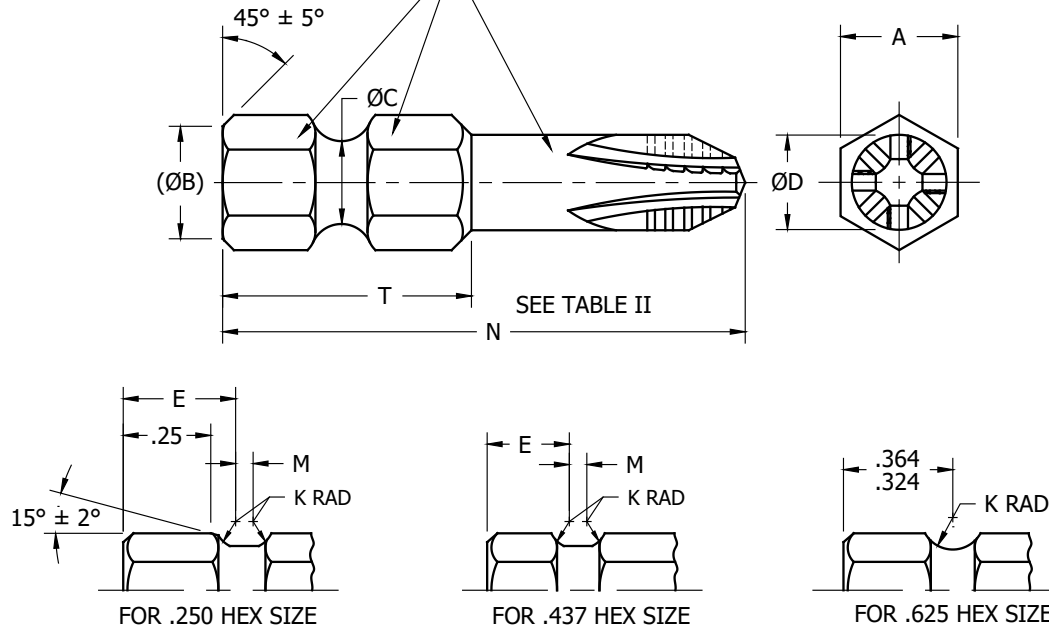


FED. SUPPLY CLASS

5120

IDENTIFICATION MARKING /4/



DETAIL B – RETAINING GROOVES

FIGURE 1 – BIT CONFIGURATION

TABLE I – BIT SIZES AND DIMENSIONS

DRIVER SIZE NUMBER	RECESS SIZE	A +.000 -.004	(ØB)	ØC ±.010	ØD	E ±.020	K RAD	M ±.020	N ±.12	MIN ULT TORQUE LBF-IN	FATIGUE TORQUE LBF-IN	
06	6	.250	.203	.188	.185 .180	.375	.094	.062	1.25	35	16	
08	8				.247					65	30	
03	10				.242					100	45	
04	1/4	.437	.391	.344	.434 .429	.250	.109	.047		250	115	
05	5/16				500					200		

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MIL-B-85643/5(AS), PARTS NUMBERS REMAIN M85643/5 (2)

THIRD
ANGLE
PROJECTION

PROCUREMENT
SPECIFICATION

NASM85643

CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

TITLE

**BIT, SCREWDRIVER, INSERT TYPE, RIBBED,
OFFSET CRUCIFORM, EXTERNAL HEXAGON SHANK,
MANUALLY DRIVEN**

REVISION

2

CLASSIFICATION
PART STANDARD

NASM85643/5
SHEET 1 OF 4

USE OF OR RELIANCE UPON THIS DOCUMENT OR ANY NATIONAL AEROSPACE STANDARD IS ENTIRELY VOLUNTARY. AIA DOES NOT QUALIFY SUPPLIERS OR CERTIFY CONFORMANCE OF ITEMS PRODUCED UNDER NATIONAL AEROSPACE STANDARDS. AIA MAKES NO REPRESENTATION OR CLAIM RESPECTING (1) THE SUITABILITY OF ITEMS FOR ANY PARTICULAR APPLICATION OR (2) THE EXISTENCE OF OR APPLICABILITY THERETO OF PATENT OR TRADEMARKS RIGHTS.

MATERIAL:

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

②

HARDNESS:

58 TO 62 HRC.

EXAMPLE OF PART NUMBER:

M85643/5-03

DRIVER SIZE NUMBER (SEE TABLE I)

②

BASIC PART NUMBER

NOTES:

- (1) DIMENSIONS IN INCHES.
- (2) DIMENSIONS AND CONFIGURATION:
BIT AND RETAINING GROOVE: IN ACCORDANCE WITH FIGURE I AND TABLE I.
DRIVER POINT: IN ACCORDANCE WITH NASM14191.
- (3) OFFSET CRUCIFORM DRIVER BIT GAGE: IN ACCORDANCE WITH FIGURE 2 AND TABLE II.
- /4/ IDENTIFICATION: STAMP PART NUMBER (SEE EXAMPLE OF PART NUMBER) AND MANUFACTURER'S NAME, TRADEMARK OR SYMBOLS.
- (5) TEST RECESS: THE TEST RECESS CONFIGURATION AND DIMENSIONS SHALL CONFORM TO FIGURE 3 AND TABLE III.
- (6) MINIMUM ULTIMATE TORQUE LOADS: IN ACCORDANCE WITH TABLE I.
- (7) TORQUE FATIGUE LOADS: IN ACCORDANCE WITH TABLE I.
- (8) ~~ACR AND TORQUE ARE REGISTERED TRADEMARKS OF PHILLIPS SCREW COMPANY. PATENT 4,187,892 EXPIRES 12 FEBRUARY 1997. THE GOVERNMENT DOES NOT HAVE A ROYALTY FREE LICENSE.~~
- (9) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (10) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (11) 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.
- (12) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

REVISION

2

NASM85643/5

SHEET 2



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