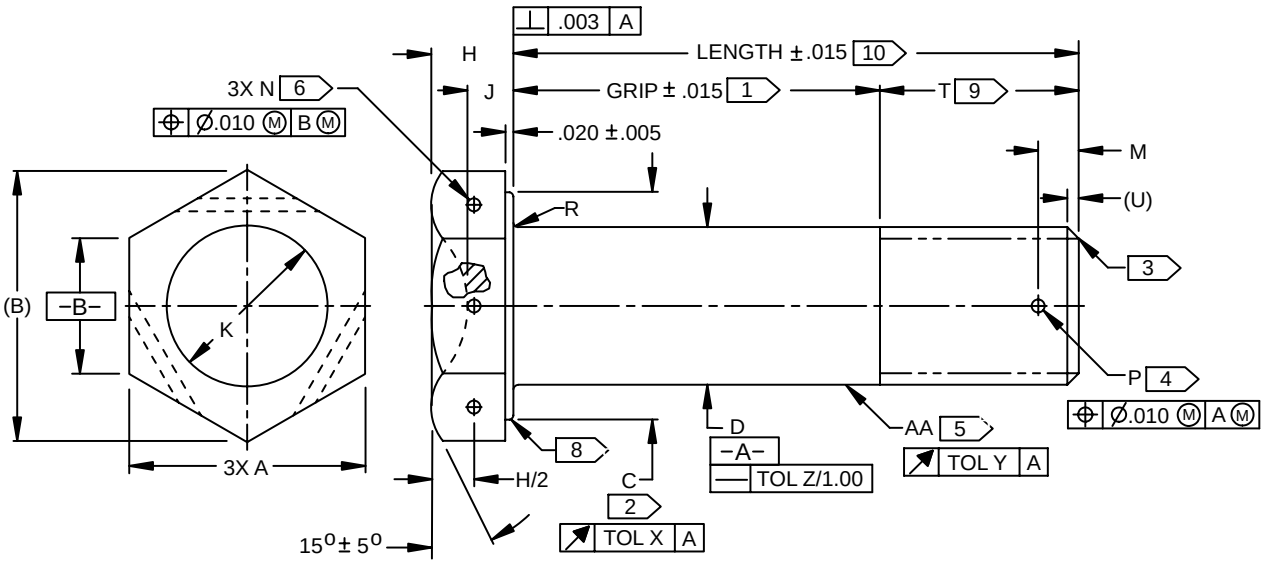


DIMENSIONING AND TOLERANCING PER ANSI Y14.5M–1982.
DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED.
DIMENSIONS APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.

TABLE I

BOEING STANDARD NUMBER BACB30DM 7	AA NOMINAL THREAD SIZE AS8879 UNJF–3A 5	A	B REF	∅ C MIN	∅ D	H +.015 –.000	J +.015 –.000	∅ K ± .01	M ± .010
3	.1900–32	.376 .367	.43	.359	.1895 .1890	.110	.073	.19	.117
4	.2500–28	.439 .430	.51	.422	.2495 .2490	.125	.083	.25	.116
5	.3125–24	.502 .492	.58	.484	.3120 .3115	.156	.104	.31	.119
6	.3750–24	.564 .553	.65	.547	.3745 .3740	.188	.125	.38	.120

TECHNICAL CHANGES IDENTIFIED BY REVISION BAR.

TABLE I (CONTINUED)

BOEING STANDARD NUMBER BACB30DM [7]	N ± .010	∅ P + .010 – .000	R RAD	T [9]	U REF [3]	X TOL	Y TOL	Z TOL
3	.046	.070	.020 .010	.338	.016	.005	.0045	.0040
4	.046	.076	.020 .010	.425	.018	.006	.0045	.0030
5	.070	.076	.020 .010	.469	.021	.008	.0045	.0030
6	.070	.106	.025 .015	.578	.021	.009	.0060	.0025

NOTES

[1] TO DETERMINE THE NOMINAL GRIP LENGTH, MULTIPLY THE GRIP LENGTH NUMBER BY .0625. THE GRIP LENGTH IS MEASURED FROM THE UNDERSIDE OF THE HEAD TO THE END OF THE FULL CYLINDRICAL PORTION OF SHANK.

[2] WASHER FACE DIAMETER – MAX NOT TO EXCEED ACTUAL WIDTH ACROSS FLATS; MINIMUM AS TABULATED ABOVE.

[3] END TO BE FLAT AND CHAMFERED PER BPS–F–69.

[4] DRILL “P” WHEN SPECIFIED BY PART NUMBER; COUNTERSINK OPTIONAL.

