

FED. SUPPLY CLASS

5307

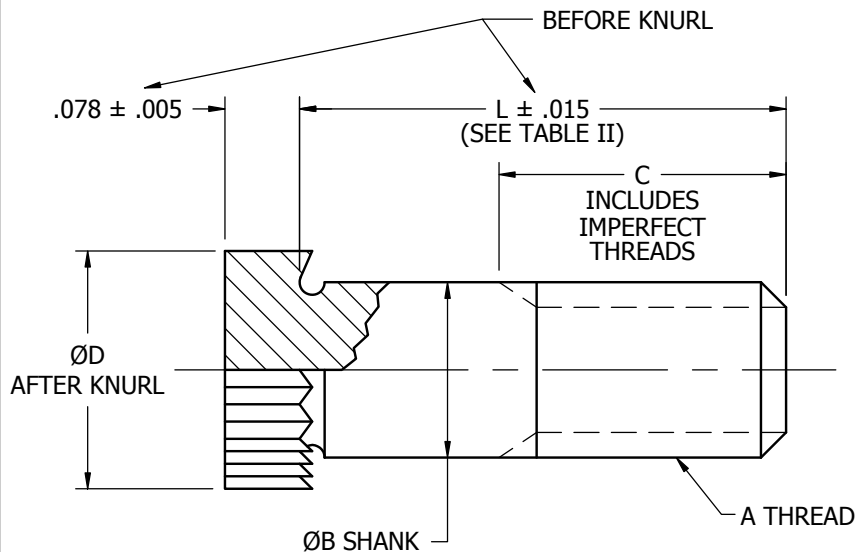


FIGURE 1 – STUD, LONG LENGTH

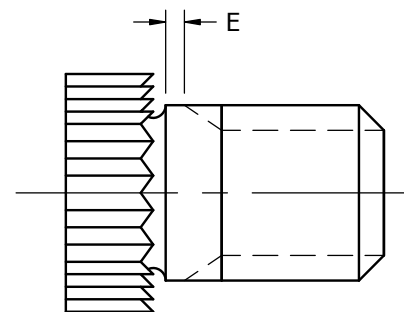


FIGURE 2 – STUD, SHORT LENGTH /2/

TABLE I – PART DIMENSIONS

A THREAD	ØB +.000 -.005	C ± .015	ØD ± .015	E +.015 -.010
.0860-64 UNF-3A	.086	.500	.170	.023
.0860-56 UNC-3A				.030
.1120-48 UNF-3A	.112		.200	
.1120-40 UNC-3A				
.1380-40 UNF-3A	.138		.220	
.1380-32 UNC-3A				
.1640-36 UNF-3A	.164		.260	.047
.1640-32 UNC-3A				
.1900-32 UNF-3A	.190	.620	.320	.055
.1900-24 UNC-3A				
.2500-28 UNF-3A	.250			
.2500-20 UNC-3A				

1 COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MIL-S-63540/2. PART NUMBERS REMAIN M63540/2.



THIRD
ANGLE
PROJECTION

PROCUREMENT
SPECIFICATION

NASM63540

CUSTODIAN

NATIONAL AEROSPACE STANDARDS COMMITTEE

TITLE

STUD, SELF-LOCKING, FLUSH AND PROTRUDING HEAD

REVISION

1

CLASSIFICATION
PART STANDARD

NASM63540/2

SHEET 1 OF 5

MATERIAL:

STEEL – 4130 (UNS G41300) PER ~~FED-STD-66~~ AIR4127.
CRES – 303 (UNS S30300) PER ~~FED-STD-66~~ AIR4127.

FINISH:

ALLOY STEEL SHALL BE CADMIUM PLATED IN ACCORDANCE WITH AMS-QQ-P-416, TYPE II, CLASS 3.
CRES SHALL BE CLEANED, DESCALED, AND PASSIVATED IN ACCORDANCE WITH ASTM A380.

CODE:

THE PART NUMBER CONSISTS OF THE LETTER "M", THE BASIC PART STANDARD NUMBER, THREAD SIZE
AND LENGTH DASH NUMBER (TABLE II) AND EITHER LETTER "C" FOR CRES OR BLANK FOR
ALLOY STEEL.

EXAMPLE OF PART NUMBER:

M63540/2 - 09-20 C

— MATERIAL CODE (BLANK IF ALLOY STEEL)
— THREAD SIZE AND LENGTH DASH NUMBER
(“E” IN PLACE OF DASH FOR SHORT LENGTHS)
— BASIC PART NUMBER

NOTES:

- (1) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- /2/ DETAILS SAME AS FIGURE 1 EXCEPT FOR DIMENSION "E". "C" THREAD LENGTH IS NOT APPLICABLE.
- (3) HARDNESS: ALLOY STEEL SHALL BE 26-32 HRC. CRES SHALL BE 171 HB MINIMUM.
- (4) THREADS SHALL BE IN ACCORDANCE WITH FED-STD-H28/2.
- (5) PUSH-OUT AND TORQUE-OUT VALUES SHALL BE AS SPECIFIED IN TABLE IV WHEN INSTALLED IN SPECIFIED MATERIAL.
- /6/ DASH NUMBERS ABOVE HEAVY LINE ARE FOR SHORT LENGTH STUDS PER FIGURE 2. DASH NUMBERS BELOW HEAVY LINE ARE FOR LONG LENGTH STUDS PER FIGURE 1.
- (7) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (8) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (9) 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.
- (10) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

REVISION
1
NASM63540/2
SHEET 2

① COMPLETELY REVISED