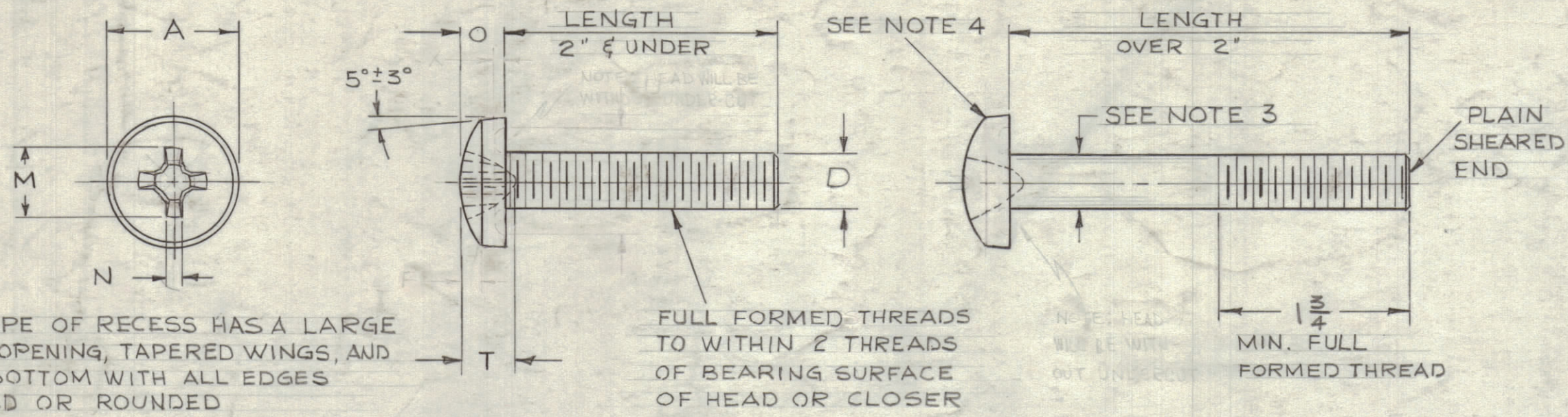


CHART 1

SCREW, MACHINE, PAN HEAD, CROSS RECESS (DESIGN I)



REVISIONS						
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
ALL	-	"SCBP" SERIES EXTRACTED FROM STD "SC" I SIZE DWG. & COMPLETELY REVISED & REDRAWN	7/27/62	-		16 16
B1, C1	A	SUFFIX "F" NOTE ON CHART #1 & TMC PART NO. "F" ADDED UNDER CUT DELETED; DIM "D" & "X" DELETED FROM CHART #1	11-2-62	7588	GH	JH
-	B	CHART #1 REVISED COMPLETELY "PAN HEAD" WAS "BINDING HEAD" UNDER CUT NOTES DELE. "IMPORTANT" NOTE REVISED	5-22-64	11408	HWB	JC

CHART NO. 2 THREAD SIZES & CODES

ALL THREADS SHALL BE CLASS 2A

THREAD SIZE	TMC THREAD CODE	THREAD SERIES	THREAD SIZE	TMC THREAD CODE	THREAD SERIES
2-56	0256	UNC	10-24	1024	UNC
2-64	0264	UNF	10-32	1032	UNF
3-48	0348	UNC	12-24	1224	UNC
3-56	0356	UNF	12-28	1228	UNF
4-40	0440	UNC	1/4-20	2520	UNC
4-48	0448	UNF	1/4-28	2528	UNF
5-40	0540	UNC	5/16-18	3118	UNC
5-44	0544	UNF	5/16-24	3124	UNF
6-32	0632	UNC	3/8-16	3716	UNC
6-40	0640	UNF	3/8-24	3724	UNF
8-32	0832	UNC			
8-36	0836	UNF			

NOM SIZE	D		A		O		F		U		X		M		T		N	DRIVER SIZE REQ'D
	DIA. OF SCREW	HEAD DIAMETER	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MIN	
2	0.0860	0.167	0.155	0.062	0.053								0.104	0.091	0.059	0.041	0.017	1
3	0.0990	0.193	0.180	0.071	0.062								0.112	0.099	0.068	0.050	0.019	1
4	0.1120	0.219	0.205	0.080	0.070								0.112	0.109	0.078	0.060	0.019	1
5	0.1250	0.245	0.231	0.089	0.079								0.158	0.145	0.083	0.057	0.028	2
6	0.1380	0.270	0.256	0.097	0.087								0.166	0.153	0.091	0.066	0.028	2
8	0.1640	0.322	0.306	0.115	0.105								0.182	0.169	0.108	0.082	0.030	2
10	0.1900	0.373	0.357	0.133	0.122								0.199	0.186	0.124	0.100	0.031	2
12	0.2160	0.425	0.407	0.151	0.139								0.259	0.246	0.141	0.115	0.034	3
1/4	0.2500	0.492	0.473	0.175	0.162								0.281	0.268	0.161	0.135	0.036	3
5/16	0.3125	0.615	0.594	0.218	0.203								0.350	0.337	0.193	0.169	0.059	4
3/8	0.3750	0.740	0.716	0.261	0.244								0.389	0.376	0.233	0.210	0.065	4

