

DIMENSIONS	RECESS NUMBER					
	0	1	2	3	4	5
0 +.002 -.000	.032	.050	.090	.150	.200	.311
B	.0250 ±.0010	.0380 <sup>+.0000</sup> <sub>-.0010</sub>	.0578 ±.0010	.0950 ±.0010	.1370 ±.0010	.2270 ±.0010
MILLING ANGLE	7° <sup>+15'</sup> <sub>-0</sub>	7° <sup>+15'</sup> <sub>-0</sub>	5°45' <sup>+15'</sup> <sub>-0</sub>	5°45' <sup>+15'</sup> <sub>-0</sub>	7° <sup>+15'</sup> <sub>-0</sub>	7° <sup>+15'</sup> <sub>-0</sub>
POINT ANGLE	28° <sup>+0</sup> <sub>-1°</sub>	28° <sup>+0</sup> <sub>-1°</sub>	28° <sup>+0</sup> <sub>-1°</sub>	28° <sup>+0</sup> <sub>-1°</sub>	28° <sup>+0</sup> <sub>-1°</sub>	28° <sup>+0</sup> <sub>-1°</sub>
WING ANGLE <sup>+15'</sup> <sub>-0</sub> (C)	26°30'	26°30'	26°30'	26°30'	26°30'	26°30'
BASE FLUTE ANGLE <sup>+0</sup> <sub>-15'</sub>	---	138°	140°	146°	153°	162°46'
SIDE FLUTE ANGLE	92° <sup>+0</sup> <sub>-15'</sub>	92° <sup>+0</sup> <sub>-15'</sub>	92° <sup>+0</sup> <sub>-15'</sub>	92° <sup>+0</sup> <sub>-15'</sub>	92° <sup>+0</sup> <sub>-15'</sub>	92° <sup>+0</sup> <sub>-15'</sub>
WIDTH OF BOTTOM OF FLUTE	.0140 .0104	.0180 .0160	.0330 .0310	.0800 .0780	.0960 .0960	.1640 .1590
WING THICKNESS F	.014 .012	.021 .019	.029 .026	.032 .029	.050 .047	.070 .067
A	.0101 .0075 (C)	---	---	---	---	---

(a) UNLESS OTHERWISE SPECIFIED, USE SHEET 4 VALUES FOR DIMENSIONS W, T, N, K, AND DEPTH OF GAGE PENETRATIONS. IF THE SHEET 4 VALUES ARE NOT COMPATIBLE WITH THE HEAD CONFIGURATION AND PERFORMANCE REQUIREMENTS OF A PARTICULAR ITEM, THE VALUES WILL BE SPECIFIED ON THE ITEM STANDARD.

SHEETS 1 AND 2 OF THIS STANDARD ARE THE SUBJECT OF INTERNATIONAL STANDARDIZATION AGREEMENT ABC AIR STD 17/30. WHEN REVISION OR CANCELLATION OF THIS STANDARD IS PROPOSED, THE DEPARTMENTAL CUSTODIANS WILL INFORM THEIR RESPECTIVE DEPARTMENTAL STANDARDIZATION OFFICES SO THAT APPROPRIATE ACTION MAY BE TAKEN RESPECTING THE INTERNATIONAL AGREEMENT CONCERNED.

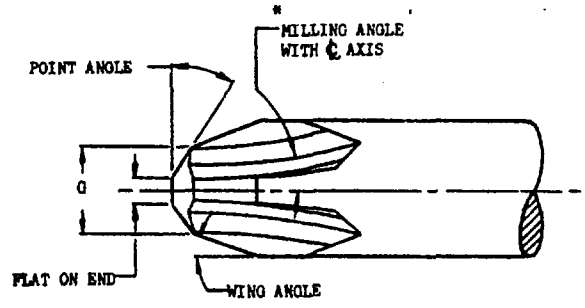
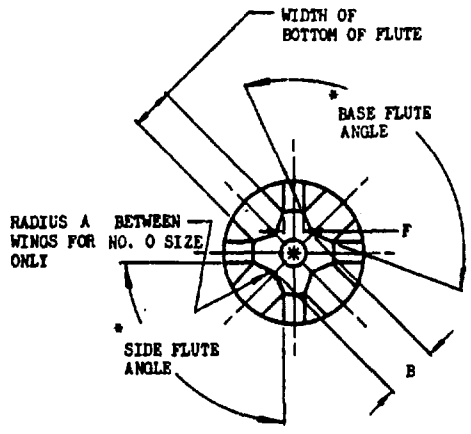
THIS IS A DESIGN STANDARD. NOT TO BE USED AS A PART NUMBER. (C) FOR CHANGES SEE SHEETS 2, 3, ...

