

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODDSS SPECIFIED IN THE SOLICITATION: FT-5-92

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE DEPARTMENT OF DEFENSE.

Form Approved
OMB No 0704-0188

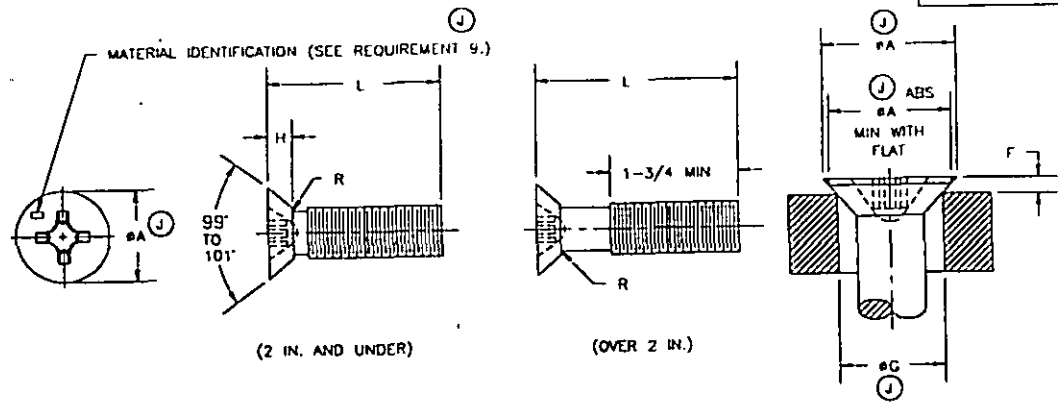


TABLE 1

THREAD SIZE	.0600 (#0)		.0860 (#2)		.1120 (#4)		.1360 (#6)		.1640 (#8)		.1900 (#10)		.2500		.3125		.3750	
	80 UNF		56 UNC		40 UNC 48 UNF		32 UNC 40 UNF		32 UNC 36 UNF		24 UNC 32 UNF		20 UNC 28 UNF		18 UNC 24 UNF		16 UNC 24 UNF	
#A HEAD DIAMETER	MAX SHARP	.119	.172	.225	.279	.332	.385	.438	.491	.544	.597	.650	.703	.756	.809	.862	.915	.968
	MIN SHARP	.104	.155	.207	.257	.308	.359	.410	.461	.512	.563	.614	.665	.716	.767	.818	.869	.920
	ABS. MIN	.095	.143	.191	.238	.285	.333	.381	.429	.477	.525	.573	.621	.669	.717	.765	.813	.861
F PROTRUSION ABOVE GAGING DIAMETER	MAX	.020	.022	.025	.028	.031	.034	.037	.040	.043	.046	.049	.052	.055	.058	.061	.064	.067
	MIN	.012	.014	.016	.017	.019	.021	.022	.023	.024	.025	.026	.027	.028	.029	.030	.031	.032
#G GAGING DIAMETER		.074	.121	.167	.214	.261	.307	.354	.400	.447	.493	.540	.586	.633	.679	.726	.772	.819
H HEAD HEIGHT	REF	.026	.037	.049	.060	.072	.083	.094	.105	.116	.127	.138	.149	.160	.171	.182	.193	.204
R FILLET RADIUS	MAX	.007	.008	.015	.015	.020	.020	.020	.020	.020	.020	.020	.020	.020	.020	.020	.020	.020
	MIN	.003	.004	.010	.010	.010	.010	.010	.010	.010	.010	.010	.010	.010	.010	.010	.010	.010

REQUIREMENTS:

