

FOR STATUS OF INACTIVATION
SEE APPLICABILITY BLOCK

TABLE I 1

BOEING STANDARD NUMBER BACB30CT 7	Ø A TO SHARP CORNER 3	Ø A' MIN 3	B MAX 3	Ø C REF	Ø D	E MAX	Ø F MAX	H 6 GAGE PROTRUSION	
								NOM	± TOL
6	.305	.262	.043	.164	.2025 .2010	.013	.183	.0230	.0020
8	.399	.346	.057	.224	.2650 .2635	.017	.243	.0255	.0023
10	.479	.417	.064	.268	.3275 .3260	.020	.299	.0280	.0025
12	.566	.496	.075	.339	.3900 .3885	.023	.359	.0305	.0028

TABLE I (CONTINUED) 1

BOEING STANDARD NUMBER BACB30CT 7	Ø J	K MAX	Ø M	Ø Q	R RAD	Ø S	U RAD MAX	Ø W GAGE +.0002 -.0000
6	.2045 .2010	.031	.151 .143	.185 .177	.015 .008	.2025 .2000	.020	.2438
8	.2670 .2635	.042	.201 .190	.246 .235	.020 .010	.2650 .2625	.020	.3312
10	.3295 .3260	.052	.247 .236	.298 .290	.025 .010	.3275 .3250	.025	.4045
12	.3920 .3885	.062	.300 .290	.369 .357	.030 .010	.3900 .3875	.025	.4852

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

CAGE CODE 81205

BACB30CT

SH 2

BOLT,
LOCK, 100 DEGREE HEAD, SHEAR,
.0156 OVERSIZE, PULL TYPE, GUN
DRIVEN

BACB30CT

SH 2

FOR STATUS OF INACTIVATION
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TABLE II 9

SECOND DASH NO.	MAX GRIP	STRUCTURE THICKNESS		G ± .010 8	Ø .190	
		MIN	MAX		L ± .005	P +.20 -.00
2	.125	.062	.125	.125	.319	1.38
3	.188	.126	.188	.188	.381	1.50
4	.250	.189	.250	.250	.444	1.62
5	.312	.251	.312	.312	.506	1.75
6	.375	.313	.375	.375	.569	1.88
7	.438	.376	.438	.438	.631	2.00
8	.500	.439	.500	.500	.694	2.12
9	.562	.501	.562	.562	.756	2.25
10	.625	.563	.625	.625	.819	2.38
11	.688	.626	.688	.688	.881	2.50
12	.750	.689	.750	.750	.944	2.62
13	.812	.751	.812	.812	1.006	2.75
14	.875	.813	.875	.875	1.069	2.88
15	.938	.876	.938	.938	1.131	3.00
16	1.000	.939	1.000	1.000	1.194	3.12
17	1.062	1.001	1.062	1.062	1.256	3.12
18	1.125	1.063	1.125	1.125	1.319	3.12
19	1.188	1.126	1.188	1.188	1.381	3.12
20	1.250	1.189	1.250	1.250	1.444	3.12
21	1.312	1.251	1.312	1.312	1.506	3.12
22	1.375	1.313	1.375	1.375	1.569	3.12
23	1.438	1.376	1.438	1.438	1.651	3.12
24	1.500	1.439	1.500	1.500	1.694	3.12
25	1.562	1.501	1.562	1.562	1.756	3.12
26	1.625	1.563	1.625	1.625	1.819	3.12
27	1.688	1.626	1.688	1.688	1.881	3.12
28	1.750	1.689	1.750	1.750	1.944	3.12
29	1.812	1.751	1.812	1.812	2.006	3.12
30	1.875	1.813	1.875	1.875	2.069	3.12
31	1.938	1.876	1.938	1.938	2.131	3.12
32	2.000	1.939	2.000	2.000	2.194	3.12

