



PROPRIETARY INFORMATION
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DRAWING NUMBER
SPS-B-96628

ISSUE DATE
 5/08/04

REVISION
 1

2/16/05

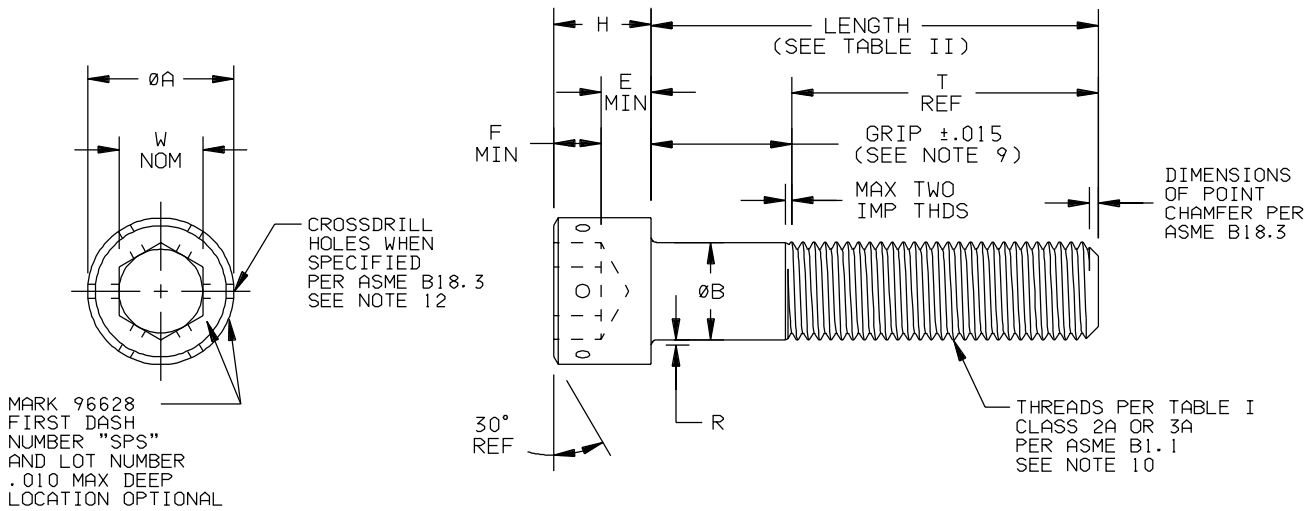


TABLE I

BASIC DIAMETER DASH NUMBER	THREADS UNRC UNRF	ØA	ØB	E MIN	F MIN	H	R FILLET EXT	T REF	W NOM	AXIAL TENSILE STRENGTH LBS. MIN
3	.1900-24	.312	.1900	.065	.090	.190	.014	.875	.156	3,150
	.1900-32	.303	.1840							3,600
4	.2500-20	.375	.2500	.095	.120	.250	.014	1.000	.188	5,700
	.2500-28	.365	.2435							6,600
5	.3125-18	.469	.3125	.119	.151	.312	.017	1.125	.250	9,400
	.3125-24	.457	.3053							10,400
6	.3750-16	.562	.3750	.143	.182	.375	.020	1.250	.312	13,900
	.3750-24	.550	.3678							15,800
7	.4375-14	.656	.4375	.166	.213	.438	.023	1.375	.375	19,100
	.4375-20	.642	.4294							21,400
8	.5000-13	.750	.5000	.190	.245	.500	.026	1.500	.375	25,500
	.5000-20	.735	.4919							28,800
9	.5625-12	.843	.5625	.214	.265	.562	.028	1.625	.437	32,800
	.5625-18	.827	.5538							36,500
10	.6250-11	.938	.6250	.238	.307	.625	.032	1.750	.500	40,700
	.6250-18	.921	.6163							46,100
12	.7500-10	1.125	.7500	.285	.370	.750	.039	2.000	.625	60,100
	.7500-16	1.107	.7406							67,100
14	.8750-9	1.312	.8750	.333	.432	.875	.044	2.250	.750	83,200
	.8750-14	1.293	.8647							91,700
16	1.0000-8	1.500	1.0000	.380	.495	1.000	.050	2.500	.750	109,000
	1.0000-12	1.479	.9886							119,000
18	1.1250-8	1.688	1.1250	.428	.557	1.125	.055	2.812	.875	142,000
	1.1250-12	1.665	1.1086							154,000
20	1.2500-8	1.875	1.2500	.475	.620	1.250	.060	3.125	.875	180,000
	1.2500-12	1.852	1.2336							193,000
22	1.3750-8	2.062	1.3750	.523	.682	1.375	.065	3.437	1.000	222,000
	1.3750-12	2.038	1.3568							237,000
24	1.5000-8	2.250	1.5000	.570	.745	1.500	.070	3.750	1.000	268,000
	1.5000-12	2.224	1.4818							285,000
28	1.7500-8	2.625	1.7500	.665	.870	1.750	.080	4.375	1.250	375,000
	1.7500-12	2.597	1.7295							394,000

TABLE II

NOMINAL DIAMETER	LENGTH TOLERANCE			
	UP TO 1" INCL.	OVER 1" TO 2-1/2" INCL.	OVER 2-1/2" TO 6" INCL.	OVER 6"
3/16 THRU 3/8	-.030	-.040	-.060	-.120
7/16 THRU 3/4	-.030	-.060	-.080	-.120
7/8 THRU 1-3/4	-.050	-.100	-.140	-.200

