



Thread
Per Handbook H 28 Screw Thread
Standards for Federal Services 1957

User: Army - GL
 Army - EL, MI, MO, NI, WC
 USAF - G9
 Revisers:

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.

THREAD	D DIA MAX	F		Y		SELF-LOCKING DESIGN DATA		T HEX DEPTH MIN
				118° ± 2° FOR LENGTHS AND UNDER	90° ± 2° FOR LENGTHS AND OVER	P(d) MAX		
				MAX	MIN	116°	88°	
#4-40NC-3A #6-32NC-3A	.112 .138	.0510 .0635	.0500 .0625	1/8 1/8	5/32 3/16	.060 .075	.083 .104	.040 .050
#8-32NC-3A #10-32NF-3A 1/4-28UNF-3A	.164 .190 .250	.0791 .0947 .1270	.0781 .0937 .1250	3/16 3/16 1/4	1/4 1/4 5/16	.084 .092 .114	.117 .131 .166	.062 .075 .100
5/16-24UNF-3A 3/8-24UNF-3A 1/2-20UNF-3A	.3125 .375 .500	.1582 .1895 .2520	.1562 .1875 .2500	5/16 3/8 1/2	3/8 7/16 9/16	.137 .159 .206	.204 .236 .309	.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		29	30	31	32				
1/2		33	34	35	36	37	38	39	40
9/16		41	42	43	44	45			
5/8		46	47	48	49	50	51	52	53
3/4			54	55	56	57	58	59	60
7/8	± .015		61	62	63	64	65	66	
1				67	68	69	70	71	
1-1/4						73	74	75	
1-1/2						77	78	79	
1-3/4		± .020	For lengths above heavy line see note (g)					81	82
2						84	85		
2-1/2	± .031							87	
3							88		

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

P.A. Navy - WP Other Cust Army - WC USAF - G9	TITLE SETScrew, HEXAGON SOCKET, CONE POINT, 250° SELF LOCKING ELEMENT, CORROSION RESISTING STEEL, PASSIVATED	MILITARY STANDARD MS18068
PROCUREMENT SPECIFICATION FF-S-200 & MM-F-18240	SUPERSEDES:	SHEET 1 OF 2

APPROVED 4 Jun 63
 REVISED 22 Dec 64