



FULL HEAD

TABLE I DIMENSIONS AND PART NUMBERS.

NOMINAL SIZE		.138	.164	.190	.250	.3125	.375
THREADS PER INCH UNC-2A		32	32	24	20	18	16
Ø D - BODY DIAMETER	MAX MIN	.1380 .1141	.1640 .1399	.1900 .1586	.2500 .2127	.3125 .2712	.3750 .3287
Ø A - HEAD DIAMETER	MAX SHARP ABS MIN	.2790 .2440	.3320 .2920	.3850 3400	.5070 .4520	.6350 .5680	.7620 .6850
H - HEAD HEIGHT	REF	.0830	.1000	.1160	.1530	.1910	.2300
R - RADIUS	MAX	.055	.0660	.0760	.1000	.1250	.1500
MINIMUM TENSILE LOAD - LBS		545	8400	1,050	1,900	3,140	4,650
L - LENGTH	TOLERANCE	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO
.250 .375 .500 .750 .875 1.000	+ .000 - .031	01 02 03 04 05	06 07 08	09 10 11	12 13 14 15 16	17 18	19 20
1.250 1.500 2.750	+ .000 - .062 + .000 - .094						

USER ACTIVITIES
ARMY-ME,MI
NAVY-OSREVIEWER ACTIVITIES
ARMY-AVEA,MA
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 Other Cust	AR SH 99	INTERNATIONAL INTEREST	TITLE SCREW, MACHINE, 82° FLAT COUNTERSUNK HEAD, CROSS-RECESSED, CARBON STEEL, UNC-2A	MILITARY STANDARD MS51481
PROCUREMENT SPECIFICATION FF-S-92			SUPERSEDES	PAGE 1 OF 2

FED SUP CLASS
5305USER ACTIVITIES
ARMY-ME, MI
NAVY-OS, MCREVIEWER ACTIVITIES
ARMY-AV, EA, MA
AIR FORCE-82
DLA-IS
NSA-NS

REQUIREMENTS:

1. 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.
2. FINISH. ZINC COATING IN ACCORDANCE WITH ASTM B633-78, Fe/Zn 5 (5 μ m), TYPE II.
3. 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.
4. 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. LONGER SCREWS SHALL HAVE A MINIMUM THREAD LENGTH OF 1.500 INCHES. THREADS SHALL NOT EXTEND TO THE FILLET RADIUS NOR SHALL THREADS EXTEND TO AND UNDERCUT THE HEAD OF THE SCREW.
5. RECESS. THE RECESS SHALL BE IN ACCORDANCE WITH MS9006.
6. PART NUMBER. THE BASIC MS PART NUMBER IS FOLLOWED BY A DASH NUMBER FROM TABLE I

EXAMPLE: MS51481-01 - SCREW, MACHINE, 82° FLAT COUNTERSUNK HEAD, CROSS-RECESSED, CARBON STEEL, .138-32UNC-2A, LENGTH .250, ZINC COATED

NOTES:

1. ALL DIMENSIONS ARE IN INCHES.
2. 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
3. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN

APPROVED | AUG 84 | REVISED

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DD FORM 1 MAY 73 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5305-1489

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