

FED. SUPPLY CLASS

5305

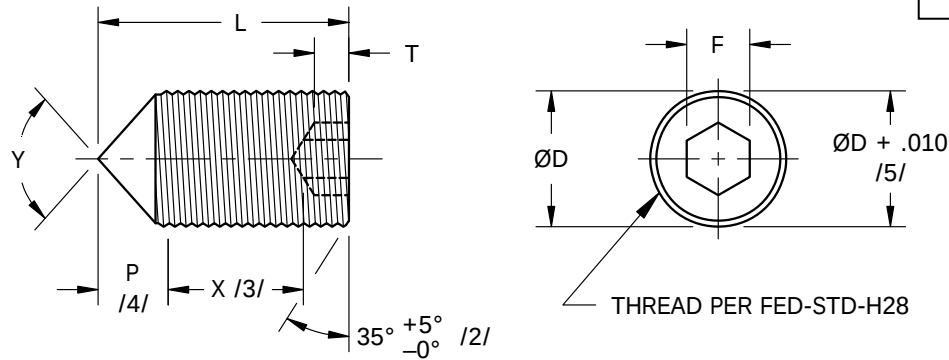


TABLE I – DIMENSIONS

THREAD	ØD MAX	F		Y		SELF-LOCKING DESIGN DATA		T HEX DEPTH
				118° ± 2° FOR LENGTHS AND UNDER	90° ± 2° FOR LENGTHS AND OVER	P MAX /4/		
		MAX	MIN			116°	88°	MIN
#4-40 NC-3A	.1120	.0510	.0500	1/8	5/32	.060	.083	.040
#6-32 NC-3A	.1380	.0635	.0625	1/8	3/16	.075	.104	.050
#8-32 NC-3A	.1640	.0791	.0781	3/16	1/4	.084	.117	.062
#10-32 NF-3A	.1900	.0947	.0937	3/16	1/4	.092	.131	.075
1/4-28 UNF-3A	.2500	.1270	.1250	1/4	5/16	.114	.166	.100
5/16-24 UNF-3A	.3125	.1582	.1562	5/16	3/8	.139	.204	.125
3/8-24 UNF-3A	.3750	.1895	.1875	3/8	7/16	.159	.236	.150
1/2-20 UNF-3A	.5000	.2520	.2500	1/2	9/16	.206	.309	.200

MATERIAL:

STEEL, ALLOY (SEE PROCUREMENT SPECIFICATION).

HEAT TREATMENT:

HARDENED BY QUENCHING IN OIL FROM THE HARDENING TEMPERATURE AND TEMPERED TO A ROCKWELL HARDNESS OF 33-40 HRC OR EQUIVALENT.

FINISH:

STEEL: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 3, EXCEPT THAT EXCEPT THAT HYDROGEN EMBRITTLEMENT RELIEF TESTING IS NOT APPLICABLE.

① COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS18067, REVISION A. PART NUMBERS REMAIN MS18067.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
PROCUREMENT SPECIFICATION FF-S-200 & MIL-DTL-18240	TITLE SETSCREW, HEXAGON SOCKET, CONE POINT, 250 °F, SELF LOCKING ELEMENT, ALLOY STEEL, CADMIUM PLATED	CLASSIFICATION PART STANDARD MS18067

EXAMPLE OF PART NUMBER:

MS18067-57 = 1/4-28 UNF-3A X 3/4 LONG CADMIUM PLATED STEEL CONE POINT SELF-LOCKING SET SCREW.

NOTES:

- /1/ UNASSIGNED DASH NUMBERS 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 THRU FREELY OR WITH FINGER PRESSURE.
- (6) SEE MS51937 AND NASM51974 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) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (11) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (12) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (13) 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.
- (14) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
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THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME
PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST
REVISION DATE.

FORM 09-01

① COMPLETELY REVISED

REVISION
1
NASM18067
SHEET 2



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