P.A. USAF - ASD Other Cust Army - WC Navy - Maps	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
		RECESSES - CROSS, LOW TORQUE DRIVE, DIMENSIONS AND GAGE DIMENSIONS FOR	MS9006
PROCUREMENT SPECIFICATION NONE	SUPERSEDES: MS9001 THRU MS9005, MS33578 AND ANDI0477 (C)		SHEET 1 OF 4

NOTICE—When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility, nor any obligation whatsoever; and the fact that the Government may have furnished, or in any way supplied, the said drawings, specifications, or other data is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

This article is approved by the Department of Defense and is mandatory on all activities. Submission for all new engineering and design applications and for repetitive use shall be made from this document.

APPROVED 1 049 57 REVISED (A) 13 Oct 54 (B) 21 Nov 51 (C) 20 Jun 53



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DIMENSIONS	DIMENSIONS OF GAGE POINTS					
	RECESS NUMBER (C)					
	0	1	2	3	4	5
G +.001 -.000	.032	.050	.090	.150	.200	.311
B +.0000 -.0010	.0240	.0394	.0606	.0983	.1407	.2310
MILLING ANGLE	7° +0 -15'	7° +0 -15'	5°45' +0 -15'	5°45' +0 -15'	7° +0 -15'	7° +0 -15'
POINT ANGLE	18° +1° -0	18° +1° -0	18° +1° -0	18° +1° -0	18° +1° -0	18° +1° -0
FLAT ON END	.015 .010	.020 .015	.020 .015	.020 .015	.020 .015	.025 .020
WING ANGLE +0 -15'	26°30'	26°30'	26°30'	26°30'	26°30'	26°30'
BASE FLUTE ANGLE +15' -0	- - -	138°	140°	146°	153°	162°46'
SIDE FLUTE ANGLE +15' -0	92°	92°	92°	92°	92°	92°
WIDTH OF BOTTOM OF FLUTE	.0151 .0125	.0202 .0192	.0434 .0424	.0826 .0816	.1078 .1068	.1730 .1720
WING THICKNESS F	.012 .010	.020 .018	.025 .023	.031 .029	.044 .042	.063 .061
A	.0109 .0090	- - -	- - -	- - -	- - -	- - -

This military standard is approved by the Department of Defense and is mandatory on all activities. Solicitation for all new engineering and design applications and for repetitive use shall be made from this document.

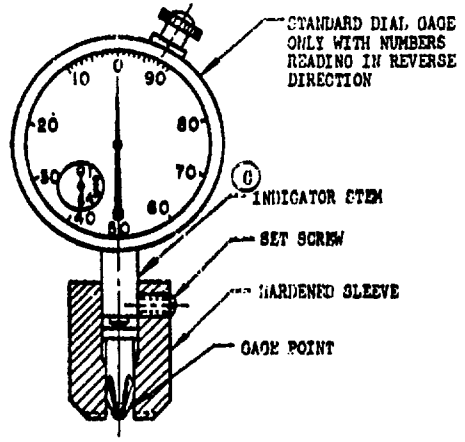
THIS IS A DESIGN STANDARD. NOT TO BE USED AS A PART NUMBER.

P. A. USAF - ASD Other Code Army - WC Navy - Mops	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
		RECESSES - CROSS, LOW TORQUE DRIVE, DIMENSIONS AND GAGE DIMENSIONS FOR	MS9006
PROCUREMENT SPECIFICATION NONE	SUPERSEDES: MS9001 THRU MS9005, 1533578 AND AND10477	(C)	SHEET 2

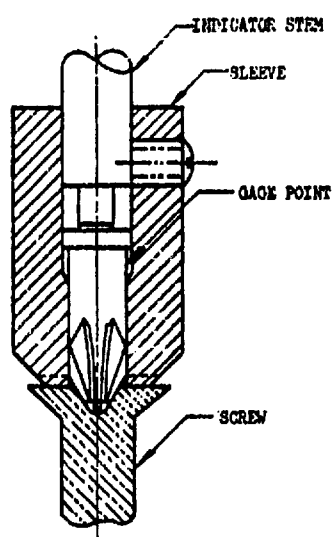
APPROVED 1 Aug 57 REVISED (C) FOR CHANGES SEE SHEETS 1, 2, 3