- MATERIAL:**
ALUMINUM ALLOY PER QQ-A-225/6. BRASS PER ASTM B16, ASTM B36, ASTM B134 OR ASTM B206. COPPER-SILICON ALLOY PER ASTM B98 OR ASTM B99, UNS C65100, UNS C85500 OR UNS C66100. NICKLE-COPPER ALLOY PER QQ-N-281, TYPE A (UNS N04400). CARBON STEEL PER FED-STD-88. CORROSION RESISTANT STEEL PER FED-STD-66, COMPOSITION 302, 303, 304, 305 OR 316 OR EQUAL TO OR INTERCHANGEABLE WITH 16-18 OR 18-8 CHROMIUM-NICKLE ALLOY STEEL (DEVELOPED FOR COLD HEADING).
- PROTECTIVE COATING, PLATING OR TREATMENT:**
ANODIZE IN ACCORDANCE WITH MIL-A-8625, TYPE I OR II, CLASS 1. BLACK CHEMICAL FINISH IN ACCORDANCE WITH MIL-F-495. BLACK OXIDE COATING IN ACCORDANCE WITH MIL-C-13924. CADMIUM PLATE IN ACCORDANCE WITH QQ-P-416, TYPE II, CLASS 3. NICKLE PLATE IN ACCORDANCE WITH QQ-N-290, CLASS 1, GRADE E. CLEAN AND DESCALE IN ACCORDANCE WITH ASTM A380.
- MAGNETIC PERMEABILITY:**
CORROSION RESISTANT STEEL SCREWS SHALL HAVE A MAGNETIC PERMEABILITY IN ACCORDANCE WITH THE PROCUREMENT SPECIFICATION.
- HEAT TREATMENT:**
ALUMINUM ALLOY SCREWS. 62 KSI MINIMUM ULTIMATE TENSILE STRENGTH IN ACCORDANCE WITH MIL-H-6088.
- RECESS:**
THE RECESS SHALL BE IN ACCORDANCE WITH MS9006.
- THREADS:**
THREADS SHALL BE CLASS 2A IN ACCORDANCE WITH FED-STD-H28/2. ACCEPTABILITY OF SCREW THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/20, SYSTEM 21.
- THREAD LENGTH:**
FOR SCREWS UP TO AND INCLUDING 2.000 INCHES IN LENGTH, THE COMPLETE THREADS SHALL EXTEND TO WITHIN TWO (2) THREADS OF THE BEARING SURFACE OF THE HEAD, OR CLOSER IF PRACTICABLE. SCREWS OF LONGER LENGTH SHALL HAVE A MINIMUM COMPLETE THREAD LENGTH OF 1.750 INCHES.

(J) DENOTES CHANGE(S)

INCH-POUND

PREPARING ACTIVITY: IS CUSTODIANS: ARMY- AR NAVY- AS AIR FORCE- 99 REVIEW: AT, AV, EA, MC, ME, MI, NS, SH USER: PROJECT NUMBER: 5305-2071	MILITARY SPECIFICATION SHEET TITLE SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, CROSS RECESSED, UNC-2A AND UNF-2A	SPECIFICATION SHEET NUMBER MS24693 14 FEB 95 REV J SUPERSEDING MS24693H 26 OCT 84 AND AN501 21 APR 67 AMSC- N/A FSC 5305
DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.		Page 1 of 5

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8. UNTHREADED PORTION:
THE DIAMETER OF THE UNTHREADED PORTION OF SCREWS SHALL NOT BE LESS THAN THE MINIMUM PITCH DIAMETER NOR MORE THAN THE MAXIMUM MAJOR DIAMETER OF THE THREAD.
9. MATERIAL IDENTIFICATION:
CORROSION RESISTING STEEL SCREWS WITH NOMINAL SIZES .1380 (#6) AND LARGER SHALL BE PERMANENTLY MARKED WITH ONE DASH ("-"). MARKING SHALL BE PLACED ON THE TOP OF HEAD AND INDENTED. METHOD AND SIZE OF MARKING SHALL CONFORM TO THE REQUIREMENTS FOR PERMANENT MARKINGS SPECIFIED IN SAE AS478.
10. POINTS:
SCREWS SHALL HAVE PLAIN SHEARED ENDS. HEADER POINTS ARE ACCEPTABLE IN ACCORDANCE WITH ANSI B18.6.3.
11. CODE:
- "A" BEFORE DASH NUMBER - ANODIZED, ALUMINUM ALLOY SCREW.
 - "B" BEFORE DASH NUMBER - UNCOATED, BRASS SCREW.
 - "BB" BEFORE DASH NUMBER - BLACK CHEMICAL FINISH, BRASS SCREW.
 - "C" BEFORE DASH NUMBER - CLEANED AND DESCALED, CORROSION RESISTANT STEEL SCREW.
 - "CB" BEFORE DASH NUMBER - CADMIUM PLATED, BRASS SCREW.
 - "N" BEFORE DASH NUMBER - UNCOATED, NICKEL-COPPER SCREW.
 - "NB" BEFORE DASH NUMBER - NICKEL PLATED, BRASS SCREW.
 - "S" BEFORE DASH NUMBER - CADMIUM PLATED, CARBON STEEL SCREW.
 - "U" BEFORE DASH NUMBER - UNCOATED, COPPER-SILICON SCREW.
 - "B" AFTER DASH NUMBER - BLACK OXIDE COATED, CORROSION RESISTANT STEEL SCREW.
12. PART NUMBER:
THE PART NUMBER SHALL CONSIST OF THE BASIC MS NUMBER FOLLOWED BY A DASH NUMBER WITH A DASH NUMBER CODE. ONLY ONE (1) DASH NUMBER CODE SHALL BE USED PER PART NUMBER. DO NOT USE UNASSIGNED DASH NUMBERS OR CODES. SEE TABLE D AND PART NUMBER EXAMPLES.

