



TABLE I. DIMENSIONS AND PART NUMBERS.

NOMINAL SIZE		.250
THREADS PER INCH UNC - 3A		20
J - SOCKET WIDTH ACROSS FLATS	NOM	.125
Y - CONE POINT ANGLE 118° +2° FOR LENGTH UNDER 90° +2° FOR THIS LENGTH AND OVER		.312
T - KEY ENGAGEMENT	MIN	.125
L - LENGTH		DASH NO
250 +010		1
375 +010		2
500 +010		3

REQUIREMENTS

- MATERIAL.** ALLOY STEEL IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.
- HARDNESS.** 45-53HRC
- FINISH.** ZINC COATING IN ACCORDANCE WITH ASTM B633-78, Fe/Zn 5 (5 μ m), TYPE II.
- THREADS.** THE THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H2B/2. ACCEPTABILITY OF SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H2B/20, SYSTEM 21.
- PART NUMBER.** THE BASIC MS PART NUMBER IS FOLLOWED BY A DASH NUMBER FROM TABLE I

EXAMPLE MS51482-1 - SETSCREW, HEXAGON SOCKET, CONE POINT, ALLOY STEEL, .250-20UNC-3A, LENGTH .250, 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.

PA Other Cust	AR SH 99	INTERNATIONAL INTEREST	TITLE SETSCREW, HEXAGON SOCKET, CONE POINT, ALLOY STEEL, UNC-3A	MILITARY STANDARD
PROCUREMENT SPECIFICATION FF-S-200			SUPERSEDES	MS51482
			PAGE	OF

USER ACTIVITIES
ARMY-AV, ME, MIREVIEWER ACTIVITIES
ARMY-AV, CR, EA
AIR FORCE -82
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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