

FED. SUPPLY CLASS

5305

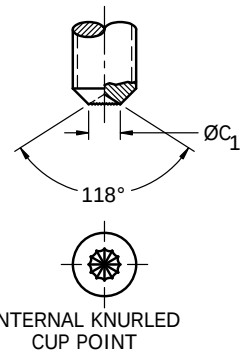
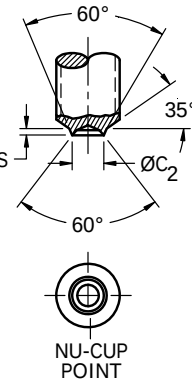
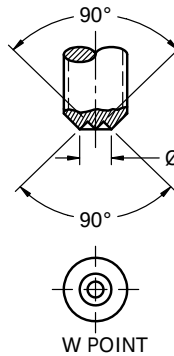
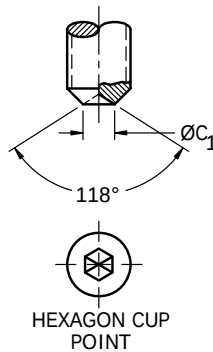
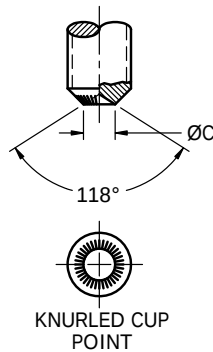
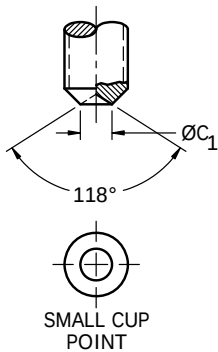
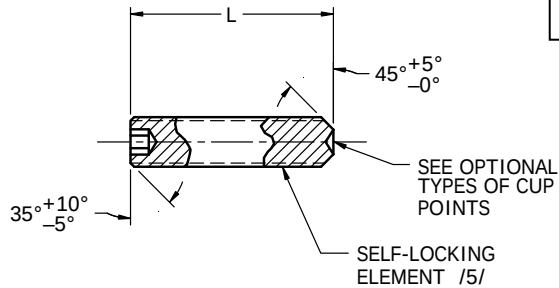
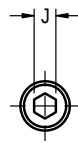
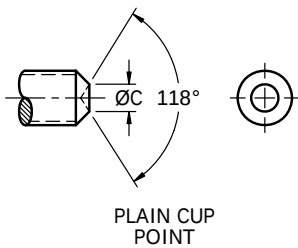
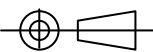


TABLE I – DIMENSIONS

NOMINAL SIZE	THREADS PER INCH	J SOCKET WIDTH ACROSS FLATS NOM	ØC POINT		ØC1 POINT		ØC2 POINT		S POINT LENGTH	
			MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN
.0600	80 UNF-3A	.028	.033	.027	.032	.027	.027	.022	.007	.004
.0860	64 UNF-3A	.035	.047	.039	.043	.038	.043	.038	.010	.007
.1120	48 UNF-3A	.050	.061	.051	.056	.051	.059	.054	.013	.008
.1380	40 UNF-3A	.062	.074	.064	.069	.062	.074	.068	.017	.012
.1640	36 UNF-3A	.078	.087	.076	.082	.074	.090	.084	.021	.016
.1900	32 UNF-3A	.094	.102	.088	.095	.086	.101	.095	.024	.019
.2500	28 UNF-3A	.125	.132	.118	.125	.114	.156	.150	.027	.022
.3125	24 UNF-3A	.156	.172	.156	.156	.144	.190	.185	.038	.033
.3750	24 UNF-3A	.188	.212	.194	.187	.174	.241	.236	.041	.036
.4375	20 UNF-3A	.219	.252	.232	.218	.204	.286	.281	.047	.042
.5000	20 UNF-3A	.250	.291	.270	.250	.235	.333	.328	.054	.049
.6250	18 UNF-3A	.312	.371	.347	.312	.295	.425	.420	.067	.062
.7500	16 UNF-3A	.375	.450	.425	.375	.357	.523	.518	.081	.076
.8750	14 UNF-3A	.500	.530	.502	.437	.418	—	—	—	—
1.0000 /8/	14 UNF-3A	.562	.609	.579	.500	.480	—	—	—	—

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS51964, REVISION E. PART NUMBERS REMAIN MS51964.

THIRD ANGLE PROJECTION



CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

REVISION

3

PROCUREMENT SPECIFICATION

FF-S-200

TITLE

**SETSCREW, HEXAGON SOCKET, CUP POINT,
ALLOY STEEL, CADMIUM PLATED, UNF-3A,
PLAIN AND SELF-LOCKING**

CLASSIFICATION
PART STANDARD

NAS 51964
SHEET 1 OF 4



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MATERIAL:

ALLOY STEEL PER PROCUREMENT SPECIFICATION.

FINISH:

CADMIUM PLATED PER PROCUREMENT SPECIFICATION.

CODE:

THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER TAKEN FROM TABLE II.

EXAMPLE OF PART NUMBER:

MS51964 - 1 = SETSCREW, HEXAGON SOCKET, CUP POINT, ALLOY STEEL, CADMIUM PLATED;
.0600-80 UNF-3A; LENGTH .125; PLAIN.

└───┬───┬───
DASH NUMBER
BASIC PART NUMBER

NOTES:

- (1) ALL DIMENSIONS ARE IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (2) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (3) 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.
- (4) THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/2. ACCEPTABILITY OF SCREW THREADS FOR SIZES .1900 AND SMALLER SHALL BE IN ACCORDANCE WITH FED-STD-H28/20, SYSTEM 21. ACCEPTABILITY OF SCREW THREADS FOR SIZES .2500 AND LARGER SHALL BE IN ACCORDANCE WITH FED-STD-H28/20, SYSTEM 22. SELF-LOCKING SCREWS SHALL BE INSPECTED PRIOR TO INSTALLATION OF LOCKING ELEMENT.
- /5/ SELF-LOCKING ELEMENT:
 - (a) THE SELF-LOCKING ELEMENT SHALL BE IN ACCORDANCE WITH THE PROCUREMENT DOCUMENT.
 - (b) MAXIMUM RING GAGE DIAMETER THAT LOCKING REGION OF SETSCREW MUST PASS THRU FREELY OR WITH FINGER PRESSURE SHALL BE THE NOMINAL SIZE PLUS .010.
 - (c) MIL-DTL-18240 DOES NOT ESTABLISH TORQUE REQUIREMENTS FOR LENGTHS ABOVE THE DASHED LINE. ONLY A POSITIVE INDICATION OF TORQUE IS REQUIRED.
- (6) TOLERANCES UNLESS OTHERWISE SPECIFIED: ANGLES $\pm 5^\circ$.
- /7/ INACTIVE FOR NEW DESIGN AFTER 29 DECEMBER 1972. FOR DESCRIPTION OF STATUS NOTES, SEE NAS380.
- /8/ INACTIVE FOR NEW DESIGN AFTER 30 JUNE 1988. FOR DESCRIPTION OF STATUS NOTES, SEE NAS380.

REVISION

3

NAS51964

SHEET 2



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