

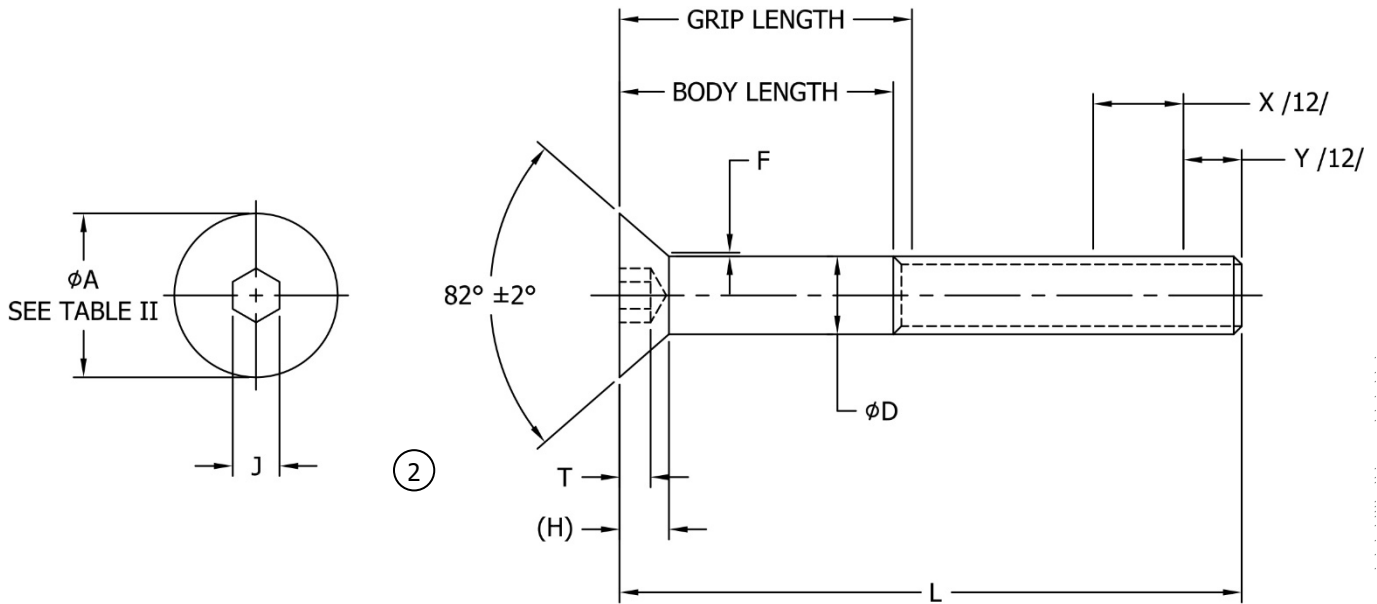


FIGURE 1 – SCREW CONFIGURATION

TABLE I – DIMENSIONS AND STRENGTH VALUES

NOMINAL SIZE	THREADS PER INCH UNC-3A	ØD BODY		(H) HEAD HEIGHT	J SOCKET SIZE NOM	F FILLET EXTENSION ABOVE ØD MAX	T MINIMUM KEY ENGAGE- MENT	TENSILE STRENGTH LBF MIN
		MAX	MIN					
.1120	40	.1120	.1075	.083	.062	.012	.055	900
.1380	32	.1380	.1329	.097	.078	.015	.066	1,350
.1640	32	.1640	.1585	.112	.094	.015	.076	2,085
.1900	24	.1900	.1840	.127	.125	.015	.087	2,610
.2500	20	.2500	.2435	.161	.156	.015	.111	4,750
.3125	18	.3125	.3053	.198	.188	.015	.135	7,800
.3750	16	.3750	.3678	.234	.219	.015	.159	11,600
.4375	14	.4375	.4294	.234	.250	.015	.159	15,900
.5000	13	.5000	.4919	.251	.312	.015	.172	21,200
.6250	11	.6250	.6163	.324	.375	.015	.220	33,800
.7500	10	.7500	.7406	.396	.500	.015	.220	50,000

② COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS24667, REVISION D. PART NUMBERS REMAIN MS24667.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION FF-S-86	TITLE SCREW, CAP, SOCKET HEAD, FLAT COUNTERSUNK, 82°, ALLOY STEEL, UNC-3A	CLASSIFICATION PART STANDARD
		MSM24667 SHEET 1 OF 5

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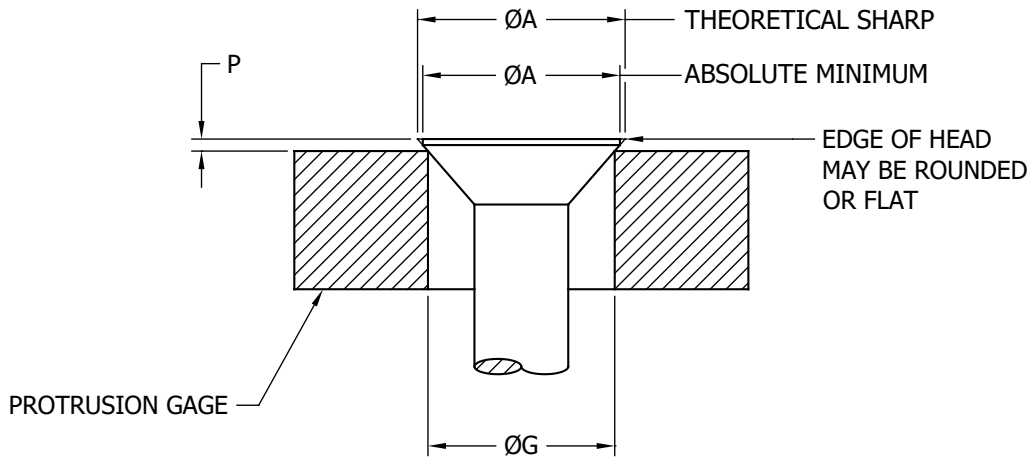


FIGURE 2 – PROTRUSION MEASUREMENT

TABLE II – HEAD RELATED DIMENSIONS /8/

NOMINAL SIZE	ØA HEAD DIAMETER		ØG PROTRUSION GAGE DIAMETER +.000 –.001	P HEAD PROTRUSION	
	THEORETICAL SHARP	ABSOLUTE		MAX	MIN
	MAX	MIN			
.1120	.255	.218	.172	.049	.025
.1380	.307	.263	.220	.052	.023
.1640	.359	.311	.267	.055	.024
.1900	.411	.359	.313	.058	.025
.2500	.531	.480	.424	.064	.031
.3125	.656	.600	.539	.070	.033
.3750	.781	.720	.653	.076	.037
.4375	.844	.781	.690	.092	.050
.5000	.938	.872	.739	.119	.073
.6250	1.188	1.112	.962	.135	.083
.7500	1.438	1.355	1.186	.150	.093

MATERIAL:

ALLOY STEEL, IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.

FINISH:

ZINC COATING IN ACCORDANCE WITH ASTM F1941, TYPE II, CLASS FE/ZN 5 OR BY MECHANICAL PLATING IN ACCORDANCE WITH AMS-C-81562 TYPE II, CLASS 3.

CADMIUM PLATING IN ACCORDANCE WITH AMS-QQ-P-416, TYPE II, CLASS 3. /6/

② BLACK CHEMICAL FINISH IN ACCORDANCE WITH MIL-DTL-13924, CLASS 1 OR MIL-DTL-16232, TYPE M, CLASS 4.

PHOSPHATE COATING IN ACCORDANCE WITH MIL-DTL-16232, TYPE Z, CLASS 2.

HEAT TREATMENT:

HARDNESS IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.

② COMPLETELY REVISED

REVISION

2

NASM24667

SHEET 2



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