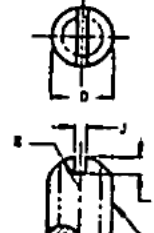
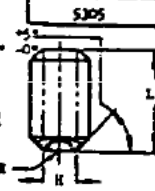


FD-302 (Rev. 5-22-64)



NOMINAL SIZE	THREAD T	D MAX DIA	FLUTED SOCKET HEAD						
			NUMBER OF FLUTES	J		M		N	
				SOCKET DIAMETER, NUTS		SOCKET DIAMETER, MAJES		SOCKET LAND WIDTH	
				MAX	MIN	MAX	MIN	MAX	MIN
NO. 2	PT. 2-56UNC-3A	.085	4	.038	.0375	.050	.049	.017	.016
NO. 4	PT. 4-40UNC-3A	.112	6	.051	.050	.062	.061	.021	.020
NO. 6	PT. 6-32UNC-3A	.138	4	.056	.055	.079	.078	.023	.022

NOMINAL SIZE	THREAD	D MAX DIA	MAX CORE READ		SLOTTED READ			TYPES A AND D			TYPE D		TYPES E AND C				TYPE F
			P		R RAD	L LOW	K HIGH	Q DIA		R OTHER RAD	115°-120° FOR LEAST-3 AND UNDER	90°-120° FOR LEAST-3 AND OVER	S		P	R RADIUS ±.015	
			MAX	MIN				MAX	MIN				MAX	MIN			
1/16-32	2-56UNF-3A	.185	.0355	.0350	.027	.018	.022	.047	.039	.031	3/32	7/64	.057	.053	.022	.043	.163
1/8-32	3-48UNF-3A	.249	.0525	.0520	.043	.034	.038	.054	.045	.037	7/64	1/8	.066	.062	.025	.054	.078
1/4-20	4-40UNF-3A	.375	.0710	.0705	.067	.050	.058	.081	.071	.062	1/8	3/32	.075	.070	.028	.056	.128
5/16-18	5-40UNF-3A	.500	.0915	.0910	.087	.068	.078	.107	.097	.087	1/8	3/16	.083	.078	.030	.060	.076
3/8-16	6-32UNF-3A	.750	.1165	.1160	.113	.093	.105	.134	.124	.114	1/8	3/16	.092	.087	.033	.070	.109
1/2-13	8-32UNF-3A	1.000	.1470	.1465	.144	.124	.137	.166	.156	.146	3/16	1/2	.104	.101	.035	.080	.125
5/8-11	10-24UNF-3A	1.315	.1825	.1820	.180	.160	.173	.202	.192	.182	1/2	1/2	.127	.125	.043	.090	.161
3/4-10	12-24UNF-3A	1.625	.2175	.2170	.215	.195	.208	.237	.227	.217	1/2	5/16	.156	.154	.063	.125	.163
7/8-9	14-28UNF-3A	2.125	.2770	.2765	.275	.255	.268	.297	.287	.277	1/2	5/16	.156	.154	.063	.125	.163
1-8	16-28UNF-3A	2.625	.3365	.3360	.335	.315	.328	.357	.347	.337	1/2	3/8	.203	.201	.078	.156	.231
1 1/8-7	18-28UNF-3A	3.125	.3960	.3955	.395	.375	.388	.417	.407	.397	1/2	3/8	.203	.201	.078	.156	.231
1 1/4-7	20-28UNF-3A	3.625	.4555	.4550	.455	.435	.448	.477	.467	.457	1/2	3/8	.203	.201	.078	.156	.231
1 1/2-6	24-28UNF-3A	4.125	.5150	.5145	.515	.495	.508	.537	.527	.517	1/2	3/8	.203	.201	.078	.156	.231
1 3/4-5	28-28UNF-3A	4.625	.5745	.5740	.575	.555	.568	.597	.587	.577	1/2	3/8	.203	.201	.078	.156	.231
2-4	32-28UNF-3A	5.125	.6340	.6335	.635	.615	.628	.657	.647	.637	1/2	3/8	.203	.201	.078	.156	.231
2 1/4-4	36-28UNF-3A	5.625	.6935	.6930	.695	.675	.688	.717	.707	.697	1/2	3/8	.203	.201	.078	.156	.231
2 1/2-4	40-28UNF-3A	6.125	.7530	.7525	.755	.735	.748	.777	.767	.757	1/2	3/8	.203	.201	.078	.156	.231
2 3/4-4	44-28UNF-3A	6.625	.8125	.8120	.815	.795	.808	.837	.827	.817	1/2	3/8	.203	.201	.078	.156	.231
3-3	48-28UNF-3A	7.125	.8720	.8715	.875	.855	.868	.897	.887	.877	1/2	3/8	.203	.201	.078	.156	.231
3 1/4-3	52-28UNF-3A	7.625	.9315	.9310	.935	.915	.928	.957	.947	.937	1/2	3/8	.203	.201	.078	.156	.231
3 1/2-3	56-28UNF-3A	8.125	.9910	.9905	.995	.975	.988	.1017	.								

