



FULL HEAD UNDERCUT HEAD

NOMINAL SIZE D	#0 (.0600)	#1 (.0730)	#2 (.0870)	#4 (.1120)	#6 (.1380)	#8 (.1640)	#10 (.1900)	1/4 (.2500)
THREADS PER INCH	30NF	22NF	14NF	43NF	40NF	32NF	32NF	23UNF
BODY DIAMETER D _E	Max .0600 Min .049	Max .0730 Min .0615	Max .0870 Min .0733	Max .1120 Min .0954	Max .1380 Min .1184	Max .1640 Min .1424	Max .1900 Min .1658	Max .2500 Min .2225
HEAD DIAMETER A	Max Sharp .119 Min Sharp .105 Abs Min .101	Max Sharp .141 Min Sharp .130 Abs Min .126	Max Sharp .172 Min Sharp .156 Abs Min .150	Max Sharp .225 Min Sharp .207 Abs Min .200	Max Sharp .279 Min Sharp .257 Abs Min .249	Max Sharp .332 Min Sharp .308 Abs Min .300	Max Sharp .395 Min Sharp .359 Abs Min .348	Max Sharp .507 Min Sharp .477 Abs Min .462
SLOT WIDTH J	Max .023 Min .016	Max .026 Min .019	Max .031 Min .023	Max .039 Min .031	Max .048 Min .039	Max .054 Min .045	Max .060 Min .050	Max .075 Min .064
FLAT S	Max .002	Max .003	Max .003	Max .004	Max .005	Max .006	Max .007	Max .009
RADIUS R	Max .025	Max .027	Max .031	Max .041	Max .050	Max .055	Max .062	Max .071
FULL HEAD	HEAD HEIGHT H	Max .035 Min .026	Max .043 Min .033	Max .051 Min .040	Max .077 Min .055	Max .093 Min .069	Max .100 Min .084	Max .116 Min .098
	SLOT DEPTH T	Max .015 Min .010	Max .019 Min .012	Max .023 Min .015	Max .030 Min .020	Max .038 Min .024	Max .045 Min .029	Max .053 Min .034
UNDERCUT HEAD	HEAD HEIGHT H ₁	Max .025 Min .017	Max .032 Min .022	Max .037 Min .026	Max .048 Min .036	Max .060 Min .048	Max .071 Min .055	Max .083 Min .065
	SLOT DEPTH T ₁	Max .012 Min .010	Max .016 Min .012	Max .019 Min .015	Max .025 Min .020	Max .032 Min .024	Max .037 Min .029	Max .044 Min .034
LENGTH L	Tolerance	Dash No.	Dash No.	Dash No.	Dash No.	Dash No.	Dash No.	Dash No.
THREADS SHALL EXTEND TO WITHIN 2 THREADS OF THE BEARING SURFACE OF THE HEAD, OR CLOSER IF PRACTICABLE.	1/8	+0 -1/32	1	6	13	22	33	48
	3/16		2	7	14	23	34	49
	1/4		3	8	15	24	35	50
	5/16		4	9	16	25	36	51
	3/8	5	10	17	26	37	52	
	7/16	11	18	27	38	53	70	
	1/2	12	19	28	39	54	71	
	5/8	20	29	40	55	73	72	
	3/4	21	30	41	56	74	73	
	7/8	31	42	57	75	91	92	
1	32	43	58	76	93	94		
1-1/4	44	59	77	94	95	96		
1-1/2	45	60	78	95	96	97		
1-3/4	46	61	79	96	97	98		
2	47	62	80	97	98	99		
Minimum complete thread length of 1-3/4.	2-1/4	+0 -3/32	63	81	98	99	100	
	2-1/2	64	82	99	100	101		
	2-3/4	65	83	100				
	3	66	84	101				

CANCELLED
SEE SHEET 2

MATERIAL: Corrosion Resisting Steel, Specification QQ-S-763, 70,000 PSI minimum tensile strength, minimum elongation 16% in 2 inches.
FINISH: Passivated by immersion for a period of 20 minutes in a solution containing 15% (by weight) of nitric acid at a temperature of 70°F ±5°, followed by a thorough rinse in hot water.
THREADS: The threads shall be in accordance with Screw-Thread Standards for Federal Services Handbook H-28.
HEAD MARKING: For corrosion resisting steel screws. Only one visible dash necessary after slotting operation. Position optional. Screws size #4 and smaller require no head markings.
NOTES: (1) Referenced documents of issue in effect on date of invitation for bids shall apply.
 (2) In case of conflict with any referenced document, this standard will govern.
 (3) The MS part number consists of the MS sheet number, plus the dash number. Example: MS 35250-1.
 (4) Sizes above dotted line have undercut head.
 (5) All dimensions in inches.

