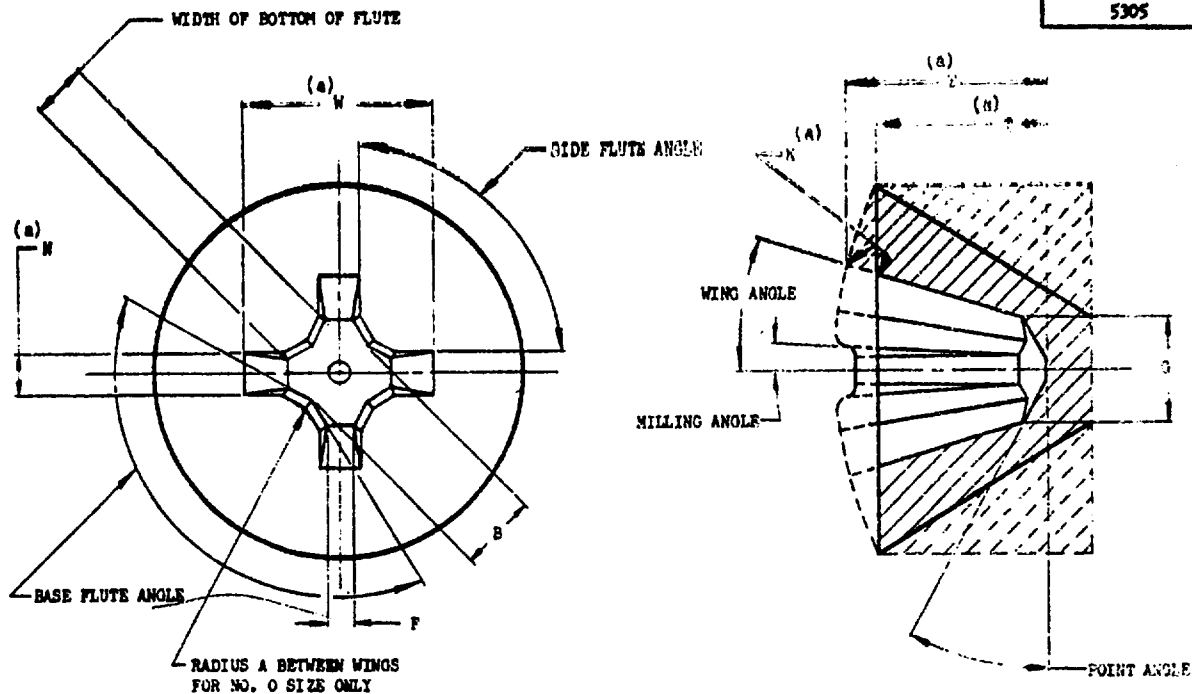


FED. SUP CLASS  
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DIMENSIONS OF RECESSES

DIMENSIONS	RECESS NUMBER					
	0	1	2	3	4	5
0 $\begin{smallmatrix} +.002 \\ -.000 \end{smallmatrix}$	.032	.050	.090	.150	.200	.311
B	.0250 $\pm .0010$	.0380 $\begin{smallmatrix} +.0000 \\ -.0010 \end{smallmatrix}$	.0578 $\pm .0010$	.0950 $\pm .0010$	.1370 $\pm .0010$	.2270 $\pm .0010$
MILLING ANGLE	7° $\begin{smallmatrix} +15' \\ -0' \end{smallmatrix}$	7° $\begin{smallmatrix} +15' \\ -0' \end{smallmatrix}$	5°45' $\begin{smallmatrix} +15' \\ -0' \end{smallmatrix}$	5°45' $\begin{smallmatrix} +15' \\ -0' \end{smallmatrix}$	7° $\begin{smallmatrix} +15' \\ -0' \end{smallmatrix}$	7° $\begin{smallmatrix} +15' \\ -0' \end{smallmatrix}$
POINT ANGLE	28° $\begin{smallmatrix} +0' \\ -1' \end{smallmatrix}$	28° $\begin{smallmatrix} +0' \\ -1' \end{smallmatrix}$	28° $\begin{smallmatrix} +0' \\ -1' \end{smallmatrix}$	28° $\begin{smallmatrix} +0' \\ -1' \end{smallmatrix}$	28° $\begin{smallmatrix} +0' \\ -1' \end{smallmatrix}$	28° $\begin{smallmatrix} +0' \\ -1' \end{smallmatrix}$
WING ANGLE $\begin{smallmatrix} +15' \\ -0' \end{smallmatrix}$ (C)	26°30'	26°30'	26°30'	26°30'	26°30'	26°30'
BASE FLUTE ANGLE $\begin{smallmatrix} +0' \\ -15' \end{smallmatrix}$	- - -	138°	140°	146°	153°	162°46'
SIDE FLUTE ANGLE	92° $\begin{smallmatrix} +0' \\ -15' \end{smallmatrix}$	92° $\begin{smallmatrix} +0' \\ -15' \end{smallmatrix}$	92° $\begin{smallmatrix} +0' \\ -15' \end{smallmatrix}$	92° $\begin{smallmatrix} +0' \\ -15' \end{smallmatrix}$	92° $\begin{smallmatrix} +0' \\ -15' \end{smallmatrix}$	92° $\begin{smallmatrix} +0' \\ -15' \end{smallmatrix}$
WIDTH OF BOTTOM OF FLUTE	.0140 .0104	.0180 .0160	.0330 .0310	.0800 .0780	.0960 .0940	.1640 .1590
WING THICKNESS F	.014 .012	.021 .019	.029 .026	.032 .029	.050 .047	.070 .067
A	.0101 .0075 (C)	- - -	- - -	- - -	- - -	- - -