⑤ FOR CHANGES SEE SHEET 2

PROCUREMENT SPECIFICATION

FF-S-200

AIR FORCE-NAVY AERONAUTICAL STANDARD

SETSCREW-HEXAGON AND FLUTED
SOCKET. HEADLESS

SUPERLEDES
SUPERLEDES MAP DRAWINGS 163 AND 166

AN565

SHEET 1 OF 3

[illegible]

NOTE: This drawing was approved by joint action of the Air Force and Navy Departments to the Air Force-Bery standard for this product. This drawing represents all educational standard drawings for the same product and that anyone should be for the procurement of non-standard equipment, or for use in test units, not have this drawing as the final one of approval above.

APPROVED 27 Dec 74 26 Feb 75 29 Dec 72 8 NOV 74 23 JUN 1975

Approved for Release by NSA on 09-08-2013 pursuant to E.O. 13526

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NOTE: This drawing was approved by Joint Chiefs of Staff, the Air Force and Navy Departments on the 14th February 1954. The drawing is a reproduction of a standard drawing for the same product and shall become effective for use by Government of commercial suppliers, or for use in new design, and that after 6 months after the issue date of approved sheet.

THE NO. 2 SIZE IS NOW PREFERRED FOR AIRFRAME USE

NO. 3-48, NO. 5-40, NO. 10-24, 1/4-20, 5/16-18, 3/8-16, AND 1/2-13 COARSE THREAD SETSCREWS EXACTLY FOR DESIGN AFTER 1 JULY 1954

