

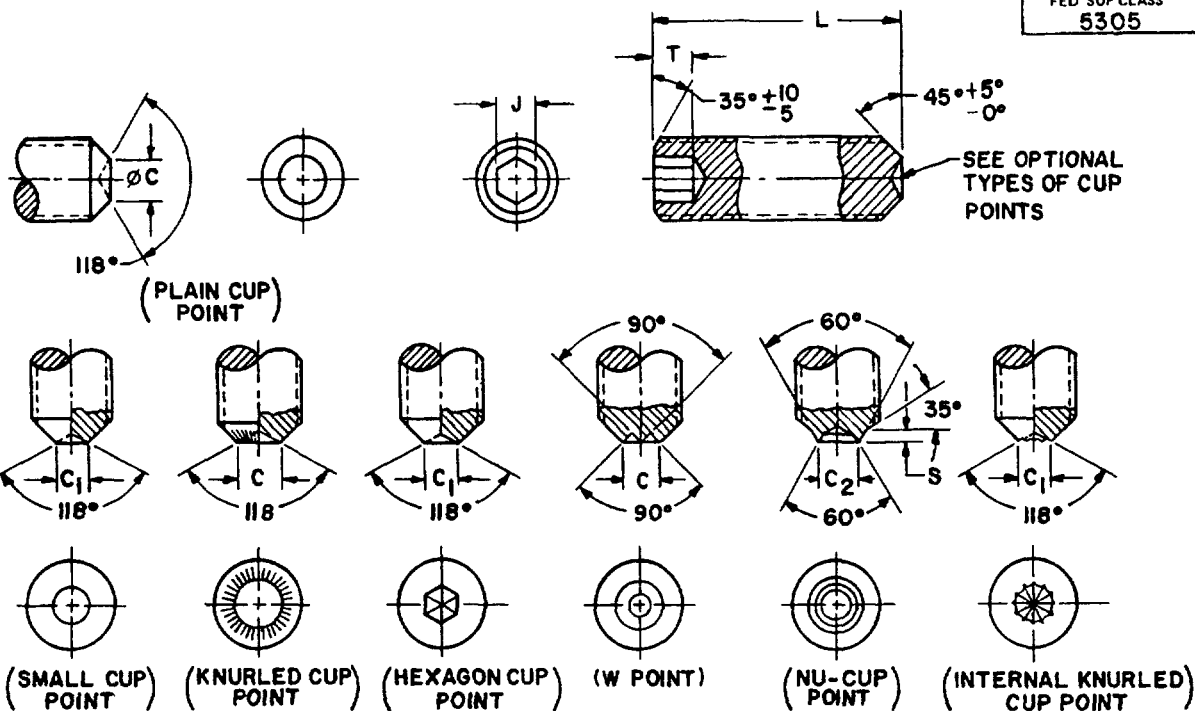
FED SUP CLASS
5305

TABLE I. DIMENSIONS AND PART NUMBERS

NOMINAL SIZE		.190	.250	.3125	.375
THREADS PER INCH UNF - 3A		32	28	24	24
J - SOCKET WIDTH ACROSS FLATS	NOM	.094	.125	.156	.188
Ø C - POINT DIAMETER	MAX MIN	.102 .088	.132 .118	.172 .156	.212 .194
Ø C ₁ - POINT DIAMETER	MAX MIN	.095 .086	.125 .114	.156 .144	.187 .174
Ø C ₂ - POINT DIAMETER	MAX MIN	.101 .095	.156 .150	.190 .185	.241 .236
T - KEY ENGAGEMENT	MIN	.100	.125	.156	.188
S - POINT LENGTH	MAX MIN	.024 .019	.027 .022	.038 .033	.041 .036
L - LENGTH	TOLERANCE	DASH NO	DASH NO	DASH NO	DASH NO
250 375 500	±.010	1 2	3 4	5	6

USER ACTIVITIES
ARMY-ME,MI
NAVY-MC,OSREVIEWER ACTIVITIES
ARMY-EA
AIR FORCE-82
DLA-IS
NSA-NSThis military standard is approved 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 when applicable

PA	AR	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
Other Cust	SH		SETSCREW, HEXAGON SOCKET, CUP POINT, ALLOY STEEL, UNF - 3A	MS51477
99				
PROCUREMENT SPECIFICATION	SUPERSEDES	PAGE	OF	
FF-S-200		1	2	

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REQUIREMENTS:

1. MATERIAL. ALLOY STEEL IN ACCORDANCE WITH PROCUREMENT SPECIFICATION
2. HARDNESS. 45-53HRC
3. FINISH. ZINC COATING IN ACCORDANCE WITH ASTM B633-78, Fe/Zn 5 (5 μ m), TYPE II
4. THREADS. THE 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
5. PART NUMBER. THE BASIC PART NUMBER IS FOLLOWED BY A DASH NUMBER FROM TABLE I

EXAMPLE. MS51477-1 - SETSCREW, HEXAGON SOCKET, CUP POINT, ALLOY STEEL, 190-32UNF-3A, LENGTH .250, ZINC COATED

NOTES:

1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCE OF ANGLES $\pm 5^\circ$ UNLESS OTHERWISE SPECIFIED.
3. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BIDS OR REQUEST FOR PROPOSAL, EXCEPT THAT REFERENCED ADOPTED INDUSTRY DOCUMENTS SHALL GIVE THE DATE OF THE ISSUE ADOPTED
4. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN

USER ACTIVITIES
ARMY - ME, MI
NAVY - MC, OS

REVIEWER ACTIVITIES:
ARMY - E, A
AIR FORCE - 82
DLA - IS
NSA - NS

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APPROVED 1 AUG 84
REVISED

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Other Cust	SH 99		SETSCREW, HEXAGON SOCKET, CUP POINT, ALLOY STEEL, UNF-3A	MS51477
PROCUREMENT SPECIFICATION FF-S-200		SUPERSEDES		PAGE 2 OF 2

DD FORM 1 MAY 73 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5305-1483