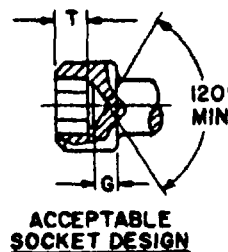
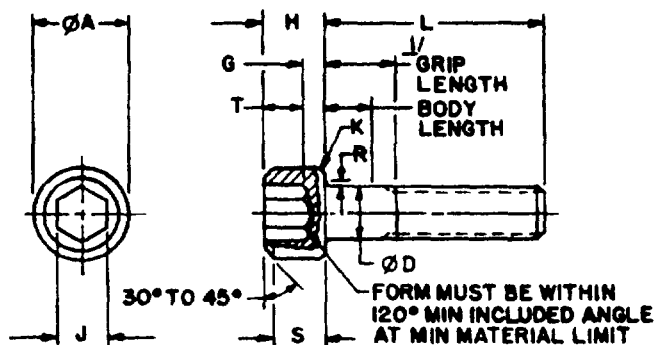


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DASH NO	1/ GRIP LENGTH MAX
03	.375
08	.500
09	1.000
10	1.500
19	.500
20	1.000
21	1.500
26	.750
27	.750
28	2.250

TABLE I DIMENSIONS AND PART NUMBERS.

NOMINAL SIZE		.138	.190	.250	.3125	.375	.500	.750
THREADS PER INCH UNC - 3A		32	24	20	18	16	13	10
Ø D - BODY DIAMETER	MAX	.1380	.1900	.2500	.3125	.3750	.5000	.7500
	MIN	.1329	.1840	.2435	.3053	.3678	.4919	.7406
Ø A - HEAD DIAMETER	MAX	.2260	.3125	.3750	.4688	.5625	.7500	1.1250
	MIN	.2180	.3030	.3650	.4570	.5500	.7350	1.1070
H - HEAD HEIGHT	MAX	.1380	.1900	.2500	.3125	.3750	.5000	.7500
	MIN	.1340	.1850	.2440	.3060	.3680	.4920	.7400
S - HEAD SIDE HEIGHT	MIN	.1240	.1710	.2250	.2810	.3370	.4500	.6750
J - SOCKET WIDTH ACROSS FLATS	MAX	.1111	.1587	.1900	.2530	.3160	.3790	.6310
	MIN	.1094	.1562	.1875	.2500	.3125	.3750	.6250
T - KEY ENGAGEMENT	MIN	.0640	.0900	.1200	.1510	.1820	.2450	.3700
G - WALL THICKNESS	MIN	.0470	.0650	.0950	.1190	.1430	.1900	.2850
K - CHAMFER OR RADIUS	MAX	.0050	.0050	.0080	.0080	.0080	.0100	.0100
B - FILLET EXTENSION	MAX	.0100	.0140	.0140	.0170	.0200	.0260	.0390
	MIN	.0060	.0090	.0090	.0120	.0150	.0200	.0300
MINIMUM TENSILE LOAD - LBS		1,450	2,800	5,100	8,400	12,400	22,700	53,400
L - LENGTH	TOLERANCE	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO
.375				04				
.500	+.000			05	11			
.750	-.031	01		06	12	15		
1.000			02			16	22	
1.250				07		17		
1.500	+.000		03 1/2			18	23	
1.750	-.060			08 1/2	13	19 1/2	24	
2.000				09 1/2		20 1/2	25	29
2.500				10 1/2			26 1/2	
2.750							27 1/2	
3.000	+.000				14	21 1/2	28 1/2	
4.000	-.080							

1/ GRIP LENGTH MAX

USER ACTIVITIES  
ARMY - ME, MI  
NAVY - MCREVIEWER ACTIVITIES  
ARMY - AV, EA  
NAVY - OS  
AIR FORCE - 62  
DLA - IS  
NSA - NSa military standard is approved for use by all Departments and Agencies of the Department of Defense.  
action for all new engineering and design applications and for repetitive use shall be made from this  
document when applicable.

P.A.	AR	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
Other Cost	SH 99		SCREW CAP, SOCKET HEAD, ALLOY STEEL, UNC-3A	MS51484
PROCUREMENT SPECIFICATION	FF-S-86	SUPERSEDES	PAGE 1 OF 2	

REVISED  
APPROVED 1 AUG 84

USER ACTIVITIES  
ARMY - ME, MI  
NAVY - MC

REVIEWER ACTIVITIES  
ARMY - AV, EA  
NAVY - OS  
AIR FORCE - 82  
DA - 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 replacement shall be made from this document, when applicable.

FED SUP CLASS  
5305

#### REQUIREMENTS

1. **MATERIAL.** ALLOY STEEL IN ACCORDANCE WITH PROCUREMENT SPECIFICATION HAVING A MINIMUM TENSILE STRENGTH OF 160,000 PSI
2. **FINISH** ZINC COATING IN ACCORDANCE WITH ASTM B633-78,  $P_2/7_{15}$  (5  $\mu\text{m}$ ), TYPE II
3. **THREADS.** THE THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/2. ACCEPTABILITY OF SCREW THREAD SHALL BE IN ACCORDANCE WITH FED-STD-H28/20, SYSTEM 21
4. **THREAD LENGTH** SCREWS, DASH NUMBERS 01, 02, 04, 05, 06, 07, 11, 12, 15, 16, 17, 18, 22, 23, 24 AND 25 SHALL HAVE COMPLETE (FULL FORM) THREADS EXTENDING WITHIN TWO THREADS OF THE HEAD AS MEASURED WITH A THREAD RING GAGE. THREADS SHALL NOT EXTEND TO THE R RADIUS 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 MS51484-01 - SCREW, CAP, SOCKET HEAD, ALLOY STEEL, .138-32UNC-3A, THREAD LENGTH .750, ZINC COATED

#### NOTES

1. ALL DIMENSIONS ARE IN INCHES
2. THE HEAD MAY OR MAY NOT BE KNURLED AT THE MANUFACTURER'S OPTION. TYPE OF KNURLING OPTIONAL
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.

APPROVED 1 AUG 84 REVISED

P.A. Other Cost	AR SH 99	INTERNATIONAL INTEREST	TITLE  SCREW, CAP, SOCKET HEAD, ALLOY STEEL, UNC - 3A	MILITARY STANDARD  MS51484
PROCUREMENT SPECIFICATION FF-3-86		SUPERSEDES		PAGE 2 OF 2