



SIZE DESIGNATION	THDS PER INCH	D MAX MAJOR DIA	HEAD DIMENSIONS									
			A HEAD DIA		C MAX CHAMFER	H HEAD HGT		J SLOT WIDTH		(a) T SLOT DEPTH		(b) MAX RAD
			MAX	MIN		MAX	MIN	MAX	MIN	MAX	MIN	
.30 UNH	318	.0118	.021	.019	.002	.012	.010	.004	.003	.006	.004	.002
.40 UNH	254	.0157	.025	.023	.002	.016	.013	.005	.003	.008	.006	.002
.50 UNH	203	.0197	.033	.031	.003	.020	.017	.006	.004	.010	.007	.002
.60 UNH	169	.0236	.041	.039	.004	.025	.021	.008	.005	.012	.008	.003
.80 UNH	127	.0315	.051	.049	.005	.032	.028	.010	.007	.016	.012	.004
1.00 UNH	102	.0394	.062	.059	.006	.040	.035	.012	.008	.020	.016	.005
1.20 UNH	102	.0472	.082	.078	.008	.050	.045	.016	.012	.025	.020	.006

- (a) "T" MEASURED FROM BEARING SURFACE.
- (b) RELATIVE TO MAX MAJOR DIA.
- (c) FOR SCREW LENGTHS FOUR TIMES THE MAXIMUM MAJOR DIAMETER OR LESS, THREAD LENGTH (L_T) SHALL EXTEND TO WITHIN TWO THREADS OF THE HEAD BEARING SURFACE. SCREWS OF GREATER LENGTH SHALL HAVE COMPLETE THREADS FOR A MINIMUM OF FOUR MAXIMUM MAJOR DIAMETERS.

MATERIAL: CORROSION-RESISTANT STEELS: QQ-S-763
 CLASS 303, COND A
 CLASS 416, COND A, HEAT TREAT TO 125,000-145,000 PSI
 CLASS 420, COND A, HEAT TREAT TO 220,000-240,000 PSI
 BRASS: QQ-B-626, COMP 22, TEMPER HALF HARD.
 NICKEL SILVER: QQ-C-506, COMP 4, TEMPER HARD.
 FINISH: CORROSION-RESISTANT STEEL: PASSIVATE. SEE PROCUREMENT SPECIFICATION.
 BRASS: UNCOATED; BLACK OXIDE, MIL-F-195
 NICKEL SILVER: UNCOATED.

SURFACE ROUGHNESS: SURFACE ROUGHNESS OF HEADS SHALL BE AA63 MAXIMUM IN ACCORDANCE WITH MIL-STD-10.

SCREWS SHALL BE FREE OF ALL PROJECTING BURRS, OBSERVED AT 3X MAGNIFICATION.

DIMENSIONS IN INCHES.

THE DIAMETER OF THE UNTHREADED BODY SHALL NOT BE MORE THAN THE MAXIMUM MAJOR DIAMETER NOR LESS THAN THE MINIMUM PITCH DIAMETER OF THE THREAD.

EXAMPLE OF PART NUMBERS: MS21268A1 - .30 UNH CLASS 303 PASSIVATED CORROSION-RESISTANT STEEL SCREW, .020 MAX LENGTH.
 MS21268B1 - .30 UNH CLASS 416 PASSIVATED CORROSION-RESISTANT STEEL SCREW, .020 MAX LENGTH.

FOR SCREW FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.
 REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID. (A) FOR CHANGES SEE SHEETS 1 & 2.

P.A. USAF - ASD	TITLE	MILITARY STANDARD
Other Cost Navy - Ships Army - WC	SCREW, INSTRUMENT - FILLISTER HEAD	MS21268
PROCUREMENT SPECIFICATION 77-8-89	SUPERSEDES:	SHEET 1 OF 2

Dear Activities: Army - MI, NI Navy - Maps

Dear Activities: Army - MD, EL, MC Navy - Ships Navy - ASD, MA

This work is approved by the Department of Defense and is mandatory for all activities. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

