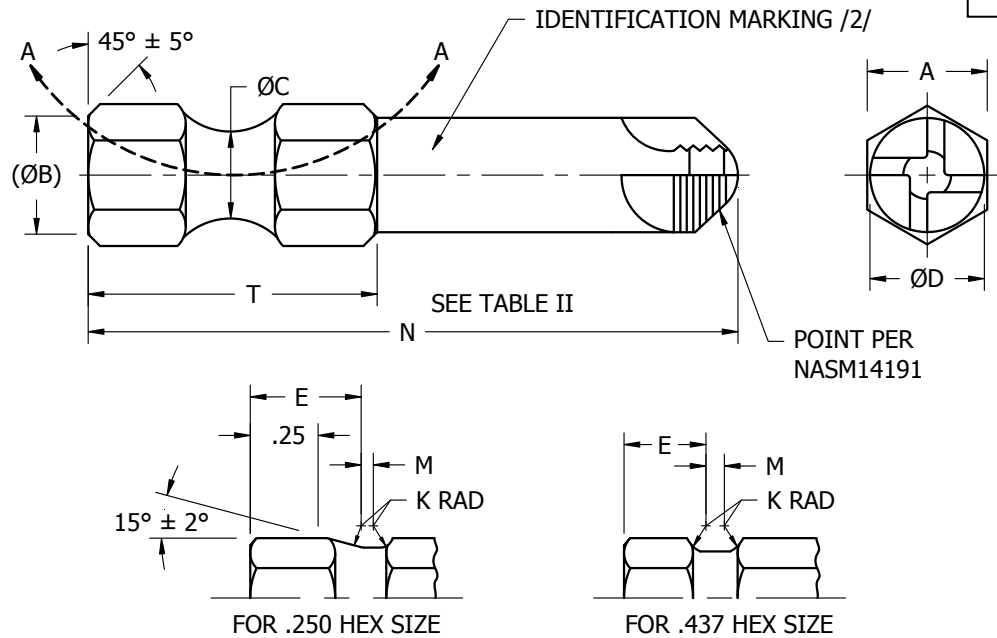


FED. SUPPLY CLASS

5120



DETAIL A - RETAINING GROOVES

FIGURE 1 - BIT CONFIGURATION

TABLE I - SIZES AND DIMENSIONS

DRIVER NUMBER	RECESS SIZE	A +.000 -.004	(ØB)	ØC ±.010	ØD	E ±.020	K RAD	M ± .020	T	MIN ULT TORQUE (LBF-IN)	FATIGUE TORQUE (LBF-IN)
06	6	.250	.203	.188	.188	.344	.094	.062	1.375 .625	35	16
08	8				.172					65	30
03	10				.250					100	45
04	1/4	.437	.391	.344	.344	.250	.109	.047	1.375 1.000	250	115
05	5/16				.328 .375 .359					500	200

MATERIAL:

TOOL STEEL, AISI S-1 (UNS T41901) OR AISI S-2 (UNS T41902) PER QQ-T-570 ASTM A681, TYPE S1 OR S2.

HEAT TREATMENT:

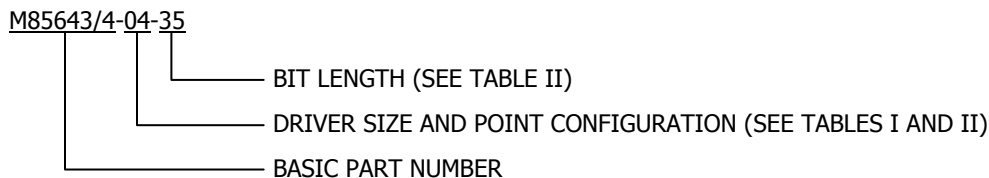
58 TO 62 HRC.

① COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MIL-B-85643/4(AS). PART NUMBERS REMAIN M85643/4.

FORM 09-01	THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
	PROCUREMENT SPECIFICATION		CLASSIFICATION PART STANDARD
	NASM85643	TITLE BIT, SCREWDRIVER, RIBBED, OFFSET CRUCIFORM, LONG SHANK, EXTERNAL HEXAGON SHANK ①	NASM85643/4 SHEET 1 OF 4

EXAMPLE OF PART NUMBER:



NOTES:

(1) DIMENSIONS AND CONFIGURATION:

BIT AND RETAINING GROOVE: IN ACCORDANCE WITH FIGURE 1 AND TABLE I. LENGTH IN ACCORDANCE WITH TABLE II
 DRIVER POINT: IN ACCORDANCE WITH NASM14191.
 OFFSET CRUCIFORM DRIVER BIT GAGE: IN ACCORDANCE WITH TABLE III AND FIGURE 2.
 TEST RECESS: IN ACCORDANCE WITH FIGURE 3 AND TABLE IV.

/2/ IDENTIFICATION: STAMP PART NUMBER (SEE EXAMPLE OF PART NUMBER) AND MANUFACTURER'S NAME, TRADEMARK OR SYMBOLS.

(3) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

(4) MINIMUM ULTIMATE TORQUE LOADS: IN ACCORDANCE WITH TABLE I.

(5) TORQUE FATIGUE LOADS: IN ACCORDANCE WITH TABLE I.

(6) APEX MACHINE AND TOOL COMPANY, DAYTON OH, AND ZEPHYR MANUFACTURING COMPANY, INGLEWOOD CA, ARE THE ONLY COMPANIES LICENSED TO MANUFACTURE RIBBED (ACR) TORQUE SET BITS UNDER UNITED STATES PATENT NUMBER 4,187,892. PATENT NUMBER 4,187,892 EXPIRES 12 FEBRUARY 1997. THE GOVERNMENT DOES NOT HAVE A ROYALTY-FREE LICENSE. ACR AND TORQUE SET ARE REGISTERED TRADEMARKS OF PHILLIPS SCREW COMPANY.

(7) DIMENSIONS IN INCHES.

(8) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.

(9) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.

(10) 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.

TABLE II – LENGTH AND DASH NUMBER

RECESS AND DRIVER SIZE	N + .12			
	1.94	2.75	3.50	6.00
	DASH NUMBER INDICATING RECESS SIZE AND BIT LENGTH			
6	0619	0627	0635	0660
8	0819	0827	0835	0860
10	319	327	335	360
1/4	–	–	435	460
5/16	–	–	535	560

REVISION

1

NASM85643-4

SHEET 2

① COMPLETELY REVISED