

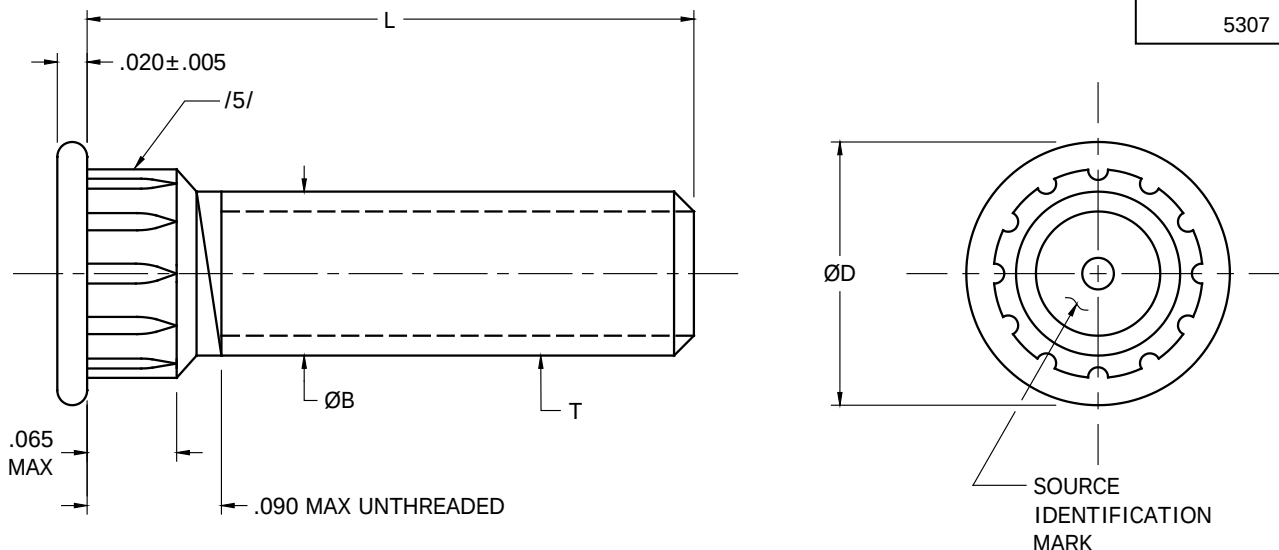


FIGURE 1 – STUD, SELF-LOCKING, BROACHING TYPE

TABLE I – PART DIMENSIONS

T THREAD SIZE CLASS 2A	ØB STUD	ØD ± .010
.112-40UNC (4-40)	.112	.180
.138-32UNC (6-32)	.138	.200
.164-32UNC (8-32)	.164	.225
.190-32UNF (10-32)	.190	.250

MATERIAL:

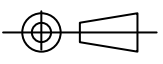
PHOSPHOR BRONZE SHALL BE COPPER ALLOY (UNS C51000) IN ACCORDANCE WITH ASTM B 159/B 159M, TEMPER H01.

HARDNESS:

PHOSPHOR BRONZE STUDS SHALL HAVE A HARDNESS OF 121 HB MINIMUM (68 HRB MINIMUM).

② COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MIL-S-63540/7. PART NUMBERS REMAIN M63540/7

FORM 09-01	THIRD ANGLE PROJECTION 	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 2
	PROCUREMENT SPECIFICATION NASM63540	TITLE STUD, SELF-LOCKING, BROACHING TYPE	CLASSIFICATION PART STANDARD
			NASM63540-7 SHEET 1 OF 4

CODE:

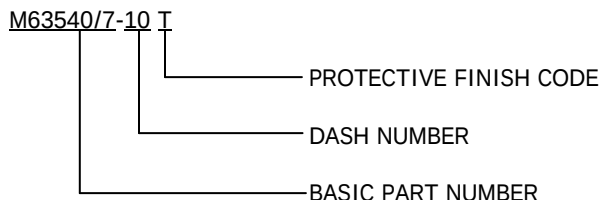
THE PART NUMBER CONSISTS OF THE LETTER "M", THE BASIC NUMBER OF THIS PART STANDARD AND A DASH NUMBER TAKEN FROM TABLE II, FOLLOWED BY A PROTECTIVE FINISH CODE LETTER.

FINISH CODE:

"T" = ELECTRODEPOSITED TIN

"L" = ELECTRODEPOSITED TIN-LEAD

EXAMPLE OF PART NUMBER:



M63540/7-10T INDICATES – STUD, SELF-LOCKING, BROACHING TYPE; PHOSPHOR BRONZE WITH ELECTRODEPOSITED TIN; .138-32UNC-2A THREAD; .500 LENGTH; .200 HEAD DIAMETER; .020 ± .005 HEAD HEIGHT.

M63540/7-20L INDICATES – STUD, SELF-LOCKING, BROACHING TYPE; PHOSPHOR BRONZE WITH ELECTRODEPOSITED TIN-LEAD; .190-32UNF-2A THREAD; .625 LENGTH; .250 HEAD DIAMETER; .020 ± .005 HEAD HEIGHT.

NOTES:

- (1) DIMENSIONS IN INCHES AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- (2) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (3) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (4) REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.
- /5/ BROACHING PROFILE MAY VARY.
- (6) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- /7/ THE LOAD VALUES SHOWN ARE THE MINIMUM NON-DESTRUCT VALUES THAT APPLY DURING TESTING.
- /8/ THIS LOAD IS THE LIMITING LOAD WHEN THE NUT IS FASTENED TO THE STUD AT ASSEMBLY.
- (9) PUSH-OUT AND TORQUE-OUT VALUES: WHEN THE STUD IS PROPERLY INSTALLED, (SEE INSTALLATION PROCEDURES), PUSH-OUT AND TORQUE-OUT VALUES SHALL BE AS SPECIFIED IN TABLE III.

② COMPLETELY REVISED

REVISION

2

NAS63540/7

SHEET 2



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