



FULL HEAD

TABLE I DIMENSIONS AND PART NUMBERS

NOMINAL SIZE		190
THREADS PER INCH UNF - 2A		32
ØD - BODY DIAMETER	MAX MIN	1900 1658
ØA - HEAD DIA	MAX SHARP APS MIN	.3850 .3400
H - HEAD HEIGHT	RFP	.1160
R - RADIUS	MAX	.0760
MINIMUM TENSILE LOAD - LBS		1,200
L - LENGTH	TOLERANCE	DASH NO
500	+ .000 - .031	1
1.250	+ .000 - .062	2
1.500		3

REQUIREMENTS

- MATERIAL.** CARBON STEEL IN ACCORDANCE WITH ASTM A29-79 GRADE 1015 (UNS G10150) THRU GRADE 1030 (UNS G10300) OR ASTM A29-79 GRADE 1116 (UNS G11160) THRU GRADE 1132 (UNS G11320). THE MINIMUM ULTIMATE TENSILE STRENGTH SHALL BE 60,000 PSI.
- FINISH.** ZINC COATING IN ACCORDANCE WITH ASTM B633-78, Fe/Zn 5 (5 µm), TYPE II.
- 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 2.
- THREAD LENGTH.** SCREWS 2.000 INCHES LONG AND SHORTER SHALL HAVE COMPLETE THREADS EXTENDING TO WITHIN 2 THREADS OF THE HEAD, OR CLOSER IF PRACTICABLE. THREADS SHALL NOT EXTEND TO THE FILLET RADIUS NOR SHALL THREADS EXTEND TO AND UNDERCUT THE HEAD OF THE SCREW.
- RECESS.** THE RECESS SHALL BE IN ACCORDANCE WITH MS9006.
- PART NUMBER.** THE BASIC PART NUMBER IS FOLLOWED BY A DASH NUMBER FROM TABLE I.

EXAMPLE MS51479-1 - SCREW, MACHINE, 82° FLAT COUNTERSUNK HEAD, CROSS-RECESSED, CARBON STEEL, .190-32UNF-2A, LENGTH 500, ZINC COATED

NOTES:

- ALL DIMENSIONS ARE IN INCHES.
- REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BIDS OR REQUEST FOR PROPOSAL, EXCEPT THAT REFERENCED ADOPTED INDUSTRY DOCUMENTS SHALL GIVE THE DATE OF THE ISSUE ADOPTED.
- FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.

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PROCUREMENT SPECIFICATION FF-S-92			SUPERSEDES	PAGE 1 OF 1

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

REVIEWER ACTIVITIES
ARMY-EA, GL
AIR FORCE-B2
DLA-IS
NSA-NS

This 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

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APPROVED 1 AUG 84