



THREAD	D DIA MAX	F		H DIA		SELF-LOCKING DESIGN DATA		T HEX DEPTH
		MAX	MIN	MAX	MIN	P(d)		
						50°	MAX	MIN
#4-40NC-3A #6-32NC-3A	.112 .138	.0510 .0635	.0500 .0625	.061 .074	.051 .064	.062 .076		.040 .050
#8-32NC-3A #10-32NF-3A 1/4-28UNF-3A	.164 .190 .250	.0791 .0947 .1270	.0781 .0937 .1250	.087 .102 .132	.076 .088 .118	.085 .093 .116		.068 .075 .100
5/16-24UNF-3A 3/8-24UNF-3A 1/2-20UNF-3A	.3125 .375 .500	.1582 .1895 .2520	.1562 .1875 .2500	.172 .212 .291	.156 .194 .270	.136 .151 .188		.125 .150 .200

L LENGTH	TOLERANCE	DASH NUMBERS (a)							
		#4-40	#6-32	#8-32	#10-32	1/4-28	5/16-24	3/8-24	1/2-20
1/8	± .010	1	2	3	4				
3/16		5	6	7	8	9			
1/4		10	11	12	13	14	15		
5/16		16	17	18	19	20	21		
3/8		22	23	24	25	26	27	28	29
7/16		30	31	32	33	34	35	36	37
1/2		38	39	40	41	42	43	44	45
9/16		46	47	48	49	50	51	52	53
5/8		54	55	56	57	58	59	60	61
3/4		62	63	64	65	66	67	68	69
7/8	± .015								
1									
1-1/4									
1-1/2									
1-3/4									
2	± .020	For lengths above heavy line see note (g)							
2-1/2									
3	± .031								

This Standard takes precedence over documents referenced herein.  
Reference documents shall be of the issue in effect on the date of invitation for bid.

Replaces: Navy - WP, Army - SI, MI, R, RI, RC, USAF - 69  
 This military standard 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.

P.A. Navy - WP Other Comd. Army - WC USAF - 69	TITLE SETScrew, HEXAGON SOCKET, CUP POINT, 250°P SELF LOCKING ELEMENT, CORROSION RESISTING STEEL, PASSIVATED	MILITARY STANDARD <b>MS18064</b>
PROCUREMENT SPECIFICATION PT-S-200 & MIL-P-18040	SUPERSEDES:	SHEET 1 OF 2

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- (a) Unassigned dash numbers shall not be used.
  - (b) Socket end of screw shall be flat and chamfered. The chamfer shall extend to the minor diameter of the thread and the edge between flat and chamfer shall be slightly rounded.
  - (c) Location of effective locking area "X" shall be in accordance with MS 15981 except as noted herein.
  - (d)  $P_{Max}$  = Maximum point plus minimum of 1 thread pitch. For ease in starting, locking element shall not be effective within this area.
  - (e) Maximum major thread diameter plus .010 = Maximum ring gage diameter that locking region of part must pass through freely or with finger pressure.
  - (f) See MS51021 and MS51023 for set screws without self-locking feature.
  - (g) As MIL-F-18240 doesn't establish torque requirements for items above the heavy line, only a positive indication of torque is required.
- MATERIAL:**  
Steel corrosion resisting; Federal Standard 66, numbers 302, 303, 304, 316 or equal to or interchangeable with 16:18 Chromium-Nickel Alloy Steel.
- LOCKING ELEMENT:**  
In accordance with Specification MIL-F-18240.
- DESIGN AND USAGE LIMITATIONS:**  
See MS 15981.
- TREATMENT:**  
Passivated (See Procurement Specification).
- MAGNETIC PERMEABILITY:**  
These screws have a magnetic permeability of 2.0 maximum (air = 1.0) for a field of  $H = 200$  orstedts using a magnetic indicator per MIL-I-17214.
- EXAMPLE OF PART NUMBER:**  
MS-18064-57 = 1/4-28UNF-3A x 3/4 long corrosion resisting steel cup point self-locking set screw.

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 Approved: Army - AF, Navy - NP, USAF - 69  
 Army - EI, Navy - 63, USAF - 69

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 REVISED (A) 22 MAR 64

P.A. Navy - NP Other Cust Army - MC USAF - 69	TITLE	MILITARY STANDARD
	SETSCREW, HEXAGON SOCKET, CUP POINT, 250PF, SELF LOCKING ELEMENT, CORROSION RESISTING STEEL, PASSIVATED	MS18064
PROCUREMENT SPECIFICATION PP-3-300 & MIL-F-18240	SUPERSEDES:	SHEET 2 OF 2