



TABLE I DIMENSIONS AND PART NUMBERS.

NOMINAL SIZE		.190
THREADS PER INCH UNF - 2A		32
Ø D - BODY DIAMETER	MAX	.1900
	MIN	.1658
Ø A - HEAD DIAMETER	MAX	.3750
	MIN	.3570
H - HEAD HEIGHT	MAX	.1330
	MIN	.1220
P - HEAD RADIUS	MIN	.0200
R - FILLET RADIUS	MAX	.0290
MINIMUM TENSILE LOAD LBS		1,200
L - LENGTH	TOLERANCE	DASH NO
.375	+.000	1
.750	-.032	2
1.000		3

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 µm), TYPE II
3. **THREADS** THE THREADS SHALL BE IN ACCORDANCE WITH FED-STD-R28/2 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 BEARING SURFACE OF THE HEAD, OR CLOSER IF PRACTICABLE.
5. **RECESS** THE RECESS SHALL BE IN ACCORDANCE WITH MS9006.
6. **PART NUMBER** THE BASIC PART NUMBER IS FOLLOWED BY A DASH NUMBER FROM TABLE I
EXAMPLE MS51493-1 - SCREW, MACHINE, PAN HEAD, CROSS-RECESSED, CARBON STEEL, 190-32UNF-2A, LENGTH .375, 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

PA Other Cust	AR SH 99	INTERNATIONAL INTEREST	TITLE SCREW, MACHINE, PAN HEAD, CROSS-RECESSED, CARBON STEEL UNF-2A	MILITARY STANDARD MS51493
PROCUREMENT SPECIFICATION FF-S-92	SUPERSEDES		PAGE 1 OF 1	

USER ACTIVITIES
ARMY - ME, MI
NAVY - MC, OSREVIEWER ACTIVITIES
ARMY - 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
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APPROVED