

		FED. SUP CLASS 5305										
NOMINAL SIZE		4(.112)		6(.138)		8(.164)		10(.190)		1/4(.250)		
THREADS PER INCH		24		20		18		16		14		
A	HEAD DIA	MAX SHARP MIN FLAT		.225 .195		.279 .244		.332 .292		.385 .340		
	H		HEAD HEIGHT - REF		.067		.083		.100		.116	
H1	UNDERCUT	MAX		.047		.059		.070		.081		
	HEAD HEIGHT		MIN		.038		.048		.058		.068	
		DASH NUMBER										
L	LENGTH	TOL.	CARBON STEEL	CRES STEEL	CARBON STEEL	CRES STEEL	CARBON STEEL	CRES STEEL	CARBON STEEL	CRES STEEL	CARBON STEEL	CRES STEEL
.250	±.031		1	1C	12	12C	21	21C	33	33C	54	54C
.312		3	3C	13	13C	23	23C	34	34C			
.375		4	4C	14	14C	24	24C					
.500		5	5C	15	15C	25	25C	35	35C	55	55C	
.625	±.047		6	6C	16	16C	26	26C	36	36C	56	56C
.750					17	17C	27	27C	37	37C	57	57C
.875					18	18C	28	28C	38	38C	58	58C
1.000												
1.250	±.047					29	29C	39	39C	59	59C	
1.500						30	30C	40	40C	60	60C	
1.750								41	41C	61	61C	
2.000								42	42C	62	62C	
2.250										63	63C	
2.500										64	64C	
<p>NOTES:</p> <p>(A) 1. MATERIAL: Carbon steel shall be AISI 1016, 1018, 1019, 1021, 1022 or 1024 (hardened) in accordance with Fed. Std. No. 66. Corrosion-resisting steel shall be AISI 410 (hardened) in accordance with Fed. Std. No. 66.</p> <p>(A) 2. PROTECTIVE COATING: Carbon steel shall be cadmium plated in accordance with QQ-P-416, Type II, Class 3. Corrosion-resisting steel shall be passivated in accordance with QQ-P-35.</p> <p>3. THREADS: The threads shall be in accordance with procurement specification</p> <p>4. RECESS: The recess shall be in accordance with MS9006.</p> <p>5. SHORT LENGTHS: Lengths above dotted line shall have undercut heads.</p> <p>6. HOLE SIZES: For approximate hole sizes see MS24632.</p> <p>7. DIMENSIONS: All dimensions are in inches, unless otherwise specified.</p> <p>8. PART NUMBER: The MS part number consists of the MS number, plus the dash number. Example: MS51862-1.</p> <p>9. Referenced documents shall be of the issue in effect on date of invitations for bid.</p> <p>10. For design feature purposes, this standard takes precedence over procurement documents referenced herein.</p>												
P.A. WC		TITLE						MILITARY STANDARD				
Other Code YD 82		SCREW, TAPPING - THREAD FORMING, TYPE AB, FLAT 82° COUNTERSUNK HEAD, CROSS-RECESSED						MS51862				
PROCUREMENT SPECIFICATION PF-S-107		SUPERSEDES MS24615, MS24616, MS24619, MS24620, MS24635, MS24636, MS24639 & MS24640; BCXX2.1, BCXX4.1, BCXX4.2 & BCXX1.2.						SHEET 1 OF 2				

FED. SUP CLASS
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INTERCHANGEABILITY TABLE

The screws covered by the following dash numbers of MS24635, MS24636, MS24639, and MS24640 are cancelled after 25 February 1963. The screws covered by the following dash numbers of MS24615 and MS24616 are cancelled after 27 August 1969. The screws covered by the following dash numbers of MS24619 and MS24620 are cancelled after 15 May 1975. The cancelled screws cannot always replace the superseding screws and should be used until existing stock is depleted. Use only the superseding screws of MS51862 for design and engineering. Replacement shall be in accordance with this table.

