

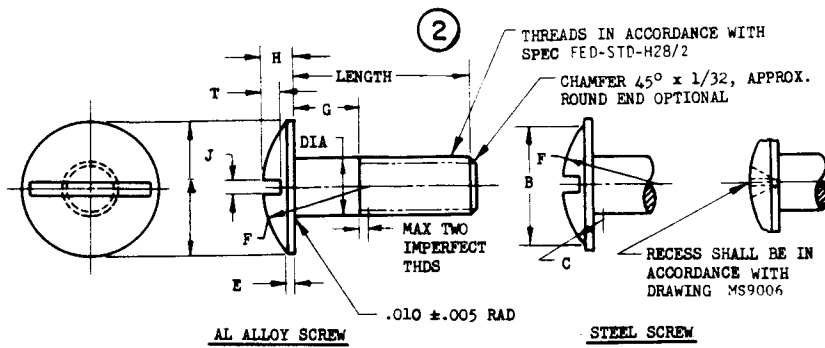
APR 15 1985

FED. SUP CLASS  
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This military standard is approved 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.



②

SIZE	DIA +.000 -.002	A DIA	B DIA	C RAD	E +.005 -.000	F RAD	H $\pm$ .005	J	T $\pm$ .005
.164-32UNC-3A	.164	.375	.312	.078	.023	.312	.087	.043 +.007 -.006	.049
.164-36UNF-3A	.190	.437	.375	.078	.025	.398	.094	.047 +.008 -.006	.054
.190-32UNC-3A	.250	.500	.437	.097	.028	.474	.101	.053 +.013 -.002	.058

DASH NOS. FOR SLOTTED HEAD STEEL SCREWS.

LENGTH $\pm 1/32$	G	DASH NUMBERS				LENGTH $\pm 1/32$	G	DASH NUMBERS			
		#8-32	#8-36	#10-32	1/4-28			#8-32	#8-36	#10-32	1/4-28
3/8	1/32	832-6	8-6	10-6	416-6	1-1/8	23/32	832-18	8-18	10-18	416-18
7/16	1/16	832-7	8-7	10-7	416-7	1-1/4	27/32	832-20	8-20	10-20	416-20
1/2	1/8	832-8	8-8	10-8	416-8	1-3/8	31/32	832-22	8-22	10-22	416-22
9/16	5/32	832-9	8-9	10-9	416-9	1-1/2	1-3/32	832-24	8-24	10-24	416-24
5/8	7/32	832-10	8-10	10-10	416-10	1-5/8	1-7/32	832-26	8-26	10-26	416-26
11/16	9/32	832-11	8-11	10-11	416-11	1-3/4	1-11/32	832-28	8-28	10-28	416-28
3/4	11/32	832-12	8-12	10-12	416-12	1-7/8	1-15/32	832-30	8-30	10-30	416-30
7/8	15/32	832-14	8-14	10-14	416-14	2	1-19/32	832-32	8-32	10-32	416-32
1	19/32	832-16	8-16	10-16	416-16						

- ② 1. MATERIAL: STEEL SPEC AMS 6300 OR MIL-S-6050 TENSILE STRENGTH, 125,000 PSI (MIN).  
AL ALLOY, QQ-A-200/5 TENSILE STRENGTH, 62,000 PSI (MIN).
- ② 2. FINISH: STEEL, CAD PLATE, SPEC QQ-P-416, TYPE II, CLASS 3 OR ZINC PLATE, PER ASTM B 633-78, Fe/Zn 13, TYPE II.
3. PART NUMBERS: ADD "R" BETWEEN FIRST AND SECOND DASH NOS. FOR RECESSED HEAD SCREWS.  
ADD "D" BEFORE FIRST DASH NUMBER FOR AL ALLOY SCREWS: SIZE 8 AVAILABLE WITH NC THREAD ONLY.  
EXAMPLE OF PART NO.: AN525-10-6 = .190-32 SLOTTED HEAD STEEL SCREW, 3/8 LONG WITH 1/32 GRIP.  
AN525D10-6 = .190-32 SLOTTED HEAD AL ALLOY SCREW, 3/8 LONG WITH 1/32 GRIP.  
AN525-10R6 = .190-32 RECESSED HEAD STEEL SCREW, 3/8 LONG WITH 1/32 GRIP.
4. BEARING SURFACE OF HEAD MUST BE FREE FROM BURRS AND TOOL MARKS.
5. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: FRACTIONS  $\pm 1/64$ , DECIMALS  $\pm .010$ , ANGLES  $\pm 5^\circ$ .
6. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BIDS, OR REQUEST FOR PROPOSAL, EXCEPT THAT REFERENCED ADOPTED INDUSTRY DOCUMENTS SHALL GIVE THE DATE OF THE ISSUE ADOPTED.
7. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.

