



FOR STATUS OF INACTIVATION  
SEE APPLICABILITY BLOCK

## NOTES

- 1 SEE TABLE II FOR "G", "L" AND "P" DIMENSIONS.
- 2 WHEN USED TO REPLACE BACB30AR STUMP TYPE, LOCKBOLTS MUST BE CUT AT BREAKNECK GROOVE PRIOR TO INSTALLATION.
- 3 TAPER AND LOCKING GROOVE ANGLES AT END OF SHANK NEED NOT BLEND. SLIGHT HOOK AT JUNCTURE OF ANGLES NORMAL TO COLD ROLLING IS PERMISSIBLE.
- 4 SHANK TAPER ALLOWED: "J" DIAMETER FOR "K" LENGTH UNDER HEAD; "S" DIAMETER FOR "K" LENGTH AT END OF SHANK; "D" DIAMETER FOR REMAINDER OF SHANK.
- 5 FOR COMPLETE BOEING PART NUMBER, SEE CODING SECTION.
- 6 MEASURE GRIP LENGTH FROM UNDERSIDE OF HEAD TO END OF FULL CYLINDRICAL PORTION OF SHANK.
- 7 PINS BELOW HEAVY LINE, WHEN USED IN INTERFERENCE FIT HOLES, MUST BE DRIVEN INTO HOLE SUFFICIENTLY TO ALLOW THE INSTALLATION TOOL TO PROPERLY ENGAGE THE PULL GROOVES OF THE PIN.
- 8 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.
- 9 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.

## PROCUREMENT SPECIFICATION

BPS-F-46, EXCEPT AS NOTED.

## MATERIAL

ALLOY STEEL – AISI 4340, 8740 OR 4140 PER AMS-STD-66.

## HEAT TREATMENT

RESTORE SURFACE CARBON, IF NECESSARY. QUENCH AND TEMPER.

## FINISH

- |           |   |   |
|-----------|---|---|
| NO LETTER | – | CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.<br>EMBRITTLMENT TEST PER AMS-QQ-P-416 DOES NOT APPLY. |
| LETTER N  | – | CADMIUM –NICKEL PLATE PER AMS 2416.   |

DATE 02-APR-1956 REV (M) 11-DEC-2006

CAGE CODE 81205

**BAC B30CU**

**SH 2**

**BOLT,  
LOCK, FLAT HEAD, SHEAR, .0156  
OVERSIZE, PULL TYPE, GUN  
DRIVEN**

**BAC B30CU**

**SH 2**

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## SURFACE TEXTURE

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

## LUBRICATION

PER BPS-F-46.

## ROCKWELL HARDNESS

CORE – 36–42 HRC, SURFACE (PLATING REMOVED) 76–81 HR15N.

## HEAD MARKING

DEPRESSED SPOT CONTAINING A RAISED H. MANUFACTURER'S TRADEMARK OPTIONAL.

## PROCUREMENT

ALCOA FASTENING SYSTEMS – CARSON (CAGE CODE 17446) 

CHERRY AEROSPACE LLC (CAGE CODE 11815) 

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.

RECOMMENDED PROCUREMENT PRACTICE: REDUCE INVENTORIES AND FACILITATE PROCUREMENT BY PURCHASING OVERSIZE LOCKBOLTS IN GRIP DIMENSIONS DESIGNATED BY EVEN DASH NUMBERS ONLY. THESE MAY BE USED TO REPLACE STANDARD SIZE LOCKBOLTS OF SAME GRIP DASH NUMBER OR THE ODD DASH NUMBER WHICH IS .062 SHORTER. WHEN REPLACING SHORTER DASH NUMBER, PLACE WASHER UNDER COLLAR AS NECESSARY TO BRING TOTAL THICKNESS WITHIN GRIP RANGE.

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**BAC B30CU**

SH 3

**BOLT,  
LOCK, FLAT HEAD, SHEAR, .0156  
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DRIVEN**

**BAC B30CU**

SH 3

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## USAGE AND APPLICATION INFORMATION

.0156 OVERSIZE SHANK FOR REPLACEMENT OF BACB30GW AND BACB30AR LOCKBOLTS.

SEE BACB30GW FOR A286 OVERSIZE BOLTS.