(A) For changes see sheets 1 and 2.

APPROVED FEB 9, 1954 REVISED 19 DEC 63

P.A. WC	TITLE	MILITARY STANDARD
Other Cust Ships MOAMA	SCREW, MACHINE, FLAT COUNTERSUNK HEAD, SLOTTED, CORROSION RESISTING STEEL, PASSIVATED, NF-2A AND UNF-2A	MS 35250
PROCUREMENT SPECIFICATION PP-3-92	SUPERSEDES:	SHEET 1 OF 2

NOMINAL SIZE D		5/16 (.3125)	3/8 (.3750)	7/16 (.4375)	1/2 (.5000)	9/16 (.5625)	5/8 (.6250)	3/4 (.7500)	
THREADS PER INCH		24UNF	24UNF	20UNF	20UNF	18UNF	18UNF	14UNF	
BODY DIAMETER D _E	Max	.3125	.3750	.4375	.5000	.5625	.6250	.7500	
	Min	.2900	.3430	.3995	.4619	.5205	.5825	.7029	
HEAD DIAMETER A	Max Sharp	.335	.402	.4812	.575	1.000	1.125	1.375	
	Min Sharp	.600	.722	.771	.831	.940	1.009	1.306	
	Abs Min	.581	.700	.743	.902	.919	1.035	1.207	
SLOT WIDTH J	Max	.084	.094	.094	.100	.119	.133	.149	
	Min	.072	.081	.081	.091	.102	.116	.131	
FLAT S	Max	.011	.013	.016	.018	.020	.023	.027	
RADIUS R	Max	.083	.083	.100	.100	.110	.110	.125	
	Min	.191	.230	.223	.223	.260	.298	.372	
FULL HEAD HEAD HEIGHT H	Max	.191	.230	.223	.223	.260	.298	.372	
	Min	.165	.200	.190	.186	.220	.253	.319	
SLOT DEPTH T	Max	.088	.106	.103	.103	.120	.137	.171	
	Min	.058	.070	.066	.065	.077	.099	.111	
UNDERCUT HEAD HEAD HEIGHT H ₁	Max	.135	.162	.156	.160	.195	.212	.264	
	Min	.109	.132	.126	.123	.145	.167	.211	
SLOT DEPTH T ₁	Max	.073	.088	.085	.085	.100	.114	.142	
	Min	.058	.070	.066	.065	.077	.099	.111	

LENGTH L	Tolerance	Dash No.	Dash No.	Dash No.	Dash No.	Dash No.	Dash No.	Dash No.
THREADS SHALL EXTEND TO WITHIN 2 THREADS OF THE BEARING SURFACE OF THE HEAD, OR CLOSER IF PRACTICABLE	+0 -1/32	1/8						
		3/16						
		1/4						
		5/16						
		3/8	102					
	7/16	103						
	1/2	104	117					
	5/8	105	118	130				
	3/4	106	119	131	142			
	7/8	107	120	132	143	153		
+0 -1/16	1	108	121	133	144	154	164	173
	1-1/4	109	122	134	145	155	165	174
	1-1/2	110	123	135	146	156	166	175
	1-3/4	111	124	136	147	157	167	176
	2	112	125	137	148	158	168	177
Minimum complete thread length of 1-3/4.	2-1/4	113	126	138	149	159	169	178
	2-1/2	114	127	139	150	160	170	179
	2-3/4	115	128	140	151	161	171	180
3	116	129	141	152	162	172	181	

Ⓐ CANCELLED
SEE NOTE

NOTE: For illustration, material, finish, and other pertinent data see sheet 1.

Ⓐ CANCELLED AFTER 19 Dec 1963 USE M351960. INTERCHANGEABILITY RELATIONSHIP-M351960 can replace the cancelled screws of the same size. The cancelled MS35250 cannot always replace MS51960 and should be used until existing stock is depleted. Then use only the superseding MS screws of the same size for design and replacement.

APPROVED FEB 9, 1964 REVISED Ⓐ FOR CHANGES SEE SHEETS 1 AND 2

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PROCUREMENT SPECIFICATION FF-3-92	SUPERSEDES:	SHEET 2 OF