

FED. SUPPLY CLASS

5305

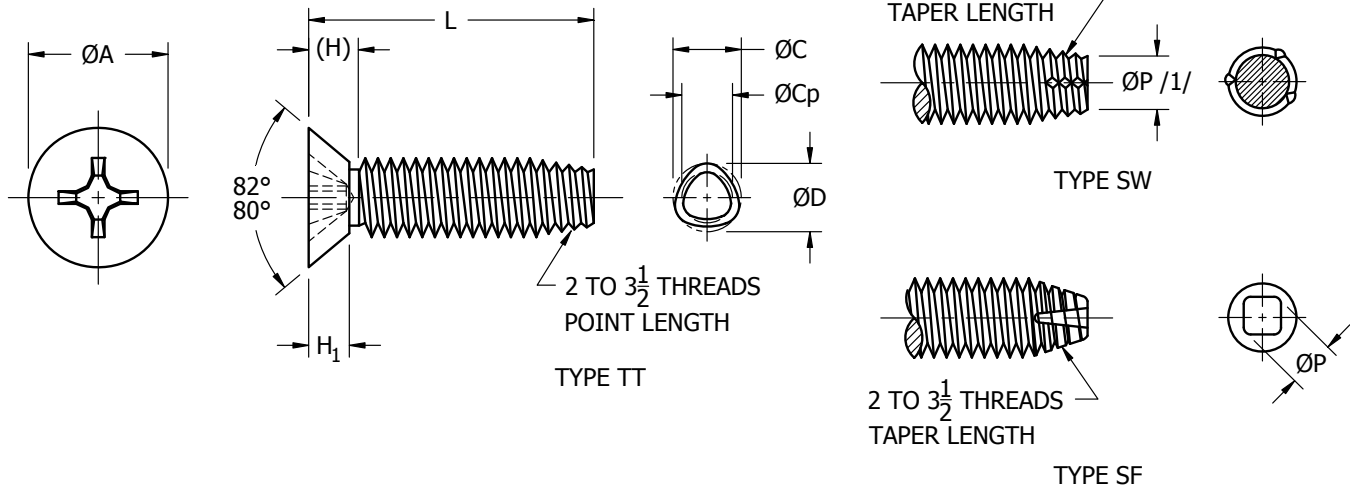


TABLE I – DIMENSIONS

NOM SIZE	THREADS PER INCH	ØA HEAD		(H) HEAD HEIGHT	H ₁ HEAD HEIGHT UNDERCUT		ØC		ØCp MAX	D ACROSS CENTER		ØP POINT TYPE SW /1/		ØP POINT TYPE SF	
		MAX SHARP	MIN FLAT		MAX	MIN	MAX	MIN		MAX	MIN	MAX	MIN	MAX	MIN
.1380	32	.279	.244	.083	.059	.048	.141	.135	.111	.135	.129	.096	.091	.106	.095
.1900	24	.385	.340	.116	.081	.068	.194	.188	.153	.185	.179	.1295	.1245	.147	.133
.2500	20	.507	.452	.153	.107	.092	.2550	.2490	.206	.246	.240	.180	.175	.198	.181

MATERIAL:

CARBON STEEL AND 410 CRES (UNS S41000) IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.

FINISH:

CARBON STEEL: CADMIUM PLATED IN ACCORDANCE WITH AMS-QQ-P-416, TYPE II, CLASS 2 OR
AMS-C-81562, TYPE II, CLASS 2.

CRES: PASSIVATED IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4.

CODE:

THE PART NUMBER CONSISTS OF THE BASIC PART NUMBER, PLUS THE DASH NUMBER FROM TABLE II.

EXAMPLE OF PART NUMBER:

MS51870-1

② COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS51870. PART NUMBERS REMAIN M51870.

THIRD ANGLE PROJECTION		CUSTODIAN		REVISION	
		NATIONAL AEROSPACE STANDARDS COMMITTEE		2	
		TITLE		CLASSIFICATION	
PROCUREMENT SPECIFICATION	FF-S-107	SCREW, TAPPING, HIGH PERFORMANCE, THREAD ROLLING, TYPES SF, SW AND TT, FLAT COUNTERSUNK HEAD, CROSS RECESSED		PART STANDARD	
				NASM51870	
		SHEET 1 OF 2			

NOTES:

- /1/ BEFORE THREADING.
- (2) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (3) THE THREADS SHALL BE IN ACCORDANCE WITH THE APPLICABLE REQUIREMENTS OF THE PROCUREMENT SPECIFICATION.
- (4) THE RECESS SHALL BE IN ACCORDANCE WITH NASM9006.
- (5) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- /6/ LENGTHS ABOVE DASHED LINES SHALL HAVE UNDERCUT HEADS.
- (7) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- (8) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (9) 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.
- (10) TYPE TT TRI-LOBULAR SECTION IS MAINTAINED THROUGHOUT THE FULL LENGTH OF THE SCREW.

TABLE II – LENGTH DASH NUMBERS

L LENGTH	TOLERANCE	.1380		.1900		.2500	
		CARBON STEEL	CRES STEEL	CARBON STEEL	CRES STEEL	CARBON STEEL	CRES STEEL
.250	+.000 −.030	1	C1	—	—	—	—
.375		2	C2	12	C12	—	—
.500		3	C3	13	C13	23	C23
.625		4	C4	14	C14	24	C24
.750		5	C5	15	C15	25	C25
.875	+.000 −.050	—	—	16	C16	26	C26
1.000		—	—	17	C17	27	C27
1.250		—	—	—	—	28	C28
1.500		—	—	—	—	29	C29
1.750		—	—	—	—	30	C30
2.000	−.060	—	—	—	—	31	C31

/6/

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
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THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST REVISION DATE.

FORM 09-01

REVISION

2

Document
NASM51870

SHEET 2

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Full document details: AIA NASM51870 2011