FSC MAP CLASS 5305

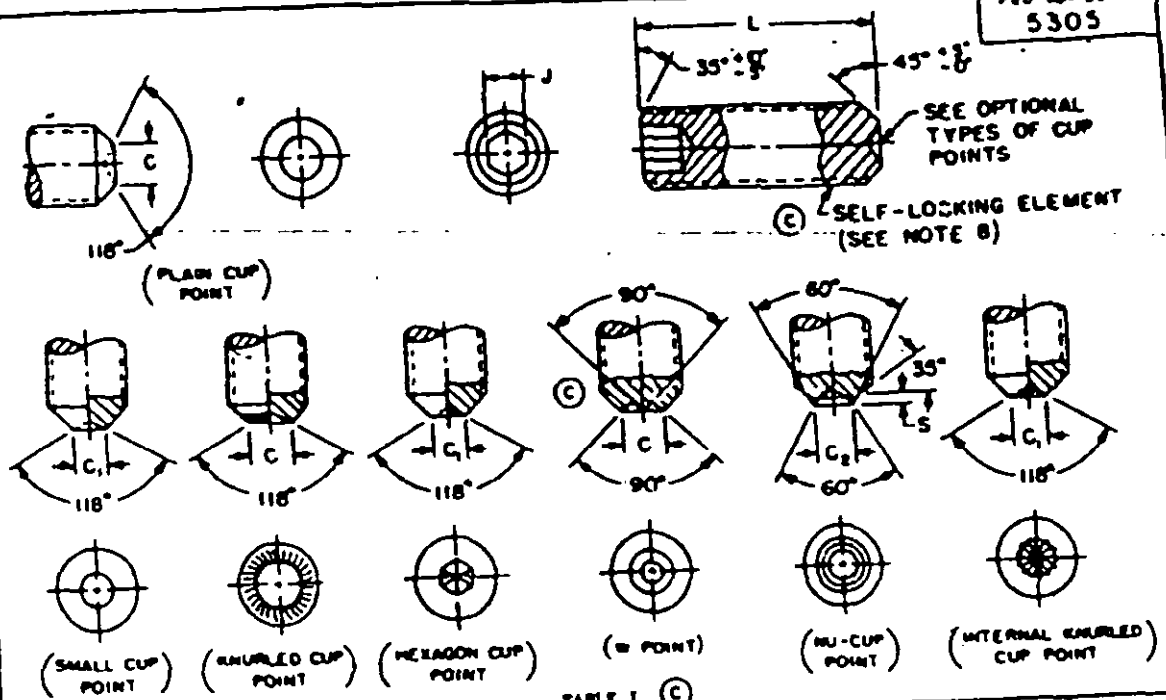

TABLE I (C)

NOMINAL SIZE		.060	.086	.112	.138	.164	.190	.250	.3125	.375	.500
THREADS PER INCH (UNF-3A)		80	64	48	40	36	32	28	24	24	20
J SOCKET WIDTH ACROSS FLATS	NOM	.028	.035	.050	.062	.078	.094	.125	.156	.188	.250
C POINT DIAMETER	MAX	.031	.047	.061	.074	.087	.102	.132	.172	.212	.291
	MIN	.027	.039	.051	.064	.076	.088	.118	.156	.192	.270
C_1 POINT DIAMETER	MAX	.032	.043	.056	.069	.082	.095	.125	.156	.187	.250
	MIN	.027	.038	.051	.063	.074	.086	.114	.144	.174	.235
C_2 POINT DIAMETER	MAX	.027	.043	.059	.074	.090	.101	.156	.190	.241	.333
	MIN	.022	.038	.054	.068	.084	.095	.150	.185	.236	.328
S POINT LENGTH	MAX	.007	.010	.013	.017	.021	.024	.027	.038	.041	.054
	MIN	.004	.007	.008	.012	.016	.019	.022	.033	.036	.049

L LENGTH	TOL	DASH NUMBER														
		PLAIN	PLAIN	PLAIN	PLAIN	PLAIN	PLAIN	SELF LOCK	PLAIN	SELF LOCK	PLAIN	SELF LOCK	PLAIN	SELF LOCK	PLAIN	SELF LOCK
.125	±.010	1	9	18	27		48	101*		112						
.188		2	10	19	28		49	102	60	113	72°	125				
.250		3	11	20	29	38	50	103	61	114	73	126	83°			
.312			12	21	30	39	51	104	62	115	74	127	84	137	93	147
.375					31	40		105	63							
.438								106		116						
.500					32	41	52	107	64	117	75	128	85	138	94	148
.562								108		118						
.625						42	53	109	65	119	76	129	86°	139	95°	149
.750	±.020						54	110	66	120	77°	130	87°	140	96°	150
.875								111		121		131		141		151
1.000										122		132		142		152
1.250										123		133		143		153
1.500										124		134		144		154
1.750												135		145		155
2.000												136		146		156
2.500	±.031															157
3.000																158

* Inactive for new design after 29 DEC 1972

(C) For changes see sheets 1 and 2.

