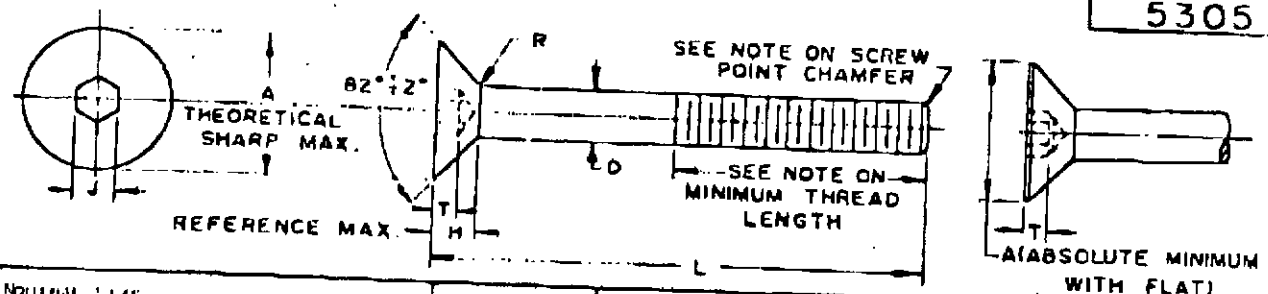
FED. SUP CLASS
5305



Nominal Size		#10 (.190)	1/4	5/16	3/8	1/2
Threads Per Inch		32UNF-3A	28UNF-3A	24UNF-3A	24UNF-3A	20UNF-3A
D Body Diameter	Max Min	.190 .1867	.250 .2464	.3125 .3074	.375 .3705	.500 .4868
A Head Diameter	Theor. Sharp Max Assy. Min	.411 .359	.531 .480	.656 .600	.781 .720	.937 .872
H Head Height	Reference Max	.127	.161	.198	.234	.251
J Socket Width Across Flats	Max Min	.1270 .1250	.1902 .1562	.1895 .1875	.2207 .2187	.3155 .3125
T Key Engagement	Min	.047	.111	.135	.159	.172
R Radius	Max	.019	.025	.031	.037	.050
Minimum Breaking Strength	Lbs	1400	2550	4060	6150	11200

L Length	Tol.	Dash No.	Fin	Dash No.	Fin	Dash No.	Fin	Dash No.	Fin	Dash No.	Fin
3/8 1/2 5/8 3/4 1	+1/16 -1/16	1 2 3 4 5		9 10 11 12 13		17 18 19 20 21		25 26 27 28		32 33	
1-1/4 1-1/2 1-3/4 2	+1/32 -1/16	6 7		14 15		22 23		29 30		34 35 36 37	

MATERIAL: STEEL, CORROSION RESISTING, IN ACCORDANCE WITH FEDERAL STANDARD #66, CLASS 303 OR CLASS 304; ULTIMATE LOAD - 70,000 PSI MIN TENSILE STRENGTH; PROOF LOAD - 30,000 PSI MIN YIELD STRENGTH; ELONGATION - 35 PERCENT MIN.

PROTECTIVE COATING: PASSIVATED IN ACCORDANCE WITH THE PROCUREMENT SPECIFICATION.

THREADS: THE THREADS SHALL BE IN ACCORDANCE WITH SCREW-THREAD STANDARDS FOR FEDERAL SERVICES, HANDBOOK H-28.

MINIMUM THREAD LENGTH: THE MINIMUM USABLE THREAD LENGTH SHALL BE EQUAL TO 2D PLUS 1/2". THE THREAD LENGTH TOLERANCE SHALL BE EQUAL TO THE NOMINAL DIAMETER. SCREWS TOO SHORT FOR APPLICATION OF THE FORMULA SHALL BE THREADED AS CLOSE TO THE HEAD AS PRACTICABLE.

POINT CHAMFER: THE POINTS SHALL BE FLAT AND CHAMFERED. THE FLAT SHALL BE NORMAL TO THE AXIS OF THE SCREW. THE CHAMFER SHALL EXTEND SLIGHTLY BELOW THE ROOT OF THE THREAD AND THE EDGE BETWEEN THE FLAT AND THE CHAMFER MAY BE ROUNDED. THE INCLUDED ANGLE OF THE THREADED POINT SHALL BE APPROXIMATELY 90°. CHAMFERING OF SCREW SIZES UP TO AND INCLUDING #8 SHALL BE AT THE OPTION OF THE MANUFACTURER.

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: MS24672-1.

NOTES: (1) REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.
(2) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.

(A) CANCELLED AFTER 27 MAR. 61.
NO SUPERSEDING STANDARD

APPROVED 27 MAR. 61 REVISED (A)

P.A.	TITLE	MILITARY STANDARD
Ord Other Cogs Ships	SCREW, CAP, SOCKET HEAD, FLAT COUNTERSUNK, CORROSION RESISTING STEEL, UNF-3A	MS24672
PROCUREMENT SPECIFICATION PF-S-86	SUPERSEDES	SHEET 1 OF 1