CHART NO. 3 MATERIALS

TMC CODE	MATERIAL
B	BRASS, COMM. 1/2 HARD
S	STEEL, PLAIN
S	STAINLESS STEEL TYPE 18-8
N	NAVAL BRONZE USE ONLY FOR SPECIAL APPLIC.

CHART NO. 4 FINISHES

TMC CODE	FINISH	TMC SPEC
N	BRIGHT NICKEL	S135
S	PASSIVATE FOR STAINLESS STL. ONLY	S104
P	SILVER PLATE	S245
R	NO FINISH	
*C	CADMIUM PLATE (DO NOT USE)	

\* DO NOT USE - REPLACED BY CODE N, NICKEL PLATE

NOTES:

- ALL DIMENSIONS IN INCHES
- TOLERANCE ON SCREW LENGTHS:
 

SCREW LENGTH	TOLERANCE
UP TO & INCL. 1"	-1/32
OVER 1" TO & INCL. 2"	-1/16
OVER 2"	-3/32
- DIAMETER OF UNTHREADED BODY SHALL NOT BE LESS THAN THE MIN. PITCH DIA. OF THE THREAD NOR MORE THAN THE BASIC MAJOR DIA.
- BREAK SHARP EDGES WHERE SPHERICAL & CONICAL SURFACES MEET.
- THE SUFFIX "F" ON THE TMC PART NO SHALL BE USED ONLY FOR SPECIAL APPLICATION SCREWS WHEN IT IS ESSENTIAL TO HAVE FULL FORMED THREADS TO THE BEARING SURFACE OF THE HEAD (WITHIN TWO(2) THREADS), WHEN THE SCREW IS OVER 2 INCHES LONG. EXAMPLE: TMC NO SCBP1032BN40 IS A 10-32 THD. SCREW BY 2-1/2 INCHES LONG, AND REFERRING TO CHART #1, IT WOULD NORMALLY BE THREADED 1-3/4 INCHES MIN. IF IT IS ABSOLUTELY NECESSARY TO HAVE FULL THREADS TO HEAD, THE TMC NO. SHALL BE INDICATED AS SCBP1032BN40F.

IMPORTANT: ALL SPECIFICATIONS, TOLERANCES, ETC. SHALL BE IN ACCORDANCE WITH FED. SPEC FF-5-92 SCREW MACHINE; SLOTTED OR CROSS RECESS.

STANDARD DRAWING

TMC PART NO. TO BE IN THE FOLLOWING FORM:

SCBP 2520 B N 16 F

BASIC DWG. & PART NO.	THREAD SIZE CODE DESIRED	MATERIAL CODE DESIRED	FINISH CODE DESIRED	LENGTH CODE DESIRED IN 1/16ths OF AN INCH	USE ONLY FOR SPECIAL APPLICATION SEE NOTE 5 (BELOW CHART #1)
	SEE CHART 2	SEE CHART 3	SEE CHART 4		

EXAMPLES: SCBP1032BN8-SCREW, PAN HD., 10-32 UNF THD., BRASS N1 PLATE 1/2" LG.  
 SCBP2520SS16-SCREW, PAN HD., 1/4-20 UNF THD. ST. STL, 1" LG.

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
	MATERIAL	SEE CHART 3		
	FINISH	SEE CHART 4		

LIST OF MATERIAL

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK

TITLE: SCREW, MACHINE, PAN HEAD CROSS RECESSED

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	DRAWN T. RAMIREZ	DATE 8/30/62	FINAL APPROVAL	DATE
DECIMALS *±.05 **±.04 ***±.005	CHECKED J. Gabel	DATE	SCBP	
FRACTIONS ± 1/64 ± 1/32 ANGLES ± 0°-30'	ELECT. DES. L. Gabel	DATE 8/31/62		
TOLERANCES PER ASAB18.6	MECH. DES. L. Gabel	DATE		

NOTES

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