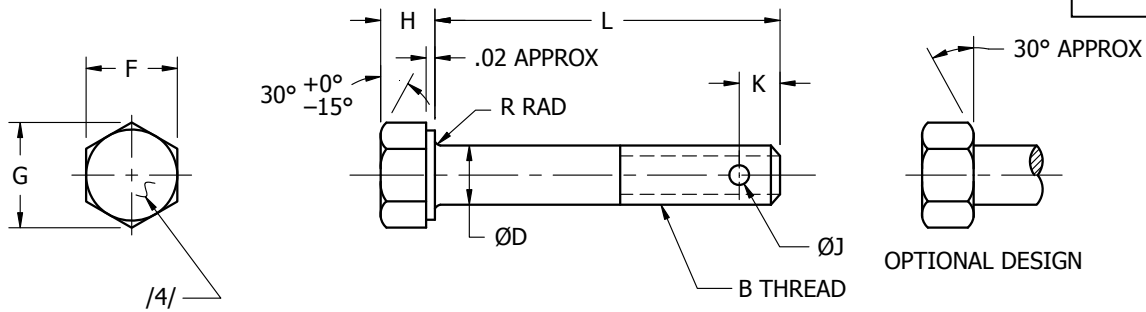


FED. SUPPLY CLASS

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(2)

TABLE I – DIMENSIONS

NOMINAL SIZE	B THREAD UNC-2A	ØD BODY		F WIDTH ACROSS FLATS		G WIDTH ACROSS CORNERS		H HEAD HEIGHT		ØJ HOLE +.006 -.002	K ±.010	R RAD		MIN TENSILE STRENGTH LBF
		MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN			MAX	MIN	
.250	.2500-20	.2500	.2450	.4375	.4280	.505	.488	.163	.150	.076	.109	.025	.015	2,220
.323	.3125-18	.3125	.3065	.5000	.4890	.577	.557	.211	.195	.076	.125	.025	.015	3,660
.375	.3750-16	.3750	.3690	.5625	.5510	.650	.628	.243	.226	.107	.156	.025	.015	5,420
.438	.4375-14	.4375	.4305	.6250	.6120	.722	.698	.291	.272	.107	.156	.025	.015	7,420
.500	.5000-13	.5000	.4930	.7500	.7360	.866	.840	.323	.302	.107	.172	.025	.015	9,900
.625	.6250-11	.6250	.6170	.9375	.9220	1.083	1.051	.403	.378	.140	.188	.045	.020	15,800
.750	.7500-10	.7500	.7410	1.1250	1.1000	1.299	1.254	.483	.455	.140	.219	.045	.020	23,350
.875	.8750-9	.8750	.8660	1.3125	1.2850	1.516	1.465	.563	.531	.140	.250	.065	.040	32,300
1.000	1.0000-8	1.0000	.9900	1.5000	1.4690	1.732	1.675	.627	.591	.140	.250	.095	.060	42,400

MATERIAL:

CRES, 400 SERIES, IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS2759: 70 KSI FTU.

FINISH:

PASSIVATED IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.

CODE:

THE PART NUMBER CONSISTS OF THE BASIC PART NUMBER, PLUS THE DASH NUMBER.

EXAMPLE OF PART NUMBER:

(2) MS51109-1 = SCREW, CAP, HEXAGON HEAD, DRILLED SHANK,
CRES, .2500-20 UNC-2A THREAD, .375 LONG.

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS51109, REVISION B. PART NUMBERS REMAIN MS51109.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION FF-S-85	TITLE SCREW, CAP, HEXAGON HEAD, FINISHED HEXAGON BOLT, SHANK DRILLED FOR COTTER PIN, CRES, PASSIVATED, UNC-2A	CLASSIFICATION PART STANDARD
		MS51109 SHEET 1 OF 2

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NOTES:

- (1) THE THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28.
- (2) MINIMUM THREAD LENGTH SHALL BE TWICE THE DIAMETER PLUS .250 INCHES. THE TOLERANCE SHALL BE PLUS .188 INCHES OR 2.500 THREADS, WHICHEVER IS GREATER. ON SCREWS THAT ARE TOO SHORT FOR MINIMUM THREAD LENGTHS, THE DISTANCE FROM THE BEARING SURFACE OF THE HEAD TO THE FIRST COMPLETE THREAD SHALL NOT EXCEED THE LENGTH OF 2.500 THREADS.
- (3) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- /4/ HEADS SHALL BE MARKED IN ACCORDANCE WITH MIL-HDBK-131. RAISED MARKINGS ARE PREFERRED, STAMPINGS ARE ACCEPTABLE.
- (5) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (6) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (7) 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.
- (8) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

(2) TABLE II – LENGTHS

NOMINAL SIZE			.250	.313	.375	.438	.500	.625	.750	.875	1.000
L LENGTH	TOLERANCE		DASH NUMBERS								
	SIZE .750 AND UNDER	SIZE .875 AND OVER									
.375	+.000 -.031	-	1	27	-	-	-	-	-	-	-
.438			2	28	-	-	-	-	-	-	-
.500			3	29	55	-	-	-	-	-	-
.562			4	30	56	-	-	-	-	-	-
.625			5	31	57	-	-	-	-	-	-
.750			6	32	58	84	110	133	-	-	-
.875			7	33	59	85	111	134	-	-	-
1.000	+.000 -.062	+.000 -.125	8	34	60	86	112	135	157	-	-
1.250			9	35	61	87	113	136	158	182	206
1.500			10	36	62	88	114	137	159	183	207
1.750			11	37	63	89	115	138	160	184	208
2.000			12	38	64	90	116	139	161	185	209
2.250	+.000 -.094	+.000 -.188	13	39	65	91	117	140	162	186	210
2.500			14	40	66	92	118	141	163	187	211
2.750			15	41	67	93	119	142	164	188	212
3.000			16	42	68	94	120	143	165	189	213
3.250			17	43	69	95	121	144	166	190	214
3.500			18	44	70	96	122	145	167	191	215
3.750			19	45	71	97	123	146	168	192	216
4.000			20	46	72	98	124	147	169	193	217
4.250			21	47	73	99	125	148	170	194	218
4.500			22	48	74	100	126	149	171	195	219
4.750			23	49	75	101	127	150	172	196	220
5.000			24	50	76	102	128	151	173	197	221
5.500			-	-	-	-	129	152	174	198	222
6.000			-	-	-	-	130	153	175	199	223

REVISION

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