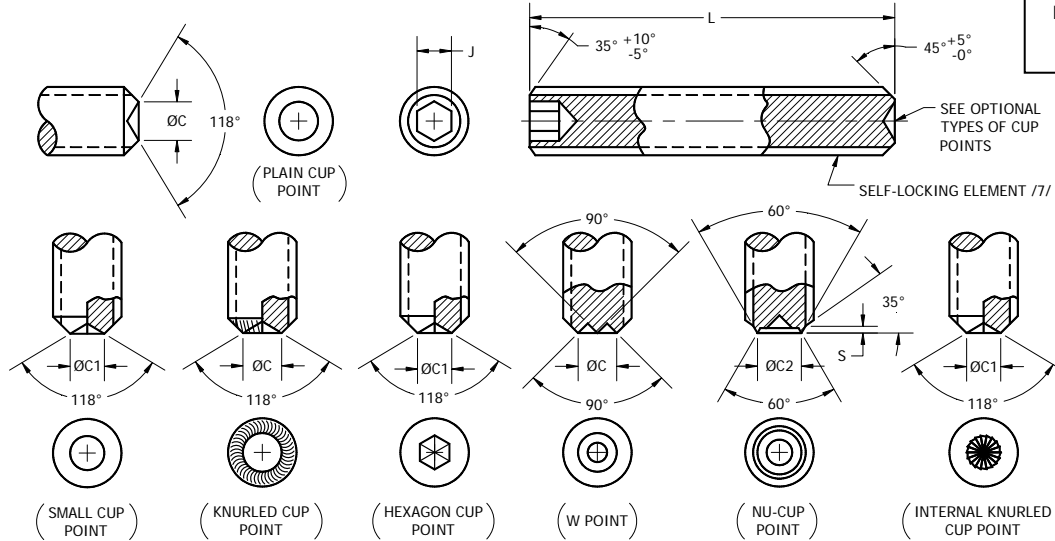


AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209



FED. SUPPLY CLASS
5305

2

TABLE I - DIMENSIONS

NOMINAL SIZE		.0600	.0860	.1120	.1380	.1640	.1900	.2500	.3125	.3750	.5000						
THREADS PER INCH (UNF-3A)		80	64	48	40	36	32	28	24	24	20						
J	SOCKET WIDTH NOM	.028	.035	.050	.062	.078	.094	.125	.156	.188	.250						
ØC	POINT DIAMETER MAX	.033	.047	.061	.074	.087	.102	.132	.172	.212	.291						
	MIN	.027	.039	.051	.064	.076	.088	.118	.156	.192	.270						
ØC1	POINT DIAMETER MAX	.032	.043	.056	.069	.082	.095	.125	.156	.187	.250						
	MIN	.027	.038	.051	.062	.074	.086	.114	.144	.174	.235						
ØC2	POINT DIAMETER MAX	.027	.043	.059	.074	.090	.101	.156	.190	.241	.333						
	MIN	.022	.038	.054	.068	.084	.095	.150	.185	.236	.328						
S	POINT LENGTH MAX	.007	.010	.013	.017	.021	.024	.027	.038	.041	.054						
	MIN	.004	.007	.008	.012	.016	.019	.022	.033	.036	.049						
DASH NUMBER																	
L	LENGTH	PLAIN		PLAIN		SELF LOCK	PLAIN	SELF LOCK	PLAIN	SELF LOCK	PLAIN	SELF LOCK					
.125	±.010	1	9	18	27		48	101*	60	112							
.188		2	10	19	28		48	102	61	113	72*	125					
.250		3	11	20	29	38	49	103	62	114	73	126	83*				
.312				12	21	30	39	50	104	62	114	74	127	84	137	93	147
.375						31	40	51	105	63	115	74	127	84	137	93	147
.438									106		116						
.500						32	41	52	107	64	117	75	128	85	138	94	148
.562									108		118						
.625						42	53	109	65	119	76	129	86*	139	95*	149	
.750							54	110	66	120	77*	130	87*	140	96*	150	
.875										121		131		141		151	
1.000								111		122		132		142		152	
1.250		±.020								123		133		143		153	
1.500										124		134		144		154	
1.750												135		145		155	
2.000												136		146		156	
2.500	±.031														157		
3.000															158		

* INACTIVE FOR NEW DESIGN AFTER 29 DEC 1972.