NOTICE—When Government drawings, specifications, or other data are used for any purpose other than a definitely related Government procurement operation, the United States Government thereby incurs no responsibility, nor any obligation whatsoever, and the fact that the Government may have furnished, furnished, or in any way supplied the said drawings, specifications, or other data is not to be regarded by implication or otherwise as in any manner forming the basis or a part thereof or in any way constituting an endorsement, approval, or recommendation of the manufacturer, user, or seller of any product or material shown or referred to in this document, or conveying any right of permission to manufacture, use, or sell any patented invention that may, in any way, be related thereto.

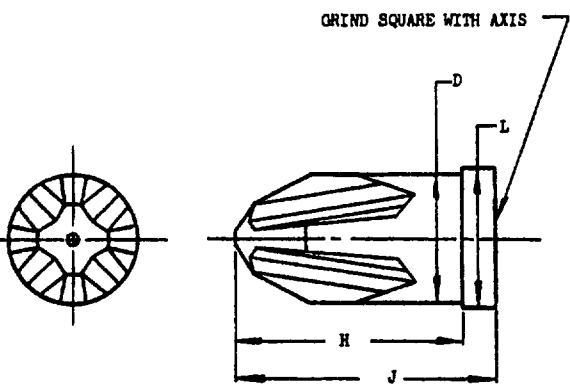
This military standard is approved by the Department of Defense and is mandatory on all activities. Selection for all new engineering and design applications and for repetitive use shall be made from this document.



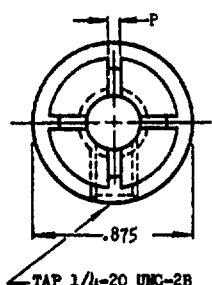
GAGE ASSEMBLY



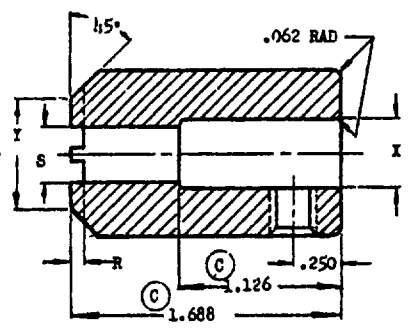
GAGE SHOWN IN GAGING POSITION



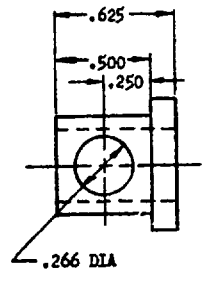
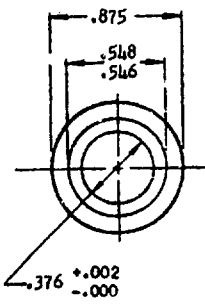
GAGE POINT



SLEEVE



RECESS NUMBER	GAGE POINT				SLEEVE				
	D ±.0002 SHANK DIA	H ±.005	J ±.005	L ±.005 DIA	P ±.002	R ±.003	S ±.0002 DIA	X +.002 -.000 DIA	Y ±.005 DIA
0	.0450	.656	.781	.094	.008	.015	.0460		
1	.0870	.688	.812	.156	.012	.020	.0880		
2	.1410	.750	.875	.219	.018	.031	.1420	.376	.562
3	.2090	.781	.906	.250	.022	.037	.2100		
4	.3120	.844	.969	.359	.031	.062	.3130		
5	.500	1.031	1.156	.531	.041	.094	.5010	.549	.750



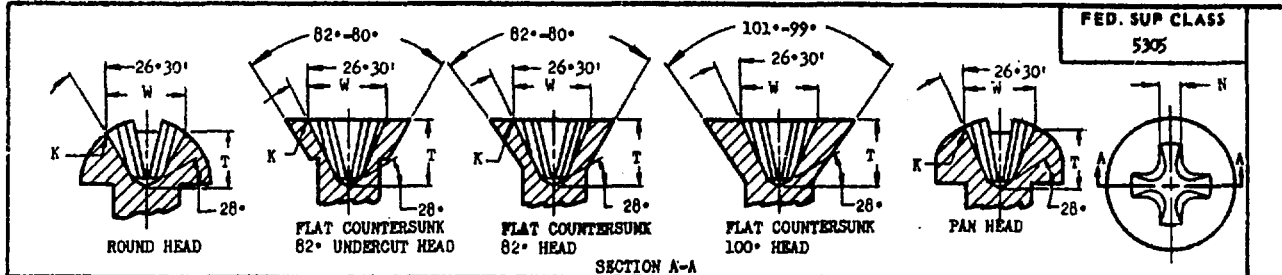
BUSHING FOR NO. 5 GAGE SLEEVE

DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS ±.016. FOR DRIVER DATA, SEE GOG-S-121.