(a) UNLESS OTHERWISE SPECIFIED, USE SHEET 4 VALUES FOR DIMENSIONS W, T, N, K, AND DEPTH OF GAGE PENETRATIONS. IF THE SHEET 4 VALUES ARE NOT COMPATIBLE WITH THE HEAD CONFIGURATION AND PERFORMANCE REQUIREMENTS OF A PARTICULAR ITEM, THE VALUES WILL BE SPECIFIED ON THE ITEM STANDARD.

SHEETS 1 AND 2 OF THIS STANDARD ARE THE SUBJECT OF INTERNATIONAL STANDARDIZATION AGREEMENT ABC AIR STD 17/30. WHEN REVISION OR CANCELLATION OF THIS STANDARD IS PROPOSED, THE DEPARTMENTAL CUSTODIANS WILL INFORM THEIR RESPECTIVE DEPARTMENTAL STANDARDIZATION OFFICES SO THAT APPROPRIATE ACTION MAY BE TAKEN RESPECTING THE INTERNATIONAL AGREEMENT CONCERNED.

THIS IS A DESIGN STANDARD. NOT TO BE USED AS A PART NUMBER.

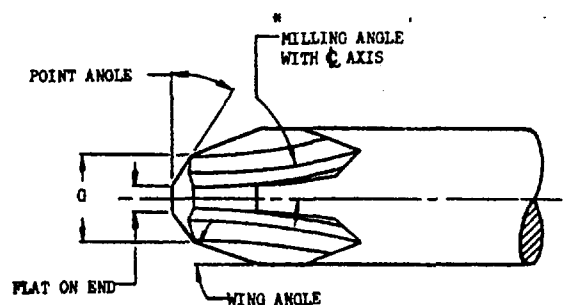
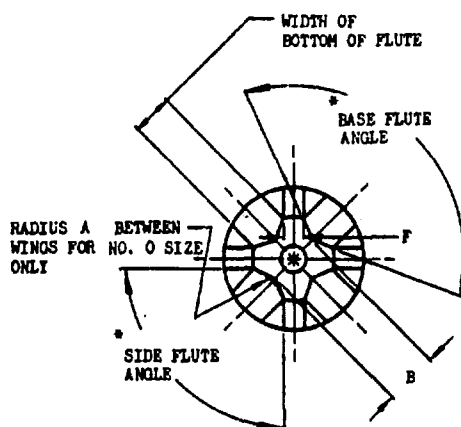
(C) FOR CHANGES SEE SHEETS 2, 3, ...

P.A. USAF - ASD Other Cust Army - WC Navy - Maps	INTERNATIONAL INTEREST	TITLE  RECESSES - CROSS, LOW TORQUE DRIVE, DIMENSIONS AND GAGE DIMENSIONS FOR	MILITARY STANDARD  MS9006
PROCUREMENT SPECIFICATION NONE	SUPERSEDES: MS9001 THRU MS9005, MS33578 AND AND10477 (C)	SHEET 1 OF 4	

NOTICE—When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility, nor any obligation whatsoever; and the fact that the Government may have furnished, or in any way supplied the said drawings, specifications, or other data is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

This drawing is approved by the Department of Defense and is mandatory on all activities. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

APPROVED 1 Aug 57 REVISED (A) 13 Oct 56 (B) 21 Nov 51 (C) 20 Jun 53

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This military standard is approved by the Department of Defense and is supplementary to all activities. Solicitation for all new engineering and design applications and for repetitive use shall be made from this document.