### CODING

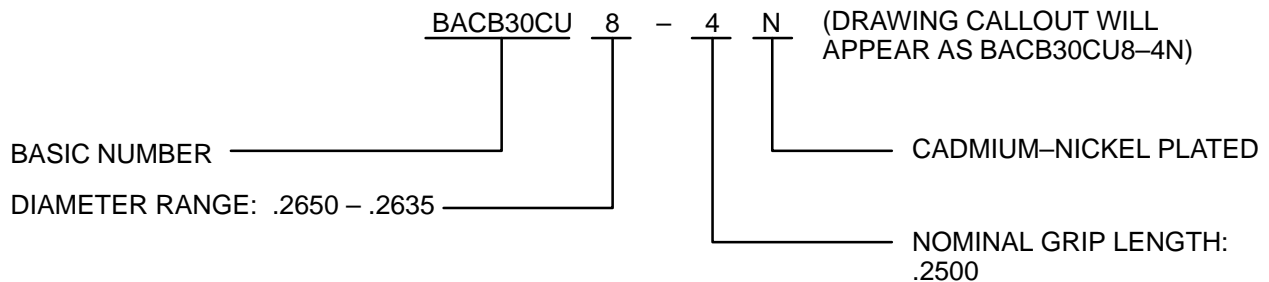
FIRST DASH NUMBER DESIGNATES DIAMETER RANGE PER TABLE I.

SECOND DASH NUMBER DESIGNATES NOMINAL GRIP IN .062 INCREMENTS.

NO CODE FOLLOWING SECOND DASH NUMBER DESIGNATES CADMIUM PLATE.

LETTER "N" FOLLOWING SECOND DASH NUMBER DESIGNATES CADMIUM-NICKEL PLATING.

### EXAMPLE OF PART NUMBER



### FASTENER CODE

SEE BACD2074 FOR FASTENER CODES.

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SH 4

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**BAC B30CU**

SH 4

FOR STATUS OF INACTIVATION  
SEE APPLICABILITY BLOCK

TABLE II 7

SECOND DASH NUMBER	MAX GRIP	STRUCTURE THICKNESS RANGE (FOR DESIGN)		G ±.010 <span style="border: 1px solid black; padding: 0 5px;">6</span>	Ø .190		Ø .250	
		MIN	MAX		L ±.005	P +.20 -.00	L ±.005	P +.20 -.00
1	.062	.020	.062	.062	.256	1.25	---	---
2	.125	.062	.125	.125	.319	1.38	.371	1.78
3	.188	.126	.188	.188	.381	1.50	.433	1.91
4	.250	.189	.250	.250	.444	1.62	.496	2.03
5	.312	.251	.312	.312	.506	1.75	.558	2.16
6	.375	.313	.375	.375	.569	1.88	.621	2.28
7	.438	.376	.438	.438	.631	2.00	.683	2.41
8	.500	.439	.500	.500	.694	2.12	.746	2.53
9	.562	.501	.562	.562	.756	2.25	.808	2.66
10	.625	.563	.625	.625	.819	2.38	.871	2.78
11	.688	.626	.688	.688	.881	2.50	.933	2.91
12	.750	.689	.750	.750	.944	2.62	.996	3.03
13	.812	.751	.812	.812	1.006	2.75	1.058	3.16
14	.875	.813	.875	.875	1.069	2.88	1.121	3.16
15	.938	.876	.938	.938	1.131	3.00	1.183	3.16
16	1.000	.939	1.000	1.000	1.194	3.12	1.246	3.16
17	1.062	1.001	1.062	1.062	1.256	3.12	1.308	3.16
18	1.125	1.063	1.125	1.125	1.319	3.12	1.371	3.16
19	1.188	1.126	1.188	1.188	1.381	3.12	1.433	3.16
20	1.250	1.189	1.250	1.250	1.444	3.12	1.496	3.16
21	1.312	1.251	1.312	1.312	1.506	3.12	1.558	3.16
22	1.375	1.313	1.375	1.375	1.569	3.12	1.621	3.16
23	1.438	1.376	1.438	1.438	1.631	3.12	1.683	3.16
24	1.500	1.439	1.500	1.500	1.694	3.12	1.746	3.16
25	1.562	1.501	1.562	1.562	1.756	3.12	1.808	3.16
26	1.625	1.563	1.625	1.625	1.819	3.12	1.871	3.16
27	1.688	1.626	1.688	1.688	1.881	3.12	1.933	3.22
28	1.750	1.689	1.750	1.750	1.944	3.12	1.996	3.28
29	1.812	1.751	1.812	1.812	2.006	3.12	2.058	3.34
30	1.875	1.813	1.875	1.875	2.069	3.12	2.121	3.41
31	1.938	1.876	1.938	1.938	2.131	3.12	2.183	3.47
32	2.000	1.939	2.000	2.000	2.194	3.12	2.246	3.53