THIS IS A DESIGN STANDARD. NOT TO BE USED AS A PART NUMBER.

P.A. USAP-ASD Other Cust Army-NC Navy-Maps	INTERNATIONAL INTEREST	TITLE  RECESSES - CROSS, LOW TORQUE DRIVE, DIMENSIONS AND GAGE DIMENSIONS FOR	MILITARY STANDARD <b>MS9006</b>
PROCUREMENT SPECIFICATION NONE	SUPERSEDES: MS9001 THRU MS9005, MS33578, AND AND10L77		SHEET 3

NOTICE.—When Government drawings, specifications, or other data are used for any purpose other than that for which they were prepared, the Government assumes no responsibility, and it is hereby disclaimed, in any drawing, specification, or other data, in any way supplied the said drawings, specifications, or other data, is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.



FED. SUP CLASS  
5305

NOM SIZE	W		T		N		K	DRIVER SIZE	DEPTH OF PENETRATION		NOM SIZE	W		T		N		K	DRIVER SIZE	DEPTH OF PENETRATION						
	DIAMETER OF RECESS		DEPTH OF RECESS		WIDTH OF RECESS				MAX			MIN		DIAMETER OF RECESS		DEPTH OF RECESS				WIDTH OF RECESS		MAX		MIN		
	MAX	MIN	MAX	MIN	MAX	MIN			MAX	MIN		MAX	MIN	MAX	MIN	MAX	MIN			MAX	MIN	MAX	MIN	MAX	MIN	
ROUND HEAD WOOD SCREWS																										
0	.073	.060	.042	.011	.010	0	.035	.015	0	.069	.056	.043	.011	.010	0	.036	.020	0	.077	.064	.051	.015	.010	0	.044	.028
1	.082	.069	.052	.015	.010	0	.045	.026	1	.102	.089	.063	.017	.020	1	.056	.040	1	.107	.094	.068	.018	.020	1	.061	.045
2	.114	.101	.064	.018	.020	1	.057	.035	2	.128	.115	.089	.018	.020	1	.082	.066	2	.154	.141	.086	.027	.025	2	.075	.052
3	.122	.109	.073	.019	.020	1	.066	.045	3	.174	.161	.106	.029	.025	2	.095	.072	3	.174	.161	.106	.029	.025	2	.110	.087
4	.130	.117	.083	.019	.020	1	.076	.056	4	.189	.176	.121	.030	.025	2	.110	.087	4	.204	.191	.136	.032	.025	2	.125	.102
5	.154	.141	.074	.027	.025	2	.063	.035	5	.214	.201	.146	.033	.025	2	.135	.112	5	.214	.201	.146	.033	.025	2	.135	.112
6	.162	.149	.084	.027	.025	2	.073	.045	6	.258	.245	.146	.034	.030	3	.129	.106	6	.258	.245	.146	.034	.030	3	.129	.106
7	.170	.157	.092	.028	.025	2	.081	.055	7	.283	.270	.171	.036	.030	3	.154	.131	7	.283	.270	.171	.036	.030	3	.154	.131
8	.178	.165	.101	.030	.025	2	.090	.064	8	.303	.290	.191	.039	.030	3	.174	.151	8	.303	.290	.191	.039	.030	3	.174	.151
9	.186	.173	.110	.030	.025	2	.099	.073	9	.327	.314	.216	.045	.030	3	.199	.176	9	.327	.314	.216	.045	.030	3	.199	.176
10	.195	.182	.119	.031	.025	2	.108	.082	10	.378	.365	.230	.062	.035	4	.210	.188	10	.378	.365	.230	.062	.035	4	.210	.188
12	.249	.236	.125	.032	.030	3	.108	.082	12	.393	.380	.245	.065	.035	4	.225	.203	12	.393	.380	.245	.065	.035	4	.225	.203
14	.265	.252	.142	.034	.030	3	.125	.099	14	.424	.411	.276	.069	.035	4	.256	.234	14	.424	.411	.276	.069	.035	4	.256	.234
16	.281	.268	.159	.038	.030	3	.142	.119	16									16								
18	.339	.326	.176	.057	.035	4	.156	.131	18									18								
20	.356	.343	.194	.059	.035	4	.174	.148	20									20								
24	.387	.374	.228	.064	.035	4	.208	.182	24									24								

