

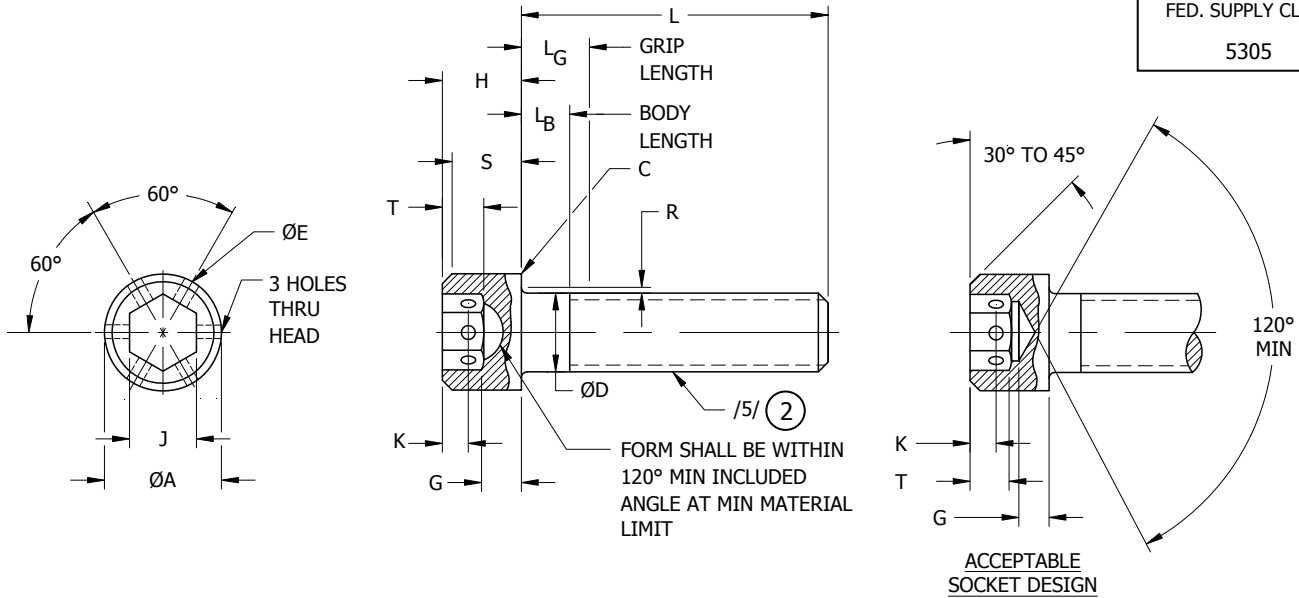


TABLE I - DIMENSIONS

NOMINAL SIZE		#10 (.190)			1/4 (.250)			5/16 (.3125)			3/8 (.375)		
THREADS PER INCH (UNF-3A)		32			28			24			24		
ØD BODY DIAMETER	MAX	.1900			.2500			.3125			.3750		
	MIN	.1840			.2435			.3053			.3678		
ØA HEAD DIAMETER	MAX	.312			.375			.469			.562		
	MIN	.303			.365			.457			.550		
H HEAD HEIGHT	MAX	.190			.250			.312			.375		
	MIN	.185			.244			.306			.368		
S HEAD SIDE HEIGHT	MIN	.171			.225			.281			.337		
J SOCKET WIDTH ACROSS FLATS	MAX	.1587			.1900			.2530			.3160		
	MIN	.1562			.1875			.2500			.3125		
T KEY ENGAGEMENT	MIN	.090			.120			.151			.182		
G WALL THICKNESS	MIN	.065			.095			.119			.143		
C CHAMFER OR RADIUS	MAX	.005			.008			.008			.008		
R FILLET EXTENSION	MAX	.014			.014			.017			.020		
	MIN	.009			.009			.012			.015		
K HOLE LOCATION	MAX	.065			.085			.104			.123		
	MIN	.045			.065			.084			.103		
ØE HOLE DIAMETER	MAX	.050			.050			.050			.067		
	MIN	.044			.044			.044			.061		
RECOMMENDED SAFETY WIRE DIAMETER	MAX	.040			.040			.040			.057		
	MIN	.032			.032			.032			.045		
/9/ ALIGNMENT PLUG DIAMETER		.030			.030			.030			.051		
/10/ TENSILE STRENGTH, LBF		MIN 1,600			2,920			4,640			7,020		
L LENGTH	TOLERANCE	DASH NO.	Lg MAX	Lb MIN	DASH NO.	Lg MAX	Lb MIN	DASH NO.	Lg MAX	Lb MIN	DASH NO.	Lg MAX	Lb MIN
.375	+.00 −.03	-1			-9			-16 -17 -18			-19		
.500		-2			-10								
.625		-3			-11								
.750		-4											
.875		-5											
1.000		-6			-12								
1.250	+.00 −.04	-7	.38	.17	-13						-20 -21 -22		
1.500		-8	.38	.17	-14	.50	.25						