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BACB30CT

SH 3

BOLT,
LOCK, 100 DEGREE HEAD, SHEAR,
.0156 OVERSIZE, PULL TYPE, GUN
DRIVEN

BACB30CT

SH 3

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TABLE II (CONTINUED) 9

SECOND DASH NO.	Ø.250		Ø.312		Ø.375	
	L ± .005	P +.20 -.00	L ± .005	P +.20 -.00	L ± .005	P +.20 -.00
2	.371	1.78	---	---	---	---
3	.433	1.91	.458	1.81	.509	1.94
4	.496	2.03	.521	1.94	.572	2.06
5	.558	2.16	.583	2.06	.634	2.19
6	.621	2.28	.646	2.19	.697	2.31
7	.683	2.41	.708	2.31	.759	2.44
8	.746	2.53	.771	2.44	.822	2.56
9	.808	2.66	.833	2.56	.884	2.69
10	.871	2.78	.896	2.69	.947	2.81
11	.933	2.91	.958	2.81	1.009	2.94
12	.996	3.03	1.021	2.94	1.072	3.06
13	1.058	3.16	1.083	2.94	1.134	3.06
14	1.121	3.16	1.146	2.94	1.197	3.06
15	1.183	3.16	1.208	2.94	1.259	3.06
16	1.246	3.16	1.271	2.94	1.322	3.06
17	1.308	3.16	1.333	2.94	1.384	3.06
18	1.371	3.16	1.396	2.94	1.447	3.06
19	1.433	3.16	1.458	2.94	1.509	3.06
20	1.496	3.16	1.521	2.94	1.572	3.06
21	1.558	3.16	1.583	2.94	1.634	3.06
22	1.621	3.16	1.646	2.94	1.697	3.06
23	1.683	3.16	1.708	2.94	1.759	3.06
24	1.746	3.16	1.771	2.94	1.822	3.06
25	1.808	3.16	1.833	3.00	1.884	3.12
26	1.871	3.16	1.896	3.06	1.947	3.19
27	1.933	3.22	1.958	3.12	2.009	3.25
28	1.996	3.28	2.021	3.19	2.072	3.31
29	2.058	3.34	2.083	3.25	2.134	3.38
30	2.121	3.41	2.146	3.31	2.197	3.44
31	2.183	3.47	2.208	3.38	2.259	3.50
32	2.246	3.53	2.271	3.44	2.322	3.56

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BACB30CT

SH 4

**BOLT,
LOCK, 100 DEGREE HEAD, SHEAR,
.0156 OVERSIZE, PULL TYPE, GUN
DRIVEN**

BACB30CT

SH 4

FOR STATUS OF INACTIVATION
SEE APPLICABILITY BLOCK

NOTES

- 1 SEE TABLE II FOR "G", "L" AND "P" DIMENSIONS.
- 2 WHEN USED TO REPLACE STUMP TYPE LOCK BOLTS, BACB30CT MUST BE CUT AT BREAK NECK GROOVE PRIOR TO INSTALLATION.
- 3 DIMENSIONS "A", "A' ", AND "B" ARE FOR ENGINEERING REFERENCE ONLY, NOT FOR INSPECTION. VALUES ARE CALCULATED LIMITS RESULTING FROM TOLERANCES ON D, W, H, E, AND HEAD ANGLE.
- 4 SHANK TAPER ALLOWED: "J" MAXIMUM DIAMETER FOR "K" LENGTH UNDER HEAD; "S" DIAMETER FOR "K" LENGTH AT END OF SHANK; "D" DIAMETER FOR REMAINDER OF SHANK.
- 5 TAPER AND LOCKING GROOVE ANGLES AT END OF SHANK NEED NOT BLEND. SLIGHT HOOK AT JUNCTURE OF ANGLES NORMAL TO COLD ROLLING IS PERMISSIBLE.
- 6 INSPECT GAGE PROTRUSION "H" AT GAGE DIAMETER "W" PER D-11805.
- 7 FOR COMPLETE BOEING PART NUMBER, SEE CODING SECTION.
- 8 MEASURE GRIP LENGTH FROM TOP OF HEAD TO END OF FULL CYLINDRICAL PORTION OF SHANK.
- 9 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.
- 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.