FLAT COUNTERSUNK 82° UNDERCUT HEAD MACHINE AND TAPPING SCREWS (EXCEPT TYPE "A" (b))																	
NOM SIZE	W		T		N		K	DRIVER SIZE	DEPTH OF PENETRATION								
	DIAMETER OF RECESS		DEPTH OF RECESS		WIDTH OF RECESS				MAX		MIN						
	MAX	MIN	MAX	MIN	MAX	MIN			MAX	MIN	MAX	MIN					
0	.069	.056	.043	.011	.010	0	.036	.020	0	.069	.056	.043	.011	.010	0	.036	.020
1	.077	.064	.051	.015	.010	0	.044	.028	1	.102	.089	.063	.017	.020	1	.056	.040
2	.095	.082	.056	.017	.020	1	.049	.033	2	.128	.115	.089	.018	.020	1	.082	.066
3	.122	.109	.063	.018	.020	1	.056	.040	3	.174	.161	.106	.029	.025	2	.095	.072
4	.117	.104	.078	.018	.020	1	.071	.055	4	.189	.176	.121	.030	.025	2	.110	.087
5	.128	.115	.089	.018	.020	1	.082	.066	5	.214	.201	.146	.033	.025	2	.135	.112
6	.146	.133	.078	.025	.025	2	.057	.044	6	.258	.245	.146	.034	.030	3	.129	.106
7	.154	.141	.086	.027	.025	2	.075	.052	7	.283	.270	.171	.036	.030	3	.154	.131
8	.174	.161	.106	.029	.025	2	.095	.072	8	.303	.290	.191	.039	.030	3	.174	.151
10	.189	.176	.121	.030	.025	2	.110	.087	10	.327	.314	.216	.045	.030	3	.199	.176
12	.233	.220	.121	.030	.030	3	.104	.081	12	.378	.365	.230	.062	.035	4	.210	.188
1/4	.250	.237	.136	.032	.030	3	.119	.096	1/4	.393	.380	.245	.065	.035	4	.225	.203
5/16	.317	.304	.168	.053	.035	4	.148	.126	5/16	.409	.396	.261	.068	.035	4	.241	.219
3/8	.365	.352	.216	.061	.035	4	.196	.174	3/8								
7/16	.393	.380	.245	.065	.035	4	.225	.203	7/16								
1/2	.409	.396	.261	.068	.035	4	.241	.219	1/2								

FLAT COUNTERSUNK 82° HEAD MACHINE AND TAPPING SCREWS (EXCEPT TYPE "A" (b))																	
NOM SIZE	W		T		N		K	DRIVER SIZE	DEPTH OF PENETRATION								
	DIAMETER OF RECESS		DEPTH OF RECESS		WIDTH OF RECESS				MAX		MIN						
	MAX	MIN	MAX	MIN	MAX	MIN			MAX	MIN	MAX	MIN					
0	.069	.056	.043	.011	.010	0	.036	.020	0	.069	.056	.043	.011	.010	0	.036	.020
1	.077	.064	.051	.015	.010	0	.044	.028	1	.102	.089	.063	.017	.020	1	.056	.040
2	.095	.082	.056	.017	.020	1	.049	.033	2	.128	.115	.089	.018	.020	1	.082	.066
3	.122	.109	.063	.018	.020	1	.056	.040	3	.174	.161	.106	.029	.025	2	.095	.072
4	.117	.104	.078	.018	.020	1	.071	.055	4	.189	.176	.121	.030	.025	2	.110	.087
5	.128	.115	.089	.018	.020	1	.082	.066	5	.214	.201	.146	.033	.025	2	.135	.112
6	.146	.133	.078	.025	.025	2	.057	.044	6	.258	.245	.146	.034	.030	3	.129	.106
7	.154	.141	.086	.027	.025	2	.075	.052	7	.283	.270	.171	.036	.030	3	.154	.131
8	.174	.161	.106	.029	.025	2	.095	.072	8	.303	.290	.191	.039	.030	3	.174	.151
10	.189	.176	.121	.030	.025	2	.110	.087	10	.327	.314	.216	.045	.030	3	.199	.176
12	.233	.220	.121	.030	.030	3	.104	.081	12	.378	.365	.230	.062	.035	4	.210	.188
1/4	.250	.237	.136	.032	.030	3	.119	.096	1/4	.393	.380	.245	.065	.035	4	.225	.203
5/16	.317	.304	.168	.053	.035	4	.148	.126	5/16	.409	.396	.261	.068	.035	4	.241	.219
3/8	.365	.352	.216	.061	.035	4	.196	.174	3/8								
7/16	.393	.380	.245	.065	.035	4	.225	.203	7/16								
1/2	.409	.396	.261	.068	.035	4	.241	.219	1/2								

