

FED. SUPPLY CLASS

5305

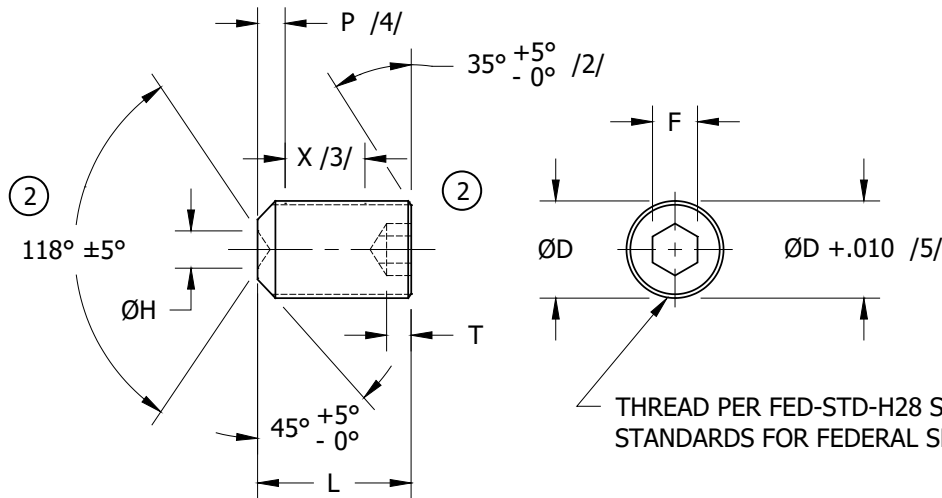


TABLE I – DIMENSIONS

THREAD	ØD MAX	F		ØH		SELF-LOCKING DESIGN DATA	T HEX DEPTH
		MAX	MIN	MAX	MIN	P / 4/ 50° MAX	
.1120-40 UNC-3A	.112	.0510	.0500	.061	.051	.062	.040
.1380-32 UNC-3A	.138	.0635	.0625	.074	.064	.076	.050
.1640-32 UNC-3A	.164	.0791	.0781	.087	.076	.085	.062
.1900-32 UNF-3A	.190	.0947	.0937	.102	.088	.093	.075
.2500-28 UNF-3A	.250	.1270	.1250	.132	.118	.116	.100
.3125-24 UNF-3A	.3125	.1582	.1562	.172	.156	.136	.125
.3750-24 UNF-3A	.375	.1895	.1875	.212	.194	.151	.150
.5000-20 UNF-3A	.500	.2520	.2500	.291	.270	.188	.200

MATERIAL: ② CRES – AIR 4127, NUMBERS 302, 303, 304, 316 OR EQUAL TO OR INTERCHANGEABLE WITH 16-18 CHROMIUM-NICKEL ALLOY STEEL.

FINISH: PASSIVATED (SEE PROCUREMENT SPECIFICATION).

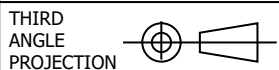
CODE:

② MS18064 - 57
BASIC NUMBER DASH NUMBER (TABLE II)

EXAMPLE OF PART NUMBER:

② MS18064-57 = .2500-28 UNF-3A x .750 LONG CRES CUP POINT SELF-LOCKING SET SCREW.

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS18064, REVISION A. PART NUMBERS REMAIN MS18064.



THIRD
ANGLE
PROJECTION

CUSTODIAN
NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION
2

PROCUREMENT
SPECIFICATION
MIL-DTL-18240

TITLE
**SETSCREW, HEXAGON SOCKET, CUP POINT, 250 °F,
SELF-LOCKING ELEMENT, CRES, PASSIVATED**

CLASSIFICATION
PART STANDARD

MS18064
SHEET 1 OF 3

NOTES:

- /1/ UNASSIGNED DASH NUMBERS SHALL NOT BE USED.
- /2/ SOCKET END OF SCREW SHALL BE FLAT AND CHAMFERED. THE CHAMFER SHALL EXTEND TO THE MINOR DIAMETER OF THE THREAD AND THE EDGE BETWEEN FLAT AND CHAMFER SHALL BE SLIGHTLY ROUNDED.
- /3/ LOCATION OF EFFECTIVE LOCKING AREA "X" SHALL BE IN ACCORDANCE WITH NASM15981 EXCEPT AS NOTED HEREIN.
- /4/ P_{MAX} = MAXIMUM POINT PLUS MINIMUM OF 1 THREAD PITCH. FOR EASE IN STARTING, LOCKING ELEMENT SHALL NOT BE EFFECTIVE WITHIN THIS AREA.
- /5/ MAXIMUM MAJOR THREAD DIAMETER PLUS .010 = MAXIMUM RING GAGE DIAMETER THAT LOCKING REGION OF PART MUST PASS THROUGH FREELY OR WITH FINGER PRESSURE.
- (6) SEE NASM51021 AND NASM51023 FOR SET SCREWS WITHOUT SELF-LOCKING FEATURE.
- /7/ AS MIL-DTL-18240 DOESN'T ESTABLISH TORQUE REQUIREMENTS FOR ITEMS ABOVE THE HEAVY LINE, ONLY A POSITIVE INDICATION OF TORQUE IS REQUIRED.
- (8) LOCKING ELEMENT IN ACCORDANCE WITH SPECIFICATION MIL-DTL-18240.
- (9) DESIGN AND USAGE LIMITATIONS: SEE NASM15981.
- (10) MAGNETIC PERMEABILITY SHALL BE LESS THAN 2.0 (AIR = 1.0) FOR A FIELD STRENGTH $H = 200$ OERSTEDS USING A MAGNETIC PERMEABILITY INDICATOR PER ASTM A342/A342M, TEST METHOD 3.
- (11) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (12) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (13) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (14) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- (15) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

REVISION

2

NASM18064

SHEET 2



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