

**USER ACTIVITIES**  
**NAVY - MC**

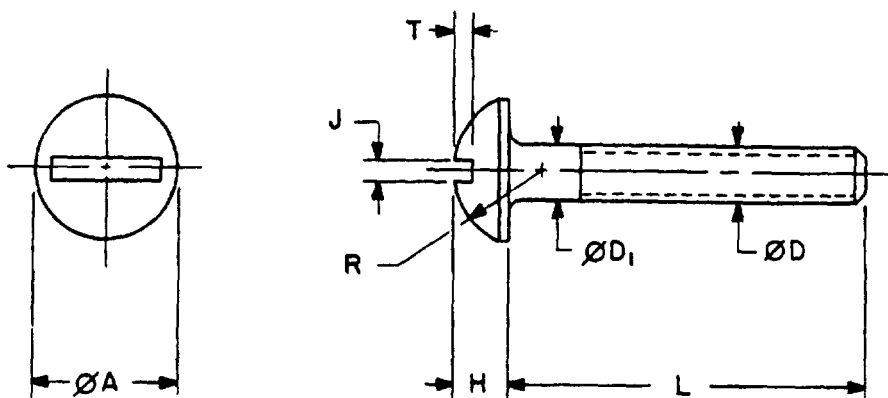


TABLE 1. DASH NUMBERS AND DIMENSIONS

Ø D NOMINAL SIZE		86 .1380	98 .1640					110 .1900	
THREADS PER INCH		32 UNC-2A	32 UNC-2A					32 UNF-2A	
Ø D <sub>2</sub> BODY	MAX MIN	.1380 .1141	.1640 .1399	.1640 .1399	.1640 .1399	.1640 .1399	.1640 .1399	.1900 .1658	.1900 .1658
Ø A HEAD	MAX MIN	.321 .303	.384 .364	.384 .364	.406 .386	.422 .408	.384 .364	.448 .425	.448 .425
H HEAD HEIGHT	MAX MIN	.086 .076	.102 .092	.085 .075	.081 .071	.085 .075	.102 .092	.118 .103	.125 .110
R HEAD RADIUS	MAX	.254	.254	.254	.346	.254	.254	.283	.283
J SLOT WIDTH	MAX MIN	.048 .039	.054 .045	.054 .045	.054 .045	.054 .045	.054 .045	.060 .050	.060 .050
T SLOT DEPTH	MAX MIN	.050 .037	.050 .037	.040 .027	.040 .027	.050 .037	.058 .045	.068 .053	.068 .053
L LENGTH	TOLERANCE	DASH NUMBER	DASH NUMBER	DASH NUMBER	DASH NUMBER	DASH NUMBER	DASH NUMBER	DASH NUMBER	DASH NUMBER
.125			2						
.140			6		3				
.156			7						
.172			8						
.187			9			10			
.218			11						
.234				12					
.250			13					4	
.281	+0		14						
.296	-.031			15					
.312			16			17			
.344			18						
.375		1	19						
.406			20						
.438			21						
.500			22						5
.562			23						
.625							24		

(A) ENTIRE STANDARD REVISED

P A <b>ARMY - AR</b> <small>Other Cust</small> <b>NAVY - EC</b>	INTERNATIONAL INTEREST	TITLE  SCREW, MACHINE, BOOM SUPPORT ASSEMBLY	<b>MILITARY STANDARD</b>  <b>MS51475</b>
PROCUREMENT SPECIFICATION FF-S-92	SUPERSEDES	PAGE 1 OF 2	

APPROVED 10 JUN 83 REVISED (A) 27 SEPT 88

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AMSC N/A

DD FORM 672-1 COORDINATED

PREVIOUS EDITIONS: 17-51000-1 (2005)

5305-1703

FED SUP CLASS  
5305

## REQUIREMENTS:

1. MATERIAL: STEEL, CORROSION RESISTANT, TYPE 300 SERIES, IN ACCORDANCE WITH PROCUREMENT SPECIFICATION BRASS, IN ACCORDANCE WITH QQ-B-613, QQ-B-626, OR QQ-W-321.
2. CLEANED, DESCALED AND PASSIVATED: CORROSION RESISTANT STEEL SCREWS SHALL BE CLEANED, DESCALED, AND PASSIVATED IN ACCORDANCE WITH QQ-P-35, TYP. I.
3. PROTECTIVE COATING AND SURFACE TREATMENT: WHEN REQUIRED, CORROSION RESISTANT STEEL SCREWS SHALL BE BLACK OXIDE COATED IN ACCORDANCE WITH PROCUREMENT SPECIFICATION. BRASS SCREWS SHALL HAVE BLACK CHEMICAL FINISH IN ACCORDANCE WITH MIL-P-495, NICKEL PLATING IN ACCORDANCE WITH QQ-N-290, GRADE E, OR NO PROTECTIVE COATING
4. MAGNETIC PERMEABILITY: CORROSION RESISTANT STEEL SCREWS SHALL MEET THE MAGNETIC PERMEABILITY REQUIREMENTS OF THE PROCUREMENT SPECIFICATION.
5. THREADS: THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/2. ACCEPTABILITY OF SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/20, SYSTEM 21.
6. THREAD LENGTH: SCREWS SHALL BE THREADED TO WITHIN A DISTANCE OF NOT LESS THAN TWO THREADS OF THE BEARING SURFACE OF THE HEAD.
7. PART NUMBER: THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER TAKEN FROM TABLE I, FOLLOWED BY A MATERIAL CODE LETTER AND A FINISH CODE LETTER IF APPLICABLE

EXAMPLE: MS51475-4B

## FINISH CODE:

FOR CORROSION RESISTANT STEEL: "B" BLACK OXIDE COATING  
NO CODE - CLEANED, DESCALED AND PASSIVATED

## FOR BRASS:

"C" - BLACK CHEMICAL FINISH

"N" - NICKEL PLATING

NO CODE - NO PROTECTIVE COATING OR SURFACE TREATMENT

## DASH NUMBER

## MATERIAL CODE:

"S" - CORROSION-RESISTANT STEEL

"B" - BRASS

## BASIC MS NUMBER

MS51475-4B INDICATES - SCREW, MACHINE, BOOM SUPPORT ASSEMBLY, .1900-32 UNF-2A; .250 LENGTH, CORROSION RESISTANT STEEL

MS51475B4 INDICATES - SCREW, MACHINE, BOOM SUPPORT ASSEMBLY; .1900-32 UNF-2A, .250 LENGTH, BRASS; NO PROTECTIVE COATING OR SURFACE TREATMENT

## NOTES:

1. ALL DIMENSIONS ARE IN INCHES.
2. 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.
3. 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.

P A ARMY - AR Other Cust NAVY - EC	INTERNATIONAL INTEREST	TITLE  SCREW, MACHINE, BOOM SUPPORT ASSEMBLY	MILITARY STANDARD
			MS51475
PROCUREMENT SPECIFICATION FF-S-92	SUPERSEDES	PAGE 2	OF 2

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5305-1703

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NAVY - MCREVIEWER ACTIVITIES  
ARMY - CR  
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FOR CHANGES SEE PAGES

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