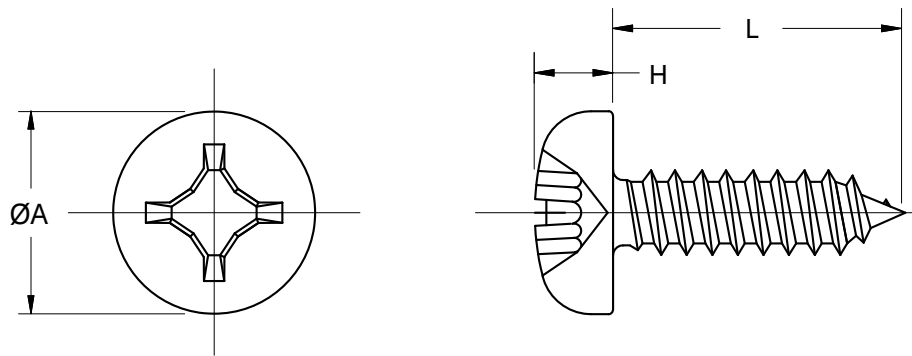


FED.SUPPLY CLASS

5305



4

TABLE I – DIMENSIONS AND DASH NUMBERS

NOMINAL SIZE		.0860		.1120		.1380		.1640		.1900		.2500	
THREADS PER INCH		32		24		20		18		16		14	
ØA HEAD	MAX	.167		.219		.270		.322		.373		.492	
	MIN	.155		.205		.256		.306		.357		.473	
H HEAD HEIGHT	MAX	.062		.080		.097		.115		.133		.175	
	MIN	.053		.070		.087		.105		.122		.162	
L LENGTH	TOL.	DASH NO.											
		CARBON STEEL	CRES STEEL	CARBON STEEL	CRES STEEL	CARBON STEEL	CRES STEEL	CARBON STEEL	CRES STEEL	CARBON STEEL	CRES STEEL	CARBON STEEL	CRES STEEL
.188	±.031	1	1C										
.250		2	2C	12	12C	22	22C	--	--	--	--	--	--
.312		3	3C	--	13C	--	23C	--	33C	--	--	--	--
.375		4	4C	14	14C	24	24C	34	34C	44	44C	--	--
.500		--	--	15	15C	25	25C	35	35C	45	45C	65	65C
.625	±.031	--	--	16	16C	26	26C	36	36C	46	46C	66	66C
.750		--	--	17	17C	27	27C	37	37C	47	47C	67	67C
.875		--	--	--	--	28	28C	38	38C	48	48C	68	68C
1.000		--	--	--	--	29	29C	39	39C	49	49C	69	69C
1.250		±.047	--	--	--	--	--	--	40	40C	50	50C	70
1.500	--		--	--	--	--	--	41	41C	51	51C	71	71C
1.750	--		--	--	--	--	--	--	--	52	52C	72	72C
2.000	--		--	--	--	--	--	--	--	53	53C	73	73C
2.250	--		--	--	--	--	--	--	--	--	--	--	74
2.500		--	--	--	--	--	--	--	--	--	--	75	75C

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS51861, REVISION A. PART NUMBERS REMAIN MS51861.

THIRD ANGLE PROJECTION	CUSTODIAN	REVISION
	NATIONAL AEROSPACE STANDARDS COMMITTEE	4
PROCUREMENT SPECIFICATION	TITLE	CLASSIFICATION PART STANDARD
FF-S-107	SCREW, TAPPING, THREAD FORMING, TYPE AB, PAN HEAD, CROSS-RECESSED	MS51861

MATERIAL:

CARBON STEEL SHALL BE AISI 1016 (UNS G10160), 1018 (UNS G10180), 1019 (UNS G10190), 1021 (UNS G10210), 1022 (UNS G10220) OR 1024 (UNS G10240) (HARDENED) IN ACCORDANCE WITH AIR4127.

CORROSION-RESISTING STEEL SHALL BE AISI 410 (UNS S41000) (HARDENED) IN ACCORDANCE WITH AIR 4127.

FINISH:

CARBON STEEL SHALL BE CADMIUM PLATED IN ACCORDANCE WITH AMS-QQ-P-416, TYPE II, CLASS 3.

CORROSION-RESISTING STEEL SHALL BE PASSIVATED IN ACCORDANCE WITH AMS 2700, METHOD 1, CLASS 4.

CODE:

④

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

EXAMPLE OF PART NUMBER:

④

MS51861-12 = CARBON STEEL, .1120-24 THREAD, .250 LONG, CADMIUM PLATED.

NOTES:

- (1) THREADS SHALL BE IN ACCORDANCE WITH THE PROCUREMENT SPECIFICATION.
- (2) ALL DIMENSIONS ARE IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (3) THE RECESS SHALL BE IN ACCORDANCE WITH NAS9006.
- (4) HOLE SIZES: FOR APPROXIMATE HOLE SIZES SEE MS24632.
- ④ (5) 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.
- (6) FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.
- (7) SUPERSEDES AN530, MS24617, MS24618, MS24621, MS24622, MS24641, AND MS24642; BCXX3.1, BCXX3.2, BCXX5.1, BCXX5.2, BQBX3.1 AND BQBX5.1.
- (8) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- ④ (9) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- ④ (10) FOR DESCRIPTION OF STATUS NOTES SEE NAS380

REVISION

4

NAS51861

SHEET 2



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