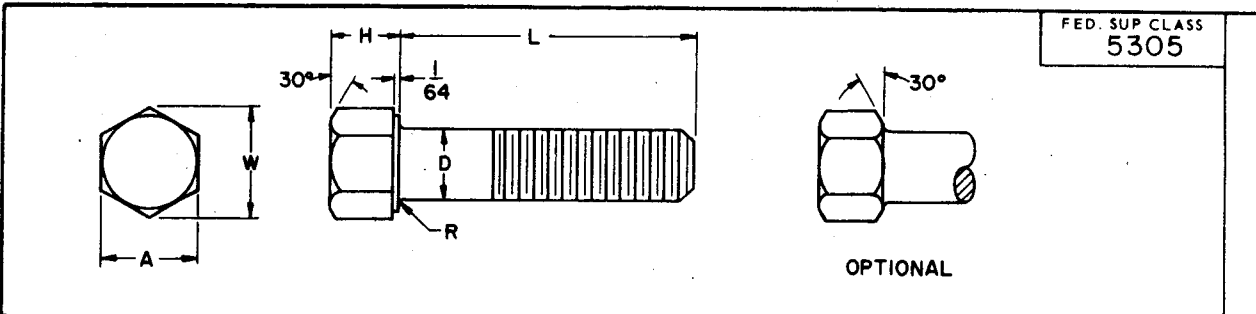


NOTICE.—When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility, nor any obligation whatsoever; and the fact that the Government may have formulated, furnished, or in any way supplied the said drawings, specifications, or other data is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.



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NOMINAL SIZE			1/4	5/16	3/8	7/16	1/2	9/16	5/8
THREADS PER INCH			28UNF	24UNF	24UNF	20UNF	20UNF	18UNF	18UNF
BODY DIAMETER	D	Max Min	.2500 .2450	.3125 .3065	.3750 .3690	.4375 .4305	.5000 .4930	.5625 .5545	.6250 .6170
WIDTH ACROSS FLATS	A	Max Min	.4375 .4280	.5000 .4890	.5625 .5510	.6250 .6120	.7500 .7380	.8125 .7990	.9375 .9220
WIDTH ACROSS CORNERS	W	Max Min	.5050 .4880	.5770 .5570	.6500 .6280	.7220 .6980	.8600 .8400	.9380 .9100	1.0330 1.0510
HEAD HEIGHT	H	Max Min	.1630 .1500	.2110 .1950	.2430 .2260	.2910 .2720	.3230 .3020	.3710 .3480	.4030 .3790
RADIUS	R	Max Min	.023 .009	.023 .009	.023 .009	.023 .009	.023 .009	.041 .021	.041 .021
LENGTH	L	Tolerance	Dash Number	Dash Number	Dash Number	Dash Number	Dash Number	Dash Number	Dash Number
3/8			1	27	53				
7/16			2	28	54	79			
1/2			3	29	55	80	104		
9/16		+0	4	30	56	81	105	130	
5/8		-1/32	5	31	57	82	106	131	155
3/4			6	32	58	83	107	132	156
7/8			7	33	59	84	108	133	157
1			8	34	60	85	109	134	158
1-1/8			9	35	61	86	110	135	159
1-1/4			10	36	62	87	111	136	160
1-3/8		+0	11	37	63	88	112	137	161
1-1/2		-1/16	12	38	64	89	113	138	162
1-3/4			13	39	65	90	114	139	163
2			14	40	66	91	115	140	164
2-1/4			15	41	67	92	116	141	165
2-1/2			16	42	68	93	117	142	166
2-3/4			17	43	69	94	118	143	167
3			18	44	70	95	119	144	168
3-1/4			19	45	71	96	120	145	169
3-1/2		+0	20	46	72	97	121	146	170
3-3/4		-3/32	21	47	73	98	122	147	171
4			22	48	74	99	123	148	172
4-1/4			23	49	75	100	124	149	173
4-1/2			24	50	76	101	125	150	174
4-3/4			25	51	77	102	126	151	175
5			26	52	78	103	127	152	176
5-1/2							128	153	177
6							129	154	178

Ⓐ CANCELLED
SEE SHEET 2

MATERIAL: Low Carbon Steel, Grade 2 of procurement specification. Minimum tensile strength: 60,000 psi for diameters through 1/2"; 64,000 psi for diameters 9/16" through 3/4"; 95,000 psi for diameters over 3/4".

FINISH: Cadmium or Zinc Plated, Specification QQ-P-416, Type II, Class C, or Specification QQ-P-416, Type II, Class 3.

THREADS: The threads shall be in accordance with Screw-Thread Standards for Federal Services Handbook H-23.

MINIMUM THREAD LENGTH: Shall be twice the diameter plus 1/4" for lengths up to and including 6". The tolerance shall be plus 3/16" or 2-1/2 threads, whichever is greater. On products that are too short for minimum thread lengths, the distance from the bearing surface of the head to the first complete thread shall not exceed the length of 2-1/2 threads, for sizes up to and including 1" and 3-1/2 threads for sizes larger than 1".

