

FED. SUPPLY CLASS

5305

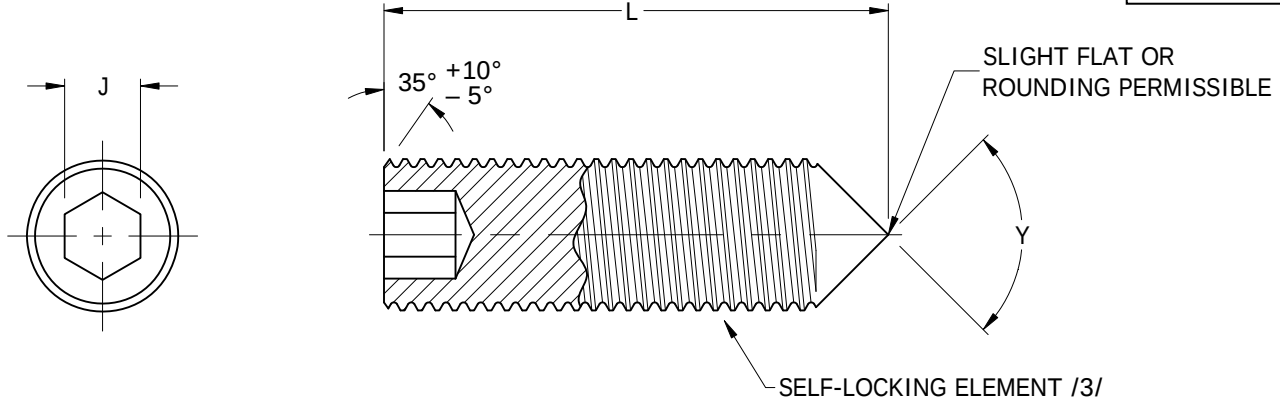


TABLE I – DIMENSIONS

NOMINAL SIZE		.0860	.1120	.1380	.1640	.1900	.2500	.3125	.3750	.5000								
THREADS PER INCH (UNF-3A)		64	48	40	36	32	28	24	24	20								
J	SOCKET WIDTH ACROSS FLATS	NOMINAL	.035	.050	.062	.078	.094	.125	.156	.188	.250							
Y	CONE POINT ANGLE	118° ± 2° FOR LENGTHS LESS THAN	.109	.156	.188	.250	.250	.312	.375	.438	.562							
		90° ± 2° FOR THESE LENGTHS AND GREATER																
L	LENGTH	TOLERANCE	DASH NUMBER															
			PLAIN	PLAIN	PLAIN	PLAIN	PLAIN	SELF LOCK	PLAIN	SELF LOCK	PLAIN	SELF LOCK	PLAIN	SELF LOCK	PLAIN	SELF LOCK		
	.125	±.010	1*	8*	16*	25*		101*										
	.188		2*	9*	17*	26*	34*	102		112*								
	.250			10*	18*	27*	35*	103	44*	113		125*						
	.312				19*	28*	36*	104	45*	114	55*	126						
	.375						37*	105	46*	115	56*	127	65*	137		147*		
	.438							106*		116*								
	.500						38*	107	47*	117	57*	128	66*	138	74*	148		
	.562							108*		118*								
	.625							109	48*	119	58*	129	67*	139	75*	149		
								110	49*	120	59*	130	68*	140	76*	150		
	.750	±.020																
	.875																	
	1.000							111										
	1.250																	
	1.500	±.031								124		134		144		154		
	1.750										135		145		155			
	2.000										136		146		156			
	2.500														157			
	3.000														158			

* INACTIVE FOR NEW DESIGN AFTER 29 DECEMBER 1972.

① COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS51974, REVISION B. PART NUMBERS REMAIN MS51974.

THIRD ANGLE PROJECTION	CUSTODIAN	REVISION
	NATIONAL AEROSPACE STANDARDS COMMITTEE	1
PROCUREMENT SPECIFICATION	TITLE	CLASSIFICATION PART STANDARD
FF-S-200	SETSCREW, HEXAGON SOCKET, CONE POINT, ALLOY STEEL, CADMIUM PLATED, UNF-3A, PLAIN AND SELF-LOCKING ①	MS51974

MATERIAL:

ALLOY STEEL IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.

HARDNESS:

45-53HRC.

FINISH:

CADMIUM PLATED IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.

CODE:

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

EXAMPLE OF PART NUMBER:

MS51974-34 = SETSCREW, PLAIN, .1900-32 UNF-3A x .188 LONG.

NOTES:

- (1) THE THREADS SHALL BE IN ACCORDANCE WITH MIL-S-7742.
- (2) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- /3/ SELF-LOCKING ELEMENT:
 - (a) THE SELF-LOCKING ELEMENT SHALL BE IN ACCORDANCE WITH MIL-DTL-18240.
 - (b) FOR DESIGN AND USAGE LIMITATIONS, SEE NASM15981.
 - (c) LOCATION OF EFFECTIVE LOCKING AREA SHALL BE IN ACCORDANCE WITH NASM15981.
 - (d) MAXIMUM RING GAGE DIAMETER THAT LOCKING REGION OF SETSCREW MUST PASS THRU FREELY OR WITH FINGER PRESSURE SHALL BE THE NOMINAL SIZE PLUS .010.
 - (e) MIL-DTL-18240 DOES NOT ESTABLISH TORQUE REQUIREMENTS FOR LENGTHS ABOVE THE DASHED LINE IN TABLE I. ONLY A POSITIVE INDICATION OF TORQUE IS REQUIRED.
- (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) FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.
- (6) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (7) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

① COMPLETELY REVISED

REVISION
1

NASM51974
SHEET 2



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