

FED. SUPPLY CLASS

5305

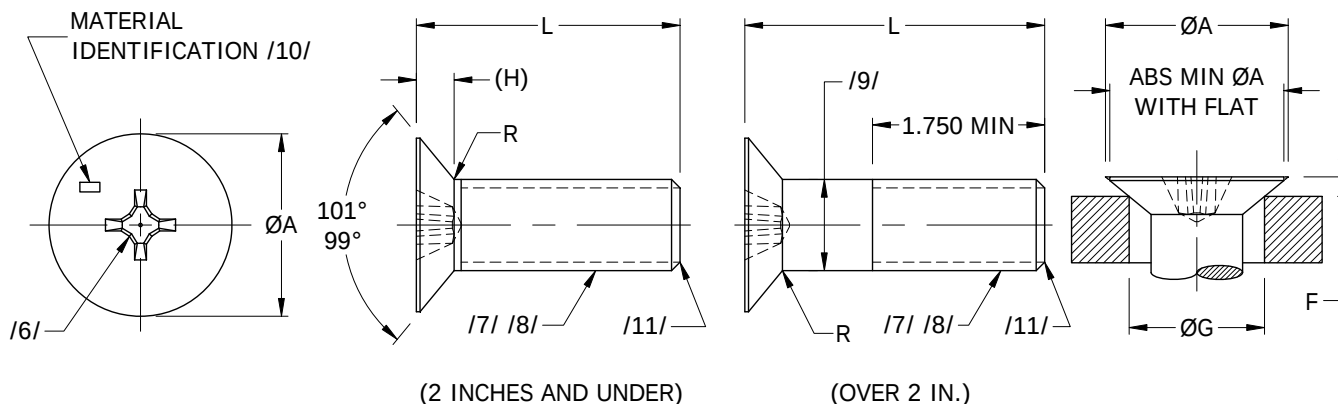


TABLE I – DIMENSIONS

THREAD SIZE	.0600 (#0)	.0860 (#2)	.1120 (#4)	.1380 (#6)	.1640 (#8)	.1900 (#10)	.2500	.3125	.3750
THREADS PER INCH	80	56	40 48	32 40	32 36	24 32	20 28	18 24	16 24
ØA MAX SHARP	.119	.172	.225	.279	.332	.385	.507	.635	.762
ØA MIN SHARP	.104	.156	.207	.257	.308	.359	.477	.600	.722
ØA ABS MIN	.096	.143	.191	.238	.285	.333	.442	.556	.670
PROTRUSION ABOVE F MAX	.020	.022	.025	.028	.031	.034	.040	.047	.053
GAGING DIAMETER F MIN	.012	.014	.016	.017	.019	.021	.025	.030	.034
GAGING DIAMETER ØG	.074	.121	.167	.214	.261	.307	.415	.526	.638
HEAD HEIGHT (H)	.026	.037	.049	.060	.072	.083	.110	.138	.165
FILLET RADIUS R MAX	.007	.008	.015	.015	.020	.020	.020	.025	.030
FILLET RADIUS R MIN	.003	.004	.010	.010	.010	.010	.010	.010	.015

MATERIAL:

ALUMINUM ALLOY PER AMS-QQ-A-225/6. BRASS PER ASTM B16/B16M, ASTM B36/B36M, ASTM B134/B134M OR ASTM B206/B206M.
COPPER-SILICON ALLOY PER ASTM B98/B98M OR ASTM B99/B99M, UNS C65100, UNS C65500 OR UNS C66100.
NICKEL-COPPER ALLOY PER QQ-N-281, TYPE A (UNS N04400).
CARBON STEEL PER ~~AMS-STD-66~~ OR AIR4127.
CORROSION RESISTANT STEEL PER ~~AMS-STD-66~~ OR AIR4127, COMPOSITION 302, 303, 304, 305 OR 316 OR EQUAL TO OR INTERCHANGEABLE WITH 16-18 OR 18-8 CHROMIUM-NICKEL ALLOY STEEL (DEVELOPED FOR COLD HEADING). /5/

HEAT TREATMENT:

ALUMINUM ALLOY SCREWS, 62 KSI MINIMUM ULTIMATE TENSILE STRENGTH IN ACCORDANCE WITH AMS2770.

FINISH:

ANODIZE IN ACCORDANCE WITH MIL-A-8625, TYPE I OR II, CLASS 1.
BLACK CHEMICAL FINISH IN ACCORDANCE WITH MIL-F-495.
BLACK OXIDE COATING IN ACCORDANCE WITH MIL-DTL-13924.
CADMIUM PLATE IN ACCORDANCE WITH AMS-QQ-P-416, TYPE II, CLASS 3.
NICKEL PLATE IN ACCORDANCE WITH AMS2403, .0006 THICK MIN.
PASSIVATE PER AMS2700, METHOD 1, CLASS 4.