APPROVED 28 Sep 61 REVISED 31 Oct 63

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CORROSION RESISTANT STEEL CLASS 303	CORROSION RESISTANT STEEL CLASS 316	CORROSION RESISTANT STEEL CLASS 320	BRASS	BRASS BRASS OXIDE	NICKEL SILVER	L LUMENS	
DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	DASH NO.	MIN.	MAX.
.30 UNM							
A1	B1	C1	D1	E1	F1	.020	.074
A2	B2	C2	D2	E2	F2	.025	.081
A3	B3	C3	D3	E3	F3	.032	.087
A4	B4	C4	D4	E4	F4	.040	.094
A5	B5	C5	D5	E5	F5	.050	.101
A6	B6	C6	D6	E6	F6	.060	.108
A7	B7	C7	D7	E7	F7	.080	.115
A8	B8	C8	D8	E8	F8	.100	.122
A9	B9	C9	D9	E9	F9	.120	.130
.40 UNM							
A19	B19	C19	D19	E19	F19	.025	.081
A20	B20	C20	D20	E20	F20	.032	.087
A21	B21	C21	D21	E21	F21	.040	.094
A22	B22	C22	D22	E22	F22	.050	.101
A23	B23	C23	D23	E23	F23	.060	.108
A24	B24	C24	D24	E24	F24	.080	.115
A25	B25	C25	D25	E25	F25	.100	.122
A26	B26	C26	D26	E26	F26	.120	.130
A27	B27	C27	D27	E27	F27	.160	.150
.50 UNM							
A37	B37	C37	D37	E37	F37	.032	.087
A38	B38	C38	D38	E38	F38	.040	.094
A39	B39	C39	D39	E39	F39	.050	.101
A40	B40	C40	D40	E40	F40	.060	.108
A41	B41	C41	D41	E41	F41	.080	.115
A42	B42	C42	D42	E42	F42	.100	.122
A43	B43	C43	D43	E43	F43	.120	.130
A44	B44	C44	D44	E44	F44	.160	.150
A45	B45	C45	D45	E45	F45	.200	.188
.60 UNM							
A55	B55	C55	D55	E55	F55	.040	.094
A56	B56	C56	D56	E56	F56	.050	.101
A57	B57	C57	D57	E57	F57	.060	.108
A58	B58	C58	D58	E58	F58	.080	.115
A59	B59	C59	D59	E59	F59	.100	.122
A60	B60	C60	D60	E60	F60	.120	.130
A61	B61	C61	D61	E61	F61	.160	.150
A62	B62	C62	D62	E62	F62	.200	.188
A63	B63	C63	D63	E63	F63	.250	.238
.80 UNM							
A73	B73	C73	D73	E73	F73	.050	.101
A74	B74	C74	D74	E74	F74	.060	.108
A75	B75	C75	D75	E75	F75	.080	.115
A76	B76	C76	D76	E76	F76	.100	.122
A77	B77	C77	D77	E77	F77	.120	.130
A78	B78	C78	D78	E78	F78	.160	.150
A79	B79	C79	D79	E79	F79	.200	.188
A80	B80	C80	D80	E80	F80	.250	.238
A81	B81	C81	D81	E81	F81	.320	.304
1.00 UNM							
A91	B91	C91	D91	E91	F91	.060	.108
A92	B92	C92	D92	E92	F92	.080	.115
A93	B93	C93	D93	E93	F93	.100	.122
A94	B94	C94	D94	E94	F94	.120	.130
A95	B95	C95	D95	E95	F95	.160	.150
A96	B96	C96	D96	E96	F96	.200	.188
A97	B97	C97	D97	E97	F97	.250	.238
A98	B98	C98	D98	E98	F98	.320	.304
A99	B99	C99	D99	E99	F99	.400	.384
1.20 UNM							
A109	B109	C109	D109	E109	F109	.080	.122
A110	B110	C110	D110	E110	F110	.100	.130
A111	B111	C111	D111	E111	F111	.120	.130
A112	B112	C112	D112	E112	F112	.160	.150
A113	B113	C113	D113	E113	F113	.200	.188
A114	B114	C114	D114	E114	F114	.250	.238
A115	B115	C115	D115	E115	F115	.320	.304
A116	B116	C116	D116	E116	F116	.400	.384
A117	B117	C117	D117	E117	F117	.500	.480

User Activities: Army - AI, MI Navy - Mops
 Army - MO, ZL, MC Navy - Ships USMP - ASD, PMA
 New Level Activities
 This activity is supported by the Department of Defense and is necessary to all activities. Changes to all new technological developments and for operations are listed in each issue of this document.

APPROVED 28 Sep 61 REVISED FOR CHANGE SEE SHEETS 1 & 2.

P.A. DMM7-ASD	TITLE	MILITARY STANDARDS
Other Code	SCREW, INSTRUMENT - FILLISTER HEAD	MS21268
Navy-Ships Army- W0		
PROCUREMENT SPECIFICATION F7-8-09	SUPERSEDES:	SHEET 2

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.