FED SUPCLASS 5305

USER ACTIVITIES
ARMY-ME
NAVY-OS

REVIEWER ACTIVITIES ARMY-AV, CR, E.A. AIR FORCE - 82 DL.A-IS NSA-NS

This multiary 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 when applicable

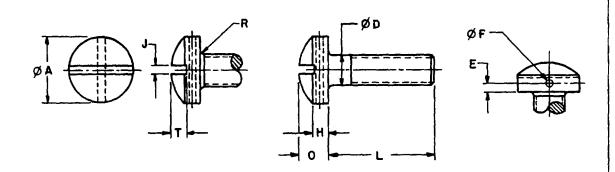


TABLE I DIMENSIONS AND PART NUMBERS. NOMINAL SIZE - - - - - - - -.164 190 250 .112 .138 THREADS PER INCH 40 32 32 24 20 MAX MIN .1900 1586 .2500 .2127 .1380 ØD - BODY .1120 .1640 0925 .1141 1399 ØA - READ .1830 .1660 DIAMETER .2260 2700 313 .292 .2500 MTN 2080 .389 .1130 130 .123 H - HEAD SIZE MAX .0790 0960 MIN .0720 HEIGHT 0890 .161 .237 O - TOTAL HEAD MAX 1070 .1320 .1560 .180 HEIGHT - -MIN 0940 1180 .1410 165 .075 .064 J - SLOT WIDTH MAX .0390 .0480 .0540 .060 0310 .0390 0450 .050 .0380 0300 .0450 .0350 0650 .0540 102 .087 T - SLOT DEPTH MAX 075 064 MIN E - DRILL LOCATION MOM .0350 .0430 .0430 .043 062 - - -- DRITLED HOLE MOM .0370 0460 .0460 .046 .062 DIAMETER - - - - -R - RADIUS - - - - -MAX .0170 .0210 .0250 .028 **.03**8 362 840 1,908 TENSILE LOAD, LBS - MIN 545 1,050 DASH NO DASH NO OM READ DASH NO L - LENGTH DASH NO .375 +.000 3 -.031 1.500 +.000 4 5 6

PA	A D	INTERNATIONAL		CODEW MACHINE DOUGED BY LICEP	MILITARY STANDARD			
	SH 99			SCREW, MACHINE, DRILLED FILLISTER HEAD, SLOTTED, CARBON STEEL, UNC-2A	MS	51	48	3
PROCUREMENT SPECIFICATION FF-S-92		SUPERS	SUPERSEDES		ı	OF	2	

REVISED

1 AUG 1984

REQUIREMENTS:

- MATERIAL. CARBON STEEL IN ACCORDANCE WITH ASTM A29-79 GRADE 1015 (UNS G10150) THRU GRADE 1030 (UNS G10300) OR ASTM A29-79 GRADE 1116 (UNS G11160) THRU GRADE 1132 (UNS G11320). THE MINIMUM ULTIMATE TENSILE STRENGTH SHALL BE 60,000 PSI.
- 2. FINISH, ZINC COATED IN ACCORDANCE WITH ASTM B633-78, Fe/Z_n5 (5 μm), TYPE II.
- THREADS. THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/2. ACCEPTABILITY OF SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/20, SYSTEM 21.
- 4. THREAD LENGTH. FULL FORM THREADS SHALL EXTEND TO WITHIN 2 THREADS OR LESS OF HEAD BEARING SURFACE FOR LENGTHS THRU 2.00 INCHES. LONGER LENGTHS SHALL HAVE A MINIMUM FULL FORM THREAD LENGTH OF 1.500 INCHES. THREADS SHALL NOT EXTEND TO THE R RADIUS DIMENSON NOR SHALL THREADS EXTEND TO AND UNDERCUT THE HEAD OF THE SCREW.
- 5. PART NUMBER. THE BASIC MS PART NUMBER IS FOLLOWED BY A DASH NUMBER FROM TABLE 1.

EXAMPLE: MS51483-1 - SCREW, MACHINE, DRILLED FILLISTER HEAD, SLOTTED, CARBON STEEL, 112-40UNC-2A, LENGTH .375, ZINC COATED

NOTES:

- 1. ALL DIMENSIONS ARE IN INCHES.
- 2. 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.
- REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BIDS OR REQUEST FOR PROPOSAL, EXCEPT THAT REFERENCED ADOPTED INDUSTRY DOCUMENTS SHALL GIVE THE DATE OF THE ISSUE ADOPTED.
- 4. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.

INTERNATIONAL MILITARY STANDARD PA AR SCREW, MACHINE, DRILLED FILLISTER Other Cust HEAD, SLOTTED, CARBON STEEL, UNC-2A SH MS51483 99 PROCUREMENT SPECIFICATION SUPERSEDES PAGE 2 2 FF-S-92