

FOR STATUS OF INACTIVATION
SEE APPLICABILITY BLOCK

TABLE I (CONTINUED)

BOEING STANDARD NUMBER BACB30CH 8	J 4	K MAX 4	Ø M	N	R RAD	S MAX 9	T MAX 9	U MAX 4	Ø W GAGE +.0002 -.0000
6	.2085	.047	.185 .177	.014 .010	.020 .010	.0010	.094	.078	.3270
8	.2675	.062	.242 .235	.018 .014	.020 .010	.0015	.125	.094	.4318
10	.3315	.078	.305 .294	.023 .017	.025 .010	.0020	.156	.109	.5449
12	.3925	.094	.368 .361	.027 .021	.030 .010	.0030	.188	.125	.6580

NOTES

- 1 FOR "G" AND "L" DIMENSIONS: SEE NAS1456 THRU 1462, EXCEPT FOR "L" FOR .312 AND .375 SIZES SEE TABLE II.
- 2 "P" LENGTH IS OPTIONAL TO MANUFACTURER DUE TO VARIATION IN PIN TAIL LENGTH. PIN TAIL MUST BE ADEQUATE FOR INSTALLATION PER BAC5004.
- 3 WHEN BACB30CH PARTS ARE USED TO REPLACE STUMP TYPE LOCK BOLTS, THESE PARTS MUST BE CUT AT BREAK NECK GROOVE BEFORE DRIVING.
- 4 SHANK TAPER ALLOWED: "J" MAXIMUM DIAMETER FOR "K" LENGTH UNDER HEAD; BLENDED UNDER FILL FOR "U" LENGTH AT END OF SHANK.
- 5 DIMENSIONS A, A' AND B ARE FOR ENGINEERING REFERENCE ONLY, NOT FOR INSPECTION. A, A' AND B ARE CALCULATED LIMITS RESULTING FROM TOLERANCES ON D, W, H, E AND HEAD ANGLE.
- 6 DIMENSIONS FOR GAGE PROTRUSION "H": INSPECT PER BOEING DOCUMENT D-11805.
- 7 RECOMMENDED PROCUREMENT PRACTICE: REDUCE INVENTORIES AND FACILITATE PROCUREMENT BY PURCHASING OVERSIZE LOCK BOLTS IN GRIP DIMENSIONS DESIGNATED BY EVEN DASH NUMBERS ONLY. THESE MAY BE USED TO REPLACE STANDARD SIZE LOCK BOLTS OF THE SAME GRIP DASH NUMBER OR THE ODD DASH NUMBER WHICH IS .062 SHORTER. WHEN REPLACING SHORTER LOCK BOLTS, ADD A WASHER UNDER COLLAR AS NECESSARY TO BRING TOTAL MATERIAL THICKNESS WITHIN GRIP RANGE.
- 8 FOR COMPLETE BOEING PART NUMBER, SEE CODING SECTION.

DATE 22-APR-1955 REV (T) 08-DEC-2006

CAGE CODE 81205

BACB30CH

SH 2

**BOLT,
LOCK, TENSION, 100 DEG (AN509)
HEAD, ALLOY STEEL, .0156 OVERSIZE
(PULL TYPE, GUN DRIVEN)**

BACB30CH

SH 2

FOR STATUS OF INACTIVATION
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NOTES (CONTINUED)

- 9 SHANK IMPERFECTIONS PERMITTED: SPIRAL UNDERFILL FOR "T" WIDTH NOT TO EXCEED "S" DEPTH.
- 10 FORMERLY TEXTRON AEROSPACE. NAME CHANGE ONLY. NO CHANGE TO PLANT LOCATION OR FACILITIES. STOCK MANUFACTURED UNDER THE TEXTRON AEROSPACE FASTENERS NAME MAY BE PROCURED AND USED UNTIL DEPLETED,
- 11 HUCK INTERNATIONAL INC (CARSON) IS NOW ALCOA FASTENING SYSTEMS – CARSON. THIS CHANGE WAS A NAME CHANGE ONLY. STOCK MANUFACTURED UNDER THE HUCK NAME MAY BE PROCURED AND USED UNTIL DEPLETED.

