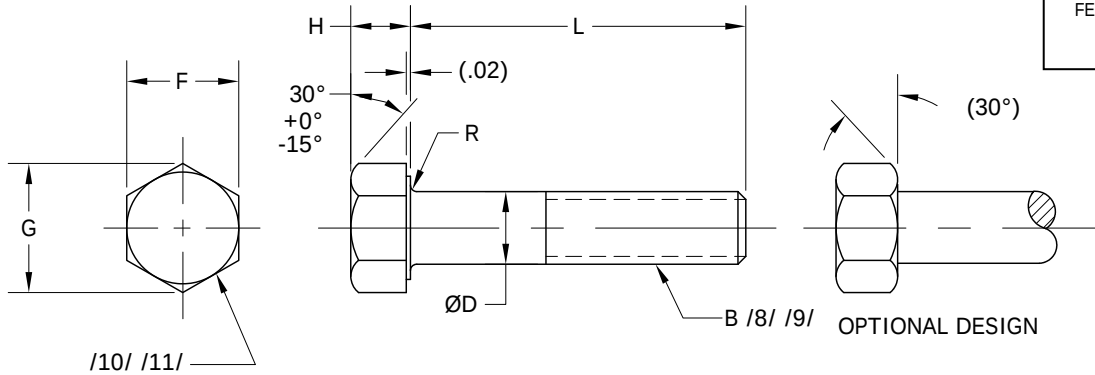




FED. SUPPLY CLASS

5305

TABLE I – DIMENSIONS AND DASH NUMBERS

NOMINAL SIZE		.2500	.3125	.3750	.4375	.5000	.5625	.6250	.7500	.8750	1.0000	1.1250	1.2500
B THREADS PER INCH UNC-2A /8/ /9/		20	18	16	14	13	12	11	10	9	8	7	7
ØD BODY	MAX	.2500	.3125	.3750	.4375	.5000	.5625	.6250	.7500	.8750	1.0000	1.1250	1.2500
	MIN	.2450	.3065	.3690	.4305	.4930	.5545	.6170	.7410	.8660	.9900	1.1140	1.2390
F WIDTH ACROSS FLATS	MAX	.4375	.5000	.5625	.6250	.7500	.8125	.9375	1.1250	1.3125	1.5000	1.6875	1.8750
	MIN	.4280	.4890	.5510	.6120	.7360	.7980	.9220	1.1000	1.2850	1.4690	1.6310	1.8120
G WIDTH ACROSS CORNERS	MAX	.505	.577	.650	.722	.866	.938	1.083	1.299	1.516	1.732	1.949	2.165
	MIN	.488	.557	.628	.698	.840	.910	1.051	1.254	1.465	1.675	1.859	2.066
H HEAD HEIGHT	MAX	.163	.211	.243	.291	.323	.371	.403	.483	.563	.627	.718	.813
	MIN	.150	.195	.226	.272	.302	.348	.378	.455	.531	.591	.658	.749
R RADIUS	MAX	.025	.025	.025	.025	.025	.045	.045	.045	.065	.095	.095	.095
	MIN	.015	.015	.015	.015	.015	.020	.020	.020	.040	.060	.060	.060
TENSILE STRENGTH LBS-MIN /12/		2,540	4,190	6,200	8,500	11,300	14,500	18,050	23,350	32,300	42,400	53,400	67,800
L LENGTH	TOLERANCE	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.
.375	+.000 -.031	301	327	353									
.438		302	328	354	379								
.500		303	329	355	380	404							
.562		304	330	356	381	405	430						
.625		305	331	357	382	406	431	455					
.750		306	332	358	383	407	432	456	479				
.875		307	333	359	384	408	433	457	480	502			
1.000		308	334	360	385	409	434	458	481	503	524		
1.125	+.000 -.062	309	335	361	386	410	435	459	482	504	525	545	
1.250		310	336	362	387	411	436	460	483	505	526	546	565
1.375		311	337	363	388	412	437	461	484	506	527	547	566
1.500		312	338	364	389	413	438	462	485	507	528	548	567
1.750		313	339	365	390	414	439	463	486	508	529	549	568
2.000		314	340	366	391	415	440	464	487	509	530	550	569
2.250		315	341	367	392	416	441	465	488	510	531	551	570
2.500		316	342	368	393	417	442	466	489	511	532	552	571
2.750	+.000 -.094	317	343	369	394	418	443	467	490	512	533	553	572
3.000		318	344	370	395	419	444	468	491	513	534	554	573
3.250		319	345	371	396	420	445	469	492	514	535	555	574
3.500		320	346	372	397	421	446	470	493	515	536	556	575
3.750		321	347	373	398	422	447	471	494	516	537	557	576
4.000		322	348	374	399	423	448	472	495	517	538	558	577
4.250		323	349	375	400	424	449	473	496	518	539	559	578
4.500		324	350	376	401	425	450	474	497	519	540	560	579
4.750		325	351	377	402	426	451	475	498	520	541	561	580
5.000		326	352	378	403	427	452	476	499	521	542	562	581
5.500						428	453	477	500	522	543	563	582
6.000						429	454	478	501	523	544	564	583

