



TABLE I DIMENSIONS AND PART NUMBERS.

NOMINAL SIZE - - - - -		.112	.138	.164	190	250
THREADS PER INCH UNC-2A - - - - -		40	32	32	24	20
ØD - BODY DIAMETER - - - - -	MAX MIN	.1120 .0925	.1380 .1141	.1640 .1399	.1900 .1586	.2500 .2127
ØA - HEAD DIAMETER - - - - -	MAX MIN	.1830 .1660	.2260 .2080	.2700 .2500	.313 .292	.414 .389
H - HEAD SIZE HEIGHT - - - - -	MAX MIN	.0790 .0720	.0960 .0890	.1130 .1060	.130 .123	.170 .161
O - TOTAL HEAD HEIGHT - - - - -	MAX MIN	.1070 .0940	.1320 .1180	.1560 .1410	.180 .165	.237 .219
J - SLOT WIDTH - - - - -	MAX MIN	.0390 .0310	.0480 .0390	.0540 .0450	.060 .050	.075 .064
T - SLOT DEPTH - - - - -	MAX MIN	.0380 .0300	.0450 .0350	.0650 .0540	.075 .064	.102 .087
E - DRILL LOCATION - - -	NOM	.0350	.0430	.0430	.043	.062
ØF - DRILLED HOLE DIAMETER - - - - -	NOM	.0370	.0460	.0460	.046	.062
R - RADIUS - - - - -	MAX	.0170	.0210	.0250	.028	.038
TENSILE LOAD, LBS - MIN		362	545	840	1,050	1,908
L - LENGTH		DASH NO	DASH NO	DASH NO	DASH NO	DASH NO
.375 +.000 -.031		1	2	3		
1.500 +.000 -.062				4	5	6

P A	AR	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
Other Cust	SH 99		SCREW, MACHINE, DRILLED FILLISTER HEAD, SLOTTED, CARBON STEEL, UNC-2A	MS51483
PROCUREMENT SPECIFICATION FF-S-92		SUPERSEDES		PAGE 1 OF 2

USER ACTIVITIES
ARMY-ME
NAVY-OSREVIEWER ACTIVITIES
ARMY-AV, CR, 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 applicableREVISED
APPROVED 1 AUG 1984

FED SUP CLASS
5305

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 COATED IN ACCORDANCE WITH ASTM B633-78, Fe/Zn 5 (5 μ m), TYPE II.
3. 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.
4. THREAD LENGTH. FULL FORM THREADS SHALL EXTEND TO WITHIN 2 THREADS OR LESS OF HEAD BEARING SURFACE FOR LENGTHS THRU 2.00 INCHES. LONGER LENGTHS SHALL HAVE A MINIMUM FULL FORM THREAD LENGTH OF 1.500 INCHES. THREADS SHALL NOT EXTEND TO THE R RADIUS DIMENSION NOR SHALL THREADS EXTEND TO AND UNDERCUT THE HEAD OF THE SCREW.
5. PART NUMBER. THE BASIC MS PART NUMBER IS FOLLOWED BY A DASH NUMBER FROM TABLE I.

EXAMPLE: MS51483-1 - SCREW, MACHINE, DRILLED FILLISTER HEAD, SLOTTED, CARBON STEEL,
112-40UNC-2A, LENGTH .375, ZINC COATED

NOTES:

1. ALL DIMENSIONS ARE IN INCHES.
2. THE DRILLED HOLE SHALL BE APPROXIMATELY AT A RIGHT ANGLE TO THE SLOT AND MAY BE PERMITTED TO BREAK THROUGH THE BOTTOM OF THE SLOT. ALL BURRS AND SHARP EDGES SHALL BE REMOVED.
3. 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.
4. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.

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ARMY-ME
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PROCUREMENT SPECIFICATION FF-S-92		SUPERSEDES		PAGE 2 OF 2

DD FORM 1 MAY 73 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

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