TABLE II



L DIMENSIONS FOR .312 AND .375 SIZES 											
2ND DASH NUMBER	L ±.010		2ND DASH NUMBER	L ±.010		2ND DASH NUMBER	L ±.010		2ND DASH NUMBER	L ±.010	
	.312	.375		.312	.375		.312	.375		.312	.375
3	.558	.650	7	.808	.900	11	1.058	1.150	15	1.308	1.400
4	.621	.713	8	.871	.963	12	1.121	1.213	16	1.371	1.463
5	.683	.775	9	.933	1.025	13	1.183	1.275	17	1.433	1.525
6	.746	.838	10	.996	1.088	14	1.246	1.338	18	1.496	1.588

TABLE II (CONTINUED)

L DIMENSIONS FOR .312 AND .375 SIZES 											
2ND DASH NUMBER	L ± .010		2ND DASH NUMBER	L ± .010		2ND DASH NUMBER	L ± .010		2ND DASH NUMBER	L ± .010	
	.312	.375		.312	.375		.312	.375		.312	.375
19	1.558	1.650	23	1.808	1.900	27	2.058	2.150	31	2.308	2.400
20	1.621	1.713	24	1.871	1.963	28	2.121	2.213	32	2.371	2.463
21	1.683	1.775	25	1.933	2.025	29	2.183	2.275			
22	1.746	1.838	26	1.996	2.088	30	2.246	2.338			

PROCUREMENT SPECIFICATION

BPS-F-46 EXCEPT AS NOTED. MINIMUM TENSILE STRENGTH: 4225 LBS. FOR .312 SIZE; 5050 LBS. FOR .375 SIZE.

MATERIAL

ALLOY STEEL – AISI 4037, 4140 OR 4340 PER AMS-STD-66.

HEAT TREATMENT

RESTORE SURFACE CARBON IF NECESSARY. QUENCH AND TEMPER. HARDNESS: CORE 36-42 HRC; SURFACE (PLATING REMOVED) 76-81 HR15N.

DATE 22-APR-1955 REV (T) 08-DEC-2006

CAGE CODE 81205

BACB30CH

SH 3

**BOLT,
LOCK, TENSION, 100 DEG (AN509)
HEAD, ALLOY STEEL, .0156 OVERSIZE
(PULL TYPE, GUN DRIVEN)**

BACB30CH

SH 3

FOR STATUS OF INACTIVATION
SEE APPLICABILITY BLOCK

SURFACE TEXTURE

PER ASME B46.1. HEAD TO SHANK FILLET, BEARING SURFACE OF HEAD AND SHANK, 63 MICROINCHES Ra; OTHER SURFACES 125 MICROINCHES Ra.

FINISH

CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2, OR CADMIUM-NICKEL PLATE PER AMS 2416. SEE CODING SECTION.

LUBRICATION

PER BPS-F-46 EXCEPT NO LUBRICANT OR RESIDUAL CONTAMINANTS ON DIFFUSED CADMIUM-NICKEL PLATE LOCKBOLTS.

PROCUREMENT

ALCOA FASTENING SYSTEMS – CARSON (CAGE CODE 17446) 11

CHERRY AEROSPACE LLC (CAGE CODE 11815) 10

THE MANUFACTURERS LISTED IN BPS-F-46SUP AND THEIR AUTHORIZED DISTRIBUTORS ARE THE ONLY APPROVED SOURCES FOR THE ABOVE QUALIFIED PRODUCTS. SEE BPS-F-46SUP FOR PLANT ADDRESSES. NO CHANGES IN PRODUCT DESIGN, BASIC METHODS OF MANUFACTURE, PLANT SITE OR QUALITY LEVEL SHALL BE MADE WITHOUT PRIOR NOTIFICATION AND PRIOR APPROVAL IN WRITING FROM THE BOEING COMPANY. MANUFACTURERS OF COMPETITIVE PRODUCTS MAY APPLY TO A SUPPLIER MANAGEMENT AND PROCUREMENT DEPARTMENT OF THE BOEING COMPANY FOR QUALIFICATION. IF A MANUFACTURER IS SHOWN ON THIS STANDARD, BUT NOT LISTED IN THE SUPPLEMENT, CONTACT THE DIVISIONAL ENGINEERING STANDARDS FOCAL POINT OR ENGINEERING STANDARDS FOR VERIFICATION.

