



TABLE I

NOMINAL SIZE		.086	.112	.138	.164	.190	.250	.3125	.375
THREADS PER INCH, UNC-2A		56	40	32	32	24	20	18	16
D. BODY DIAMETER	MAX	.0860	.1120	.1380	.1640	.1900	.2500	.3125	.3750
	MIN	.0717	.0925	.1141	.1399	.1586	.2127	.2712	.3287
A HEAD DIAMETER	MAX	.140	.183	.226	.270	.313	.414	.518	.622
	MIN	.124	.166	.208	.250	.292	.389	.490	.590
H HEAD SIDE HEIGHT	MAX	.062	.079	.096	.113	.130	.170	.211	.253
	MIN	.055	.072	.089	.106	.123	.161	.201	.242
O TOTAL HEAD HEIGHT	MAX	.083	.107	.132	.156	.180	.237	.295	.355
	MIN	.070	.094	.118	.141	.165	.219	.276	.333
J SLOT WIDTH	MAX	.031	.039	.048	.054	.060	.075	.084	.094
	MIN	.023	.031	.039	.045	.050	.064	.072	.081
T SLOT DEPTH	MAX	.030	.038	.045	.065	.075	.102	.130	.154
	MIN	.022	.030	.035	.054	.064	.087	.110	.134
E DRILL LOCATION	NOM	.026	.035	.043	.043	.043	.062	.078	.094
F DRILLED HOLE DIA	NOM	.031	.037	.046	.046	.046	.062	.070	.070
R RADIUS	MAX	.013	.017	.021	.025	.028	.038	.047	.056
TENSILE STRENGTH, LBS-MIN		225	370	560	860	1,080	1,970	3,250	4,800
L LENGTH	TOLERANCE	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.*	DASH NO.*	DASH NO.*	DASH NO.*
.12		1	11	24	39				
.19		2	12	25	40	58			
.25		3	13	26	41	59	76		
.31		4	14	27	42	60	76		
.38	+.00	5	15	28	43	61	77	92	
.44		6	16	29	44	62	78	93	
.50		7	17	30	45	63	79	94	107
.62		8	18	31	46	64	80	95	108
.75	-.03	9	19	32	47	65	81	96	109
.88		10	20	33	48	66	82	97	110
1.00			21	34	49	67	83	98	111
1.25			22	35	50	68	84	99	112
1.50	+.00		23	36	51	69	85	100	113
1.75			37	37	52	70	86	101	114
2.00	-.06			38	53	71	87	102	115
2.25					54	72	88	103	116
2.50	+.00			55	55	73	89	104	117
2.75				56	56	74	90	105	118
3.00				57	57	75	91	106	119

(B) * Dash numbers 58 thru 119 are INACTIVE FOR NEW DESIGN AFTER 6 March 1974.

(B) FOR CHANGES SEE SHEETS 1 AND 2.

This military standard is approved for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

REVISOR: AV, IS, USER: AS, AT, MC, ME, OS, SH, WV, YD

APPROVED 9 FEB 1954 REVISED (A) 18 JUN 1962 (B) 6 MAR 1974

P.A. VC Other Code 82	TITLE SCREW, MACHINE-DRILLED FILLISTER HEAD, SLOTTED, ALUMINUM ALLOY, UNC-2A	MILITARY STANDARD MS 35277
PROCUREMENT SPECIFICATION FF-S-92	SUPERSEDES: MS35361 in part; MS35366 in part	SHEET 1 OF 2

NOTES:

- 1. **MATERIAL:** Aluminum alloy, 2024, in accordance with QQ-A-200/3 or QQ-A-225/6. The minimum ultimate tensile strength shall be 62,000 PSI.
- 2. **PROTECTIVE COATING:** Anodized in accordance with MIL-A-8625, Type I or II, Class 1.
- 3. **THREADS:** The threads shall be in accordance with Screw-Thread Standards for Federal Services, Handbook M28.
- 4. **DIMENSIONS:** All dimensions in Table I are in inches. All dimensions in Table II are in millimetres.
- 5. **PART NUMBER:** The MS part number consists of the MS number, plus the dash number. Example: MS35277-1.
- 6. **THREAD LENGTH:** Full form threads shall extend to within 2 threads or less of head bearing surface for lengths thru 2.00 inches/50.80 millimetres. Longer lengths shall have a minimum full form thread length of 1.50 inches/38.10 millimetres.
- 7. The drilled hole shall be approximately at a right angle to the slot and may be permitted to break through the bottom of the slot. All burrs and sharp edges shall be removed.
- 8. Referenced documents shall be of the issue in effect on date of invitations for bid.
- 9. For design feature purposes, this standard takes precedence over procurement documents referenced herein.

