

FED. SUPPLY CLASS

5305

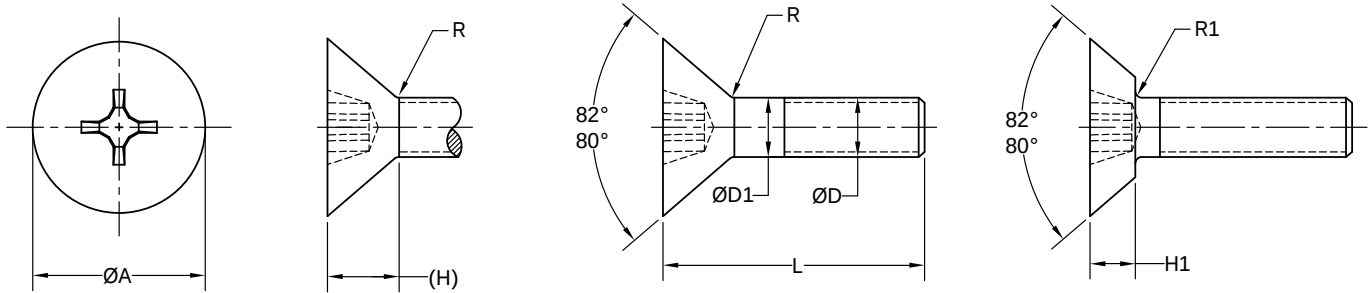
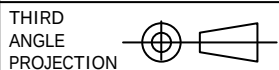


TABLE I – DIMENSIONS AND DASH NUMBERS

ØD NOMINAL SIZE		.0860	.1120	.1380	.1640	.1900	.2500	.3125	.3750
THREADS PER INCH UNC-2A		56	40	32	32	24	20	18	16
ØD1 BODY DIAMETER	MAX	.0860	.1120	.1380	.1640	.1900	.2500	.3125	.3750
	MIN	.0717	.0925	.1141	.1399	.1586	.2127	.2712	.3287
ØA HEAD DIAMETER	MAX SHARP	.172	.225	.279	.332	.385	.507	.635	.762
	MIN SHARP	.156	.207	.257	.306	.359	.477	.600	.722
	ABS MIN	.147	.195	.244	.292	.340	.452	.568	.685
(H) HEAD HEIGHT - FULL HEAD		.051	.067	.083	.100	.116	.153	.191	.230
H1 HEAD HEIGHT	MAX	.036	.047	.059	.070	.081	.107	.134	.161
	MIN	.028	.038	.045	.058	.068	.092	.116	.140
R RADIUS - FULL HEAD		.034	.045	.055	.066	.076	.100	.125	.150
R1 RADIUS - UNDERCUT HEAD		.013	.017	.021	.025	.029	.038	.047	.056
DRIVER SIZE		1	1	2	2	2	3	4	4
TENSILE STRENGTH LBF		300	480	730	1,120	1,400	2,540	4,190	6,200
L LENGTH	TOLERANCE	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.
.125	+.000 -.031	1	11	24	39	58 /7/	76	92	107
.188		2	12	25	40				
.250		3	13	26	41	59	77	93	108
.313		4	14	27	42	60			
.375		5	15	28	43	61	77	92	108
.438		6	16	29	44	62	78	93	109
.500		7	17	30	45	63	79	94	107
.625		8	18	31	46	64	80	95	108
.750		9	19	32	47	65	81	96	109
.875		10 /7/	20	33	48	66	82	97	110
1.000	+.000 -.062	21	34	49	67	83	98	108	111
1.250		22 /7/	35	50	68	84	99	109	112
1.500		23	36	51	69	85	100	110	113
1.750			37	52	70	86	101	111	114
2.000	+.000 -.094		38	53	71	87	102	112	115
2.250				54 /7/	72	88	103	113	116
2.500				55 /7/	73	89	104	114	117
2.750				56 /7/	74 /7/	90 /7/	105 /7/	115	118
3.000				57 /7/	75 /7/	91 /7/	106 /7/	116	119

(2) COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS51959, REVISION D. PART NUMBERS REMAIN MS51959.



THIRD
ANGLE
PROJECTION

CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION

2

PROCUREMENT
SPECIFICATION

FF-S-92

TITLE

**SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 82°,
CRUCIFORM RECESS, CORROSION-RESISTANT STEEL,
UNC-2A**

CLASSIFICATION
PART STANDARD

NAS 51959

SHEET 1 OF 3

Document Sharing Hub

MATERIAL:

AUSTENITIC CORROSION-RESISTANT STEEL SCREWS SHALL BE MANUFACTURED FROM TYPE 302 (UNS S30200), TYPE 304 (UNS S30400), TYPE 304L (UNS S30403), TYPE 305 (UNS S30500), TYPE 316 (UNS S31600), TYPE 316L (UNS S31603), TYPE 384 (UNS S38400), OR TYPE XM-7 (UNS S30430) IN ACCORDANCE WITH CHEMICAL COMPOSITION SPECIFIED IN AMS-QQ-S-763.

FINISH:

PASSIVATE IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4, OR BLACK OXIDE COATING (NOT AVAILABLE FOR TYPE 316 OR TYPE 316L) IN ACCORDANCE WITH MIL-DTL-13924, CLASS 4.

CODE:

THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER, FOLLOWED BY A DASH NUMBER FROM TABLE I, A MATERIAL CODE (IF APPLICABLE), AND A FINISH CODE (IF APPLICABLE).

MATERIAL CODE:

FOR 300 SERIES CRES - NO CODE AFTER DASH NUMBER INDICATES ANY 300 SERIES AUSTENITIC CORROSION-RESISTANT STEEL LISTED IN MATERIAL REQUIREMENT.

FOR TYPE 316 OR TYPE 316L CRES - "S316" AFTER DASH NUMBER INDICATES AUSTENITIC CORROSION-RESISTANT STEEL TYPE 316 OR TYPE 316L.

FINISH CODE:

PASSIVATE - NO CODE LETTER AFTER DASH NUMBER, OR AFTER MATERIAL CODE (IF APPLICABLE) INDICATES PASSIVATE.

BLACK OXIDE - "B" AFTER DASH NUMBER (NOT AVAILABLE FOR TYPE 316 OR TYPE 316L CRES), INDICATES BLACK OXIDE COATING.

EXAMPLE OF PART NUMBER:

- MS51959-1 = INDICATES SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 82°, CRUCIFORM RECESS, 300 SERIES CRES (EXCEPT 316 AND 316L), PASSIVATED; .0860-56 UNC-2A NOMINAL THREAD SIZE, .125 LENGTH.
- MS51959-1B = INDICATES SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 82°, CRUCIFORM RECESS, 300 SERIES CRES (EXCEPT 316 AND 316L), BLACK OXIDE COATED; .0860-56 UNC-2A NOMINAL THREAD SIZE, .125 LENGTH.
- MS51959-1S316 = INDICATES SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 82°, CRUCIFORM RECESS, TYPE 316 OR 316L CRES; PASSIVATED; .0860-56 UNC-2A NOMINAL THREAD SIZE, .125 LENGTH.

NOTES:

- (1) DIMENSIONS IN INCHES.
- (2) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- (3) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (4) 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.
- (5) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (6) DIMENSIONS APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- /7/ INDICATES MANUFACTURER'S NON-STOCK PRODUCTION ITEMS.

REVISION
2
NASM51959
SHEET 2



② COMPLETELY REVISED