



TABLE I. DIMENSIONS AND PART NUMBERS.

NOMINAL SIZE		.112	.139	.164	.190
THREADS PER INCH		40	32	32	24
ØD - MAJOR DIAMETER	MAX	.1120	.1390	.1640	.1900
	MIN	.1072	.1326	.1586	.1834
ØA - HEAD DIAMETER	MAX	.2190	.2700	.3220	.3730
	MIN	.2050	.2560	.3060	.3570
H - HEAD HEIGHT	MAX	.0800	.0970	.1150	.1330
	MIN	.0700	.0870	.1050	.1220
ØP - POINT DIAMETER	MAX	.0860	.1060	.1320	.1470
	MIN	.0770	.0950	.1210	.1330
L - LENGTH	TOLERANCE	DASH NO	DASH NO	DASH NO	DASH NO
.375 .500	+ .000 - .031	1 (GRIP MIN .231)	2 (GRIP MIN .203)	3 (GRIP MIN .328)	4 (GRIP MIN .281)

REQUIREMENTS:

- MATERIAL.** CARBON STEEL IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.
- FINISH.** ZINC COATING IN ACCORDANCE WITH ASTM B633-78, Fe/Zn 5 (5 µm), TYPE II.
- THREADS.** THE THREADS TO BE IN ACCORDANCE WITH APPLICABLE REQUIREMENTS OF PROCUREMENT SPECIFICATIONS.
- HEAT TREATMENT.** CASE HARDEN OR HEAT TREATMENT TO MEET PERFORMANCE REQUIREMENTS OF PROCUREMENT SPECIFICATIONS.
- RECESS.** THE RECESS SHALL BE IN ACCORDANCE WITH MS9006.
- PART NUMBER.** THE BASIC MS PART NUMBER IS FOLLOWED BY A DASH NUMBER FROM TABLE I.

EXAMPLE: MS51485-1 - SCREW, TAPPING, THREAD CUTTING, TYPES D, F, G OR T PAN HEAD, CROSS-RECESSED, CARBON STEEL, NOMINAL SIZE .112, LENGTH .375, ZINC COATED

7. **TAPE LENGTH.** THE TAPE LENGTH IS 2.500 TO 3.500 TIMES THE PITCH DISTANCE FOR SCREWS HAVING A THREAD LENGTH OF 8 PITCHES OR LESS.

NOTES:

- ALL DIMENSIONS ARE IN INCHES.
- TYPE DESIGNATIONS ARE ESTABLISHED BY THE PROCUREMENT SPECIFICATION.
- FOR AERONAUTICAL APPLICATIONS, THESE SCREWS ARE SUBJECT TO MS33749 LIMITATION AND INSTALLATION REQUIREMENTS.
- 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.
- FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.

USER ACTIVITIES
ARMY - MI
NAVY - MC, OS

REVIEWER ACTIVITIES
ARMY - 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.

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PA	AR	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
Other Cust	SH		SCREW, TAPPING, THREAD CUTTING, TYPES D, F, G, OR T PAN HEAD, CROSS-RECESSED, CARBON STEEL	MS51485
	99			
PROCUREMENT SPECIFICATION	SUPERSEDES		PAGE	OF
FF-S-107			1	1