TOLERANCES ±.010 AND ±2°
 SURFACE ROUGHNESS 125
 UNLESS OTHERWISE NOTED
 DRAFTED IN ACCORDANCE WITH ASME Y14.5M
 DRAWN BY: STEVE FOSTER
 APPROVED: S FOSTER
 APPROVED: R LEWIS

FSCM NO. 56878
 CUSTODIAN:
 JENKINTOWN, PA.
 DATE: 3/8/04
 DATE: 2/17/05

TITLE
 SCREW, SOCKET HEAD CAP
 HEXAGON RECESS
 MP98T, 180 KSI UTS

STANDARDS AND SPECIFICATIONS
 MIL-DTL-1222
 EXCEPT AS NOTED
 PART NUMBER:
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 SHEET 1 OF 2



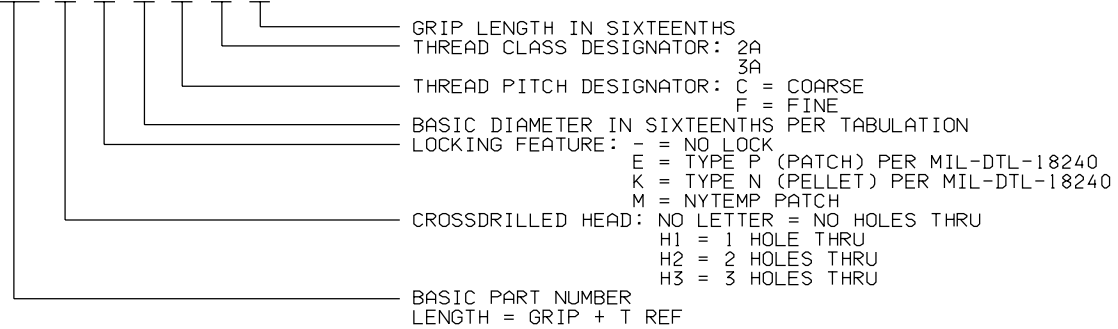
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1. MATERIAL: MP98T[®] PER AMS 5919 OR AMS 5920.
2. HEAT TREATMENT: 180 KSI TO 220 KSI ULTIMATE TENSILE STRENGTH. 150 KSI MINIMUM YIELD STRENGTH.
3. FINISH: PASSIVATE PER AMS-QQ-P-35.
4. FLUORESCENT PENETRANT INSPECT PER ASTM E1417. ACCEPTANCE CRITERIA PER SAE J123.
5. MANUFACTURING REQUIREMENTS: HEAD TO BE FORGED.
 HEXAGON RECESS MAY BE FORGED OR MACHINED.
 HEAD TO SHANK FILLET TO BE COLD WORKED.
 UNLESS OTHERWISE NOTED ON PURCHASE ORDER, FOR ALL SIZES, THREADS SHALL BE ROLLED EXCEPT WHERE THREAD LENGTH EXCEEDS THE DIMENSIONAL LIMITATIONS OF THE THREAD DIE AND/OR MACHINE, ONLY THEN ARE CUT THREADS ALLOWED WITH CUSTOMER APPROVAL PRIOR TO PURCHASE ORDER. ROLLED THREADS SHALL BE FORMED AFTER HEAT TREATMENT.
6. MECHANICAL AND LOT ACCEPTANCE TEST: SAMPLING SIZE SHALL BE PER MIL-DTL-1222.
 ULTIMATE TENSILE TEST PER ASTM F606.
 WEDGE TENSILE TEST PER ASTM F606 EXCEPT THE REQUIREMENT SHALL BE THE TEST RESULTS ARE REPORTED FOR INFORMATION ONLY.
 HARDNESS TEST PER ASTM F606 EXCEPT THE REQUIREMENT SHALL BE THE TEST RESULTS ARE REPORTED FOR INFORMATION ONLY.
7. DIMENSIONS ARE IN INCHES, AND EXCEPT AS NOTED ARE PER ASME B18.3.
8. GEOMETRIC TOLERANCING AS NOTED AND STRAIGHTNESS PER ASME B18.3 AS APPLICABLE.
9. THE GRIP LENGTH SHALL BE MEASURED FROM THE UNDERSIDE OF THE HEAD TO THE FIRST COMPLETE THREAD.
10. FOR OVERALL LENGTHS SHORTER THAN OR EQUAL TO THOSE VALUES LISTED IN COLUMN T REF. THREADS WILL BE ROLLED TO WITHIN THREE APPROXIMATE THREAD PITCHES OF BEARING SURFACE, YET NOT ALLOWED TO ENTER FILLET RADIUS.
11. UNLESS OTHERWISE SPECIFIED BREAK ALL SHARP EDGES 0.020 X 0.020 MAXIMUM.

12. PART NUMBER: 96628()()()()()



13. PERFORMANCE REQUIREMENTS OF MIL-DTL-18240 APPLY TO SCREWS WITH NON-METALLIC LOCKING FEATURES, INCLUDING NYTEMP[®]. FOR THREAD SIZES NOT LISTED IN TABLE VA OR VB OF MIL-DTL-18240, ONLY A POSITIVE INDICATION OF TORQUE IS REQUIRED FOR 5 UNSEATED INSTALLATIONS AND REMOVALS.

® MP98T IS A REGISTERED TRADEMARK OF SPS TECHNOLOGIES.
 ® NYTEMP IS A REGISTERED TRADEMARK OF NYLOK FASTENER CORPORATION.

TOLERANCES ±.010 AND ±2°
 SURFACE ROUGHNESS 125
 UNLESS OTHERWISE NOTED

DRAFTED
 IN ACCORDANCE
 WITH ASME Y14.5M



PART NUMBER:
 96628()()()()()

SHEET 2 OF 2