DASH NUMBERS

CANCELLED				SUPERSEDING MS51862	CANCELLED				SUPERSEDING MS51862
MS24615	MS24619	MS24635	MS24639		MS24616	MS24620	MS24636	MS24640	
--	1	--	--	**	--	1	--	--	**
1	2	1	1	1	1	2	1	1	1C
--	3	--	2	**	--	3	--	2	**
3	4	2	3	3	3	4	2	3	3C
4	5	3	4	4	4	5	3	4	4C
5	--	4	--	5	5	--	4	--	5C
6	--	5	--	6	6	--	5	--	6C
--	9	--	9	**	--	9	--	9	**
12	10	--	10	12	12	10	--	10	12C
13	11	10	11	13	13	11	10	11	13C
14	12	11	12	14	14	12	11	12	14C
15	13	12	13	15	15	13	12	13	15C
16	14	13	14	16	16	14	13	14	16C
17	15	14	--	17	17	15	14	--	17C
18	16	15	--	18	18	16	15	--	18C
--	17	--	--	**	--	17	--	--	**
--	18	--	--	**	--	18	--	--	**
24	22	21	20	23	24	22	21	20	23C
25	23	22	21	24	25	23	22	21	24C
26	24	23	22	25	26	24	23	22	25C
27	25	24	23	26	27	25	24	23	26C
28	26	25	24	27	28	26	25	24	27C
29	27	26	25	28	29	27	26	25	28C
30	28	27	26	29	30	28	27	26	29C
31	29	28	--	30	31	29	28	--	30C
--	30	--	--	**	--	30	--	--	**
--	31	--	--	**	--	31	--	--	**
--	32	--	--	**	--	32	--	--	**
--	33	--	--	**	--	33	--	--	**
35	--	32	--	33	35	--	32	--	33C
36	38	33	30	34	36	38	33	30	34C
37	39	34	31	35	37	39	34	31	35C
38	40	35	32	36	38	40	35	32	36C
39	41	36	33	37	39	41	36	33	37C
40	42	37	34	38	40	42	37	34	38C
41	43	38	35	39	41	43	38	35	39C
42	44	39	36	40	42	44	39	36	40C
43	45	40	37	41	43	45	40	37	41C
44	46	41	38	42	44	46	41	38	42C
--	47	--	--	**	--	47	--	--	**
--	48	--	--	**	--	48	--	--	**
49	--	46	--	**	49	--	46	--	**
50	--	47	--	**	50	--	47	--	**
51	--	48	--	**	51	--	48	--	**
52	--	49	--	**	52	--	49	--	**
53	--	50	--	**	53	--	50	--	**
--	52	--	--	54	--	52	--	--	54C
--	53	--	--	55	--	53	--	--	55C
60	54	57	42	56	60	54	57	42	56C
61	55	58	43	57	61	55	58	43	57C
62	56	59	44	58	62	56	59	44	58C
63	57	60	45	59	63	57	60	45	59C
64	58	61	46	60	64	58	61	46	60C
65	59	62	47	61	65	59	62	47	61C
66	60	63	48	62	66	60	63	48	62C
--	61	--	--	63	--	61	--	--	63C
--	62	--	--	64	--	62	--	--	64C

** NO REPLACEMENT

P.A.	WC	TITLE	MILITARY STANDARD
Other Cust	YD	SCREW, TAPPING-THREAD FORMING, TYPE AB, FLAT 82° COUNTERSUNK HEAD, CROSS-RECESSED	MS51862
82			
PROCUREMENT SPECIFICATION	SUPERSEDES MS24615, MS24616, MS24619, MS24620, MS24635, MS24636, MS24639 and MS24640; BCXX2.1, BCXX4.1, BCXX4.2 &		SHEET 2 OF BQX1.2.
FF-S-107			

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

APPROVED 27 AUG 1969 REVISED FOR CHANGES SEE SHEET 1

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.

REVIEWER EA, IS, MI, NS, PA, WV
USER AT, EL, GL, MC, ME, MU, OS