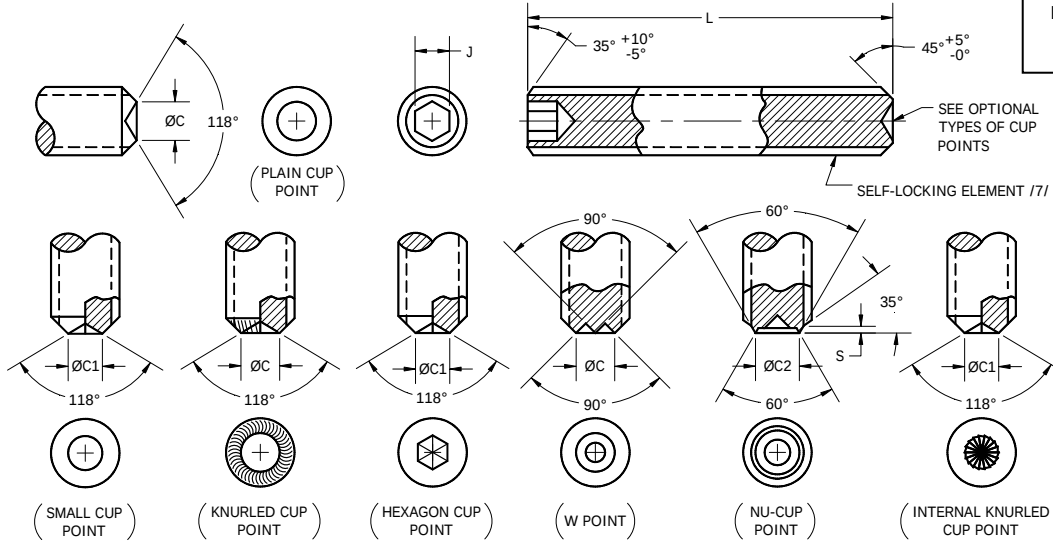


FED. SUPPLY CLASS

5305



2

TABLE I – DIMENSIONS

NOMINAL SIZE			.0600	.0860	.1120	.1380	.1640	.1900		.2500		.3125		.3750		.5000	
THREADS PER INCH (UNF-3A)			80	64	48	40	36	32		28		24		24		20	
J	SOCKET WIDTH ACROSS FLATS	NOM	.028	.035	.050	.062	.078	.094		.125		.156		.188		.250	
ØC	POINT DIAMETER	MAX	.033	.047	.061	.074	.087	.102		.132		.172		.212		.291	
		MIN	.027	.039	.051	.064	.076	.088		.118		.156		.192		.270	
ØC1	POINT DIAMETER	MAX	.032	.043	.056	.069	.082	.095		.125		.156		.187		.250	
		MIN	.027	.038	.051	.062	.074	.086		.114		.144		.174		.235	
ØC2	POINT DIAMETER	MAX	.027	.043	.059	.074	.090	.101		.156		.190		.241		.333	
		MIN	.022	.038	.054	.068	.084	.095		.150		.185		.236		.328	
S	POINT LENGTH	MAX MIN	.007 .004	.010 .007	.013 .008	.017 .012	.021 .016	.024 .019		.027 .022		.038 .033		.041 .036		.054 .049	
L	LENGTH	TOL	DASH NUMBER														
			PLAIN					PLAIN	SELF LOCK	PLAIN	SELF LOCK	PLAIN	SELF LOCK	PLAIN	SELF LOCK	PLAIN	SELF LOCK
	.125	±.010	1	9	18	27			101*								
	.188		2	10	19	28		48	102	60	112						
	.250		3	11	20	29	38	49	103	61	113	72*	125				
	.312			12	21	30	39	50	104	62	114	73	126	83*			
	.375					31	40	51	105	63	115	74	127	84	137	93	147
	.438								106		116						
	.500					32	41	52	107	64	117	75	128	85	138	94	148
	.562								108		118						
	.625						42	53	109	65	119	76	129	86*	139	95*	149
	.750	±.020					54	110	66	120	77*	130	87*	140	96*	150	
	.875									121		131		141		151	
	1.000								111		122		132		142		152
	1.250										123		133		143		153
	1.500										124		134		144		154
	1.750												135		145		155
	2.000	±.031										136		146		156	
	2.500																157
	3.000																158

* INACTIVE FOR NEW DESIGN AFTER 29 DEC 1972.

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS51023, REVISION C. PART NUMBERS REMAIN MS51023.

THIRD ANGLE PROJECTION	CUSTODIAN	REVISION
	NATIONAL AEROSPACE STANDARDS COMMITTEE	2
PROCUREMENT SPECIFICATION	TITLE	CLASSIFICATION PART STANDARD
FF-S-200	SETSCREW, HEXAGON SOCKET, CUP POINT, CORROSION RESISTANT STEEL, PASSIVATED, UNF-3A, PLAIN AND SELF-LOCKING	NAS 51023

MATERIAL:

CORROSION-RESISTING STEEL, 300 SERIES, IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.

FINISH:

- ② PASSIVATED IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4.

CODE:

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

② EXAMPLE OF PART NUMBER:

MS51023-1 = SETSCREW, HEXAGON SOCKET, CUP POINT, 300 SERIES CRES,
.0600-80 UNF-3A THREAD, .125 LENGTH, PLAIN
MS51023-117 = SETSCREW, HEXAGON SOCKET, CUP POINT, 300 SERIES CRES,
.2500-28 UNF-3A THREAD, .500 LENGTH, SELF-LOCKING

NOTES:

- (1) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (2) REMOVE ALL BURRS AND SHARP EDGES.
- (3) THE THREADS SHALL BE IN ACCORDANCE WITH MIL-S-7742.
- (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.
- (5) TOLERANCES UNLESS OTHERWISE SPECIFIED: ANGLES $\pm 5^\circ$.
- (6) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- /7/ SELF-LOCKING ELEMENT:
 - (a) THE SELF-LOCKING ELEMENT SHALL BE IN ACCORDANCE WITH MIL-DTL-18240.
 - (b) FOR DESIGN AND USAGE LIMITATIONS, SEE NASM15981.
 - (c) LOCATION OF EFFECTIVE LOCKING AREA SHALL BE IN ACCORDANCE WITH NASM15981.
 - (d) MAXIMUM RING GAGE DIAMETER THAT LOCKING REGION OF SETSCREW MUST PASS THRU
FREELY OR WITH FINGER PRESSURE SHALL BE THE NOMINAL SIZE PLUS .010.
 - (e) MIL-DTL-18240 DOESN'T ESTABLISH TORQUE REQUIREMENTS FOR LENGTHS ABOVE THE
DASHED LINE. ONLY A POSITIVE INDICATION OF TORQUE IS REQUIRED.
- 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) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (10) 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

NASM51023

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. NASM PRODUCED UNDER NATIONAL AEROSPACE STANDARD: AIA MAKES NO REPRESENTATION OR CLAIM RESPECTING (1) THE SUITABILITY OF
Provided by IHS under license with AIA/NAS. ANY PARTICULAR APPLICATION OR (2) THE EXISTENCE OF OR APPLICABLE LICENSEE= www.sepana.ir/5991803002, User=sam, albert
No reproduction or networking permitted without license from IHS. Not for Resale, 01/04/2016 02:53:50 MST TRADEMARKS RIGHTS.

Full document details: AIA NASM51023 2014