

FED. SUPPLY CLASS

5305

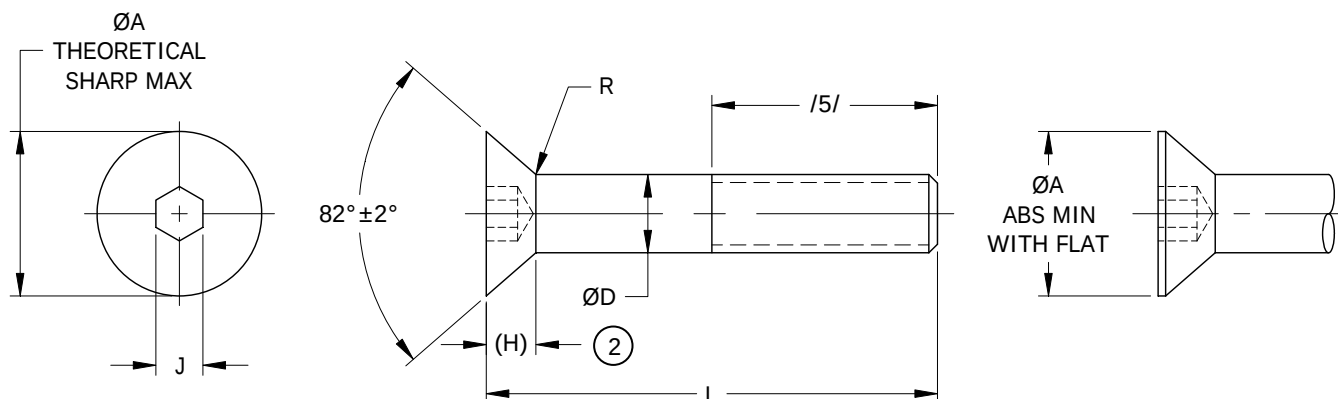


TABLE I – DIMENSIONS

NOMINAL SIZE	.112	.138	.164	.190	.250	.3125	.375	.4375	.500	.625	.750
THREADS PER INCH, UNC-3A	40	32	32	24	20	18	16	14	13	11	10
ØD BODY	MAX .1120 MIN .1075	.1380 .1329	.1640 .1585	.1900 .1840	.2500 .2435	.3125 .3053	.3750 .3678	.4375 .4294	.5000 .4919	.6250 .6163	.7500 .7406
ØA HEAD	SHARP MAX .255 ABS MIN .218	.307 .263	.359 .311	.411 .359	.531 .480	.656 .600	.781 .720	.844 .781	.937 .872	1.188 1.112	1.438 1.355
H HEAD HEIGHT	REF .083	.097	.112	.127	.161	.198	.234	.234	.251	.324	.396
J SOCKET SIZE	NOM .062	.078	.094	.125	.156	.188	.219	.250	.312	.375	.500
R RADIUS	MAX .012	.015	.015	.015	.015	.015	.015	.015	.015	.015	.015
TENSILE STRENGTH, LBF-MIN	480	725	1,120	1,400	2,540	4,190	6,200	8,500	11,300	18,000	23,300
L LENGTH	TOLERANCE		DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.
	SIZE .112 THRU .375	OVER SIZE .375									
.250			1	7							
.375			2	8							
.500			3	9	13	19	27	37			
.625	.+000	.+000	4	10	14	20	28	38	49		
.750	-.030	-.030	5	11	15	21	29	39	50	110	
.875					16	22	30	40	51	62	
1.000										111	
1.250					17	23	31	41	52	63	
1.500						24	32	42	53	64	
1.750	.+000	.+000				25	33	43	54	65	
2.000	-.040	-.060						44	55	66	
2.250								45	56	67	
2.500								46	57	68	
2.750	.+000	.+000						47	58	69	
3.000	-.060	-.080							59	70	
									60	71	
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THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS24671, REVISION C, AMENDMENT 1. PART NUMBERS REMAIN MS24671.

THIRD ANGLE PROJECTION	CUSTODIAN		REVISION
	NATIONAL AEROSPACE STANDARDS COMMITTEE		2
PROCUREMENT SPECIFICATION	TITLE		CLASSIFICATION PART STANDARD
FF-S-86	SCREW, CAP, SOCKET HEAD, FLAT COUNTERSUNK, 82°, CORROSION-RESISTING STEEL, UNC-3A		MS24671

MATERIAL:

STEEL, CORROSION-RESISTING, IN ACCORDANCE WITH ~~AMS-STD-66~~ AIR4127; AISI 302, 303, 304, 305, 316 OR 384 (DEVELOPED FOR COLD HEADING). MINIMUM ULTIMATE TENSILE STRENGTH SHALL BE 80,000 PSI FOR SIZES THRU 0.625 AND 70,000 PSI FOR SIZES OVER 0.625.

FINISH:

PASSIVATED IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4.

EXAMPLE OF PART NUMBER:

THE MS PART NUMBER CONSISTS OF THE MS NUMBER, PLUS THE DASH NUMBER.

EXAMPLE: MS24671-1

NOTES:

- (1) DIMENSIONS APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (2) REMOVE ALL BURRS AND SHARP EDGES.
- (3) 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.
- (4) THREADS SHALL BE IN ACCORDANCE WITH THE PROCUREMENT SPECIFICATION.
- /5/ THREAD LENGTH: MINIMUM FULL FORM THREAD LENGTH SHALL BE EQUAL TO 2D PLUS 0.500 INCH. THE TOLERANCE SHALL BE EQUAL TO THE NOMINAL SIZE. SCREWS TOO SHORT FOR APPLICATION OF THE FORMULA SHALL BE THREADED AS CLOSE TO THE HEAD AS PRACTICABLE.
- (6) DIMENSIONS: ALL DIMENSIONS IN TABLE I ARE IN INCHES. ALL DIMENSIONS IN TABLE II ARE IN MILLIMETERS.
- (7) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (2) (8) 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.
- (9) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- /10/ INACTIVE FOR NEW DESIGN AFTER 20 FEBRUARY 1974.
- (11) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209

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 12-01

REVISION

2

NASM24671

SHEET 2