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS35307, REVISION E. PART NUMBERS REMAIN MS35307.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION FF-S-85	TITLE SCREW, CAP, HEXAGON HEAD (FINISHED HEXAGON BOLT), STEEL, CORROSION RESISTING, PASSIVATED, UNC-2A	CLASSIFICATION PART STANDARD MSM35307



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MATERIAL:

- ② AUSTENITIC CORROSION-RESISTANT STEEL SCREWS SHALL BE MANUFACTURED FROM TYPE 304 (UNS S30400), TYPE 304L (UNS S30403), TYPE 305 (UNS S30500), TYPE 316 (UNS S31600), TYPE 316L CRES (UNS S31603), TYPE 384 (UNS S38400), OR TYPE 18-9LW (UNS S30430) IN ACCORDANCE WITH THE CHEMICAL COMPOSITIONS SPECIFIED IN ASTM F593. (SEE MATERIAL IDENTIFICATION MARKING AND MATERIAL CODE).

FINISH:

- ② PASSIVATE IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4.
② BLACK OXIDE COAT IN ACCORDANCE WITH MIL-DTL-13924, CLASS 4 (NOT AVAILABLE FOR TYPES 316 OR 316L).

CODE:

- FOR 300 SERIES CRES - NO CODE AFTER DASH NUMBER INDICATES ANY 300 SERIES AUSTENITIC CORROSION-RESISTANT STEEL LISTED IN MATERIAL REQUIREMENT.
② "B" CODE AFTER DASH NUMBER FOR BLACK OXIDE COATING.

- FOR TYPE 316 OR TYPE 316L CRES - "S316" AFTER DASH NUMBER INDICATES AUSTENITIC CORROSION-RESISTANT STEEL TYPE 316 OR TYPE 316L.

EXAMPLE OF PART NUMBER:

- ② THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER, FOLLOWED BY A DASH NUMBER FROM TABLE I.
② ADD A MATERIAL CODE FOLLOWING THE DASH NUMBER FOR TYPE 316 OR 316 L MATERIAL
ADD A "B" CODE FOLLOWING THE DASH NUMBER FOR BLACK OXIDE COATING (NOT AVAILABLE FOR 316 OR 316L MATERIAL).

MS35307-301 INDICATES SCREW, CAP, HEXAGON HEAD, 300 SERIES AUSTENITIC CORROSION-RESISTANT STEEL, PASSIVATED; .2500-20 UNC-2A NOMINAL THREAD SIZE, .375 LENGTH.

- ② MS35307-301B INDICATES SCREW, CAP, HEXAGON HEAD, 300 SERIES AUSTENITIC CORROSION-RESISTANT STEEL, BLACK OXIDE COATED; .2500-20 UNC-2A NOMINAL THREAD SIZE, .375 LENGTH.

MS35307-301S316 INDICATES SCREW, CAP, HEXAGON HEAD, AUSTENITIC CORROSION-RESISTANT STEEL TYPE 316 OR TYPE 316L, PASSIVATED; .2500-20 UNC-2A NOMINAL THREAD SIZE, .375 LENGTH.

NOTES:

- (1) ALL DIMENSIONS ARE IN INCHES.
(2) ② DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
(3) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
(4) 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.
②
(5) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
(6) REMOVE ALL BURRS AND SHARP EDGES.
(7) 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. NOTE: COLD WORKED SCREWS MAY NOT BE CAPABLE OF MEETING PERMEABILITY AND STRENGTH REQUIREMENTS SIMULTANEOUSLY.
②
/8/ THREADS: SCREW THREADS SHALL BE UNIFIED EXTERNAL THREADS CLASS 2A UNC IN ACCORDANCE WITH FED-STD-H28/2. ACCEPTABILITY OF SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/20.

REVISION

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NAS Documents
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