



TABLE I DIMENSIONS AND PART NUMBERS.

NOMINAL SIZE - - - - -		.112	.138	.164	190	250
THREADS PER INCH UNC-2A - - - - -		40	32	32	24	20
ØD - BODY DIAMETER - - - - -	MAX MIN	.1120 0925	.1380 .1141	.1640 1399	.1900 1586	.2500 .2127
ØA - HEAD DIAMETER - - - - -	MAX MIN	.1830 .1660	.2260 2080	.2700 .2500	.313 .292	.414 .389
H - HEAD SIZE HEIGHT - - - - -	MAX MIN	.0790 .0720	.0960 0890	.1130 .1060	.130 .123	.170 .161
O - TOTAL HEAD HEIGHT - - - - -	MAX MIN	.1070 0940	.1320 1180	.1560 .1410	.180 165	.237 .219
J - SLOT WIDTH - - - - -	MAX MIN	.0390 0310	.0480 .0390	.0540 0450	.060 .050	.075 .064
T - SLOT DEPTH - - - - -	MAX MIN	.0380 0300	.0450 .0350	.0650 .0540	.075 064	.102 .087
E - DRILL LOCATION - - -	NOM	.0350	.0430	.0430	.043	.062
ØF - DRILLED HOLE DIAMETER - - - - -	NOM	.0370	.0460	.0460	.046	.062
R - RADIUS - - - - -	MAX	.0170	.0210	.0250	.028	.038
TENSILE LOAD, LBS - MIN		362	545	840	1,050	1,908
L - LENGTH		DASH NO	DASH NO	DASH NO	DASH NO	DASH NO
.375 +.000 -.031		1	2	3		
1.500 +.000 -.062				4	5	6

USER ACTIVITIES
ARMY - ME
NAVY - OS

REVIEWER ACTIVITIES
ARMY - AV, CR, EA
AIR FORCE - 82
DLA - IS
NSA - NS

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 when applicable

REVISED
APPROVED | AUG 1984

P A Other Cust	AR	INTERNATIONAL INTEREST	TITLE SCREW, MACHINE, DRILLED FILLISTER HEAD, SLOTTED, CARBON STEEL, UNC-2A	MILITARY STANDARD	
	SH 99			MS51483	
PROCUREMENT SPECIFICATION FF-S-92		SUPERSEDES	PAGE	1	OF 2

REQUIREMENTS:

1. 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/Zn₅ (5 μm), TYPE II.
3. 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 DIMENSION 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 I.

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.
3. 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.

USER ACTIVITIES
ARMY - ME
NAVY - OS

REVIEWER ACTIVITIES
ARMY - AV, CR, EA
AIR FORCE
DLA - IS
NSA - NS

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 when applicable.

APPROVED 1 AUG 84
REVISED

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