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS24693, REVISION K. PART NUMBERS REMAIN MS24693.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 4
PROCUREMENT SPECIFICATION FF-S-92	TITLE SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, CROSS RECESSED, UNC-2A AND UNF-2A	CLASSIFICATION PART STANDARD MS24693

CODE:

"A"	BEFORE DASH NUMBER - ANODIZED, ALUMINUM ALLOY SCREW.
"B"	BEFORE DASH NUMBER - UNCOATED, BRASS SCREW.
"BB"	BEFORE DASH NUMBER - BLACK CHEMICAL FINISH, BRASS SCREW.
"C"	BEFORE DASH NUMBER - PASSIVATED, CORROSION RESISTANT STEEL SCREW.
"CB"	BEFORE DASH NUMBER - CADMIUM PLATED, BRASS SCREW.
"N"	BEFORE DASH NUMBER - UNCOATED, NICKEL-COPPER SCREW.
"NB"	BEFORE DASH NUMBER - NICKEL PLATED, BRASS SCREW.
"S"	BEFORE DASH NUMBER - CADMIUM PLATED, CARBON STEEL SCREW.
"U"	BEFORE DASH NUMBER - UNCOATED, COPPER-SILICON SCREW.
"B"	AFTER DASH NUMBER - BLACK OXIDE COATED, CORROSION RESISTANT STEEL SCREW.

EXAMPLE OF PART NUMBER:

THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH, FOLLOWED BY A MATERIAL/FINISH LETTER CODE (SEE CODE ABOVE), FOLLOWED BY A DASH NUMBER CODE TAKEN FROM TABLE II. ONLY ONE (1) DASH NUMBER SHALL BE USED PER PART NUMBER. DO NOT USE UNASSIGNED MATERIAL CODES OR DASH NUMBERS.

MS24693-A28	=	SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, CROSS RECESSED, .1380-32 UNC-2A THREAD, ANODIZED, ALUMINUM ALLOY, .500 INCH LENGTH.
MS24693-B54	=	SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, CROSS RECESSED, .1640-32 UNC-2A THREAD, UNCOATED, BRASS, 1.000 INCH LENGTH.
MS24693-BB80	=	SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, CROSS RECESSED, .1900-24 UNC-2A THREAD, BLACK CHEMICAL FINISH, BRASS, 1.500 INCH LENGTH.
MS24693-C202	=	SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, CROSS RECESSED, .1120-48 UNF-2A THREAD, PASSIVATED, CORROSION RESISTANT STEEL, .250 INCH LENGTH.
MS24693-CB132	=	SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, CROSS RECESSED, .3125-18 UNC-2A THREAD, CADMIUM PLATED, BRASS, 3.000 INCH LENGTH.
MS24693-N254	=	SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, CROSS RECESSED, .1640-36 UNF-2A THREAD, UNCOATED, NICKEL-COPPER ALLOY, 1.000 INCH LENGTH.
MS24693-NB106	=	SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, CROSS RECESSED, .2500-20 UNC-2A THREAD, NICKEL PLATED, BRASS, 2.000 INCH LENGTH.
MS24693-S2	=	SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, CROSS RECESSED, .1120-40 UNC-2A THREAD, CADMIUM PLATED, CARBON STEEL, .250 INCH LENGTH.
MS24693-U154	=	SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, CROSS RECESSED, .3750-16 UNC-2A THREAD, UNCOATED, COPPER-SILICON ALLOY, 3.000 INCH LENGTH.
MS24693-206B	=	SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, CROSS RECESSED, .1120-48 UNF-2A THREAD, BLACK OXIDE COATED, CORROSION RESISTANT STEEL, .500 INCH LENGTH.

NOTES:

- (1) ALL DIMENSIONS ARE IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (2) 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.
- (3) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (4) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- /5/ CORROSION RESISTANT STEEL SCREWS SHALL HAVE A MAGNETIC PERMEABILITY IN ACCORDANCE WITH THE PROCUREMENT SPECIFICATION.
- /6/ THE RECESS SHALL BE IN ACCORDANCE WITH NASM9006.

REVISION

4

NASM24693

SHEET 2



Document Sharing Hub

USE OF OR RELIANCE UPON THIS DOCUMENT OR ANY NATIONAL AEROSPACE STANDARD IS ENTIRELY VOLUNTARY. AIA DOES NOT QUALIFY SUPPLIERS OR CERTIFY

Copyright Aerospace Industries Association of America, Inc. MS PRODUCED UNDER NATIONAL AEROSPACE STANDARD: AIA MAKES NO REPRESENTATION OR CLAIM RESPECTING (1) THE SUITABILITY OF
Provided by IHS under license with AIA/NAS Licensee: www.sepana.ir/5991803002, User: sam, albert
No reproduction or networking permitted without license from IHS (2) THE EXISTENCE OF OR APPLIC Not for Resale, 01/04/2016 02:45:57 MST TRADEMARKS RIGHTS.