



TABLE I DIMENSIONS AND PART NUMBERS.

NOMINAL SIZE - - - - -		.250	.3125	.375	500
THREADS PER INCH UNC - 3A - - - - -		20	18	16	13
J - SOCKET WIDTH ACROSS FLATS	NOM	.125	.156	.188	.250
R - POINT RADIUS	MAX MIN	.219 .188	.265 .234	.312 .281	.406 .375
T - KEY ENGAGEMENT	MIN	.125	.156	.188	.250
L - LENGTH	TOLERANCE	DASH NO	DASH NO	DASH NO	DASH NO
1.000	+.020	1	2	3	4

REQUIREMENTS

- MATERIAL ALLOY STEEL IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.
- FINISH ZINC COATING, IN ACCORDANCE WITH ASTM B633-78, Fe/Zn<sub>5</sub> (5 μm), TYPE II
- HARDNESS. 45-57HRC
- THREADS THE THREADS SHALL BE IN ACCORDANCE WITH FED-STD-R29/2 ACCEPTABILITY OF SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-R29/20, SYSTEM 21.
- PART NUMBERS THE BASIC MS PART NUMBER IS FOLLOWED BY A DASH NUMBER FROM TABLE I

EXAMPLE MS51489-1 - SETSCREW, HEXAGON SOCKET, OVAL POINT, ALLOY STEEL, 250-20UNC-3A, LENGTH 1.000, 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 PROPOSALS, 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

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

REVIEWER ACTIVITIES  
ARMY - AV, 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

REVISED  
APPROVED 1 AUG 84

PA Other Cust	AR SH 99	INTERNATIONAL INTEREST	TITLE <b>SETSCREW, HEXAGON SOCKET, OVAL POINT, ALLOY STEEL</b>	<b>MILITARY STANDARD</b>
PROCUREMENT SPECIFICATION FF-S-200			SUPERSEDES	PAGE   OF
				<b>MS51489</b>