

FED. SUPPLY CLASS

5305

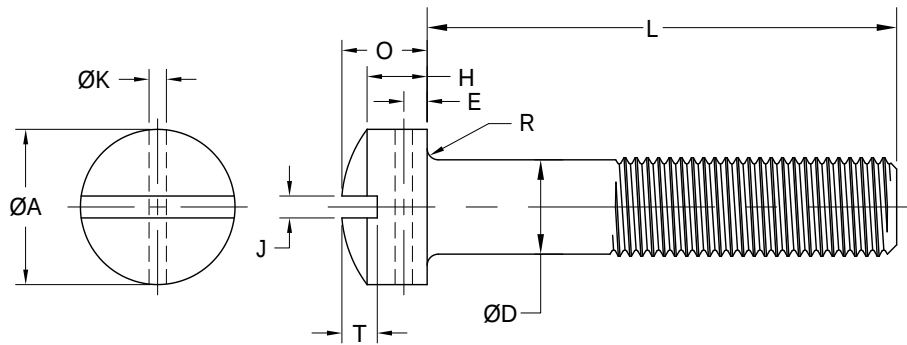


TABLE I – DIMENSIONS, STRENGTH AND LENGTH DASH NUMBERS

(2)

NOMINAL SIZE	(#2)	(#4)	(#6)	(#8)	(#10)	(1/4)	(5/16)	(3/8)
THREADS PER INCH, UNF-2A	64	48	40	36	32	28	24	24
ØD BODY	MAX .0860 MIN .0733	.1120 .0954	.1380 .1184	.1640 .1424	.1900 .1658	.2500 .2225	.3125 .2806	.3750 .3430
ØA HEAD	MAX .140 MIN .124	.183 .166	.226 .208	.270 .250	.313 .292	.414 .389	.518 .490	.622 .590
H HEAD SIDE HEIGHT	MAX .062 MIN .055	.079 .072	.096 .089	.113 .106	.130 .123	.170 .161	.211 .201	.253 .242
O TOTAL HEAD HEIGHT	MAX .083 MIN .070	.107 .094	.132 .118	.156 .141	.180 .165	.237 .219	.295 .276	.355 .333
J SLOT WIDTH	MAX .031 MIN .023	.039 .031	.048 .039	.054 .045	.060 .050	.075 .064	.084 .072	.094 .081
T SLOT DEPTH	MAX .030 MIN .022	.038 .030	.045 .035	.065 .054	.075 .064	.102 .087	.130 .110	.154 .134
E DRILL LOCATION	NOM .026	.035	.043	.043	.043	.062	.078	.094
ØK DRILLED HOLE	NOM .031	.037	.046	.046	.046	.062	.070	.070
R RADIUS	MAX .013	.017	.021	.025	.029	.038	.047	.056
TENSILE STRENGTH, LBF	MIN 310	530	810	1180	1600	2910	4640	7020
L LENGTH /5/	TOLERANCE	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.
.125		201	211	224	239			
.188		202	212	225	240	258		
.250		203	213	226	241	259		
.312		204	214	227	242	260	276	
.375		205	215	228	243	261	277	292
.438	+ .000	206	216	229	244	262	278	293
.500	– .031	207	217	230	245	263	279	294
.625		208	218	231	246	264	280	295
.750		209	219	232	247	265	281	296
.875		210	220	233	248	266	282	297
1.000			221	234	249	267	283	298
1.250			222	235	250	268	284	299
1.500	+ .000		223	236	251	269	285	300
1.750	– .062			237	252	270	286	301
2.000				238	253	271	287	302
2.250					254	272	288	303
2.500	+ .000				255	273	289	304
2.750	– .094				256	274	290	305
3.000					257	275	291	306
3.500							350	

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS35276, REVISION C, AMENDMENT 1, PART NUMBERS REMAIN MS35276

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION FF-S-92	TITLE SCREW, MACHINE, DRILLED, FILLISTER HEAD, SLOTTED, CORROSION RESISTANT STEEL, PASSIVATED, UNF-2A	CLASSIFICATION PART STANDARD MS35276

NAS Documents
SHEET 1 OF 4
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MATERIAL:

CORROSION RESISTANT STEEL, IN ACCORDANCE WITH AIR4127 ~~FED-STD-NO. 66~~: UNS S30200, UNS S30300, UNS S30400, UNS S30500, UNS S31600, OR UNS S38400 (DEVELOPED FOR COLD HEADING), OR TYPE UNS S30430 (FORMERLY IDENTIFIED AS XM-7) IN ACCORDANCE WITH THE CHEMICAL REQUIREMENTS OF ASTM A493, AND HAVING MINIMUM ULTIMATE TENSILE STRENGTH OF 80,000 PSI.

FINISH:

PASSIVATION SHALL BE IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4.

CODE:

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

EXAMPLE OF PART NUMBER:

② MS35276-201 = SCREW, DRILLED FILLISTER HEAD, SLOTTED, CRES, PASSIVATED, .0860-64 UNF-2A THREAD, .125 LENGTH.

NOTES:

- (1) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- ② (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) 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) THE THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/2. ACCEPTABILITY OF SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/20, SYSTEM 21.
- /5/ THREAD LENGTH: SCREWS 2.00 INCHES LONG AND SHORTER SHALL HAVE COMPLETE THREADS EXTENDING TO WITHIN TWO THREADS OF THE HEAD, OR CLOSER IF PRACTICABLE. LONGER SCREWS SHALL HAVE A MINIMUM THREAD LENGTH OF 1.50 INCHES.
- (6) DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED.
- (7) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (8) DRILLED HOLE IS TO BE APPROXIMATELY AT RIGHT ANGLES TO THE SLOT AND MAY BE PERMITTED TO BREAKTHROUGH THE BOTTOM OF THE SLOT. ALL SHARP EDGES SHALL BE REMOVED.
- (9) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.

REVISION

2

NAS35276

SHEET 2