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SH 5

**BOLT,  
LOCK, FLAT HEAD, SHEAR, .0156  
OVERSIZE, PULL TYPE, GUN  
DRIVEN**

**BAC B30CU**

SH 5

FOR STATUS OF INACTIVATION  
SEE APPLICABILITY BLOCK

TABLE II (CONTINUED) 7

SECOND DASH NUMBER	MAX GRIP	STRUCTURE THICKNESS RANGE (FOR DESIGN)		G ± .010 6	Ø .312		Ø .375	
		MIN	MAX		L ± .005	P +.20 -.00	L ± .005	P +.20 -.00
1	.062	.020	.062	.062	---	---	---	---
2	.125	.062	.125	.125	.396	1.69	.447	1.81
3	.188	.126	.188	.188	.458	1.81	.509	1.94
4	.250	.189	.250	.250	.521	1.94	.572	2.06
5	.312	.251	.312	.312	.583	2.06	.634	2.19
6	.375	.313	.375	.375	.646	2.19	.697	2.31
7	.438	.376	.438	.438	.708	2.31	.759	2.44
8	.500	.439	.500	.500	.771	2.44	.822	2.56
9	.562	.501	.562	.562	.833	2.56	.884	2.69
10	.625	.563	.625	.625	.896	2.69	.947	2.81
11	.688	.626	.688	.688	.958	2.81	1.009	2.94
12	.750	.689	.750	.750	1.021	2.94	1.072	3.06
13	.812	.751	.812	.812	1.083	2.94	1.134	3.06
14	.875	.813	.875	.875	1.146	2.94	1.197	3.06
15	.938	.876	.938	.938	1.208	2.94	1.259	3.06
16	1.000	.939	1.000	1.000	1.271	2.94	1.322	3.06
17	1.062	1.001	1.062	1.062	1.333	2.94	1.384	3.06
18	1.125	1.063	1.125	1.125	1.396	2.94	1.447	3.06
19	1.188	1.126	1.188	1.188	1.458	2.94	1.509	3.06
20	1.250	1.189	1.250	1.250	1.521	2.94	1.572	3.06
21	1.312	1.251	1.312	1.312	1.583	2.94	1.634	3.06
22	1.375	1.313	1.375	1.375	1.646	2.94	1.697	3.06
23	1.438	1.376	1.438	1.438	1.708	2.94	1.759	3.06
24	1.500	1.439	1.500	1.500	1.771	2.94	1.822	3.06
25	1.562	1.501	1.562	1.562	1.833	3.00	1.884	3.12
26	1.625	1.563	1.625	1.625	1.896	3.06	1.947	3.19
27	1.688	1.626	1.688	1.688	1.958	3.12	2.009	3.25
28	1.750	1.689	1.750	1.750	2.021	3.19	2.072	3.31
29	1.812	1.751	1.812	1.812	2.083	3.25	2.134	3.38
30	1.875	1.813	1.875	1.875	2.146	3.31	2.197	3.44
31	1.938	1.876	1.938	1.938	2.208	3.38	2.259	3.50
32	2.000	1.939	2.000	2.000	2.271	3.44	2.322	3.56

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SH 6

BOLT,  
LOCK, FLAT HEAD, SHEAR, .0156  
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DRIVEN

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SH 6

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

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

**INACTIVATION APPLICABILITY**

**BCA –** BACB30CU IS INACTIVE FOR DESIGN AND PROCUREMENT.  
NO SUPERSEDING STANDARD. SEE BACB30FP.

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SH 7