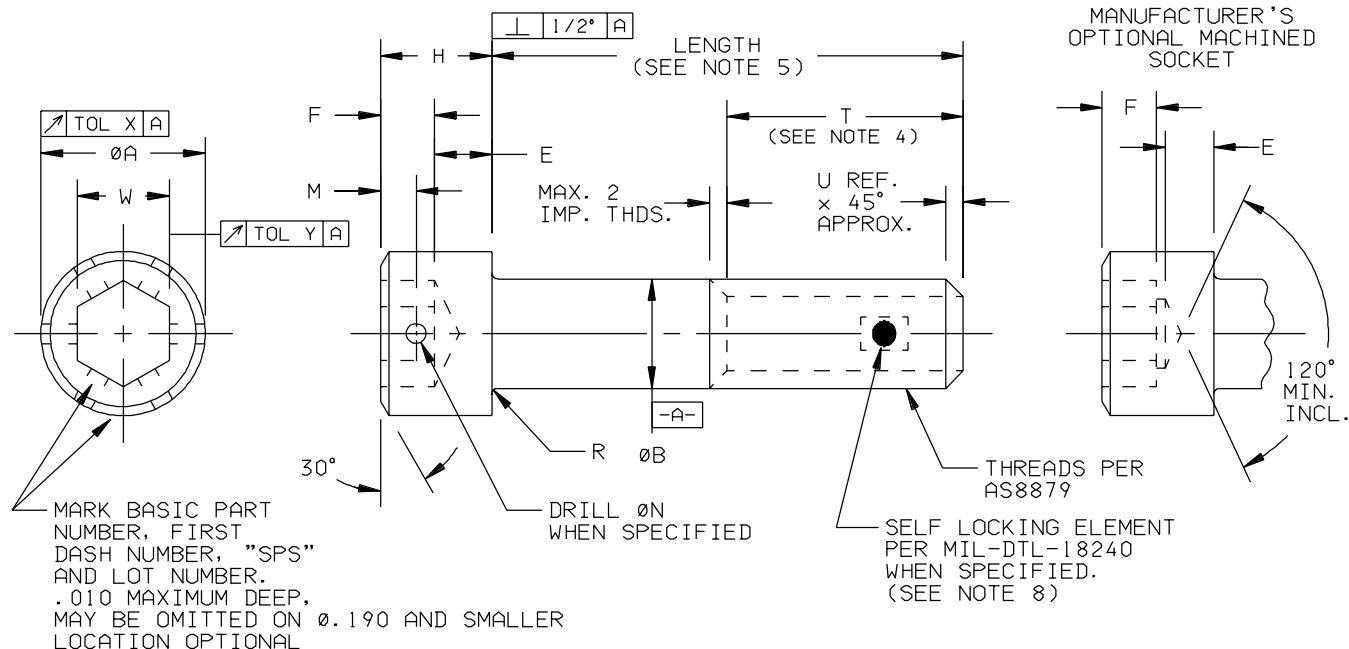




BASIC PART NUMBER AND FIRST DASH NUMBER	THREADS	ØA	ØB	E MIN.	F MIN.	H	M	N DIA.	R	T MIN.	U REF.	W	X	Y	LENGTH MIN.	
															UNJC	UNJF
95878-256	.0860-56 UNJC-3A	.140	.0860	.029	.044	.097	—	—	.008	.670	.02	.0801	.006	.007	.078	.062
95878-264	.0860-64 UNJF-3A	.136	.0840			.077			.004		.02	.0781				
95878-348	.0990-48 UNJC-3A	.161	.0990	.034	.052	.110	—	—	.008	.695	.03	.0801	.006	.007	.093	.078
95878-356	.0990-56 UNJF-3A	.157	.0968			.090			.004		.02	.0781				
95878-440	.1120-40 UNJC-3A	.183	.1120	.038	.061	.123	.044	.042	.010	.725	.03	.0957	.006	.007	.109	.093
95878-448	.1120-48 UNJF-3A	.178	.1096			.103	.024	.034	.015		.03	.0937				
95878-540	.1250-40 UNJC-3A	.205	.1250	.043	.068	.136	.049	.042	.010	.750	.03	.0957	.006	.007	.109	.093
95878-544	.1250-44 UNJF-3A	.200	.1226			.116	.029	.034	.015		.03	.0937				
95878-632	.1380-32 UNJC-3A	.226	.1380	.047	.071	.148	.054	.042	.010	.775	.04	.1114	.006	.007	.125	.109
95878-640	.1380-40 UNJF-3A	.221	.1353			.128	.034	.034	.015		.03	.1094				
95878-832	.1640-32 UNJC-3A	.270	.1640	.056	.088	.174	.059	.042	.015	.825	.04	.1426	.006	.007	.125	.125
95878-836	.1640-36 UNJF-3A	.265	.1613			.154	.039	.034	.008		.03	.1406				
95878-1024	.1900-24 UNJC-3A	.313	.1900	.065	.109	.199	.066	.042	.015	.880	.05	.1587	.006	.009	.187	.125
95878-1032	.1900-32 UNJF-3A	.306	.1867			.179	.046	.034	.008		.04	.1562				
95878-420	.2500-20 UNJC-3A	.375	.2500	.095	.126	.258	.085	.068	.020	1.000	.06	.1900	.006	.011	.281	.156
95878-428	.2500-28 UNJF-3A	.367	.2464			.238	.065	.060	.010		.04	.1875				
95878-518	.3125-18 UNJC-3A	.469	.3125	.119	.163	.320	.104	.068	.020	1.125	.07	.2530	.006	.013	.250	.187
95878-524	.3125-24 UNJF-3A	.457	.3084			.300	.084	.060	.010		.05	.2500				
95878-616	.3750-16 UNJC-3A	.563	.3750	.143	.186	.382	.123	.068	.020	1.250	.08	.3160	.008	.013	.250	.187
95878-624	.3750-24 UNJF-3A	.552	.3705			.362	.103	.060	.010		.05	.3125				
95878-714	.4375-14 UNJC-3A	.656	.4375	.166	.213	.444	.141	.068	.025	1.375	.09	.3790	.009	.018	.312	.218
95878-720	.4375-20 UNJF-3A	.642	.4326			.424	.121	.060	.015		.06	.3750				
95878-813	.5000-13 UNJC-3A	.750	.5000	.190	.245	.506	.160	.068	.030	1.500	.10	.3790	.010	.020	.500	.500
95878-820	.5000-20 UNJF-3A	.739	.4948			.486	.140	.060	.020		.06	.3750				