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS24673, REVISION D, AMENDMENT 1. PART NUMBERS REMAIN MS24673.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION FF-S-86	TITLE SCREW, CAP, SOCKET HEAD, HEXAGON, DRILLED CORROSION-RESISTING STEEL (UNF-3A)	CLASSIFICATION PART STANDARD
		NASM24673 SHEET 1 OF 2

MATERIAL:

AUSTENITIC CORROSION-RESISTING STEEL IN ACCORDANCE WITH FF-S-86.

FINISH:

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

CODE:

THE PART NUMBER CONSISTS OF THE MS NUMBER PLUS THE DASH NUMBER FROM TABLE I.

EXAMPLE OF PART NUMBER:

MS24673-1 = SCREW, CORROSION-RESISTING STEEL, .190-32UNF-3A THREAD, .375 LONG.

NOTES:

- (1) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (2) REMOVE ALL BURRS AND SHARP EDGES.
- (3) SCREWS SHALL MEET THE MECHANICAL PROPERTY REQUIREMENTS OF FF-S-86 AS WELL AS THE MAGNETIC PERMEABILITY REQUIREMENTS SPECIFIED IN NOTE 4.
- (4) 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.
- (2) /5/ THREADS SHALL BE IN ACCORDANCE WITH MIL-S-7742.
- (6) SCREWS ABOVE HEAVY LINE SHALL HAVE COMPLETE (FULL FORM) THREADS EXTENDING WITHIN TWO THREADS OF THE HEAD AS MEASURED WITH A THREAD RING GAGE.
- (7) HEAD MAY OR MAY NOT BE KNURLED AT MANUFACTURER'S OPTION. TYPE OF KNURLING OPTIONAL. DIAMETER OF KNURLED HEAD SHALL NOT EXCEED THE MAXIMUM HEAD DIAMETER SPECIFIED
- (8) DRILLED HOLE DATA:
 - (a) EDGES OF THE HOLES ON THE OUTSIDE OF THE HEAD SHALL BE CHAMFERED 45° BY .010 TO .020 DEEP.
 - (b) DRILLED HOLES SHALL BE WITHIN THE FLATS OF THE HEXAGON SOCKET AND SHALL NOT BREAK THE CORNERS OF THE HEXAGON SOCKET.
- /9/ ALIGNMENT PLUG SHALL PASS COMPLETELY THROUGH THE HEAD WITHOUT DEFLECTION.
- /10/ TENSILE STRENGTH BASED ON 80,000 PSI MINIMUM ULTIMATE TENSILE STRENGTH. POUND FORCE (2) CALCULATED BY THE STRESS AREAS INDICATED IN FED-STD-H28.
- (2) (11) 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.
- (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.
- (2) (14) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

REVISION

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ASM24673

SHEET 2



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