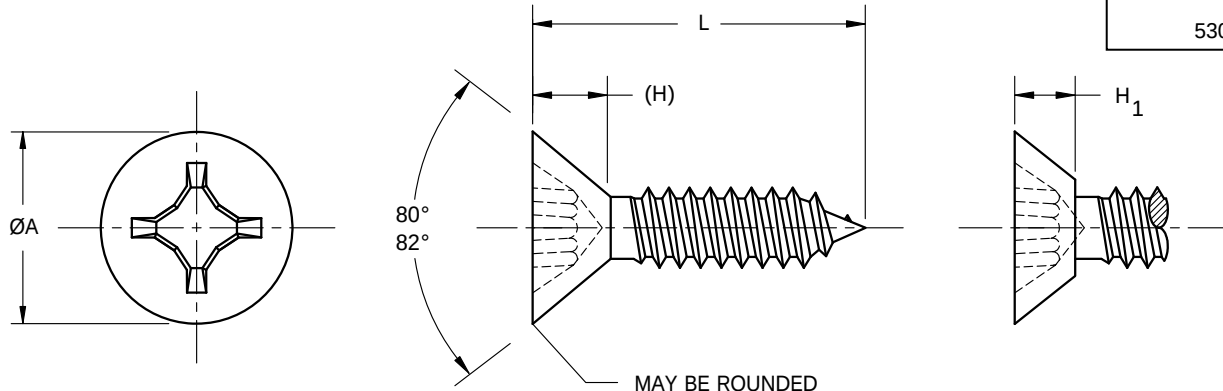


FED. SUPPLY CLASS

5305



FULL HEAD

UNDERCUT HEAD

TABLE I – DASH NUMBERS AND DIMENSIONS /3/

NOMINAL SIZE	4 (.112)	6 (.138)	8 (.164)	10 (.190)	1/4 (.250)
THREADS PER INCH	24	20	18	16	14
ØA HEAD					
MAX SHARP	.225	.279	.332	.385	.507
MIN FLAT	.195	.244	.292	.340	.452
(H) HEAD HEIGHT	.067	.083	.100	.116	.153
H ₁ UNDERCUT HEAD HEIGHT					
MAX	.047	.059	.070	.081	.107
MIN	.038	.048	.058	.068	.092

L LENGTH	TOLERANCES	DASH NO.									
		CARBON STEEL	CRES	CARBON STEEL	CRES	CARBON STEEL	CRES	CARBON STEEL	CRES	CARBON STEEL	CRES
.250	± .031	1	1C	12	12C	23	23C	33	33C	54	54C
.312		3	3C	13	13C	24	24C	34	34C		
.375		4	4C	14	14C						
.500		5	5C	15	15C	25	25C	35	35C	55	55C
.625	± .047	6	6C	16	16C	26	26C	36	36C	56	56C
.750				17	17C	27	27C	37	37C	57	57C
.875				18	18C	28	28C	38	38C	58	58C
1.000						29	29C	39	39C	59	59C
1.250	± .047					30	30C	40	40C	60	60C
1.500								41	41C	61	61C
1.750								42	42C	62	62C
2.000										63	63C
2.250										64	64C
2.500											

1 COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS51862, REVISION A. PART NUMBERS REMAIN MS51862.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
PROCUREMENT SPECIFICATION FF-S-107	TITLE SCREW, TAPPING, THREAD FORMING, TYPE AB, FLAT 82° COUNTERSUNK HEAD, CROSS-RECESSED	CLASSIFICATION PART STANDARD MS51862

SHEET 1 OF 3

MATERIAL:

CARBON STEEL SHALL BE AISI 1016, 1018, 1019, 1021, 1022 OR 1024 (HARDENED) IN ACCORDANCE WITH ~~FED-STD-66~~ AIR4127.
CRES SHALL BE AISI 410 (HARDENED) IN ACCORDANCE WITH ~~FED-STD-66~~ AIR4127.

FINISH:

CARBON STEEL SHALL BE CADMIUM PLATED IN ACCORDANCE WITH AMS-QQ-P-416, TYPE II, CLASS 3.
CRES SHALL BE PASSIVATED IN ACCORDANCE AMS2700, METHOD 1, CLASS 4.

CODE:

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

EXAMPLE OF PART NUMBER:

MS51862-1

NOTES:

- (1) THE THREADS SHALL BE IN ACCORDANCE WITH THE PROCUREMENT SPECIFICATION.
- (2) THE RECESS SHALL BE IN ACCORDANCE WITH NASM9006.
- /3/ LENGTHS ABOVE DOTTED LINE SHALL HAVE UNDERCUT HEADS.
- (4) FOR APPROXIMATE HOLE SIZES SEE MS24632.
- (5) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (6) REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.
- (7) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (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.
- (9) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- /10/ NO REPLACEMENT.

INTERCHANGEABILITY:

THE SCREWS COVERED BY THE FOLLOWING DASH NUMBERS OF MS24635, MS24636, MS24639, AND MS24640 ARE CANCELLED AFTER 25 FEBRUARY 1963. THE SCREWS COVERED BY THE FOLLOWING DASH NUMBERS OF MS24615 AND MS24616 ARE CANCELLED AFTER 27 AUGUST 1969. THE SCREWS COVERED BY THE FOLLOWING DASH NUMBERS OF MS24619 AND MS24620 ARE CANCELLED AFTER 15 MAY 1975. THE CANCELLED SCREWS CANNOT ALWAYS REPLACE THE SUPERSEDING SCREWS AND SHOULD BE USED UNTIL EXISTING STOCK IS DEPLETED. USE ONLY THE SUPERSEDING SCREWS OF MS51862 FOR DESIGN AND ENGINEERING. REPLACEMENT SHALL BE IN ACCORDANCE WITH TABLE II.

① COMPLETELY REVISED

REVISION
1
MS51862
SHEET 2