EXAMPLES:

- MS24693-A28 = SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100', CROSS RECESSED, .1380-32 UNC-2A THREAD, ANODIZED, ALUMINUM ALLOY, .500 INCH LENGTH.
- MS24693-B54 = SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100', CROSS RECESSED, .1640-32 UNC-2A THREAD, UNCOATED, BRASS, 1.000 INCH LENGTH.
- MS24693-BB80 = SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100', CROSS RECESSED, .1900-24 UNC-2A THREAD, BLACK CHEMICAL FINISH, BRASS, 1.500 INCH LENGTH.
- MS24693-C202 = SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100', CROSS RECESSED, .1120-48 UNF-2A THREAD, CLEANED AND DESCALED, CORROSION RESISTANT STEEL, .250 INCH LENGTH.
- MS24693-CB132 = SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100', CROSS RECESSED, .3125-18 UNC-2A THREAD, CADMIUM PLATED, BRASS, 3.000 INCH LENGTH.
- MS24693-N254 = SCREWS, MACHINE, FLAT COUNTERSUNK HEAD, 100', CROSS RECESSED, .1640-36 UNF-2A THREAD, UNCOATED, NICKEL-COPPER ALLOY, 1.000 INCH LENGTH.
- MS24693-NB106 = SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100', CROSS RECESSED, .2500-20 UNC-2A THREAD, NICKEL PLATED, BRASS, 2.000 INCH LENGTH.
- MS24693-S2 = SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100', CROSS RECESSED, .1120-40 UNC-2A THREAD, CADMIUM PLATED, CARBON STEEL, .250 INCH LENGTH.
- MS24693-U154 = SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100', CROSS RECESSED, .3750-16 UNC-2A THREAD, UNCOATED, COPPER-SILICON ALLOY, 3.000 INCH LENGTH.
- MS24693-2068 = SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100', CROSS RECESSED, .1120-48 UNF-2A THREAD, BLACK OXIDE COATED, CORROSION RESISTANT STEEL, .500 INCH LENGTH.

PREPARING ACTIVITY: 15 CUSTODIANS: ARMY-AR NAVY-AS AIR FORCE-99 REVIEW: AT, AV, EA, MC, ME, MI, NS, SH USER: PROJECT NUMBER: 5305-2071	MILITARY SPECIFICATION SHEET TITLE SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100', CROSS RECESSED, UNC-2A AND UNF-2A	SPECIFICATION SHEET NUMBER 14 FEB 95 MS24693 REV J
		SUPERSEDING MS24693H 26 OCT 94 AND ANS01 21 APR 67 AMSC- N/A FSC 5305
DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.		Page <u>2</u> of <u>5</u>

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NOTES:

1. ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.
2. UNLESS OTHERWISE SPECIFIED, ISSUES OF REFERENCED DOCUMENTS ARE THOSE IN EFFECT AT THE TIME OF SOLICITATION.
3. IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS DOCUMENT AND THE REFERENCES CITED HEREIN, THE TEXT OF THIS DOCUMENT SHALL TAKE PRECEDENCE.

