

TABLE I. DASH NUMBERS AND DIMENSIONS.

ØD	THREAD SIZE		.1120-40UNC-2A	
ØD <sub>1</sub>	RELIEF DIAMETER	MAX	.084	
		MIN	.078	
ØA	HEAD DIAMETER	MAX SHARP	.225	
		MIN SHARP	.207	
		ABS MIN	.191	
F	PROTRUSION ABOVE GAGING DIAMETER	MAX	.025	
		MIN	.016	
ØG	GAGING DIAMETER	REF	.167	
H	HEAD HEIGHT	REF	.049	
R	RADIUS	MAX	.020	
		MIN	.014	
T	THREAD LENGTH	MAX	.160	
		MIN	.140	
L	LENGTH	MAX	.370	.410
		MIN	.350	.390
DASH NUMBER			-1	-2

USER ACTIVITIES  
ARMY-AT, MI  
NAVY-MC

REVIEWER ACTIVITIES  
ARMY-AV, EA  
AIR FORCE -82  
DLA-IS

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.

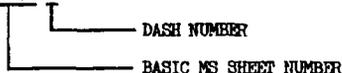
APPROVED 10 JUL 84  
REVISED

PA Other Cust	AR 99	INTERNATIONAL INTEREST	TITLE SCREW, EXTERNALLY RELIEVED BODY, FLAT COUNTERSUNK HEAD, 100°, CROSS-RECESSED	MILITARY STANDARD MS51494
PROCUREMENT SPECIFICATION FF-S-92		SUPERSEDES	PAGE 1 OF 2	

REQUIREMENTS:

1. MATERIAL. STEEL, CORROSION RESISTANT, 300 SERIES, IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.
2. CLEANED, DESCALED AND PASSIVATED. THE SCREW SHALL BE CLEANED, DESCALED AND PASSIVATED IN ACCORDANCE WITH ASTM A380-78.
3. FINISH. BLACK OXIDE COATED IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.
4. MAGNETIC PERMEABILITY. THE SCREW SHALL MEET THE MAGNETIC PERMEABILITY REQUIREMENTS OF PROCUREMENT SPECIFICATION.
5. RECESS. THE RECESS SHALL BE IN ACCORDANCE WITH MS9006.
6. 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.
7. PART NUMBER. THE PART NUMBER CONSISTS OF THE BASIC MS NUMBER, PLUS THE DASH NUMBER FROM TABLE I.

EXAMPLE: MS51494-2



MS51494-2 INDICATES - SCREW, EXTERNALLY RELIEVED BODY, FLAT COUNTERSUNK HEAD, 100°, CROSS-RECESSED, .1120-40UNC-2A NOMINAL SIZE; .410 NOMINAL LENGTH

NOTES:

1. ALL DIMENSIONS ARE IN INCHES.
2. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON THE 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.

ARMY-AT, MI  
NAVY-MC

REVIEWER ACTIVITIES  
ARMY-AV, EA  
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