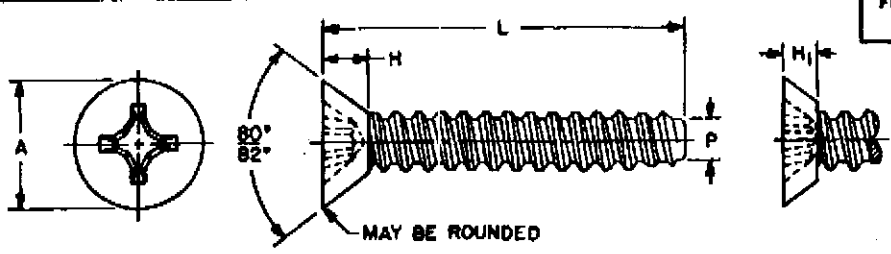


Att: Geo

FED. SUP CLASS
5305



FULL HEAD

UNDERCUT HEAD

TABLE I

NOMINAL SIZE		4 (.112)	6 (.138)	8 (.164)	10 (.190)	1/4 (.250)
THREADS PER INCH		24	20	18	16	14
A HEAD DIA	MAX SHARP	.225	.279	.332	.385	.507
	MIN FLAT	.195	.244	.292	.340	.452
H HEAD HEIGHT - REF		.067	.083	.100	.116	.153
H ₁ UNDERCUT HEAD HEIGHT	MAX	.047	.059	.070	.081	.107
	MIN	.038	.048	.058	.068	.092
P POINT DIA	MAX	.079	.095	.112	.130	.179
	MIN	.074	.089	.106	.123	.171
L LENGTH	TOL	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.
.188		1				
.250		2	9			
.312	+0	3	10			
.375	-.031	4	11	22		
.500		5	12	23	38	52
.625			13	24	39	53
.750			14	25	40	54
.875			15	26	41	55
1.000	+0		16	27	42	56
1.250	-.047		17	28	43	57
1.500			18	29	44	58
1.750				30	45	59
2.000	+0			31	46	60
2.250	-.062			32	47	61
2.500				33	48	62

REVIEWER: AV, IS, MI, NSA, OS, BR
USER: AS, AT, CL, KC, ME, OS, BR

This military standard is mandatory for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

- NOTES:
1. MATERIAL: Steel, carbon, in accordance with procurement specification.
 2. PROTECTIVE COATING: Cadmium plated in accordance with procurement specification.
 3. THREADS: The threads shall be in accordance with the applicable requirements of the procurement specification.
 4. RECESS: The recess shall be in accordance with M99006.
 5. SHORT LENGTHS: Lengths above dotted line shall have undercut heads.
 6. HOLE SIZES: For approximate hole sizes see MS24632.
 7. DIMENSIONS: Unless otherwise specified, all dimensions are in inches.
 8. PART NUMBER: The MS part number consists of the MS number, plus the dash number. Example: MS24619-1.
 9. Referenced documents shall be of the issue in effect on date of invitations for bid.
 10. For design feature purposes, this standard takes precedence over procurement documents referenced herein.

CANCELLED AFTER 15 MAY 1975

SUPERSEDED BY MS51862

INTERCHANGEABILITY TABLE

The screws covered by MS24639 are cancelled after 25 Feb 1963. The cancelled screws cannot always replace the superseding screws and should be used until existing stocks are depleted. Use only the superseding screws for design and engineering. Replacement shall be in accordance with the table below.

DASH NUMBER							
CANCELLED MS24639	SUPERSEDING MS24619	CANCELLED MS24639	SUPERSEDING MS24619	CANCELLED MS24639	SUPERSEDING MS24619	CANCELLED MS24639	SUPERSEDING MS24619
1	2	14	14	30	38	38	46
2	3	20	22	31	39	42	54
3	4	21	23	32	40	43	55
4	5	22	24	33	41	44	56
9	9	23	25	34	42	45	57
10	10	24	26	35	43	46	58
11	11	25	27	36	44	47	59
12	12	26	28	37	45	48	60
13	13						

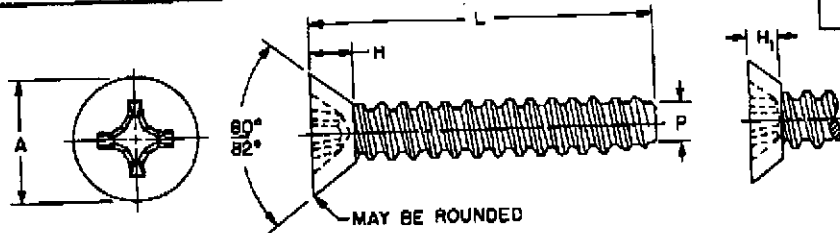
P.A. WC Other Cost 82	TITLE SCREW, TAPPING-THREAD FORMING, TYPE B, FLAT 82° COUNTERSUNK HEAD, CROSS-RECESSED, CARBON STEEL	MILITARY STANDARD MS24619
PROCUREMENT SPECIFICATION FF-S-107	SUPERSEDES: MS24639; BOM2.2 and BOM2.3 in part	SHEET 1 OF 1

DD FORM 672-1 (Continued)

5010-106 DIVISION OF THE ARMY, WASH., D.C.

