

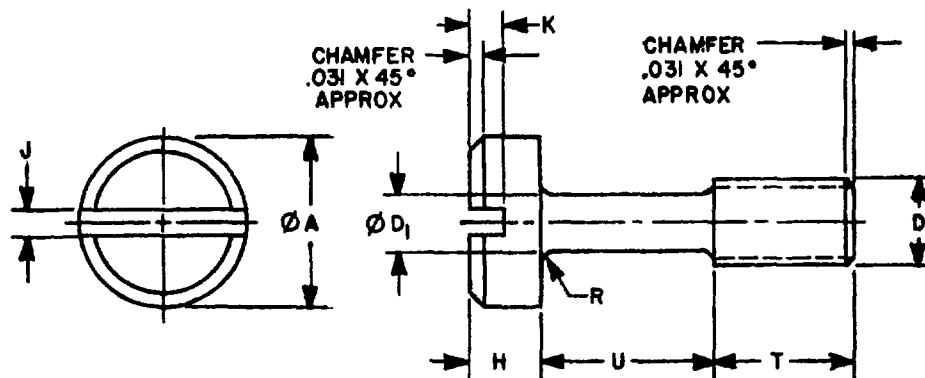
USER ACTIVITIES
ARMY-MI
NAVY-MCREVIEWER ACTIVITIES
ARMY-AT, AV
AIR FORCE-82
DLA-IS

TABLE I. DASH NUMBERS AND DIMENSIONS

DASH NO	D THREAD SIZE NOM	Ø A HEAD		Ø D ₁ RELIEF		H HEAD HEIGHT		J SLOT WIDTH		K SLOT DEPTH		R FILLET RADIUS		T THREAD LENGTH		U RELIEF BODY LENGTH	
		MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN
1	.112-4UNC-2A	.266	.234	.072	.067	.141	.109	.039	.031	.048	.035	.017	.017	.197	.177	.291	.271
2	.138-32UNC-2A	.297	.265	.086	.081	.141	.109	.048	.039	.060	.045	.021	.021	.228	.208	.322	.302
3	.138-32UNC-2A	.297	.265	.086	.081	.141	.109	.048	.039	.060	.045	.021	.021	.228	.208	.395	.365
4	.138-32UNC-2A	.297	.265	.086	.081	.141	.109	.048	.039	.060	.045	.021	.021	.228	.208	.447	.427
5	.164-32UNC-2A	.329	.297	.114	.109	.172	.140	.054	.045	.071	.054	.025	.025	.260	.240	.478	.458
6	.190-32UNF-2A	.391	.359	.136	.131	.204	.172	.060	.050	.083	.064	.029	.029	.322	.302	.603	.583

REQUIREMENTS:

1. **MATERIAL.** CORROSION RESISTANT STEEL, 300 SERIES IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.
2. **CLEANING, DESCALING AND PASSIVATION.** CLEANED, DESCALED AND PASSIVATED IN ACCORDANCE WITH ASTM A380-78.
3. **MAGNETIC PERMEABILITY.** THE SCREW SHALL MEET THE MAGNETIC PERMEABILITY REQUIREMENTS OF PROCUREMENT SPECIFICATION.
4. **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).
5. **PART NUMBER.** THE PART NUMBER SHALL CONSIST OF THE BASIC MS SHEET NUMBER, FOLLOWED BY A DASH NUMBER TAKEN FROM TABLE I.

EXAMPLE: MS51495-4

DASH NUMBER

BASIC MS SHEET NUMBER

MS51495-4 INDICATES - SCREW, EXTERNALLY RELIEVED BODY, FILLISTER HEAD; .138-32UNC-2A NOMINAL THREAD SIZE; .427 MINIMUM RELIEF BODY LENGTH

NOTES:

1. 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.

PA Other Cust	AR 99	INTERNATIONAL INTEREST	TITLE SCREW, EXTERNALLY RELIEVED BODY, FILLISTER HEAD	MILITARY STANDARD
PROCUREMENT SPECIFICATION FF-S-92			SUPERSEDES	PAGE OF
			MS51495	