COARSE THREAD

L LENGTH	NO. 2-36	NO. 3-48	NO. 4-40	NO. 5-40	NO. 6-32	NO. 8-32	NO. 10-24	DASH NUMBERS			
								1/4-20	5/16-18	3/8-16	1/2-13
1/16	.015	2-1	3-1	4-1	5-1	6-1	10-1	1/4-3			
1/8	.015	2-2	3-2	4-2	5-2	6-2	10-2	1/4-4			
3/16	.015	2-3	3-3	4-3	5-3	6-3	10-3	1/4-5			
1/4	.015	2-4	3-4	4-4	5-4	6-4	10-4	1/4-6	5/16-4		
5/16	.015	2-5	3-5	4-5	5-5	6-5	10-5	1/4-7	5/16-5		
3/8	.015		3-6	4-6	5-6	6-6	10-6	1/4-8	5/16-6	3/8-6	
7/16	.015		3-7	4-7	5-7	6-7	10-7	1/4-9	5/16-7	3/8-7	
1/2	.015		3-8	4-8	5-8	6-8	10-8	1/4-10	5/16-8	3/8-8	1/2-8
9/16	.015		3-9	4-9	5-9	6-9	10-9	1/4-11	5/16-9	3/8-9	
5/8	.015		3-10	4-10	5-10	6-10	10-10	1/4-12	5/16-10	3/8-10	1/2-10
3/4	.011		3-11	4-11	5-11	6-11	10-11	1/4-13	5/16-11	3/8-11	1/2-11
7/8	.013		3-12	4-12	5-12	6-12	10-12	1/4-14	5/16-12	3/8-12	1/2-12
	.014		3-13	4-13	5-13	6-13	10-13	1/4-15	5/16-13	3/8-13	1/2-13
1-1/4	.019		3-14	4-14	5-14	6-14	10-14	1/4-16	5/16-14	3/8-14	1/2-14
1-1/2	.022		3-15	4-15	5-15	6-15	10-15	1/4-17	5/16-15	3/8-15	1/2-15
1-3/4	.026		3-16	4-16	5-16	6-16	10-16	1/4-18	5/16-16	3/8-16	1/2-16
2	.030		3-17	4-17	5-17	6-17	10-17	1/4-19	5/16-17	3/8-17	1/2-17
2-1/4	.031		3-18	4-18	5-18	6-18	10-18	1/4-20	5/16-18	3/8-18	1/2-18
2-1/2	.031		3-19	4-19	5-19	6-19	10-19	1/4-21	5/16-19	3/8-19	1/2-19
2-3/4	.031		3-20	4-20	5-20	6-20	10-20	1/4-22	5/16-20	3/8-20	1/2-20
3	.031		3-21	4-21	5-21	6-21	10-21	1/4-23	5/16-21	3/8-21	1/2-21

FINE THREAD

L LENGTH	NO. 10-32	DASH NUMBERS			
		1/4-28	5/16-24	3/8-24	1/2-20
1/8	.010	1032-3			
3/16	.010	1032-3	28-3		
1/4	.010	1032-4	28-4	5/16-4	
5/16	.010	1032-5	28-5	5/16-5	
3/8	.010	1032-6	28-6	5/16-6	3/8-6
7/16	.010	1032-7	28-7	5/16-7	3/8-7
1/2	.010	1032-8	28-8	5/16-8	3/8-8
9/16	.010	1032-9	28-9	5/16-9	3/8-9
5/8	.010	1032-10	28-10	5/16-10	3/8-10
3/4	.011	1032-11	28-11	5/16-11	3/8-11
7/8	.013	1032-12	28-12	5/16-12	3/8-12
	.014	1032-13	28-13	5/16-13	3/8-13
1-1/4	.019	1032-14	28-14	5/16-14	3/8-14
1-1/2	.022	1032-15	28-15	5/16-15	3/8-15
1-3/4	.026	1032-16	28-16	5/16-16	3/8-16
2	.030	1032-17	28-17	5/16-17	3/8-17
2-1/4	.031	1032-18	28-18	5/16-18	3/8-18
2-1/2	.031	1032-19	28-19	5/16-19	3/8-19
2-3/4	.031	1032-20	28-20	5/16-20	3/8-20
3	.031	1032-21	28-21	5/16-21	3/8-21

PROCUREMENT SPECIFICATION FF-5-200	AIR FORCE-NAVY AERONAUTICAL STANDARD SETSCREW-HEXAGON AND FLUTED SOCKET, HEADLESS	AN565 SHEET 2 OF 3	
	SUPERSEDES:		
	SUPERSEDES USAF DRAWINGS 505 AND 506		

APPROVED 26 FEB 54 REVISED 5 2

NOTE: This drawing was approved by joint action of the Air Force and Navy Requirements as the 315 Performance standard for this product. This drawing represents all standard standard drawings for the same product and shall be considered effective for the procurement of aeronautical supplies, as far as is now made, and hereinafter 3 months after the initial date of approval shown.

- IN CASE OF CONFLICT, THE REQUIREMENTS SPECIFIED HEREON SHALL TAKE PRECEDENCE OVER THE REQUIREMENTS IN SPECIFICATION FF-8-103.

SHEET 3 OF 5