DIMENSIONS OF GAGE POINTS						
DIMENSIONS	RECESS NUMBER					
	0	1	2	3	4	5
G $+0.001$ $-0.000$	.032	.050	.090	.150	.200	.311
B $+0.0000$ $-0.0010$	.0240	.0394	.0606	.0983	.1407	.2310
MILLING ANGLE	$7^{\circ} +0$ $-15'$	$7^{\circ} +0$ $-15'$	$5^{\circ}45' +0$ $-15'$	$5^{\circ}45' +0$ $-15'$	$7^{\circ} +0$ $-15'$	$7^{\circ} +0$ $-15'$
POINT ANGLE	$18^{\circ} +1^{\circ}$ $-0$	$18^{\circ} +1^{\circ}$ $-0$	$18^{\circ} +1^{\circ}$ $-0$	$18^{\circ} +1^{\circ}$ $-0$	$18^{\circ} +1^{\circ}$ $-0$	$18^{\circ} +1^{\circ}$ $-0$
FLAT ON END	.015 .010	.020 .015	.020 .015	.020 .015	.020 .015	.025 .020
WING ANGLE $+0 -15'$	$26^{\circ}30'$	$26^{\circ}30'$	$26^{\circ}30'$	$26^{\circ}30'$	$26^{\circ}30'$	$26^{\circ}30'$
BASE FLUTE ANGLE $+15' -0$	- - -	$138^{\circ}$	$140^{\circ}$	$146^{\circ}$	$153^{\circ}$	$162^{\circ}46'$
SIDE FLUTE ANGLE $+15' -0$	$92^{\circ}$	$92^{\circ}$	$92^{\circ}$	$92^{\circ}$	$92^{\circ}$	$92^{\circ}$
WIDTH OF BOTTOM OF FLUTE	.0151 .0125	.0202 .0192	.0434 .0424	.0826 .0816	.1078 .1068	.1730 .1720
WING THICKNESS F	.012 .010	.020 .018	.025 .023	.031 .029	.044 .042	.063 .061
A	.0109 .0090	- - -	- - -	- - -	- - -	- - -

THIS IS A DESIGN STANDARD. NOT TO BE USED AS A PART NUMBER.

P.A. USAF - ASD Other Coast Army - MC Navy - Mops	INTERNATIONAL INTEREST	TITLE  RECESSES - CROSS, LOW TORQUE DRIVE, DIMENSIONS AND GAGE DIMENSIONS FOR	MILITARY STANDARD <b>MS9006</b>
PROCUREMENT SPECIFICATION NONE	SUPERSEDES: MS9001 THRU MS9005, 1533578 AND AND10477	(C)	SHEET 2