PROCUREMENT SPECIFICATION

BPS-F-46, EXCEPT AS NOTED.

MATERIAL

ALLOY STEEL – AISI 4037, 4140, 4340, OR 8740 PER AMS-STD-66

HEAT TREATMENT

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

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BACB30CT

SH 5

**BOLT,
LOCK, 100 DEGREE HEAD, SHEAR,
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DRIVEN**

BACB30CT

SH 5

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FINISH

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

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.

HEAD MARKING

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

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.

THIS IS A MANUFACTURER–DESIGNED PRODUCT. BOEING MAKES NO REPRESENTATION WHATEVER REGARDING PATENT OR ANY OTHER RIGHTS AFFECTING THE PRODUCT. THE LISTING OF ANY SUPPLIER DOES NOT IMPLY ANY DETERMINATION BY THE BOEING COMPANY OR BY ANY OTHER LISTED MANUFACTURER, AS TO THE RIGHTS OF SUCH MANUFACTURER.

RECOMMENDED PROCUREMENT PRACTICE:

REDUCE INVENTORIES AND FACILITATE PROCUREMENT BY PURCHASING OVERSIZE LOCKBOLTS IN GRIP DIMENSIONS DESIGNATED BY EVEN DASH NUMBER 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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BACB30CT

SH 6

**BOLT,
LOCK, 100 DEGREE HEAD, SHEAR,
.0156 OVERSIZE, PULL TYPE, GUN
DRIVEN**

BACB30CT

SH 6

FOR STATUS OF INACTIVATION
SEE APPLICABILITY BLOCK

USAGE AND APPLICATION INFORMATION

THIS STANDARD IS INTENDED AS .0156 OVERSIZE REPLACEMENT FOR BACB30GY AND BACB30AT.

CODING

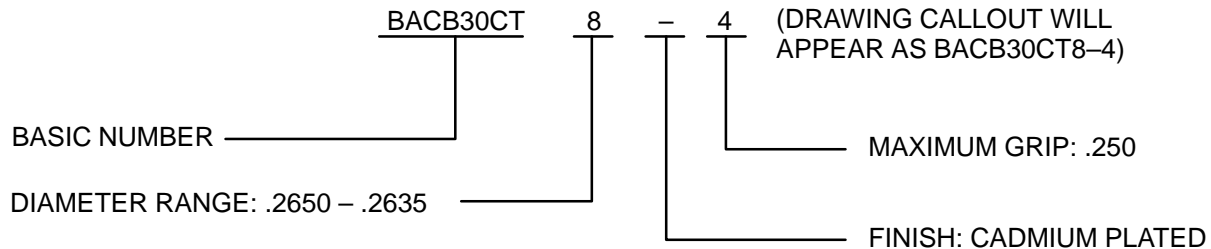
FIRST DASH NUMBER INDICATES DIAMETER RANGE PER TABLE I.

A DASH (“-”) FOLLOWING THE FIRST DASH NUMBER DESIGNATES CADMIUM PLATE EXCEPT WHEN CODE “N” IS USED.

SECOND DASH NUMBER INDICATES MAXIMUM GRIP PER TABLE II.

LETTER “N” FOLLOWING THE SECOND DASH NUMBER DESIGNATES CADMIUM-NICKEL PLATE.

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.

INACTVATION APPLICABILITY

BCA – BACB30CT IS INACTIVE FOR DESIGN AND PROCUREMENT. NO SUPERSEDING STANDARD. SEE BACB30FQ.

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BACB30CT

SH 7

**BOLT,
LOCK, 100 DEGREE HEAD, SHEAR,
.0156 OVERSIZE, PULL TYPE, GUN
DRIVEN**

BACB30CT

SH 7