DATE 22-APR-1955 REV (T) 08-DEC-2006

CAGE CODE 81205

BACB30CH

SH 4

**BOLT,
LOCK, TENSION, 100 DEG (AN509)
HEAD, ALLOY STEEL, .0156 OVERSIZE
(PULL TYPE, GUN DRIVEN)**

BACB30CH

SH 4

FOR STATUS OF INACTIVATION
SEE APPLICABILITY BLOCK

USAGE AND APPLICATION INFORMATION

CODING

FIRST DASH NUMBER DESIGNATES NOMINAL DIAMETER PER TABLE I.

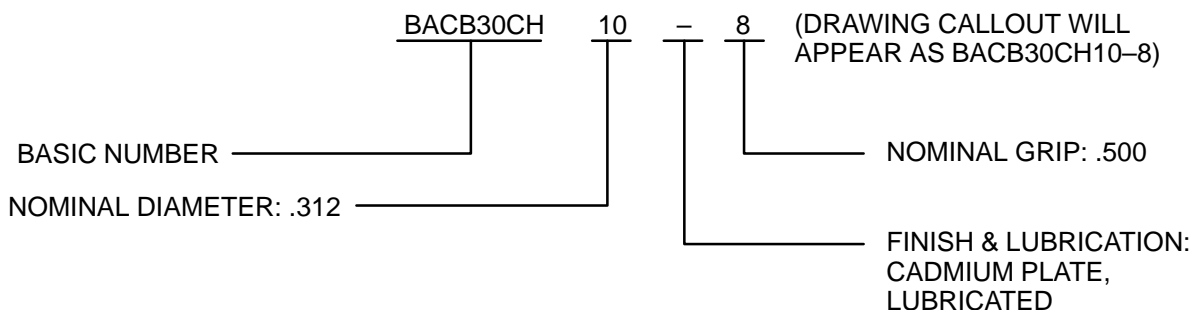
A DASH (" - ") FOLLOWING THE FIRST DASH NUMBER DESIGNATES CADMIUM PLATE WITH LUBRICATION.

SECOND DASH NUMBER DESIGNATES NOMINAL GRIP LENGTH IN .062 INCREMENTS.

1 7

LETTER "N" FOLLOWING THE SECOND DASH NUMBER DESIGNATES CADMIUM NICKEL-PLATE WITH NO LUBRICATION.

EXAMPLE OF PART NUMBER



INSTALLATION

INSTALL PER BAC5004. USE COLLAR AS CALLED FOR WITH LOCKBOLT BEING REPLACED.

FASTENER CODE

SEE BACD2074 FOR FASTENER CODES.

SEE D-590-PREFACE (INDEX) FOR INACTIVATION DEFINITIONS. SEE D-590-SUPERSESSION-LIST FOR SUPERSESSION CLASS DEFINITIONS AND SUPERSESSION LIST.

INACTIVATION APPLICABILITY

BCA - BACB30CH IS INACTIVE FOR DESIGN AND PROCUREMENT. NO SUPERSEDING STANDARD. SEE BACB30LX.

DATE 22-APR-1955 REV (T) 08-DEC-2006

CAGE CODE 81205

BACB30CH

SH 5

**BOLT,
LOCK, TENSION, 100 DEG (AN509)
HEAD, ALLOY STEEL, .0156 OVERSIZE
(PULL TYPE, GUN DRIVEN)**

BACB30CH

SH 5