APPROVED 29 OCT 45      REVISED 1 27 SEP 63      ② 29 JAN 85

P. A. AIR FORCE - 82 Other Cust AIR FORCE - 99 NAVY - AS	INTERNATIONAL INTEREST	SCREW - WASHER HEAD	AN525
PROCUREMENT SPECIFICATION MIL-S-7839	SUPERSEDES:	SHEET	OF

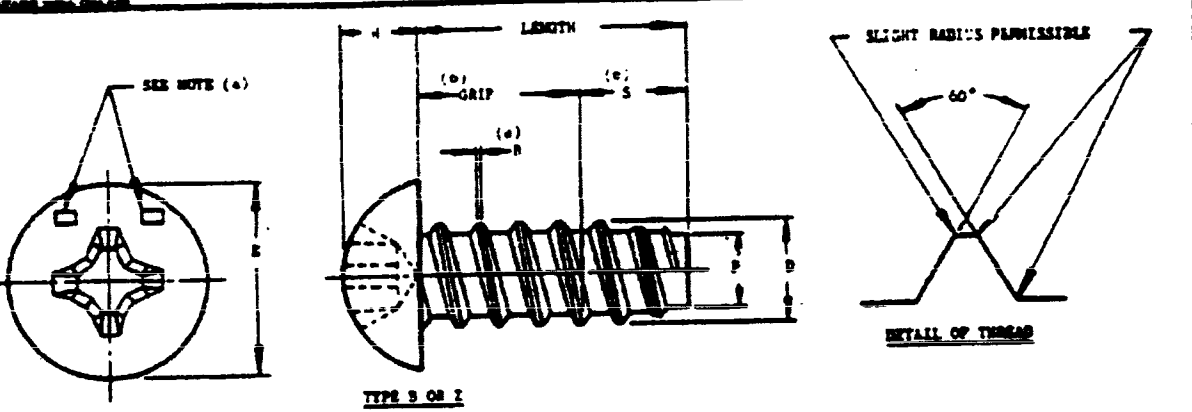
DD FORM 1 MAY 73 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

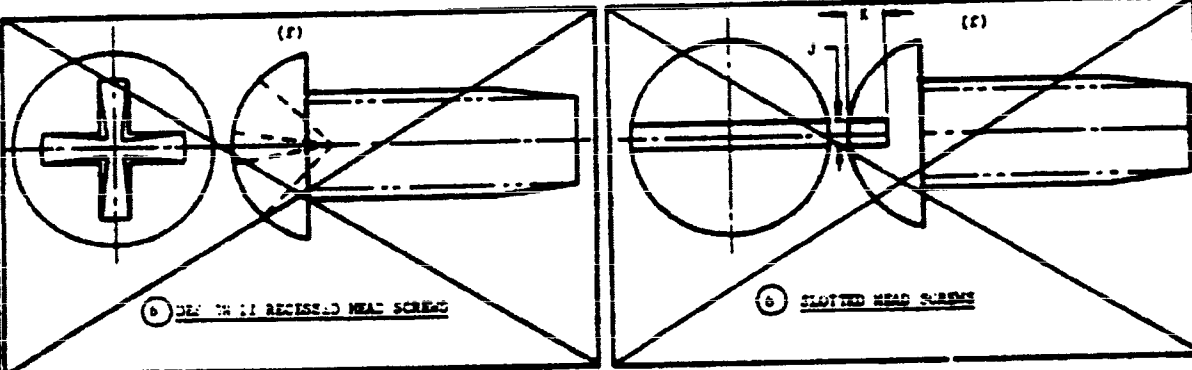
AMO 9-73



(1) This drawing was approved by joint action of the AF and Navy Departments on the 14th of February 1959. It is intended for use as a standard for the design of screws for aircraft. With drawing information all necessary standard drawings for the same problem that shall be made available for the procurement of commercial supplies at the time in use. It is not intended for use in the design of aircraft parts. The design of aircraft parts shall be approved by the AF and Navy Departments.



① DESIGN 1 RECESSED HEAD SCREW



② DESIGN 11 RECESSED HEAD SCREWS

③ SLOTTED HEAD SCREWS

④ DIMENSIONING AND GAGING OF THE ABOVE RECESS DESIGNS SHALL BE IN ACCORDANCE WITH FF-C-2.

SIZE	THREADS PER INCH	D MAX DIA	E DIA		H MAX	J		K		P DIA	
			MAX	MIN		MAX	MIN	MAX	MIN	MAX	MIN
NO. 2	32	.099	.162	.146	.369	.011	.023	.328	.037	.059	.092
NO. 4	24	.111	.181	.163	.386	.019	.031	.356	.044	.075	.107
NO. 6	20	.139	.220	.200	.433	.028	.039	.408	.051	.095	.139
NO. 8	18	.166	.259	.237	.480	.038	.049	.458	.060	.112	.156
NO. 10	16	.189	.299	.274	.527	.048	.059	.508	.070	.130	.173
1/4	14	.216	.357	.329	.570	.058	.069	.552	.080	.149	.191

⑤ DESIGN 11 RECESSED AND SLOTTED HEAD SCREWS INACTIVE FOR DESIGN AFTER 17 FEBRUARY 1959.

APPROVED 12 Feb 53 REVISED 17 Jun 53 25 Apr 54 18 Feb 54 20 Apr 59 5 10 Jun 55 6 17 Feb 59