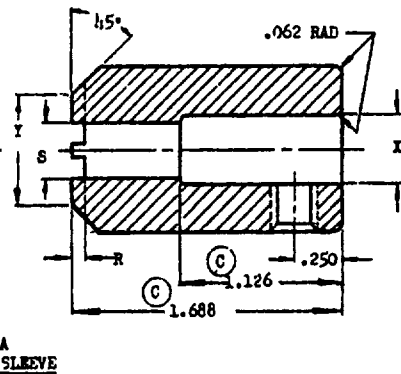
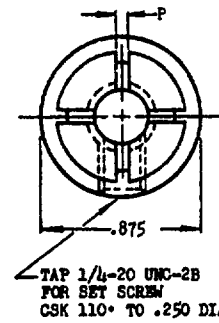
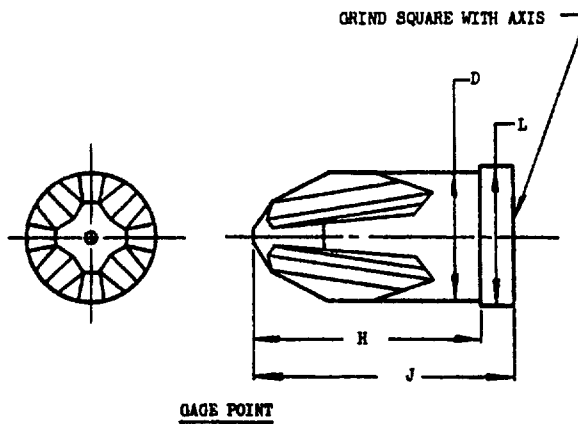
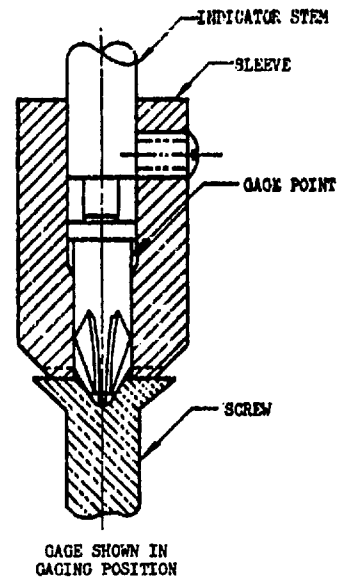
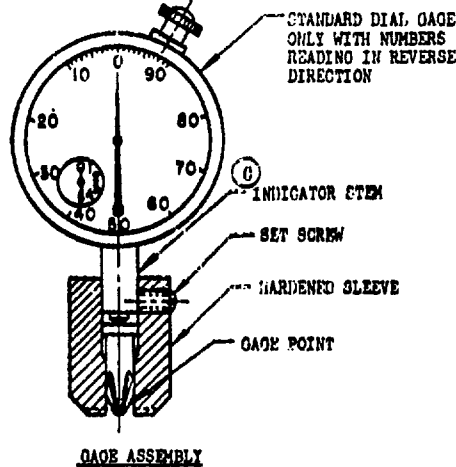
DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

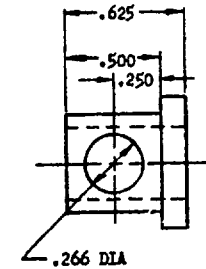
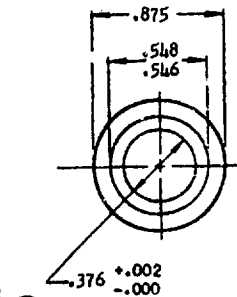
APPROVED 1 Aug 57 REVISED (C) FOR CHANGES SEE SHEETS 1, 2, 3

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NOTE—When Government drawings, specifications, or other data are used for any purpose other than a definitely related Government procurement operation, the United States Government thereby incurs no responsibility, nor any obligation whatever, and the fact that the Government may have furnished, furnished, or in any way supplied the said drawings, specifications, or other data is not to be regarded by implication or otherwise as an endorsement, approval, or recommendation of the product or of the person or corporation, or conveying any right or permission to manufacture, use, or sell any patented invention that may, in any way be related thereto.



RECESS NUMBER	GAGE POINT				SLEEVE				
	D ±.0002 SHANK DIA	H ±.005	J ±.005	L ±.005 DIA	P ±.002	R ±.003	S ±.0002 DIA	X +.002 -.000 DIA	Y ±.005 DIA
0	.0450	.656	.781	.094	.008	.015	.0460		
1	.0870	.688	.812	.156	.012	.020	.0880		
2	.1410	.750	.875	.219	.018	.031	.1420	.376	.562
3	.2090	.781	.906	.250	.022	.037	.2100		
4	.3120	.844	.969	.359	.031	.062	.3130		
5	.500	1.031	1.156	.531	.041	.094	.5010	.549	.750



DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS ±.016.  
FOR DRIVER DATA, SEE GOG-S-121.

THIS IS A DESIGN STANDARD. NOT TO BE USED AS A PART NUMBER.

P.A. USAP-ASD Other Cust Army-MC Navy-Maps	INTERNATIONAL INTEREST	TITLE  RECESSES - CROSS, LOW TORQUE DRIVE, DIMENSIONS AND GAGE DIMENSIONS FOR	MILITARY STANDARD <b>MS9006</b>
PROCUREMENT SPECIFICATION NONE	SUPERSEDES: MS9001 THRU MS9005, MS33578, AND AND10177		SHEET 3

NOTICE.—When Government drawings, specifications, or other data are used for any purpose other than that for which they were prepared, the Government assumes no responsibility. It is the policy of the Government to encourage the free use of its data, and it is in any way supplied the said drawings, specifications, or other data is not to be regarded by implication or otherwise as in any manner lending the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

This standard is approved by the Department of Defense and is mandatory on all activities. Selection for all new engineering and design projects and for repetitive use shall be made from this document.

