



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, whatever, and the fact that the Government may have furnished technical data in any way implies the use of drawings, specifications, or other data is not to be regarded by implication or otherwise as an assumption by the holder in any way of patent or copyright, or concerning any right of protection or manufacture, nor is it to be regarded as an assumption that any such right may be obtained thereon.

NOMINAL SIZE	2 (.076)	4 (.112)	6 (.138)	8 (.164)	10 (.190)	12 (.216)	14 (.242)
THREADS PER INCH	32	24	18	15	12	11	10
MAJOR DIAMETER D	MAX MIN	.084 .086	.114 .110	.144 .136	.174 .162	.204 .195	.234 .228
MINOR DIAMETER C	MAX MIN	.061 .056	.083 .078	.102 .096	.123 .116	.143 .136	.163 .157
HEAD DIAMETER A	MAX MIN	.167 .155	.219 .205	.270 .256	.322 .306	.373 .357	.424 .407
HEAD HEIGHT N	MAX MIN	.062 .051	.080 .070	.097 .087	.115 .105	.133 .122	.151 .141
RECESS DIAMETER W	MAX MIN	.104 .091	.122 .109	.146 .133	.182 .169	.219 .206	.259 .246
RECESS DEPTH T	MAX MIN	.059 .051	.078 .060	.091 .066	.108 .082	.124 .100	.141 .115
RECESS WIDTH Y	MIN	.017	.019	.028	.030	.031	.036
RADIUS K		.020	.020	.025	.025	.025	.030
DEPTH OF GAGE PENETRATION	MAX MIN	.052 .034	.071 .053	.080 .055	.097 .071	.113 .089	.124 .099
DRIVER SIZE		1	1	2	2	3	3

LENGTH	L	TOLERANCE	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.
3/16			1						
1/4			2	8	16				
5/16			3	9	17	27			
3/8		± 1/32	4	10	18	28	32	42	
1/2				11	19	29	40	50	68
5/8				12	20	30	41	51	69
3/4				13	21	31	42	52	70
7/8					22	32	43	53	71
1					23	33	44	54	72
1-1/4						34	45	55	73
1-1/2		± 3/64				35	46	56	74
1-3/4							47		
2							48		

**MATERIAL:** Steel, corrosion resisting, in accordance with Federal Standard No. 66, Steel Nos. 410 or 420 (Hardened).  
**FINISH:** Passivated.  
**THREADS:** Thread types to be in accordance with applicable requirements of procurement specification.  
**RECESS:** Except for dimensions W, T, Y, K and Depth of Gage Penetration the recess shall be in accordance with MS 9006.  
**SHORT LENGTHS:** Lengths above dotted line have fine pitch threads.  
**HOLE SIZES:** For approximate hole sizes see MS 24611.  
**DIMENSIONS:** All dimensions are in inches unless otherwise specified.  
**PART NUMBER:** The MS part number consists of the MS number plus the dash number. Example MS 24618-1.  
**NOTES:** (1) For design feature purposes, this standard takes precedence over procurement documents referenced herein.  
 (2) Referenced documents shall be of the issue in effect on date of invitations for bid.

**(B) CANCELLED - SEE SHEET 2**

**(B) FOR CHANGES SEE SHEETS 1 & 2**

P.A. WC Other Cast SM 82	TITLE COREW, TAPPING-THREAD FORMING, TYPE A, PAN HEAD, CROSS RECESSED, CORROSION RESISTING STEEL	MILITARY STANDARD	
		<b>MS 24618</b>	
PROCUREMENT SPECIFICATION FF-S-107	SUPERSEDES MS 24618	SHEET 1	OF 2

This military standard is approved by the Department of Defense and is mandatory on all parties. Substitution for all non-engineering and design applications and if regulations are made shall be made from this document.

The screws covered by the following dash numbers listed in MS 24618 are cancelled after 25 Feb 1963. Use the dash numbers given in Sheet 1. The cancelled screws cannot always replace the superseding screws and should be used until existing stocks are depleted. Use only the superseding screws for design and engineering. Replacement shall be in accordance with the table below.

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CROSS REFERENCE	
CANCELLED	SUPPERSED BY
MS 24618	MS 24618
DASH NO.	DASH NO.
1	8
2	10
3	11
4	12
5	13
10	16
11	18
12	19
13	20
14	21
15	22
16	23
22	28
23	29
24	30
25	31
26	32
27	33
28	34
29	35
31	38
34	40
35	41
36	42
37	43
38	44
39	45
40	46
41	47
42	48
45	50
46	51
47	52
48	53
49	54
50	55
51	56
56	58
57	59
58	60
59	61
60	62
61	63
62	64
63	65
64	66

(B)

CANCELLED AFTER 27 AUG 1969  
 USE MS51861.  
 FOR INTERCHANGEABILITY RELATIONSHIP  
 SEE MS51861.

This military standard is approved by the Department of Defense and is mandatory on all activities. Substitutions for all new engineering and design applications and for replacement are shall be made from this document.

P.A. WC	TITLE	MILITARY STANDARD
Other Code	SCREW, TAPPING-THREAD FORMING, TYPE A, PAN HEAD, CROSS RECESSED, CORROSION RESISTING STEEL	MS24618
SH 82		
PROCUREMENT SPECIFICATION FY-3-107	SUPERSEDES MS 24618	SHEET 1

FOR CHANGES SEE SHEETS 1 & 2