

REVISIONS: EL. 15, MI. NU
 LSR: AT. GL. MC. ME. OS. SH. TO

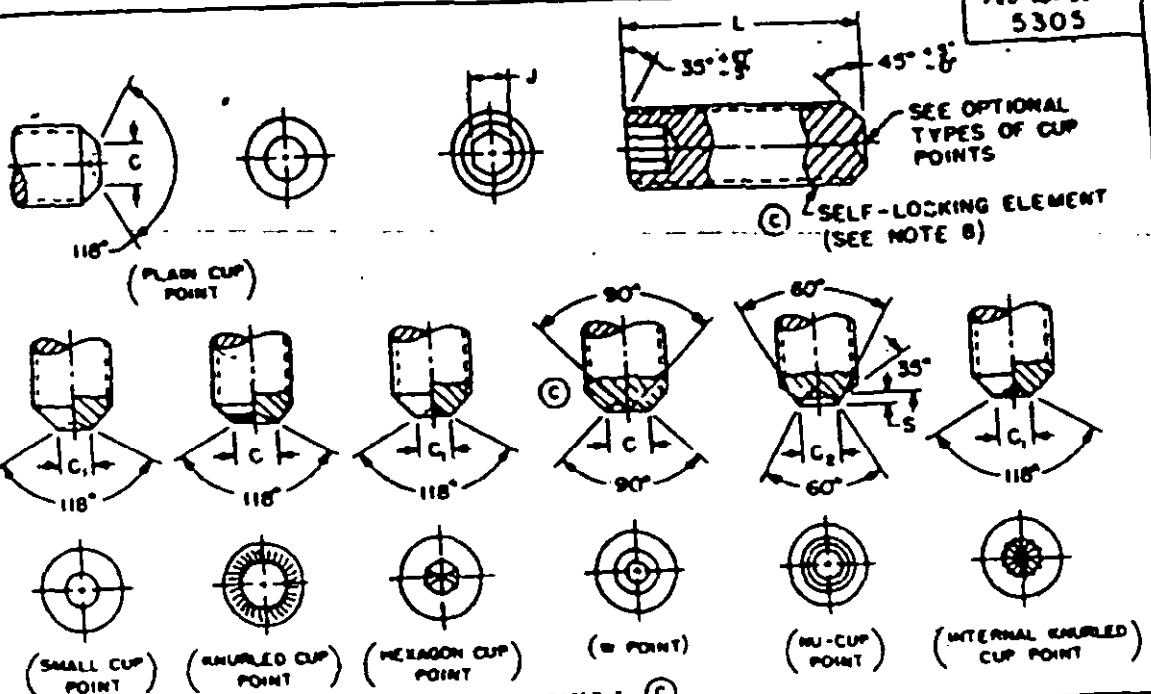


TABLE I (C)

NOMINAL SIZE	.060	.084	.112	.138	.164	.190	.250	.3125	.375	.500
THREADS PER INCH (UNF-3A)	80	64	48	40	36	32	28	24	24	20
J SOCKET WIDTH ACROSS FLATS	MIN .028	.035	.050	.062	.078	.094	.125	.156	.188	.250
C POINT DIAMETER	MAX .031 MIN .027	.047 .039	.061 .051	.074 .064	.087 .076	.102 .088	.132 .118	.172 .156	.212 .192	.291 .270
C ₁ POINT DIAMETER	MAX .032 MIN .027	.043 .038	.054 .051	.069 .062	.082 .074	.095 .086	.125 .114	.156 .144	.187 .174	.250 .235
C ₂ POINT DIAMETER	MAX .027 MIN .022	.043 .038	.059 .054	.074 .068	.090 .084	.101 .095	.154 .150	.190 .185	.241 .236	.313 .328
S POINT LENGTH	MAX .007 MIN .004	.010 .007	.013 .008	.017 .012	.021 .016	.024 .019	.027 .022	.038 .033	.041 .036	.054 .049

