

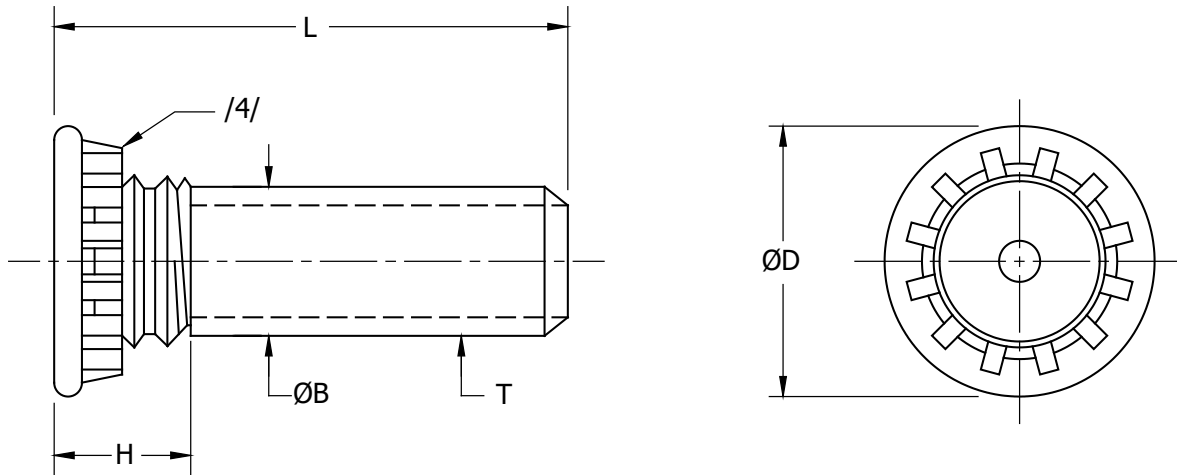


FIGURE 1 – STUD, SELF-LOCKING, FLUSH HEAD, RIBBED CLINCH TYPE

② TABLE I – PART DIMENSIONS

T THREAD SIZE CLASS 2A	ØB STUD DIA	ØD ±.015	H MAX
.0860-56 UNC (#2-56)	.086	.144	.075
.1120-40 UNC (#4-40)	.112	.176	.085
.1380-32 UNC (#6-32)	.138	.206	.090
.1640-32 UNC (#8-32)	.164	.237	.095
.1900-24 UNC (#10-24)	.190	.256	.105
.1900-32 UNF (#10-32)	.190	.256	.105
.2500-20 UNC (1/4-20)	.250	.337	.125
.3125-18 UNC (5/16-18)	.313	.376	.150

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

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
PROCUREMENT SPECIFICATION NASM63540	TITLE STUD, SELF-LOCKING, FLUSH HEAD, RIBBED CLINCH TYPE	CLASSIFICATION PART STANDARD NASM63540/1

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MATERIAL:

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CARBON STEEL - GRADE 1005 (UNS G10050) THRU GRADE 1018 (UNS G10180) IN ACCORDANCE WITH ASTM A29/A29M OR ASTM A510/A510M.
CRES - TYPE 18-9LW (UNS S30430) IN ACCORDANCE WITH ASTM A493
- TYPES 303 (UNS S30300) AND 303SE (UNS S30323) IN ACCORDANCE WITH ASTM A582/A582M.

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:

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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 A380/A380M.

CODE:

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M63540/1 - 1C
BASIC NUMBER ——— DASH NUMBER:
(TABLE II)

EXAMPLE OF PART NUMBER:

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M63540/1-1C INDICATES = STUD; SELF-LOCKING; FLUSH HEAD, RIBBED CLINCH TYPE; CRES; .0860-56 UNC-2A THREAD; .250 LENGTH; .144 HEAD DIAMETER; .075 HEAD HEIGHT.

NOTES:

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- /1/ TEST PANEL THICKNESS (.040 OR .060) IS OPTIONAL BETWEEN THREAD SIZES .0860-56 UNC AND .1900-32 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.
- (5) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- /6/ THIS LOAD IS THE LIMITING LOAD WHEN THE NUT IS FASTENED TO THE STUD AT INSTALLATION.
- (7) WHEN THE STUD IS PROPERLY INSTALLED (SEE INSTALLATION PROCEDURES), PUSH-OUT AND TORQUE-OUT VALUES SHALL BE AS SPECIFIED IN TABLE III.

REVISION

2

NASM63540/1
SHEET 2



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