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MS51023, REVISION C. PART NUMBERS REMAIN MS51023.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION FF-S-200	TITLE SETScrew, HEXAGON SOCKET, CUP POINT, CORROSION RESISTANT STEEL, PASSIVATED, UNF-3A, PLAIN AND SELF-LOCKING	CLASSIFICATION PART STANDARD NASM51023 SHEET 1 OF 3

THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST REVISION DATE.

FORM 12-01

REVISION DATE: AUGUST 29, 2014

ISSUE DATE: SEPTEMBER 1999

MATERIAL:

CORROSION-RESISTING STEEL, 300 SERIES, IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.

FINISH:

② PASSIVATED IN ACCORDANCE WITH AMS2700, METHOD 1, CLASS 4.

CODE:

THE MS PART NUMBER CONSISTS OF THE MS NUMBER PLUS THE DASH NUMBER FROM TABLE I.

② EXAMPLE OF PART NUMBER:

MS51023-1 = SETSCREW, HEXAGON SOCKET, CUP POINT, 300 SERIES CRES,
.0600-80 UNF-3A THREAD, .125 LENGTH, PLAIN
MS51023-117 = SETSCREW, HEXAGON SOCKET, CUP POINT, 300 SERIES CRES,
.2500-28 UNF-3A THREAD, .500 LENGTH, SELF-LOCKING

NOTES:

- (1) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (2) REMOVE ALL BURRS AND SHARP EDGES.
- (3) THE THREADS SHALL BE IN ACCORDANCE WITH MIL-S-7742.
- (4) MAGNETIC PERMEABILITY SHALL BE LESS THAN 2.0 (AIR = 1.0) FOR A FIELD STRENGTH
H = 200 OERSTEDS USING A MAGNETIC PERMEABILITY INDICATOR PER ASTM A342/A342M,
TEST METHOD 3.
- (5) TOLERANCES UNLESS OTHERWISE SPECIFIED: ANGLES $\pm 5^\circ$.
- (6) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- /7/ 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 DOESN'T ESTABLISH TORQUE REQUIREMENTS FOR LENGTHS ABOVE THE
DASHED LINE. ONLY A POSITIVE INDICATION OF TORQUE IS REQUIRED.
- ② (8) 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.
- (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.

REVISION
2
NASM51023
SHEET 2

INTERCHANGEABILITY

SCREWS COVERED BY THE DASH NUMBERS GIVEN IN MS51024 ARE CANCELLED AFTER 29 JANUARY 1964 AND SUPERSEDED BY THE SCREWS COVERED ON NASM51023 HAVING THE SAME DASH NUMBERS. CANCELLED SCREWS MAY BE USED UNTIL EXISTING STOCKS ARE DEPLETED. USE ONLY MS51023 SCREWS FOR NEW DESIGN.

SCREWS COVERED BY THE DASH NUMBERS GIVEN IN NASM18064 IN PART ARE CANCELLED. CANCELLED SCREWS MAY BE USED UNTIL EXISTING STOCKS ARE DEPLETED. USE ONLY THE SUPERSEDING SCREWS FOR NEW DESIGN. REPLACEMENT SHALL BE IN ACCORDANCE WITH TABLE II.

TABLE II – SUPERSEDING/CANCELLED

CANCELLED	SUPERSEDING	CANCELLED	SUPERSEDING	CANCELLED	SUPERSEDING	CANCELLED	SUPERSEDING
MS18064	MS51023	MS18064	MS51023	MS18064	MS51023	MS18064	MS51023
DASH NUMBER		DASH NUMBER		DASH NUMBER		DASH NUMBER	
4	101	32	116	64	131	82	145
8	102	37	117	70	132	85	146
13	103	45	118	74	133	92	147
19	104	50	119	78	134	40	148
25	105	57	120	81	135	53	149
31	106	63	121	84	136	60	150
36	107	69	122	91	137	66	151
44	108	73	123	39	138	72	152
49	109	77	124	52	139	76	153
56	110	15	125	59	140	80	154
68	111	21	126	65	141	83	155
9	112	27	127	71	142	86	156
14	113	38	128	75	143	87	157
20	114	51	129	79	144	88	158
26	115	58	130				

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