

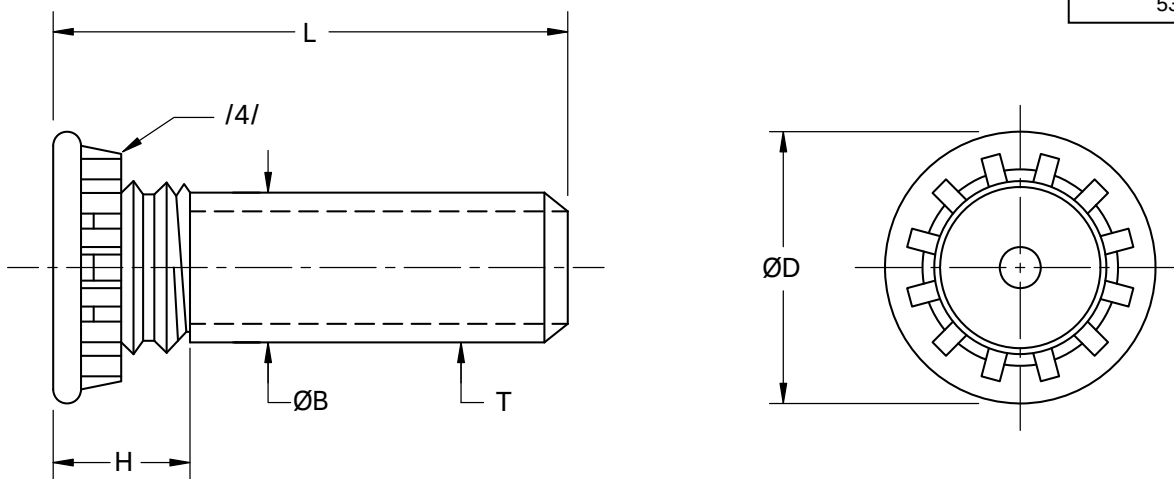


FIGURE 1 – STUD, SELF-LOCKING, FLUSH HEAD, RIBBED CLINCH TYPE

TABLE I – PART DIMENSIONS

| T<br>THREAD SIZE<br>CLASS 2A | ØB<br>STUD<br>DIA | ØD<br>±.015 | H<br>MAX |
|------------------------------|-------------------|-------------|----------|
| .086-56 UNC<br>(2-56)        | .086              | .144        | .075     |
| .112-40 UNC<br>(4-40)        | .112              | .176        | .085     |
| .138-32 UNC<br>(6-32)        | .138              | .206        | .090     |
| .164-32 UNC<br>(8-32)        | .164              | .237        | .095     |
| .190-24 UNC<br>(10-24)       | .190              | .256        | .105     |
| .190-32 UNF<br>(10-32)       | .190              | .256        | .105     |
| .250-20 UNC<br>(1/4-20)      | .250              | .337        | .125     |
| .313-18 UNC<br>(5/16-18)     | .313              | .376        | .150     |

① COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MIL-S-63540/1, REVISION A, AMENDMENT 3. PART NUMBERS REMAIN M63540/1.

|                                           |                                                                        |                                                                       |
|-------------------------------------------|------------------------------------------------------------------------|-----------------------------------------------------------------------|
| THIRD<br>ANGLE<br>PROJECTION              | CUSTODIAN<br>NATIONAL AEROSPACE STANDARDS COMMITTEE                    | REVISION<br><b>1</b>                                                  |
| PROCUREMENT<br>SPECIFICATION<br>NASM63540 | TITLE<br><b>STUD, SELF-LOCKING, FLUSH HEAD,<br/>RIBBED CLINCH TYPE</b> | CLASSIFICATION<br>PART STANDARD<br><b>NASM63540/1</b><br>SHEET 1 OF 5 |

MATERIAL:

CARBON STEEL SHALL BE GRADE 1005 (UNS G10050) THRU GRADE 1018 (UNS G10180) IN ACCORDANCE WITH ASTM A 29/A 29M OR ASTM A 510.  
CRES SHALL BE TYPE XM-7 (UNS S30430) IN ACCORDANCE WITH ASTM A 493 OR TYPES 303 (UNS S30300) AND 303 SE (UNS S30323) IN ACCORDANCE WITH ASTM A 582/A 582M.

HARDNESS:

CARBON STEEL STUDS, AFTER CARBURIZING AND TEMPERING OR CARBONITRIDING, SHALL HAVE A HARDNESS OF 75-87 HR15N. THE MINIMUM EFFECTIVE DEPTH OF CASE SHALL BE .010 INCHES.  
CRES STUDS SHALL HAVE A HARDNESS OF 171 BHN MINIMUM.

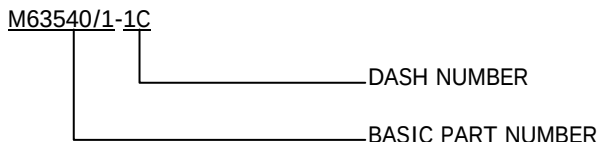
FINISH:

CARBON STEEL STUDS SHALL BE PLATED WITH ELECTRODEPOSITED CADMIUM IN ACCORDANCE WITH AMS-QQ-P-416, TYPE II, CLASS 3.  
CRES STUDS SHALL BE CLEANED, DESCALED AND PASSIVATED IN ACCORDANCE WITH ASTM A 380.

CODE:

THE PART NUMBER CONSISTS OF THE LETTER "M", THE BASIC NUMBER OF THIS PART STANDARD AND A DASH NUMBER TAKEN FROM TABLE II.

EXAMPLE OF PART NUMBER:



M63540/1-1C INDICATES – STUD; SELF-LOCKING; FLUSH HEAD, RIBBED CLINCH TYPE; CRES; .086-56 UNC-2A THREAD; .250 LENGTH; .144 HEAD DIAMETER; .075 HEAD HEIGHT.

NOTES:

- /1/ TEST PANEL THICKNESS (.040 OR .060) IS OPTIONAL BETWEEN THREAD SIZES .086-56 UNC AND .190-32 UNF, PROVIDED THE CORRESPONDING LOAD IS MAINTAINED.
- /2/ THE LOAD VALUES SHOWN ARE THE MINIMUM NON-DESTRUCT VALUES THAT APPLY DURING TESTING.
- /3/ SHEET MATERIAL HARDNESS VALUES SHALL NOT EXCEED 80 HRB FOR USE WITH CARBON STEEL STUDS OR EXCEED 70 HRB FOR USE WITH CRES STUDS.
- /4/ CLINCHING PROFILE MAY VARY.

| REVISION    |
|-------------|
| 1           |
| NASM63540-1 |
| SHEET 2     |