TABLE II

LENGTH	DASH NUMBERS															
	COURSE THREAD						FINE THREAD									
	.0880-58 UNC-2A	.1120-40 UNC-2A	.1380-32 UNC-2A	.1640-32 UNC-2A	.1900-24 UNC-2A	.2500-20 UNC-2A	.3125-18 UNC-2A	.3750-16 UNC-2A	.0800-80 UNF-2A	.1120-48 UNF-2A	.1380-40 UNF-2A	.1640-38 UNF-2A	.1900-32 UNF-2A	.2500-28 UNF-2A	.3125-24 UNF-2A	.3750-24 UNF-2A
.083 +0 -.158	15 16 17	1 2 3 4 5	23 24 25 26	46 47 48 49	69 70 71	81 82 83	118 117 116 115	138 139 140 141	217 218 219	201 202 203 204 205	224 225 226 227	248 247 248 249	268 269 270 271	294 295 296 297	316 317 318 319	332 331 330 329
.187 +.250 +.312 +.375 +.437	18 19 20 21 22	6 7 8 9 10	28 29 30 31 32	50 51 52 53 54	72 73 74 75 76	94 85 86 87 88	118 117 116 115 114	138 139 140 141 142	425	206 207 208 209 210	228 229 230 231 232	250 251 252 253 254	272 273 274 275 276	294 295 296 297 298	316 317 318 319 320	332 331 330 329 328
.500 .625 .750 .875 1.000	23 24 25 26 27	11 12 13 14	33 34 35 36	55 56 57 58	77 78 79 80	99 100 101 102	121 122 123 124	143 144 145 146	211 212 213 214 215	211 212 213 214 215	233 234 235 236 237	255 256 257 258 259	277 278 279 280 281	299 300 301 302 303	321 322 323 324 325	343 344 345 346 347
1.125 1.250 1.375 1.500 1.625	28 29 30 31 32	15 16 17 18	38 39 40 41	60 61 62 63	82 83 84 85	104 105 106 107	126 127 128 129	148 149 150 151	216	216	238 239 240 241 242	260 261 262 263 264	282 283 284 285 286	304 305 306 307 308	326 327 328 329 330	348 349 350 351 352
1.750 1.875 2.000 2.125 2.250	33 34 35 36 37	19 20 21 22 23	42 43 44 45	64 65 66 67	86 87 88 89	108 109 110 111	130 131 132 133	152 153 154 155	217 218 219 220	217 218 219 220	239 240 241 242	261 262 263 264	283 284 285 286	305 306 307 308	327 328 329 330	349 350 351 352
2.500 2.750 3.000	38 39 40	24 25 26 27	47 48 49 50	69 70 71 72	91 92 93 94	113 114 115 116	135 136 137 138	157 158 159 160	221 222 223 224	221 222 223 224	243 244 245 246	265 266 267 268	287 288 289 290	309 310 311 312	331 332 333 334	353 354 355 356

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PREPARING ACTIVITY: IS
CUSTODIANS: ARMY- AR NAVY- AS
AR FORCE- 99
REVIEW: AT, AV, EA, MC, ME, MI, NS, SH
USER:
PROJECT NUMBER: 5305-2071
DISTRIBUTION STATEMENT

