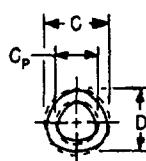
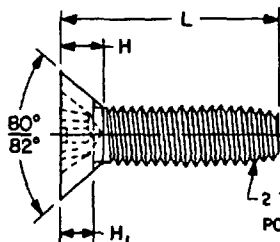
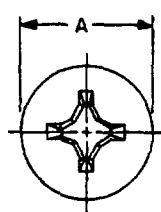
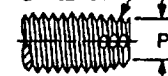


FED SUP CLASS
53052 TO 3 1/2 THREADS
POINT LENGTH

TYPE TT

2 TO 3 1/2 PITCH
TAPER LENGTH

TYPE SW

2 TO 3 1/2 PITCH
TAPER LENGTH

TYPE SF

NOMINAL SIZE		138	190	.250			
THREADS PER INCH		32	24	20			
A HEAD DIAMETER	MAX SHARP	.279	.385	.507			
	MIN FLAT	.244	.340	.452			
H HEAD HEIGHT	REF	.083	.116	.153			
H ₁ HEAD HEIGHT UNDERCUT	MAX	.059	.081	.107			
	MIN	.048	.068	.092			
C DIAMETER	MAX	.141	.194	.2550			
	MIN	.135	.188	.2490			
C _p POINT DIAMETER	MAX	.111	.153	.206			
D ACROSS CENTER	MAX	.135	.185	.246			
	MIN	.129	.179	.240			
P* POINT DIAMETER TYPE SW	MAX	.096	.1295	.180			
	MIN	.091	.1245	.175			
P POINT DIAMETER TYPE SF	MAX	.106	.147	.198			
	MIN	.095	.133	.181			
L LENGTH	TOL	DASH NUMBER					
		CARBON STEEL	CRES STEEL	CARBON STEEL	CRES STEEL	CARBON STEEL	CRES STEEL
.250 375 500 625 750	+.000 -.030	1	C1				
		2	C2				
		3	C3	12	C12		
		4	C4	13	C13	23	C23
		5	C5	14	C14	24	C24
.875 1 000 1.250 1 500	+.000 -.050			15	C15	25	C25
				16	C16	26	C26
				17	C17	27	C27
						28	C28
						29	C29
1.750 2 000	+.000 - .060					30	C30
						31	C31

* Before threading

NOTES

- MATERIAL** Carbon steel and corrosion-resisting steel (410) in accordance with procurement specification.
- PROTECTIVE COATING** Carbon steel - Cadmium plated in accordance with QQ-P-416, Type II, Class 2 or MIL-C-81562, Type II, Class 2
Corrosion-resisting steel - Passivated in accordance with QQ-P-35.
- THREADS** The threads shall be in accordance with the applicable requirements of the procurement specification.
- RECESS** The recess shall be in accordance with MS9006
- DIMENSIONS** All dimensions are in inches, unless otherwise specified.
- SHORT LENGTHS** Lengths above dashed line shall have undercut heads.
- PART NUMBER** The MS part number consists of the MS number, plus the dash number
Example MS51870-1
- Referenced documents shall be of the issue in effect on date of invitations for bid.
- For design feature purposes, this standard takes precedence over procurement documents referenced herein.
- Type TT tri-lobular section is maintained throughout the full length of the screw.

P A WC	TITLE	MILITARY STANDARD
Other Cust SH 82	SCREW, TAPPING-HIGH PERFORMANCE, THREAD ROLLING, TYPES SF, SW AND TT, FLAT COUNTERSUNK HEAD, GROSS-RECESSED	MS51870
PROCUREMENT SPECIFICATION FF-S-107	SUPERSEDES BQB1 and in part BCX2.3, BCX4.4 and BQB1 3	SHEET 1 OF 1

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

90

REVIEWER AV, IS, MU, NS
 USER AS, AT, MC, ME, OS, YD
 This military standard is mandatory 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.

APPROVED 29 SEP 1972 REVISED