[5] THREAD MAXIMUM MAJOR DIAMETER TO BE .001 LESS THAN MINIMUM SHANK DIAMETER. SEE BPS–B30DN FOR ROLLED THREAD LIMITATIONS.

[6] DRILL “N” WHEN SPECIFIED BY PART NUMBER. LOCKWIRE HOLES MUST BE FREE FROM BURRS AND SHARP EDGES.

[7] SEE CODING UNDER USAGE AND APPLICATION FOR COMPLETE BOEING PART NUMBER.

[8] CHAMFER 15 DEGREES TO “C” OPTIONAL.

[9] THE “T” DIMENSION IS NOMINAL AND DOES NOT HAVE AN APPLIED TOLERANCE. DIMENSION “T” IS NOT TO BE INSPECTED, BUT IS USED IN CALCULATION OF NOMINAL BOLT LENGTH. [10]

[10] THE TOLERANCE SHALL BE APPLIED TO A NOMINAL LENGTH DIMENSION DETERMINED BY ADDING THE NOMINAL GRIP LENGTH (GRIP LENGTH NUMBER TIMES .0625) AND “T” FROM TABLE I.

NOTES (CONTINUED)

11 NO LONGER IN OPERATION. PARTS MANUFACTURED PRIOR TO JANUARY 17, 1994 MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.

12 HUCK LAKEWOOD (FORMERLY DEUTSCH FASTENER CORP) IS NO LONGER IN OPERATION. PARTS MANUFACTURED AT THAT FACILITY (CAGE CODE 97928) UNDER EITHER NAME PRIOR TO OCTOBER 1, 1999 MAY BE PROCURED AND USED BY BOEING AND ITS SUBCONTRACTORS UNTIL STOCKS ARE DEPLETED.

13 TO DETERMINE THE GRIP LENGTH NUMBER, DIVIDE THE TOTAL THICKNESS OF PARTS BEING JOINED BY .0625. ROUND OFF DECIMALS TO NEXT LARGER WHOLE NUMBER.

14 ALCOA FASTENING SYSTEMS (TEMPLE), (FORMERLY FAIRCHILD – TEMPLE) IS NO LONGER IN BUSINESS. PARTS MANUFACTURED AT THAT FACILITY UNDER EITHER NAME (CAGE CODE 06950) PRIOR TO SEPTEMBER 1, 2006, MAY BE PROCURED AND USED BY BOEING AND ITS SUBCONTRACTORS UNTIL JUNE 1, 2010, PROVIDED THE ORIGINAL ALCOA FASTENING SYSTEMS (TEMPLE) DATA CERTIFICATIONS ACCOMPANY ALL SHIPMENTS ALONG WITH AN ALCOA FASTENING SYSTEMS CITY OF INDUSTRY, (UNRUH) CERTIFICATE OF CONFORMITY.

15 FAIRCHILD FASTENERS (UNRUH) IS NOW ALCOA FASTENING SYSTEMS – INDUSTRY (UNRUH). THIS CHANGE WAS A NAME CHANGE ONLY. STOCK MANUFACTURED UNDER THE FAIRCHILD NAME MAY BE PROCURED AND USED UNTIL DEPLETED.

16 P B FASTENERS (CAGE CODE 27624) IS NO LONGER AN APPROVED SUPPLIER OF THIS PRODUCT. BOLTS MANUFACTURED BEFORE DECEMBER 4, 2002 FROM THE 1700 W. 132ND STREET, GARDENA CA FACILITY MAY BE RECEIVED UNTIL SUPPLIES ARE EXHAUSTED.

PROCUREMENT SPECIFICATION

BPS–F–69, CLASS 125SC6.

MATERIAL

PH13–8 Mo PER AMS 5629 (UNS S13800).

FINISH

PASSIVATE PER AMS 2700, METHOD 1, TYPE 2 OR TYPE 8.

SURFACE TEXTURE

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

HEAD MARKING

BOEING BASIC PART NUMBER, APPLICABLE FIRST DASH NUMBER AND MANUFACTURER'S TRADEMARK RAISED OR DEPRESSED .010 MAXIMUM. LOCATION OPTIONAL. LETTER "C" SHALL BE INCLUDED WHEN PH13–8 Mo MATERIAL IS USED.