TABLE II
METRIC TRANSLATION OF TABLE I

NOMINAL SIZE		2.18	2.84	3.51	4.17	4.83	6.35	7.94	9.52
THREAD PITCH		.45	.64	.79	.79	1.06	1.27	1.41	1.59
D BODY DIAMETER	MAX	2.18	2.84	3.51	4.17	4.83	6.35	7.94	9.52
	MIN	1.82	2.35	2.90	3.55	4.03	5.40	6.89	8.35
A HEAD DIAMETER	MAX	3.56	4.65	5.74	6.86	7.95	10.52	13.16	15.80
	MIN	3.15	4.22	5.28	6.35	7.42	9.88	12.45	14.99
H HEAD SIDE HEIGHT	MAX	1.57	2.01	2.44	2.87	3.30	4.32	5.36	6.43
	MIN	1.40	1.83	2.26	2.69	3.12	4.09	5.11	6.15
O TOTAL HEAD HEIGHT	MAX	2.11	2.72	3.35	3.96	4.57	6.02	7.49	9.02
	MIN	1.78	2.39	3.00	3.58	4.19	5.56	7.01	8.46
J SLOT WIDTH	MAX	.79	.99	1.22	1.37	1.52	1.90	2.13	2.39
	MIN	.58	.79	.99	1.14	1.27	1.63	1.83	2.06
Y SLOT DEPTH	MAX	.76	.97	1.14	1.65	1.90	2.59	3.30	3.91
	MIN	.56	.76	.89	1.37	1.63	2.21	2.79	3.40
E DRILL LOCATION	NOM	.66	.89	1.09	1.09	1.09	1.57	1.98	2.39
F DRILLED HOLE DIA	NOM	.79	.94	1.17	1.17	1.17	1.57	1.78	1.78
R RADIUS	MAX	.33	.43	.53	.64	.71	.97	1.19	1.42

L LENGTH	TOLERANCE	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.*	DASH NO.*	DASH NO.*	DASH NO.*
3.05		1	11	24	39				
4.83		2	12	25	40				
6.35		3	13	26	41				
7.87		4	14	27	42				
9.65	+.00	5	15	28	43	61	77	92	
11.18		6	16	29	44	62	78	93	
12.70	-.76	7	17	30	45	63	79	94	107
15.75		8	18	31	46	64	80	95	108
19.05		9	19	32	47	65	81	96	109
22.35		10	20	33	48	66	82	97	110
25.40			21	34	49	67	83	98	111
31.75	+.00		22	35	50	68	84	99	112
38.10				36	51	69	85	100	113
44.45				23	37	52	70	86	101
50.80	-1.52			38	53	71	87	102	114
									115
57.15	+.00								
63.50					54	72	88	103	116
69.85					55	73	89	104	117
76.20					56	74	90	105	118
	-2.29				57	75	91	106	119

* Dash numbers 58 thru 119 are INACTIVE FOR NEW DESIGN AFTER 6 March 1974.

APPROVED 9 FEB 1954 REVISED (A) 18 JUN 1962 (B) FOR CHANGES SEE SHEETS 1 AND 2.

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REVIEWER: AV, IS USER: AS, AT, MC, ME, OS, SH, VV, YD

P.A. VC Other Com 82	TITLE SCREW, MACHINE-DRILLED FILLISTER HEAD, SLOTTED, ALUMINUM ALLOY, UNC-2A	MILITARY STANDARD MS 35277
PROCUREMENT SPECIFICATION FF-S-92	SUPERSEDES: MS35361 in part; MS35366 in part	SHEET 2 OF 2

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSALOMB Approval
No. 22-R255

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DOCUMENT IDENTIFIER AND TITLE MS35277 Rev B, Screw, Machine-Drilled Fillister
Head, Slotted, Aluminum Alloy, UNC-2A

NAME OF ORGANIZATION AND ADDRESS

CONTRACT NUMBER

MATERIAL PROCURED UNDER A

 DIRECT GOVERNMENT CONTRACT SUBCONTRACT

1. HAS ANY PART OF THE DOCUMENT CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE?

A. GIVE PARAGRAPH NUMBER AND WORDING.

B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES

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