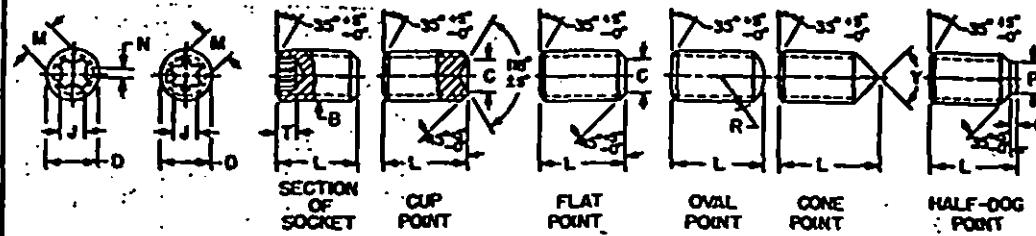


FED. SUP CLASS
5305

B NOMINAL DIAMETER		#2 (.066)	#4 (.112)	#6 (.138)
B THREADS PER INCH		56XC-3A	40XC-3A	32XC-3A
C CUP AND FLAT POINT DIAMETER	MAX	.047	.061	.074
	MIN	.049	.051	.064
R: OVAL POINT RADII'S		.0025	.004	.004
T CONE POINT ANGLE	118° ± 2° FOR THESE LENGTHS AND UNDER	1/32	1/5	1/5
	90° ± 2° FOR THESE LENGTHS AND OVER	7/64	1/32	1/16
P HALF DOG DIAMETER	MAX	.037	.075	.082
	MIN	.031	.070	.067
Q POINT LENGTH		.022	.025	.031
J SOCKET DIAMETER MINOR	MAX	.015	.031	.036
	MIN	.0175	.030	.035
K SOCKET DIAMETER MAJOR	MAX	.050	.062	.070
	MIN	.049	.061	.070
X SOCKET LAND AND WIDTH	MAX	.017	.014	.021
	MIN	.016	.013	.022
NUMBER OF FLUTES		3	6	4
F KEY ENGAGEMENT MIN		.025	.040	.050

KEY ENGAGEMENT: These dimensions apply to screws one diameter in length or longer. For screws shorter than one diameter in length, socket to be as deep as practicable.

MATERIAL: Steel, high-grade alloy, in accordance with procurement specification.

HARDNESS: Setscrews shall be hardened by heat treatment to a hardness of Rockwell C45 to 51.

PROTECTIVE COATING: Cadmium plated, in accordance with Specification QQ-P-416, Type II, Class 1.

THREADS: The threads shall be in accordance with Screw-Thread Standards for Federal Services Handbook H-25.

DIMENSIONS: All dimensions are in inches unless otherwise specified.

PART NUMBER: The MS part number consists of the MS number, plus the dash number. Example: MS51053-101.

NOTES: (1) Referenced documents shall be of the issue in effect on date of invitation for bid.

(2) This standard takes precedence over documents referenced herein.

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.

Ⓐ **CANCELLED/INACTIVE** AS OF 10 SEP 1969
SUPERSEDED IN PART BY MS51963, MS51965, MS51973, MS51977
AND MS51981 - SEE SHEET 2.

Ⓐ FOR CHANGES SEE SHEETS 1 AND 2.

P.A. 10 Other Code 5M 10	TITLE SETSCREW, FLUTED SOCKET, ALLOY STEEL, CADMIUM PLATED, NC-3A	MILITARY STANDARD	
		MS51053	
PROCUREMENT SPECIFICATION FF-3-2A	SUPERSEDES	SHEET 1 OF 2	

DD FORM 672-1 (Continued)

PREPARE DURING THE YEAR AND MONTH OF

APPROVED 7 MAY 1958 REVISED Ⓐ 10 SEP 1969

FED. SUP CLASS 5305										
		CUP POINT			FLAT POINT			CORR POINT		
		#2 56RC	#4 40RC	#6 32RC	#2 56RC	#4 40RC	#6 32RC	#2 56RC	#4 40RC	#6 32RC
LENGTH	TOLERANCE	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.
1/16		101	111		201	211		301	311	
1/8		102	112*	126	202	212	226	302	312	326
3/16		103	113	127	203	213	227	303	313	327
1/4		104	114	128	204	214	228	304	314	328
5/16	± 1-1/2% of length with a minimum of .010 in.	105	115	129	205	215	229	305	315	329
3/8			116	130		216	230		316	330
7/16			117	131		217	231		317	331
1/2			118	132		218	232		318	332
9/16			119	133		219	233		319	333
5/8			120	134		220	234		320	334
3/4				135			235			335
7/8				136			236			336

		OVAL POINT			HALF-DOC POINT		
		#2 56RC	#4 40RC	#6 32RC	#2 56RC	#4 40RC	#6 32RC
LENGTH	TOLERANCE	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.
1/16		401	411		501	511	
1/8		402	412	426	502	512	526
3/16		403	413	427	503	513	527
1/4		404	414	428	504	514	528
5/16	± 1-1/2% of length with a minimum of .010 in.	405	415	429	505	515	529
3/8			416	430		516	530
7/16			417	431		517	531
1/2			418	432		518	532
9/16			419	433		519	533
5/8			420	434		520	534
3/4				435			535
7/8				436			536

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

Ⓐ Cancelled Dash Numbers 101 thru 111 and 113 thru 136 are superseded in part by MSS1963.

Cancelled Dash Numbers 201 thru 236 are superseded in part by MSS1965.

Cancelled Dash Numbers 301 thru 336 are superseded in part by MSS1973.

Cancelled Dash Numbers 401 thru 436 are superseded in part by MSS1981.

Cancelled Dash Numbers 501 thru 536 are superseded in part by MSS1977.

* Dash Number 112 is inactive and not to be used for new design.

This military standard is mandatory for use by all Departments and Agencies of the Department of Defense. Solicitation for all new engineering and design applications and for repetitive use shall be made from this document.

P.A. NC Other Conf. 22	TITLE SETSCREW, FLUTED SOCKET, ALLOY STEEL, CADMIUM PLATED, NC-3A	MILITARY STANDARD MS51053
PROCUREMENT SPECIFICATION TY-3-200	SUPERSEDED	SHEET 2 OF

DD FORM 672-1 (Continued)

Replaces Form 672-1, 1-64, and 1-65.

☆ U. S. GOVERNMENT PRINTING OFFICE: 1963-393-065/3-2000

APPROVED 7 MAY 1950 REVISED Ⓐ FOR CHANGES SEE SHEETS 1 AND 2.