(C)

P.A. VC
Other Cont 82

TITLE: SETSCREW-HEXAGON SOCKET, CUP POINT, CORROSION-RESISTING STEEL, PASSIVATED, UNF-3A, PLAIN AND SELF-LOCKING (C)

MILITARY STANDARD

MS 51023

SHEET 1 OF 3

PROCUREMENT SPECIFICATION: FF-S-200

SUPERSEDES: MS51024, AGCII3.1 and in part MS18064 and AGCII1.2

DD FORM 672-1

REVISED (A) 29 JAN 1964 (B) 28 NOV 1967 (C) 29 DEC 1972

APPROVED 7 MAY 1958

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.

FSC CLASS
5305

NOTES

1. MATERIAL: Corrosion-Resisting Steel, 300 Series, in accordance with procurement specification.
2. PROTECTIVE COATING: Passivated in accordance with QQ-P-35.
3. THREADS The threads shall be in accordance with MIL-S-7742.
4. MAGNETIC PERMEABILITY. These setscrews have a magnetic permeability of 2.0 max (air = 1.0) for a field strength of H = 200 oersteds, when using a magnetic indicator per MIL-I-17214.
5. DIMENSIONS: All dimensions are in inches, unless otherwise specified.
6. TOLERANCES: Angles ±5°, unless otherwise specified.
7. PART NUMBER: The MS part number consists of the MS number, plus the dash number. Example: MS51023-1.
8. SELF-LOCKING ELEMENT:
   (a) The self-locking element shall be in accordance with MIL-F-18240.
   Ⓒ (b) For design and usage limitations, see MS15981.
   (c) Location of effective locking area shall be in accordance with MS15981.
   (d) Maximum ring gage diameter that locking region of setscrew must pass thru freely or with finger pressure shall be the nominal size plus 0.010.
   (e) MIL-F-18240 doesn't establish torque requirements for lengths above the dashed line. Only a positive indication of torque is required.
9. Referenced documents shall be of the issue in effect on date of invitations for bid.
10. For design feature purposes, this standard takes precedence over procurement documents referenced herein.

INTERCHANGEABILITY

Screws covered by the dash numbers given in MS51024 are cancelled after 29 January 1964 and superseded by the screws covered on MS51023 having the same dash numbers. Cancelled screws may be used until existing stocks are depleted. Use only MS51023 screws for new design.

Screws covered by the dash numbers given in MS18064 in part are cancelled. Cancelled screws may be used until existing stocks are depleted. Use only the superseding screws for new design. Replacement shall be in accordance with Table II.

Ⓒ TABLE II

CANCELLED	SUPERSEDING	CANCELLED	SUPERSEDING	CANCELLED	SUPERSEDING	CANCELLED	SUPERSEDING
MS18064	MS51023	MS18064	MS51023	MS18064	MS51023	MS18064	MS51023
DASH NUMBER		DASH NUMBER		DASH NUMBER		DASH NUMBER	
4	101	12	116	64	131	82	145
8	102	17	117	70	132	85	146
13	103	45	118	74	133	92	147
19	104	50	119	78	134	40	148
25	105	57	120	81	135	53	149
31	106	63	121	84	136	60	150
36	107	69	122	91	137	66	151
44	108	73	123	39	138	72	152
49	109	77	124	52	139	76	153
56	110	15	125	59	140	80	154
68	111	21	126	65	141	83	155
9	112	27	127	71	142	86	156
14	113	38	128	75	143	87	157
20	114	51	129	79	144	88	158
26	115	55	130				

APPROVED 7 MAY 1958 REVISED Ⓐ 29 JAN 1964 Ⓑ 20 NOV 1967 Ⓒ FOR CHANGES SEE SHEETS 1 AND 2.

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.

MILITARY CUSTODIANS: Army, AV, EL, ...; Navy, ...; Air Force, ...

P.A.	TITLE	MILITARY STANDARD
Other Cust. 82	SETSCREW-HEXAGON SOCKET, CUP POINT, CORROSION-RESISTING STEEL, PASSIVATED, UNF-3A, PLAIN AND SELF-LOCKING Ⓒ	MS51023
PROCUREMENT SPECIFICATION FF-S-200	SUPERSEDES: MS51024, BCU13.1 and in part MS18064 and BCT11.2	SHEET 2 OF 2

DD FORM 672-1 (Continued)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

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