

FED. SUPPLY CLASS

5310

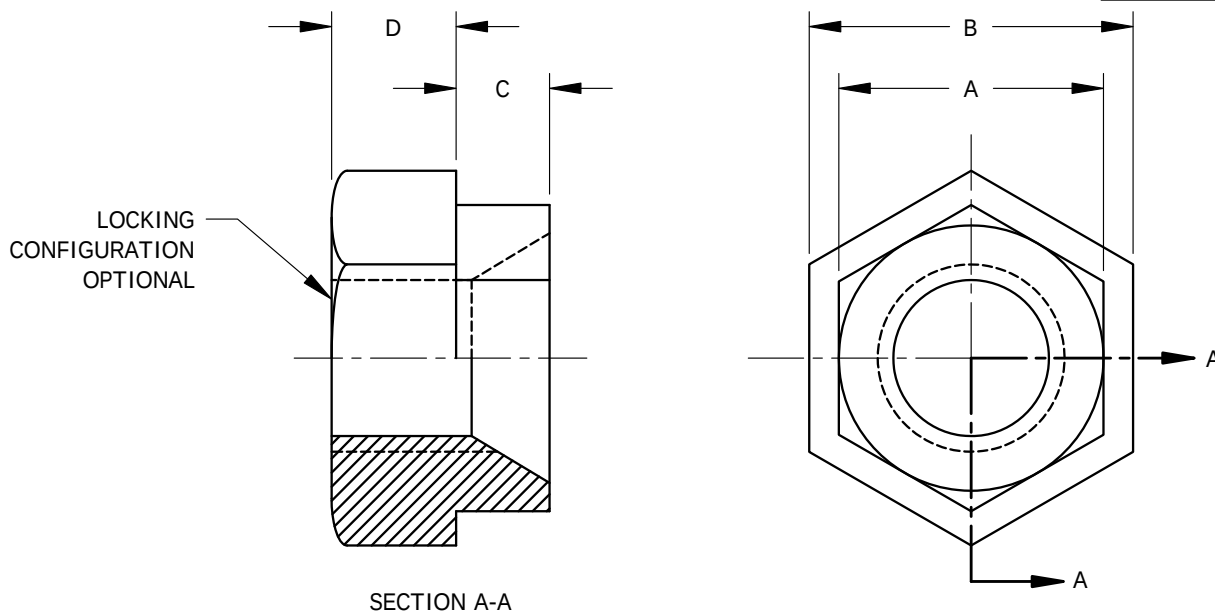


FIGURE 1 – NUT, PLAIN, CLINCH AND NUT, SELF-LOCKING, CLINCH

TABLE I – DASH NUMBERS AND DIMENSIONS

DASH NO.	THREAD	A PILOT WIDTH ACROSS FLATS ±.005	HEX HOLE SIZE IN SHEET MIN	B NUT WIDTH ACROSS FLATS ±.005	C PILOT HEIGHT ±.005	D NUT HEIGHT ±.010	SHEET THICKNESS MAX	PUSH-OUT LBF MIN
1	.1380-32 UNC-2B	.244	.250	.297	.078	.109	.036	60
2	.1640-32 UNC-2B	.305	.312	.368	.094	.125	.047	80
3	.1900-32 UNF-2B	.305	.312	.368	.094	.125	.047	100
4	.2500-28 UNF-2B	.429	.438	.521	.125	.172	.062	125
5	.3125-24 UNF-2B	.491	.500	.584	.156	.203	.078	150
6	.3750-24 UNF-2B	.551	.562	.670	.188	.234	.094	200
7	.5000-20 UNF-2B	.742	.750	.860	.250	.297	.125	300

MATERIAL:

STEEL, CARBON, TYPE 1008 (UNS G10080), TYPE 1010 (UNS G10100), TYPE 1108 (UNS G11080) OR TYPE 1110 (UNS G11100) IN ACCORDANCE WITH ASTM A549 OR ASTM A576 AS APPLICABLE.

FINISH:

STEEL, CARBON SHALL HAVE CADMIUM PLATE IN ACCORDANCE WITH AMS-QQ-P-416, TYPE II, CLASS 2.

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MIL-N-45938/2, REVISION A. PART NUMBERS REMAIN M45938/2.

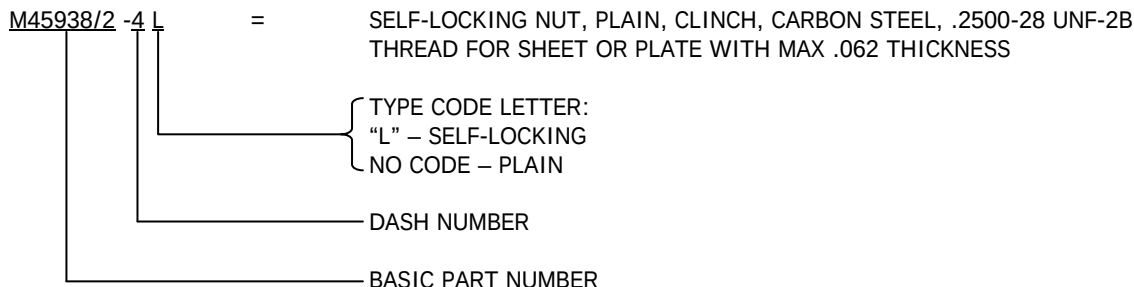
THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION NASM45938	TITLE NUT, PLAIN, CLINCH AND NUT, SELF-LOCKING, CLINCH (HEXAGON HEAD AND SHANK, SWAGE CLINCH)	CLASSIFICATION PART STANDARD NASM45938/2

SHEET 1 OF 2

CODE:

THE PART NUMBER SHALL CONSIST OF THE LETTER "M", THE BASIC NUMBER OF THE SPECIFICATION SHEET, FOLLOWED BY A DASH NUMBER TAKEN FROM TABLE I.
ADD SUFFIX LETTER "L" FOR SELF-LOCKING NUT.

EXAMPLE OF PART NUMBER:



NOTES:

- (1) THREADS SHALL BE IN ACCORDANCE WITH MIL-S-7742.
- (2) PUSH-OUT VALUES SHALL BE AS SPECIFIED IN TABLE I WHEN PROPERLY INSTALLED IN LOW CARBON STEEL SHEETS.
- (3) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (4) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (5) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- ② (6) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- (7) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

RECOMMENDED INSTALLATION PROCEDURE:

- A. PUNCH HEXAGON HOLE IN SHEET PER TABLE I.
- B. INSERT HEXAGON PILOT INTO HOLE UNTIL SHOULDER CONTACTS THE STRUCTURE FOR THE FULL 360°.
- C. INSERT FLARING TOOL INTO AND ON TOP OF COUNTERSUNK END OF PILOT.
- D. APPLY SUFFICIENT FORCE TO SWAGE END OF PILOT OVER STRUCTURE, WHILE KEEPING SHOULDER IN FULL CONTACT WITH THE STRUCTURE.
- E. INSTALL SCREW OR BOLT FROM PILOT SIDE OF NUT.

REVISION

2

NAS M45938/2
SHEET 2



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