

FED. SUPPLY CLASS

5307

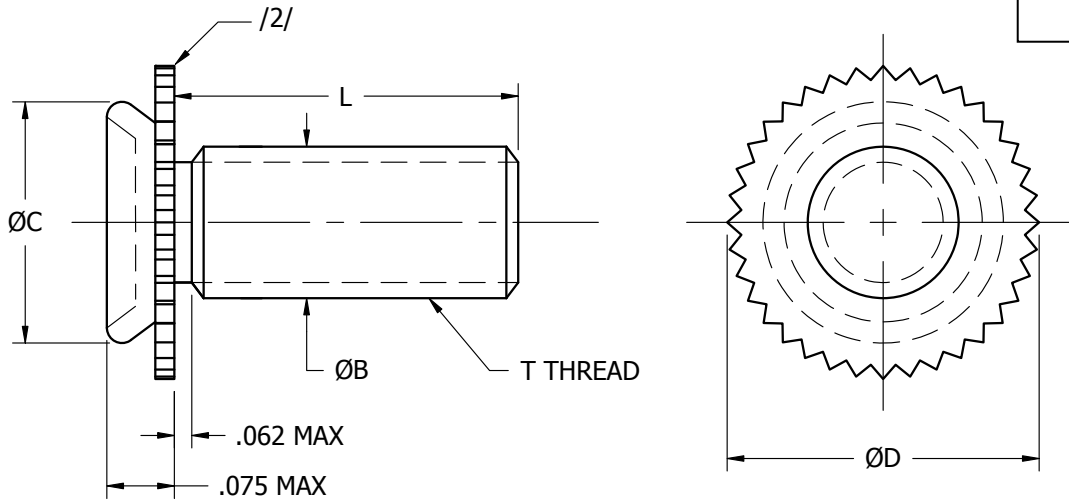


FIGURE 1 – STUD, SELF-LOCKING, CONCEALED HEAD, KNURLED CLINCH TYPE

TABLE I – PART DIMENSIONS

T THREAD SIZE	ØB STUD	ØC MAX	ØD ± .010
.1120-40 UNC-2A (4-40)	.112	.171	.205
.1380-32 UNC-2A (6-32)	.138	.212	.250
.1640-32 UNC-2A (8-32)	.164	.289	.328
.1900-24 UNC-2A (10-24)	.190	.311	.350
.1900-32 UNF-2A (10-32)	.190	.311	.350
.2500-20 UNC-2A (1/4-20)	.250	.343	.385

MATERIAL:

CRES – TYPE 18-9-LW (UNS S30430) (FORMERLY IDENTIFIED AS XM-7) IN ACCORDANCE WITH ASTM A493 OR TYPES 303 (UNS S30300) AND 303SE (UNS S30323) IN ACCORDANCE WITH ASTM A582/A582M.

FINISH:

CRES STUDS SHALL BE PASSIVATED IN ACCORDANCE WITH AMS2700, METHOD 1 CLASS 4.

CODE:

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

① COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MIL-S-63540/4, AMENDMENT 1. PART NUMBERS REMAIN M63540/3.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
		CLASSIFICATION PART STANDARD NASM63540-4
PROCUREMENT SPECIFICATION NASM63540	TITLE STUD, SELF-LOCKING, CONCEALED HEAD, KNURLED CLINCH TYPE	

EXAMPLE OF PART NUMBER:

M63540/4 - 12 = STUD, SELF-LOCKING, CONCEALED HEAD, KNURLED CLINCH TYPE; CRES;
.1640-32 UNC-2A THREAD; .250 LENGTH; Ø.289 HEAD.

DASH NUMBER

BASIC PART NUMBER

NOTES:

- (1) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- /2/ CLINCHING PROFILE MAY VARY.
- (3) BLIND HOLES MAY BE DEEPER IN PANELS THICKER THAN THE MINIMUM WITH NO ADVERSE EFFECT ON THE PERFORMANCE OF STUD.
- (4) CRES STUDS SHALL HAVE A HARDNESS OF 171 HB MINIMUM.
- (5) PULL-OUT AND TORQUE-OUT VALUES: WHEN THE STUD IS PROPERLY INSTALLED, (SEE INSTALLATION PROCEDURES), PULL-OUT AND TORQUE-OUT VALUES SHALL BE AS SPECIFIED IN TABLE III.
- (6) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (7) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (8) 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.
- (9) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

TABLE II – THREAD SIZE AND LENGTH DASH NUMBERS

L ± .015	T THREAD SIZE					
	.1120-40 UNC-2A	.1380-32 UNC-2A	.1640-32 UNC-2A	.1900-24 UNC-2A	.1900-32 UNF-2A	.2500-20 UNC-2A
.250	1	6	12			
.375	2	7	13	18	23	
.500	3	8	14	19	24	
.625	4	9	15	20	25	28
.750	5	10	16	21	26	29
1.000		11	17	22	27	30

① COMPLETELY REVISED

REVISION

1

NASM63540-4

SHEET 2