



HEAD MARKING SHALL BE RAISED OR DEPRESSED (.010 MAX) AND ARRANGED AS FOLLOWS:

- FIRST SECTOR - MARK WITH BASIC PART NUMBER ("PSC" OPTIONAL) EXCEPT MARK .1120-40 SIZE WITH "4", .1380-32 SIZE WITH "6", .1640-32 SIZE WITH "8", AND OPTIONAL .1900-32 SIZE WITH "10". THESE SIZES ALSO TO BE MARKED "V" FOR TITANIUM.
- SECOND SECTOR - MARK WITH MANUFACTURER'S SYMBOL OR TRADEMARK (SYMBOL LOCATION OPTIONAL IN ANY SECTOR) LENGTH DASH NUMBER AND "L" OR "P" WHEN APPLICABLE. (SEE NOTE 10)
 "L" IDENTIFIES SCREWS WITH OPTIONAL LOCKING ELEMENT.
 "P" IDENTIFIES SCREWS WITH PATCH TYPE LOCKING ELEMENT ONLY.
- THIRD SECTOR - MARK WITH RECESS DASH NUMBER, ENCIRCLED. RECESS NUMBER SHOULD BE APPROXIMATELY 25% LARGER THAN OTHER NUMERALS IN HEAD MARKING.

TABLE I DIMENSIONS

Ø DASH NUMBER	THREAD SIZE	NOTE 4 ØA	NOTE 1 ØD	H	ØK	RADIUS R	MAX. U	MAX. W	NOTE 6 X	NOTE 7 Y	RECESS SIZE
-04	.1120-40	.183 .178	.1120 .0939	.069 .059	.042 .034	.020 .010	.031	.157	.125	.075	1
-06	.1380-32	.226 .221	.1380 .1156	.086 .074				.193			2
-08	.1640-32	.270 .265	.1640 .1415	.102 .088			.039	.228	.156	.094	2
-3	.1900-32	.313 .306	.1900 .1674	.118 .103				.263			2
-4	.2500-28	.375 .367	.2500 .2243	.150 .133	.068 .060	.040 .030	.045	.345	.179	.107	3
-5	.3125-24	.438 .429	.3125 .2827	.183 .162			.052	.382			4
-6	.3750-24	.563 .552	.3750 .3450	.215 .191				.457	.208	.125	4

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TITLE: **SCREW, FLAT FILLISTER HD, FULL
THREAD, ACR® RIBBED PHILLIPS® RECESS,
TITANIUM, SELF-LOCK & NON-LOCK**

DRAWN: S. GUARINO	DATE: 09-07-79	DRAWING NUMBER PSC-736
CHECKED: G. LaMONICA	DATE: 08-06-04	SHEET 1 OF 3
PHILLIPS SCREW CO., 508 EDGEWATER DRIVE, WAKEFIELD, MA 01880 U.S.A. PHONE: 781-224-9750 FAX: 781-224-9753		

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08-06-04

TABLE II

	DASH NUMBER FOR PREFERRED LENGTH																						
DASH NO.	3	4	5	6	7	8	9	10	11	12	13	14	15	16	18	20	22	24	26	28	30	32	34 TO 96
LENGTH	.19	.25	.31	.38	.44	.50	.56	.62	.69	.75	.81	.88	.94	1.00	1.12	1.25	1.38	1.50	1.62	1.75	1.88	2.00	2.12 TO 6.00
LENGTH TOL.	+.00 -.03										+.00 -.06										+.00 -.09		

MATERIAL: 6AL-4V TITANIUM ALLOY PER AMS 4928 OR AMS 4967.
LOCKING ELEMENT- PLASTIC PER MIL-F-18240 AND QPL-18240.

HEAT TREAT: 160 AND 180 KSI ULTIMATE TENSILE.

FINISH: UNPLATED SCREWS - NONE

PLATED SCREWS - CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2, EXCEPT A NICKEL STRIKE MAY BE USED PRIOR TO CADMIUM PLATING. EMBRITTLEMENT TEST PER QQ-P-416 DOES NOT APPLY. CADMIUM PLATED 6AL-4V TITANIUM ALLOY SCREWS SHALL BE IDENTIFIED WITH RED DYE OR PAINT ON THE THREAD END. MAXIMUM COVERAGE MAY INCLUDE THE CHAMFER PLUS ONE COMPLETE THREAD.

COATED SCREWS - ALUMINUM COATING PER NAS4006.

CODE: FIRST DASH NUMBER INDICATES DIAMETER.
SECOND DASH NUMBER INDICATES LENGTH IN .0625 INCREMENTS. SEE TABLE II FOR TABULATIONS OF LENGTH DIMENSIONS. INTERMEDIATE OR LONGER LENGTHS MAY BE SPECIFIED BY USE OF WHOLE DASH NUMBERS ONLY. BASIC PART NUMBER = NON SELF-LOCKING SCREW.
ADD "A" AFTER DIAMETER DASH NUMBER FOR ALUMINUM COATED SCREWS. MAY BE USED WITH "L" OR "P" CODE.
ADD "H" AFTER DIAMETER DASH NUMBER FOR DRILLED HEAD SCREWS.
ADD "L" AFTER DIAMETER DASH NUMBER FOR SELF-LOCKING SCREWS, OPTIONAL CONFIGURATION.
ADD "U" AFTER DIAMETER DASH NUMBER FOR UNPLATED SCREWS.
ADD "P" AFTER DIAMETER DASH NUMBER FOR SELF-LOCKING SCREWS, PATCH TYPE.
WHEN MULTIPLE LETTER CODES ARE USED, SEQUENCE MUST BE IN ALPHABETICAL ORDER.