DASH NUMBERS

L LENGTH	TOL	DASH NUMBERS															
		PLAIN	PLAIN	PLAIN	PLAIN	FLASK	PLAIN	SELF LOCK	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		49	102		61	113	72*	125				
.250		3	11	20	29	48	50	103		62	114	73	126	83*			
.312			12	21	30	39	51	104		63	115	74	127	84	137	93	151
.375					31	40	52	105		64	116	75	128	85	138	94	148
.438	.010				32	41	52	106		117	76	129	86*	139	95*	149	
.500						42	53	107		118							
.562								108		119	77*	130	87*	140	96*	150	
.625								109		120	78*	131		141		151	
									54	110	66	121		142		152	
.750	.010																
.875																	
1.000																	
1.250																	
											122						
1.500	.010																
1.750																	
2.000																	
2.500	.011																
3.000																	

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.

(C) Inactive for new design after 29 DEC 1972. (C) For changes see sheets 1 and 2.

P.A. VC	TITLE	MILITARY STANDARD
Drawn	SETScrew-HEXAGON SOCKET, CUP POINT, CORROSION-RESISTING STEEL, PASSIVATED, UNF-3A, PLAIN AND SELF-LOCKING	MS 51023
02		
PROCUREMENT SPECIFICATION	SUPPLEMENT MS51024, BCT11.1 and in part MS18064 and BCT11.2	SHEET 1 OF 1
FF-S-100		

APPROVED 7 MAY 1956 REVISED (A) 29 JAN 1964 (B) 26 NOV 1967 (C) 29 DEC 1972

NOTES

1. **MATERIAL:** Corrosion-Resisting Steel, 300 Series, in accordance with procurement specification.
2. **PROTECTIVE COATING:** Passivated in accordance with QQ-P-35.
3. **THREADS:** The threads shall be in accordance with MIL-S-7742.
4. **MAGNETIC PERMEABILITY:** These setscrews have a magnetic permeability of 2.0 max (air = 1.0) for a field strength of H = 200 oersteds, when using a magnetic indicator per MIL-I-17214.
5. **DIMENSIONS:** All dimensions are in inches, unless otherwise specified.
6. **TOLERANCES:** Angles 15°, unless otherwise specified.
7. **PART NUMBER:** The NS part number consists of the NS number, plus the dash number.
Example: MS51023-1.
8. **SELF-LOCKING ELEMENT:**
 - (a) The self-locking element shall be in accordance with MIL-F-18240.
 - (b) For design and usage limitations, see MS15901.
 - (c) Location of effective locking area shall be in accordance with MS15901.
 - (d) Maximum ring gage diameter that locking region of setscrew must pass thru freely or with finger pressure shall be the nominal size plus 0.010.
 - (e) MIL-F-18240 doesn't establish torque requirements for lengths above the dashed line. Only a positive indication of torque is required.
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.

INTERCHANGEABILITY

Screws covered by the dash numbers given in MS51024 are cancelled after 29 January 1964 and superseded by the screws covered on MS51023 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 MS18064 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

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	12	116	64	131	82	145
6	102	37	117	70	132	85	146
11	101	45	118	74	133	92	147
19	104	50	119	78	134	40	148
25	104	57	120	81	135	53	149
31	106	61	121	84	136	60	150
36	107	69	122	91	137	66	151
44	108	71	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	84	156
14	113	38	128	75	143	87	157
20	114	51	129	79	144	88	158
26	115	59	130				

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MILITARY STANDARD 51, 11, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100

APPROVED 7 MAY 1956 REVISED A 29 JAN 1964 B 28 NOV 1967 C FOR CHANGES SEE SHEETS 1 AND 2.

NSA	NS	TITLE	MILITARY STANDARD
02		SETScrew-HEXAGON SOCKET, CUP POINT, CORROSION-RESISTING STEEL, PASSIVATED, UNF-3A, PLAIN AND SELF-LOCKING	MS51023
PROCUREMENT SPECIFICATION	SUPERSEDES	MS51024, BC11.1 and in part MS18064 and BC11.2	SHEET 1 OF 2