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NOM SIZE	W		T	N		K RAD	DRIVER SIZE	DEPTH OF PENETRATION		NOM SIZE	W		T	N		K RAD	DRIVER SIZE	DEPTH OF PENETRATION	
	DIAMETER OF RECESS		DEPTH OF RECESS	WIDTH OF RECESS				MAX MIN			DIAMETER OF RECESS		DEPTH OF RECESS	WIDTH OF RECESS				MAX MIN	
	MAX	MIN	MAX	MIN	MAX			MIN	MAX		MIN	MAX	MIN	MAX	MIN			MAX	MIN

ROUND HEAD WOOD SCREWS									
0	.073	.060	.042	.011	.010	0	.035	.015	
1	.082	.069	.052	.015	.010	0	.045	.026	
2	.114	.101	.064	.018	.020	1	.057	.035	
3	.122	.109	.073	.019	.020	1	.066	.045	
4	.130	.117	.083	.019	.020	1	.076	.056	
5	.154	.141	.074	.027	.025	2	.063	.035	
6	.162	.149	.084	.027	.025	2	.073	.045	
7	.170	.157	.092	.028	.025	2	.081	.055	
8	.178	.165	.101	.030	.025	2	.090	.064	
9	.186	.173	.110	.030	.025	2	.099	.073	
10	.195	.182	.119	.031	.025	2	.108	.082	
12	.249	.236	.125	.032	.030	3	.108	.082	
14	.265	.252	.142	.034	.030	3	.125	.099	
16	.281	.268	.159	.038	.030	3	.142	.119	
18	.339	.326	.176	.057	.035	4	.156	.131	
20	.356	.343	.194	.059	.035	4	.174	.148	
24	.387	.374	.228	.064	.035	4	.208	.182	

FLAT HEAD WOOD SCREWS									
0	.069	.056	.043	.011	.010	0	.036	.020	
1	.077	.064	.051	.015	.010	0	.044	.028	
2	.102	.089	.063	.017	.020	1	.056	.040	
3	.107	.094	.068	.018	.020	1	.061	.045	
4	.128	.115	.089	.018	.020	1	.082	.066	
5	.154	.141	.086	.027	.025	2	.075	.052	
6	.174	.161	.106	.029	.025	2	.095	.072	
7	.189	.176	.121	.030	.025	2	.110	.087	
8	.204	.191	.136	.032	.025	2	.125	.102	
9	.214	.201	.146	.033	.025	2	.135	.112	
10	.258	.245	.146	.034	.030	3	.129	.106	
12	.283	.270	.171	.036	.030	3	.154	.131	
14	.303	.290	.191	.039	.030	3	.174	.151	
16	.327	.314	.216	.045	.030	3	.199	.176	
18	.378	.365	.230	.062	.035	4	.210	.188	
20	.393	.380	.245	.065	.035	4	.225	.203	
24	.424	.411	.276	.069	.035	4	.256	.234	

FLAT COUNTERSUNK 82° UNDERCUT HEAD MACHINE AND TAPPING SCREWS (EXCEPT TYPE "A" (b) )									
0	.069	.056	.043	.011	.010	0	.036	.020	
1	.077	.064	.051	.015	.010	0	.044	.028	
2	.095	.082	.056	.017	.020	1	.049	.033	
3	.102	.089	.063	.018	.020	1	.056	.040	
4	.117	.104	.078	.018	.020	1	.071	.055	
5	.128	.115	.089	.018	.020	1	.082	.066	
6	.146	.133	.078	.025	.025	2	.067	.044	
7	.154	.141	.086	.027	.025	2	.075	.052	
8	.174	.161	.106	.029	.025	2	.095	.072	
10	.189	.176	.121	.030	.025	2	.110	.087	
12	.233	.220	.121	.030	.030	3	.104	.081	
1/4	.250	.237	.136	.032	.030	3	.119	.096	
5/16	.317	.304	.168	.053	.035	4	.148	.126	
3/8	.365	.352	.216	.061	.035	4	.196	.174	
7/16	.393	.380	.245	.065	.035	4	.225	.203	
1/2	.409	.396	.261	.068	.035	4	.241	.219	