PROCUREMENT 16

AIR INDUSTRIES CORP (CAGE CODE 06725)

ALCOA FASTENING SYSTEMS – INDUSTRY (TEMPLE) (CAGE CODE 06950) 14

ALCOA FASTENING SYSTEMS – INDUSTRY (UNRUH) (CAGE CODE 1RC86) 15

FAIRCHILD FASTENERS, CHATSWORTH OPERATIONS (CAGE CODE 9N513) 11

HUCK INTERNATIONAL INC, LAKEWOOD OPERATIONS (CAGE CODE 97928) 12

SPS TECHNOLOGIES, AEROSPACE PRODUCTS DIV (CAGE CODE 56878)

VALLEY–TODECO INC (CAGE CODE 06710)

THE MANUFACTURERS LISTED IN BPS–F–69SUP AND THEIR AUTHORIZED DISTRIBUTORS ARE THE ONLY APPROVED SOURCES FOR THE ABOVE QUALIFIED PRODUCTS. SEE BPS–F–69SUP 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.

USAGE AND APPLICATION INFORMATION

FOR USE IN APPLICATIONS THAT CAN UTILIZE 125 KSI SHEAR STRENGTH AT ROOM TEMPERATURE OR APPROXIMATELY 80 KSI AT 900 F. IT IS RECOMMENDED THAT BACB30DM BOLTS BE INSTALLED WITH LOW HEIGHT A286 NUTS, SUCH AS SHOWN ON BACN10JC. THESE NUTS WILL DEVELOP AT LEAST 125 KSI TENSILE IN BACB30DM BOLTS AT ROOM TEMPERATURE. THE BOLTS ARE PROVIDED WITH GREATER THREAD LENGTH THAN GENERALLY REQUIRED FOR LOW HEIGHT NUTS. THIS WAS DONE TO ALLOW SUFFICIENT THREADS FOR EXTREME VARIATIONS IN THICKNESS OF BOLTED MATERIAL AND TO PROVIDE SUFFICIENT BOLT THREAD TO ACCOMMODATE HIGHER NUTS. IF NUTS ARE DEVELOPED WHICH WILL CARRY THE FULL TENSILE STRENGTH OF THESE BOLTS THE NUTS WILL UNDOUBTEDLY HAVE GREATER HEIGHT THAN THOSE RECOMMENDED ABOVE. WHERE TEMPERATURES DO NOT EXCEED 450 F, THESE BOLTS MAY BE USED WITH STANDARD CADMIUM PLATED NUTS (450 F).

FOR STATUS OF INACTIVATION
SEE APPLICABILITY BLOCK

CODING

FIRST DASH NUMBER DESIGNATES NOMINAL THREAD SIZE PER TABLE I.

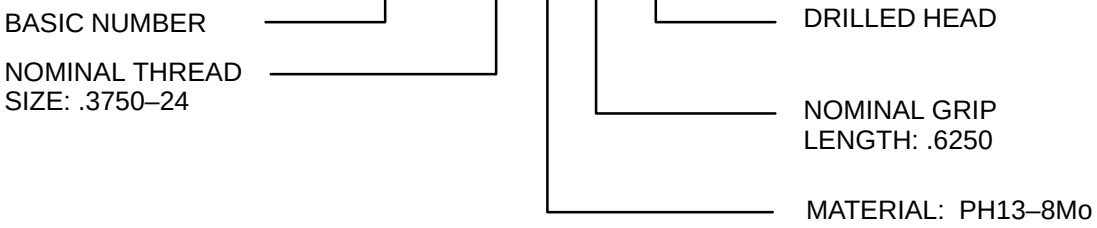
LETTER “C” FOLLOWING FIRST DASH NUMBER DESIGNATES PH13–8 Mo MATERIAL.

SECOND DASH NUMBER DESIGNATES NOMINAL GRIP LENGTH IN .0625 INCREMENTS. 13

LETTER “D” FOLLOWING SECOND DASH NUMBER DESIGNATES DRILLED SHANK.

LETTER “H” FOLLOWING SECOND DASH NUMBER DESIGNATES DRILLED HEAD.

BACB30DM 6 C 10 H (DRAWING CALLOUT WILL APPEAR AS BACB30DM6C10H)



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

INACTIVATION APPLICABILITY

BCA – BACB30DM IS INACTIVE FOR NEW DESIGN. SEE BACB30UU.

BACB30DM(3 THRU 6)–( )(NO CODE, D, H, DH) (PH15–7Mo) ARE INACTIVE FOR DESIGN AND PROCUREMENT.
BACB30DM(3 THRU 6)C( )(NO CODE, D, H, DH) ARE CLASS II SUPERSESSIONS.

IDS – BACB30DM IS INACTIVE FOR DESIGN AND PROCUREMENT.
NO SUPERSEDING PARTS.

DATE 06–MAR–1958 REV (K) 06–FEB–2008

CAGE CODE 81205

BOLT, HEX HEAD, 125 KSI SHEAR, CRES, LONG THREAD

BACB30DM SH 5