MILITARY SPECIFICATION SHEET
TITLE
SCREW, MACHINE, FLAT COUNTERSUNK HEAD,
100°, CROSS RECESSED, UNC-2A AND UNF-2A

SPECIFICATION SHEET NUMBER
MS24693 14 FEB 95
REV J
SUPERSEDING MS24693H 26 OCT 94
AND AN501 21 APR 67
AMSC- N/A FSC 5305

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TABLE III

NOMINAL SIZE	MINIMUM TENSILE STRENGTH 1/					CORROSION RESISTANT STEEL	
	CARBON STEEL	BRASS	ALUMINUM ALLOY	COPPER-SILICON ALLOY	NICKLE-COPPER ALLOY	LBS	
.0600-80 UNF-2A	105	95	110	105	140	140	
.0860-56 UNC-2A	220	200	225	220	295	295	
.1120-40 UNC-2A	380	330	370	360	490	490	
.1380-32 UNF-2A	400	360	410	400	525	525	
.1640-24 UNF-2A	545	500	560	545	725	725	
.1900-20 UNF-2A	610	560	630	610	810	810	
.2160-16 UNF-2A	640	560	670	640	1120	1120	
.2420-12 UNF-2A	680	770	810	680	1180	1180	
.2680-10 UNF-2A	840	810	910	840	1400	1400	
.2940-8 UNF-2A	1050	960	1060	1050	1600	1600	
.3200-7 UNF-2A	1200	1100	1240	1200	2540	2540	
.3460-6 UNF-2A	1910	1750	1970	1910	2910	2910	
.3720-5 UNF-2A	2180	2000	2250	2180	4190	4190	
.3980-4 UNF-2A	3480	2880	3250	3140	4840	4840	
.4240-3 UNF-2A	4650	3190	3600	4650	6200	6200	
.4500-2 UNF-2A	5270	4260	4800	5270	7020	7020	

1/ BASED ON 60 KSI MINIMUM ULTIMATE TENSILE STRENGTH FOR CARBON STEEL, 55 KSI FOR BRASS, 62 KSI FOR ALUMINUM ALLOY, 60 KSI FOR COPPER-SILICON ALLOY, 80 KSI FOR NICKLE-COPPER ALLOY AND 80 KSI FOR CORROSION RESISTANT STEEL. LOAD POUNDS ARE CALCULATED BY THE STRESS AREAS INDICATED IN SCREW THREAD STANDARDS FOR FED-STD-H2B.

PREPARING ACTIVITY: IS CUSTODIANS: ARMY-AR NAVY-AS AIR FORCE-99 REVIEW: AT, AV, EA, MC, ME, MI, NS, SH USER: PROJECT NUMBER: 5305-2071 DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.	MILITARY SPECIFICATION SHEET		SPECIFICATION SHEET NUMBER MS24693	14 OCT 95 REV J
	TITLE SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100°, CROSS RECESSED, UNC-2A AND UNF-2A		SUPERSADING MS24693H 26 OCT 94 AND AN501 21 APR 67	
	AMSC- N/A		FSC 5305	
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PREVIOUS EDITIONS ARE OBSOLETE

TABLE IV
INTERCHANGEABILITY - (Using Coded Dash Numbers)

After 21 April 1967, screws given on AN507 are canceled, but their existing stock should be used for maintenance purposes until depleted. USE ONLY THE NEW MS24693 SCREWS FOR NEW DESIGN AND ENGINEERING.

Codes for canceled and new dash numbers:

- (1) For cadmium plated, carbon steel screws: The following AN dash numbers are superseded by the following MS dash numbers with a prefix "S" added. Example: AN507-420R5 superseded by MS24693-S91.
- (2) For plain brass screws: AN dash numbers with a prefix "UB" superseded by MS dash numbers with a prefix "B". Example: AN507UB420R5 superseded by MS24693-B91.
- (3) For black chemical finish brass screws: AN dash numbers with a prefix "B" superseded by MS dash numbers with a prefix "BB". Example: AN507B420R5 superseded by MS24693-BB91.
- (4) For cadmium plated, brass screws: AN dash numbers with a prefix "PB" superseded by MS dash numbers with a prefix "CB". Example: AN507PB420R5 superseded by MS24693-CB91.
- (5) For passivated, corrosion resisting steel screws: AN dash numbers with a prefix "C" superseded by MS dash numbers with a prefix "C". Example: AN507C420R5 superseded by MS24693-C91.
- (6) For anodized, aluminum alloy screws: AN dash numbers with a prefix "DD" superseded by MS dash numbers with a prefix "A". Example: AN507DD420R5 superseded by MS24693-A91.
- (7) For AN507, part number inactive for design after 17 February 1959: Optional design II cross recessed ("R" between first and second dash numbers) and slotted head screws ("-" between first and second dash numbers) are canceled and superseded by the appropriately coded MS dash number. Example: AN507-420R5 or AN507-420-5 superseded by MS24693-S91.