APPROVED 5 OCT 1959 REVISED (A) 25 FEB 1963 (B) 27 AUG 1969 (C) 15 MAY 1975

FED. SUP CLASS
5305



FULL HEAD

UNDERCUT HEAD

NOMINAL SIZE	4 (.112)	6 (.138)	8 (.164)	10 (.190)	1/4 (.250)	
THREADS PER INCH	24	20	18	16	14	
A HEAD DIA	MAX SHARP MIN FLAT	.225 .195	.279 .244	.332 .292	.385 .340	.507 .452
N HEAD HEIGHT - REF		.067	.083	.100	.116	.153
H1 UNDERCUT HEAD HEIGHT	MAX MIN	.047 .038	.059 .048	.070 .058	.081 .068	.101 .092
P POINT DIA	MAX MIN	.079 .074	.095 .089	.112 .106	.130 .123	.179 .171
L LENGTH	TOL	DASH NO.	DASH NO.	DASH NO.	DASH NO.	
.188		1	2	3	4	
.250		2	3	4	5	
.312	+0	3	4	5	6	
.375	-.031	4	5	6	7	
.500		5	6	7	8	
.625			7	8	9	
.750			8	9	10	
.875	+0		9	10	11	
1.000	-.047		10	11	12	
1.250			11	12	13	
1.500			12	13	14	
1.750			13	14	15	
2.000	+0		14	15	16	
2.250	-.062		15	16	17	
2.500			16	17	18	

REVISIONS: AV, IS, MI, NS, OS, SH, ES, AS, AT, DL, MC, ME, OS, SH

NOTES:

- MATERIAL:** Steel, corrosion-resisting, in accordance with procurement specification.
- PROTECTIVE COATING:** Passivated in accordance with procurement specification.
- THREADS:** The threads shall be in accordance with the applicable requirements of the procurement specification.
- RECESS:** The recess shall be in accordance with MS9006.
- SHORT LENGTHS:** Lengths above dotted line shall have undercut heads.
- MOLE SIZES:** For approximate hole sizes see MS24632.
- DIMENSIONS:** Unless otherwise specified, all dimensions are in inches.
- PART NUMBER:** The MS part number consists of the MS number, plus the dash number. Example: MS24620-1.
- Referenced documents shall be of the issue in effect on date of invitations for bid.
- For design feature purposes, this standard takes precedence over procurement documents referenced herein.

CANCELLED AFTER 15 MAY 1975
SUPERSEDED BY MS51862

ANSSIC

INTERCHANGEABILITY TABLE

The screws covered by MS24640 are cancelled after 25 Feb 1963. The cancelled screws cannot always replace the superseding screws and should be used until existing stocks are depleted. Use only the superseding screws for design and engineering. Replacement shall be in accordance with the table below.

DASH NUMBER		DASH NUMBER		DASH NUMBER		DASH NUMBER	
CANCELLED MS24640	SUPERSEDING MS24620	CANCELLED MS24640	SUPERSEDING MS24620	CANCELLED MS24640	SUPERSEDING MS24620	CANCELLED MS24640	SUPERSEDING MS24620
1	2	14	14	30	38	38	46
2	3	20	22	31	39	42	54
3	4	21	23	32	40	43	51
4	5	22	24	33	41	44	56
5	6	23	25	34	42	45	57
6	7	24	26	35	43	46	58
7	8	25	27	36	44	47	59
8	9	26	28	37	45	48	60
9	10						
10	11						
11	12						
12	13						
13							

P.A. 40
Other Code 82

TITLE: SCREW, TAPPING-THREAD FORMING, TYPE B, FLAT 82° COUNTERSUNK HEAD, CROSS-RECESSED, CORROSION-RESISTING STEEL

MILITARY STANDARD
MS24620

SHEET 1 OF 1

PROCUREMENT SPECIFICATION FF-S-107 SUPERSEDED BY MS24640; BULK 4.3 in part

DD FORM 672-1 (Continued)

REVISIONS TO THIS FORM ARE SHOWN BY

REVISED (A) 23 FEB 1963 (B) 27 AUG 1969 (C) 15 MAY 1975