TOLERANCES $\pm .010$ AND $\pm 2^\circ$

SURFACE ROUGHNESS 125/

UNLESS OTHERWISE NOTED

DRAFTED IN ACCORDANCE WITH ASME Y14.5M

DRAWN BY: STEVE FOSTER

APPROVED: J. KLINE

APPROVED: S. FOSTER

FSCM NO. 56878

CUSTODIAN:
JENKINTOWN, PA.

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5ME Y14.5M

DATE: 5/09/00

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TITLE

SCREW, SOCKET HEAD CAP
ALLOY 718, 180 KSI MIN UTS

STANDARDS AND SPECIFICATIONS

FF-S-86

EXCEPT AS NOTED

PART NUMBER:

95878()()()()-()()

SHEET 1 OF 2



DRAWING NUMBER
SD. 300. 95878

ISSUE DATE
5/09/00

REVISION

①

01/02/2001

②

3/10/03

1. MATERIAL: ALLOY 718 PER AMS 5662 OR EQUIVALENT.
2. HEAT TREATMENT: 180,000 PSI MINIMUM ULTIMATE TENSILE STRENGTH.
3. FINISH: SEE NOTE 8.
4. THREAD LENGTH: THE MINIMUM FULL THREAD LENGTH SHALL BE TWICE THE THREAD DIAMETER, PLUS 1/2 INCH OR 1/2 THE LENGTH WHICH EVER IS THE GREATER. SCREWS TOO SHORT FOR THE FORMULA SHALL BE THREADED AS CLOSE TO THE HEAD AS PRACTICAL. MAXIMUM THREAD LENGTH NEED NOT EXCEED 1.50 INCH.
5. LENGTH TOLERANCE THROUGH ONE INCH $\pm .015$; OVER ONE INCH THROUGH TWO INCHES $\pm .031$ -.015.
6. PARTS SHALL BE FREE FROM BURRS AND SHARP EDGES.
7. CHAMFER "U" PLUS INCOMPLETE THREADS SHALL NOT EXCEED TWO PITCHES.
8. PART NUMBER: 95878()()()-()()

C = CADMIUM PLATE PER AMS-QQ-P-416, TYPE I, CLASS 3
M = DRY FILM LUBRICANT PER AS5272, TYPE I
P = PASSIVATE PER AMS-QQ-P-35
S = SILVER PLATE PER AMS 2410

LENGTH IN SIXTEENTHS

THREAD = C-COARSE
F-FINE

FIRST DASH NUMBER PER TABULATION

LOCKING FEATURE = NO LETTER - NO LOCKING FEATURE
E - TYPE P (PATCH) PER MIL-DTL-18240
K - TYPE N (PELLET) PER MIL-DTL-18240
TF - TRU FLEX

CROSSDRILL HEADS: H1 = 1 HOLE THRU
H2 = 2 HOLES THRU
H3 = 3 HOLES THRU
"- " = NO DRILLED HEADS

BASIC PART NUMBER

TOLERANCES $\pm .010$ AND $\pm 2^\circ$
SURFACE ROUGHNESS 125
UNLESS OTHERWISE NOTED

DRAFTED
IN ACCORDANCE
WITH ASME Y14.5M



PART NUMBER:

95878()()()-()()

SHEET 2 OF 2