PAN HEAD MACHINE AND TAPPING SCREWS (EXCEPT TYPE "A" (b))																	
NOM SIZE	W		T		N		K	DRIVER SIZE	DEPTH OF PENETRATION								
	DIAMETER OF RECESS		DEPTH OF RECESS		WIDTH OF RECESS				MAX		MIN						
	MAX	MIN	MAX	MIN	MAX	MIN			MAX	MIN	MAX	MIN					
0	.067	.054	.039	.013	.010	0	.032	.014	0	.095	.082	.056	.012	.020	1	.049	.033
1	.074	.061	.045	.014	.010	0	.040	.022	1	.102	.089	.063	.014	.020	1	.056	.040
2	.104	.091	.059	.017	.020	1	.052	.034	2	.128	.115	.089	.018	.020	1	.071	.055
3	.112	.099	.068	.019	.020	1	.061	.043	3	.174	.161	.106	.029	.025	2	.075	.052
4	.122	.109	.078	.019	.020	1	.071	.053	4	.189	.176	.121	.030	.025	2	.090	.067
5	.158	.145	.083	.028	.025	2	.072	.046	5	.214	.201	.146	.033	.025	2	.105	.082
6	.166	.153	.091	.028	.025	2	.080	.055	6	.258	.245	.146	.034	.030	3	.118	.095
7	.176	.163	.100	.029	.025	2	.089	.064	7	.283	.270	.171	.036	.030	3	.148	.126
8	.182	.169	.109	.030	.025	2	.097	.071	8	.303	.290	.191	.039	.030	3	.173	.151
10	.199	.186	.124	.031	.025	2	.113	.089	10	.327	.314	.216	.045	.030	3	.198	.176
12	.259	.246	.141	.034	.030	3	.124	.098	12	.378	.365	.230	.062	.035	4	.226	.204
1/4	.281	.268	.161	.036	.030	3	.144	.118	1/4	.393	.380	.245	.065	.035	4	.256	.234
5/16	.330	.317	.193	.059	.035	4	.173	.149	5/16	.409	.396	.261	.068	.035	4	.256	.234
3/8	.389	.376	.233	.065	.035	4	.213	.190	3/8								
7/16	.413	.400	.259	.065	.035	4	.239	.214	7/16								
1/2	.439	.422	.280	.071	.035	4	.260	.235	1/2								

(b) - R TAPPING ON COARSE-LEAD SCREW WITH A GIMLET POINT.

FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.

THIS IS A DESIGN STANDARD. NOT TO BE USED AS A PART NUMBER.

P.A. USAF ASD Other Cust	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
Army - HQ Navy - Naps		RECESSES - CROSS, LOW TORQUE DRIVE, DIMENSIONS AND GAGE DIMENSIONS FOR	MS9006
PROCUREMENT SPECIFICATION NONE	SUPERSEDES: MS9001 THRU MS9005 MS33578, AND AND10477		SHEET 4

NOTICE  
OF VALIDATION

INCH-POUND

MS9006C  
NOTICE 1  
3 October 1991

MILITARY STANDARD

RECESSES-CROSS, LOW TORQUE DRIVE,  
DIMENSIONS AND GAGE DIMENSIONS FOR

MS9006C, dated 20 June 1963, has been reviewed and determined to be valid for use in acquisition.

Custodians:  
Army - AR  
Navy - AS  
Air Force - 99

Preparing activity:  
Navy - AS