CANCELED AN507 DASH NUMBERS	NEW MS24693 DASH NUMBERS	CANCELED AN507 DASH NUMBERS	NEW MS24693 DASH NUMBERS	CANCELED AN507 DASH NUMBERS	NEW MS24693 DASH NUMBERS	CANCELED AN507 DASH NUMBERS	NEW MS24693 DASH NUMBERS
420R5	91	448R14	209	624R48	354	836R7	249
420R6	92	448R16	210	632R3	23	836R8	250
420R7	93	448R18	211	632R4	24	836R10	251
420R8	94	448R20	212	632R5	25	836R12	252
420R10	95	448R22	213	632R6	26	836R14	253
420R12	96	448R24	214	632R7	27	836R16	254
420R14	97	448R26	215	632R8	28	836R18	255
420R16	98	448R28	216	632R10	29	836R20	256
420R18	99	518R8	118	632R12	30	836R22	257
420R20	100	518R10	117	632R14	31	836R24	258
420R24	102	518R12	118	632R16	32	836R26	259
420R28	104	518R14	119	632R18	33	836R28	260
420R32	106	518R16	120	632R20	34	836R30	261
420R40	108	518R18	121	632R24	36	836R32	262
420R48	110	518R20	122	632R28	38	836R36	263
428R6	292	518R24	124	632R32	40	836R40	264
428R7	293	518R28	126	632R40	42	836R44	265
428R8	294	518R32	128	640R4	224	836R48	266
428R10	295	518R40	130	640R5	225	1024R5	69
428R12	298	518R48	132	640R8	226	1024R6	70
428R14	297	524R8	318	640R9	227	1024R7	71
428R16	298	524R10	317	640R8	228	1024R8	72
428R18	299	524R12	318	640R10	229	1024R10	73
428R20	300	524R14	319	640R12	230	1024R12	74
428R22	301	524R16	320	640R14	231	1024R14	75
428R24	302	524R18	321	640R16	232	1024R16	76
428R26	303	524R20	322	640R18	233	1024R18	77
428R28	304	524R24	324	640R20	234	1024R20	78
428R30	305	524R28	326	640R22	235	1024R24	80
428R32	306	524R32	328	640R24	236	1024R28	82
428R35	307	524R40	330	640R26	237	1024R32	84
428R40	308	524R48	332	640R28	238	1024R40	86
428R44	309	616R8	138	640R30	239	1024R48	88
428R48	310	616R10	139	640R32	240	1032R4	268
440R3	1	616R12	140	640R36	241	1032R5	269
440R4	2	616R14	141	640R40	242	1032R6	270
440R5	3	616R16	142	832R4	46	1032R7	271
440R6	4	616R18	143	832R5	47	1032R8	272
440R7	5	616R20	144	832R6	48	1032R10	273
440R8	6	616R24	146	832R7	49	1032R12	274
440R10	7	616R28	148	832R8	50	1032R14	275
440R12	8	616R32	150	832R10	51	1032R16	276
440R14	9	616R40	152	832R12	52	1032R18	277
440R16	10	615R48	154	832R14	53	1032R20	278
440R18	11	624R8	338	832R16	54	1032R22	279
440R20	12	624R10	339	832R18	55	1032R24	280
440R24	14	624R12	340	832R20	56	1032R26	281
448R3	201	624R14	341	832R24	58	1032R28	282
448R4	202	624R16	342	832R28	60	1032R30	283
448R5	203	624R18	343	832R32	62	1032R32	284
448R6	204	624R20	344	832R40	64	1032R36	285
448R7	205	624R24	346	832R48	66	1032R40	286
448R8	206	614R28	348	836R4	246	1032R44	287
448R10	207	624R32	350	836R5	247	1032R48	288
448R12	208	624R40	352	836R6	248		

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PREPARING ACTIVITY: IS	MILITARY SPECIFICATION SHEET	SPECIFICATION SHEET NUMBER
CUSTODIANS: ARMY-AR NAVY-AS	TITLE	14 FEB 95
AIR FORCE--99	SCREW, MACHINE, FLAT COUNTERSUNK HEAD, 100', CROSS RECESSED, UNC-2A AND UNF-2A	REV J
REVIEW: AT, AV, EA, MC, ME, MI, NS, SH		MS24693
USER:		SUPERSEDING MS24693H 26 OCT 94 AND AN501 21 APR 67
PROJECT NUMBER: 5305-2071		AMSC- N/A FSC 5305
DISTRIBUTION STATEMENT	A. Approved for public release; distribution is unlimited.	Page 5 of 5

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