EXAMPLE OF PART NUMBER:

PSC736-3-10 = SCREW, .1900 THREAD, .625 LENGTH, NON-LOCKING, PLATED.
PSC736-3A10 = SCREW, .1900 THREAD, .625 LENGTH, NON-LOCKING, ALUMINUM COATED.
PSC736-3H10 = SCREW, .1900 THREAD, .625 LENGTH, NON-LOCKING, DRILLED HEAD, PLATED.
PSC736-3L10 = SCREW, .1900 THREAD, .625 LENGTH, SELF-LOCKING, OPTIONAL CONFIGURATION, PLATED.
PSC736-3LU10 = SCREW, .1900 THREAD, .625 LENGTH, NON-LOCKING, OPTIONAL CONFIGURATION, UNPLATED.
PSC736-3PU10 = SCREW, .1900 THREAD, .625 LENGTH, NON-LOCKING, PATCH TYPE, UNPLATED.

NOTES:

- (1) DIAMETER OF UNTHREADED PORTION OF SCREW SHALL NOT BE LESS THAN MINIMUM PITCH DIAMETER NOR MORE THAN MAXIMUM MAJOR DIAMETER OF THREAD.
- (2) SCREWS LESS THAN 2 DIAMETERS IN LENGTH - COMPLETE THREADS SHALL EXTEND TO WITHIN 2 PITCHES OF BEARING SURFACE OF HEAD AND INCOMPLETE THREADS MAY EXTEND UP TO BEARING SURFACE.
SCREWS 2 DIAMETERS THRU 2 INCHES IN LENGTH - COMPLETE THREADS SHALL EXTEND TO WITHIN 2 PITCHES OF TANGENCY OF "R" AND INCOMPLETE THREADS MAY EXTEND UP TO "R" FILLET AREA.
SCREWS LONGER THAN 2 INCHES - COMPLETE THREADS SHALL EXTEND A MINIMUM OF 1.75 INCHES FROM END OF SCREWS AND INCOMPLETE THREADS MAY EXTEND UP TO "R" FILLET AREA.
INCOMPLETE THREADS - SEE NAS4004.
- (3) BEARING SURFACE SQUARENESS: WITHIN .003 FIM OF SHANK DIAMETER.
- (4) CONCENTRICITY: OUTSIDE DIAMETER "A" TO THREAD PITCH DIAMETER WITHIN .008 FIM.
- (5) PROTRUSION OF LOCKING ELEMENTS SHALL BE CONTROLLED SO THAT IT WILL PASS FREELY OR WITH FINGER PRESSURE THROUGH A RING GAGE WITH DIAMETER OF .010 (+.001, -.000) GREATER THAN MAXIMUM MAJOR DIAMETER OF SCREW THREAD.
- (6) "X" MINIMUM (5 THREAD PITCHES) = REGION OF MINIMUM ENGAGEMENT WITH FEMALE THREAD REQUIRED TO MEET MIL-F-18240 REQUIREMENTS. LOCKING ELEMENT WITHIN "X" REGION MUST DEVELOP REQUIRED TORQUE WHEN TESTED PER MIL-F-18240.
- (7) FOR EASE OF STARTING, LOCKING ELEMENT SHALL NOT BE EFFECTIVE IN "Y" AREA (3 THREAD PITCHES).

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- NOTES (CONTINUED):
- (8) LOCKWIRE HOLES MAY OR MAY NOT BREAK THRU INTO RECESS FOR ALL SIZES DEPENDING UPON LOCATION USED. PENETRATION THRU TOP OR BASE OF HEAD IS NOT PERMITTED. ADEQUATE EDGE DISTANCE MUST BE PROVIDED TO PREVENT BREAKOUT ON THE PERIPHERY OF THE HEAD. RECESS MUST BE FREE OF BURRS OR SLIVERS THAT INTERFERE WITH DRIVER ENGAGEMENT.
 - (9) MINIMUM TORQUE VALUES (LBF-IN) WHICH RECESS MUST DEVELOP IN REMOVAL DIRECTION WITH APPROPRIATE DRIVERS PER NAS8500 THROUGH 8506 AND 5 POUND MAXIMUM END LOAD. CAMOUT OF THE DRIVER OR EXCESSIVE DEFORMATION OF THE RECESS SHALL BE CAUSE FOR REJECTION.
 - (10) "A", ALUMINUM COATED, "H", DRILLED HEAD, AND "U", UNPLATED CODES NEED NOT APPEAR ON THE HEAD OF THE BOLT.
 - (11) DIMENSIONS TO BE MET AFTER PLATING.
 - (12) DIMENSIONS ARE IN INCHES.

SURFACE TEXTURE:

(AA MAX PER ANSI B46.1) BEARING SURFACE OF THE HEAD, THREAD FLANKS AND THREAD ROOT 32;
OTHER SURFACES 125.

PROCUREMENT SPECIFICATION:

NAS4004, EXCEPT AS NOTED. COLD WORK OF HEAD TO SHANK FILLET IS NOT REQUIRED. LOCKING ELEMENT FOR SELF-LOCKING SCREWS: PER MS15981 AND MIL-F-18240. ANY TYPE OF CONFIGURATION IS OPTIONAL WHEN "L" CODE IS SPECIFIED. PATCH TYPE LOCKING ELEMENT (WITH NO METAL REMOVED) IS REQUIRED WHEN "P" CODE IS SPECIFIED. LOCKING ELEMENT MUST BE SUPPLIED BY A QUALIFIED SOURCE LISTED IN QPL18240 OR APPROVED FOR LISTING IN QPL18240. SHIPPING NOTICE SHOULD IDENTIFY THE SUPPLIER OF SCREW AND LOCKING ELEMENT SEPARATELY. RECESS TORQUE VALUES SHALL NOT APPLY.

PREPARED FOR ROLLS-ROYCE TO REPLACE NAS5500-5506.

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