FLAT COUNTERSUNK 82° HEAD MACHINE AND TAPPING SCREWS (EXCEPT TYPE "A" (b) )									
0	.069	.056	.043	.011	.010	0	.036	.020	
1	.077	.064	.051	.015	.010	0	.044	.028	
2	.102	.089	.063	.017	.020	1	.056	.040	
3	.107	.094	.068	.018	.020	1	.061	.045	
4	.128	.115	.089	.018	.020	1	.082	.066	
5	.154	.141	.086	.027	.025	2	.075	.052	
6	.174	.161	.106	.029	.025	2	.095	.072	
7	.182	.169	.114	.030	.025	2	.103	.080	
8	.189	.176	.121	.030	.025	2	.110	.087	
10	.204	.191	.136	.032	.025	2	.125	.102	
12	.268	.255	.156	.035	.030	3	.139	.116	
1/4	.283	.270	.171	.036	.030	3	.154	.131	
5/16	.365	.352	.216	.061	.035	4	.196	.174	
3/8	.393	.380	.245	.065	.035	4	.225	.203	
7/16	.409	.396	.261	.068	.035	4	.241	.219	
1/2	.424	.411	.276	.069	.035	4	.256	.234	

PAN HEAD MACHINE AND TAPPING SCREWS (EXCEPT TYPE "A" (b) )									
0	.067	.054	.039	.013	.010	0	.032	.014	
1	.074	.061	.045	.014	.010	0	.040	.022	
2	.104	.091	.059	.017	.020	1	.052	.034	
3	.112	.099	.068	.019	.020	1	.061	.043	
4	.122	.109	.078	.019	.020	1	.071	.053	
5	.158	.145	.093	.028	.025	2	.072	.046	
6	.166	.153	.091	.028	.025	2	.080	.055	
7	.176	.163	.100	.029	.025	2	.089	.064	
8	.182	.169	.109	.030	.025	2	.097	.071	
10	.199	.186	.124	.031	.025	2	.113	.089	
12	.259	.246	.141	.034	.030	3	.124	.098	
1/4	.281	.268	.161	.036	.030	3	.144	.118	
5/16	.330	.317	.193	.059	.035	4	.173	.149	
3/8	.369	.356	.233	.065	.035	4	.213	.190	
7/16	.413	.400	.259	.065	.035	4	.239	.214	
1/2	.439	.422	.280	.071	.035	4	.260	.235	

FLAT COUNTERSUNK 100° HEAD MACHINE SCREWS									
2	.095	.082	.056	.012	.020	1	.049	.033	
3	.102	.089	.063	.014	.020	1	.056	.040	
4	.116	.103	.078	.018	.020	1	.071	.055	
6	.154	.141	.086	.027	.025	2	.075	.052	
8	.169	.156	.101	.028	.025	2	.090	.067	
10	.184	.171	.116	.030	.025	2	.105	.082	
1/4	.247	.234	.135	.033	.030	3	.118	.095	
5/16	.317	.304	.168	.053	.035	4	.148	.126	
3/8	.342	.329	.193	.056	.035	4	.173	.151	
7/16	.366	.353	.218	.060	.035	4	.198	.176	
1/2	.393	.380	.245	.063	.035	4	.226	.204	
5/8	.424	.411	.276	.068	.035	4	.256	.234	
	.511	.498	.278	.072	.035	5	.285	.263	

(b) - A TAPPING ON COARSE-LEAD SCREW WITH A GIMLET POINT.

FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.

THIS IS A DESIGN STANDARD. NOT TO BE USED AS A PART NUMBER.

P.A. USAF - ASD Other Cust Army - HQ Navy - Nops	INTERNATIONAL INTEREST	TITLE  RECESSES - CROSS, LOW TORQUE DRIVE, DIMENSIONS AND GAGE DIMENSIONS FOR	MILITARY STANDARD
			MS9006
PROCUREMENT SPECIFICATION NONE		SUPERSEDES: MS9001 THRU MS9005 MS33578, AND AND10477 <div>0</div>	SHEET 4

**NOTICE  
OF VALIDATION**

**INCH-POUND**

**MS9006C  
NOTICE 1  
3 October 1991**

**MILITARY STANDARD**

**RECESSES—CROSS, LOW TORQUE DRIVE,  
DIMENSIONS AND GAGE DIMENSIONS FOR**

MS9006C, dated 20 June 1963, has been reviewed and determined to be valid for use in acquisition.

**Custodians:**

**Army — AR  
Navy — AS  
Air Force — 99**

**Preparing activity:**

**Navy — AS**

**AMSC N/A**

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**FSC 5305**