NOTES: (1) Referenced documents of issue in effect on date of invitation for bids shall apply.
(2) In case of conflict with any referenced document, this standard will govern.
(3) The MS part number consists of the MS sheet number, plus the dash number. Example: MS 35292-1.
(4) All dimensions in inches.

Ⓐ For Changes see Sheets 1 and 2.

REVISED Ⓐ 30 APRIL 63
APPROVED 4 MAR 54

P.A.	WG	TITLE	MILITARY STANDARD
Other Cust	SHIPS ASB	SCREW, CAP, HEXAGON HEAD (FINISHED HEXAGON BOLT), LOW CARBON STEEL, CADMIUM OR ZINC FINISH, UNF-2A	MS35292
PROCUREMENT SPECIFICATION FF-S-85	SUPERSEDES:		SHEET 1 OF 2

FED. SUP CLASS
5305

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NOMINAL SIZE			3/4	7/8	1	1-1/8	1-1/4	1-3/8	1-1/2
THREADS PER INCH			16UNF	14UNF	12UNF	12UNF	12UNF	12UNF	12UNF
BODY DIAMETER	D	Max	.7500	.8750	1.0000	1.1250	1.2500	1.3750	1.5000
		Min	.7410	.8660	0.9900	1.1140	1.2390	1.3630	1.4880
WIDTH ACROSS FLATS	A	Max	1.1250	1.3125	1.5000	1.6875	1.8750	2.0625	2.2500
		Min	1.1000	1.2850	1.4690	1.6310	1.8120	1.9940	2.1750
WIDTH ACROSS CORNERS	W	Max	1.2990	1.5160	1.7320	1.9490	2.1650	2.3820	2.5980
		Min	1.2540	1.4650	1.6750	1.8590	2.0660	2.2730	2.4800
HEAD HEIGHT	H	Max	.4830	.5630	.6270	.7180	.8130	.8780	.9740
		Min	.4550	.5310	.5910	.6580	.7490	.8100	.9020
RADIUS	R	Max	.041	.062	.093	.093	.093	.093	.093
		Min	.021	.041	.062	.062	.062	.062	.062
LENGTH	L	TOLERANCE		Dash Number	Dash Number	Dash Number	Dash Number	Dash Number	Dash Number
		Size 3/4 and under	Size 7/8 and over						
3/4	1	+0	+0	179					
		-1/32	-1/16	180					
1-1/8	1			181	202				
				182	203	224			
1-1/4	1			183	204	225	245		
				184	205	226	246	265	
1-3/8	1	+0	+0	184	206	227	247	266	284
		-1/16	-1/8						
1-1/2	2			185	207	228	248	267	285
				186	208	229	249	268	286
1-3/4	2			187	209	230	250	269	287
				188	210	231	251	270	288
2-1/4	2			189	211	232	252	271	289
				190	212	233	253	272	290
2-1/2	2			191	213	234	254	273	291
				192	214	235	255	274	292
2-3/4	2			193	215	236	256	275	293
				194	216	237	257	276	294
3	3	+0	+0	195	217	238	258	277	295
		-3/32	-3/16	196	218	239	259	278	296
3-1/4	3			197	219	240	260	279	297
				198	220	241	261	280	298
3-1/2	3			199	221	242	262	281	299
				200	222	243	263	282	300
3-3/4	3			201	223	244	264	283	301
4-1/4	4			197	219	240	260	279	297
				198	220	241	261	280	298
4-1/2	4			199	221	242	262	281	299
				200	222	243	263	282	300
4-3/4	4			201	223	244	264	283	301
5	5			199	221	242	262	281	299
				200	222	243	263	282	300
5-1/2	5			201	223	244	264	283	301

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

Ⓐ CANCELLED AFTER 30 April 1963. USE MS90726. INTERCHANGEABILITY RELATIONSHIP - MS90726 can replace the cancelled screws of the same size. The cancelled MS35292 cannot always replace MS90726 and should be used until existing stock is depleted. Then use only the superseding MS screws of the same size for design and replacement.

Ⓐ CANCELLED
SEE NOTE

REVISED Ⓐ FOR CHANGES SEE SHEETS 1 AND 2.
APPROVED 4 MAR 54

This military standard is approved by the Department of Defense and is mandatory on all activities. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

P.A.	WC	TITLE	MILITARY STANDARD
Other Cust	SHIPS ASD	SCREW, CAP, HEXAGON HEAD (FINISHED HEXAGON BOLT), LOW CARBON STEEL, CADMIUM OR ZINC FINISH, UNF-2A	35292
PROCUREMENT SPECIFICATION FF-S-85	SUPERSEDES:		SHEET 2 OF