 109	7 272	7 380	7 492

PREPARING ACTIVITY DLA-IS CUSTODIANS ARMY- AV NAVY- AS AIR FORCE- 11 DLA- REVIEW 99 USER PROJECT NUMBER 5306-1675 DISTRIBUTION STATEMENT	MILITARY SPECIFICATION SHEET TITLE (F) SCREW, CLOSE TOLERANCE, 95 KSI FSU, FLUSH HEAD, 450°F	SPECIFICATION SHEET NUMBER MS27577 30 SEP 83 REV F SUPERSEDING MS27577 E 28 AUG 87 AMSC- N/A FSC 5305 (F)
A. Approved for public release, distribution is unlimited.		Page 4 of 4