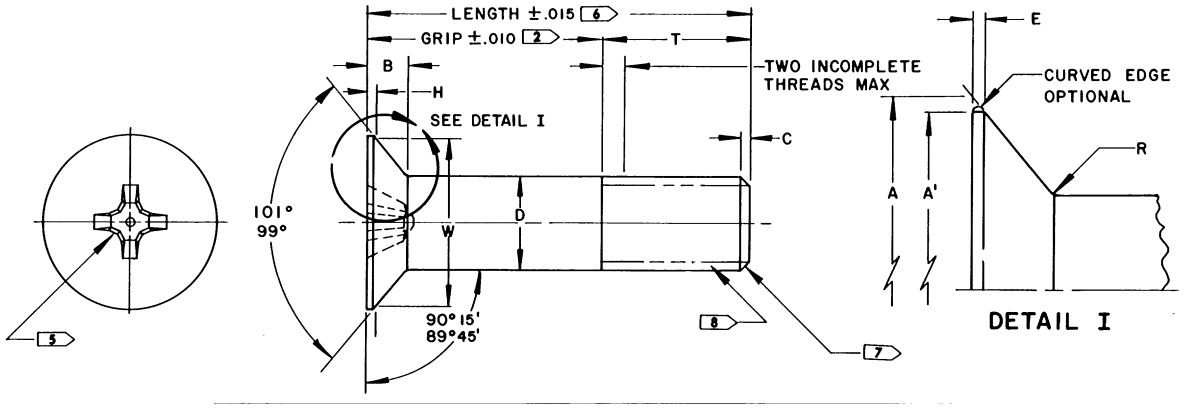


BOEING PART NUMBER BACB30BF 10 2	NOM THREAD SIZE	A DIA TO SHARP CORNER MAX 1	A'DIA ABS MIN 1	B HEAD HEIGHT MAX 1	C		D 9 DIA		E LAND WIDTH
					MAX	MIN	MAX	MIN	
3	.1900–32	.387	.332	.085	.047	.015	.189	.186	.016
4	.2500–28	.510	.446	.111	.047	.015	.249	.246	.018
5	.3125–24	.638	.567	.139	.062	.031	.312	.309	.020
6	.3750–24	.766	.685	.167	.062	.031	.374	.371	.023
7	.4375–20	.894	.804	.195	.062	.031	.437	.433	.026
8	.5000–20	1.022	.918	.223	.062	.031	.499	.495	.030
9	.5625–18	1.151	1.034	.251	.078	.047	.562	.558	.034

(CONTINUED)

BOEING PART NUMBER BACB30BF 10 2	H GAGE PROTRUSION		R RAD		T REF	W GAGE DIA +.0002 –.0000 3
	NOM	± TOL	MAX	MIN		
3	.0214	.0034	.030	.015	.406	.3270
4	.0282	.0039	.030	.015	.469	.4318
5	.0340	.0044	.040	.015	.531	.5449
6	.0395	.0050	.040	.015	.641	.6580
7	.0423	.0054	.050	.015	.656	.7782
8	.0481	.0061	.050	.015	.781	.8900
9	.0542	.0067	.050	.015	.906	1,0026

(CONTINUED)

BOEING PART NUMBER BACB30BF 10 2	INSPECTION TEST VALUES (MIN. LBS.) 4					
	AMS5721 (19–9 DL)		AMS5735 (A286)		QQ–C–530 (CU–BE) QQ–N–286 (K–MONEL)	
	TENSILE 120 KSI	DOUBLE SHEAR 72 KSI	TENSILE 130 KSI	DOUBLE SHEAR 78 KSI	TENSILE 140 KSI	DOUBLE SHEAR 75 KSI
3	2,380	4,080	2,590	4,410	2,790	4,250
4	4,340	7,070	4,710	7,650	5,070	7,360
5	6,940	11,000	7,530	11,970	8,110	11,500
6	10,500	15,900	11,400	17,200	12,300	16,500
7	14,200	21,600	15,400	23,400	16,600	22,500
8	19,100	28,300	20,800	30,600	22,400	29,400
9	24,300	35,800	26,300	38,800	28,400	37,400

NOTES

1 DIMENSIONS A, AND A′ AND B ARE INCLUDED FOR ENGINEERING REFERENCE PURPOSES ONLY AND ARE NOT TO BE USED FOR INSPECTION PURPOSES. VALUES A, A′ AND B ARE CALCULATED LIMITS RESULTING FROM TOLERANCES ON W, H, E, D AND HEAD ANGLE.

2 THE NUMBER DESIGNATING GRIP EQUALS REQUIRED GRIP LENGTH DIVIDED BY .0625–INCH.

GRIP LENGTH IS MEASURED FROM THE TOP OF THE HEAD TO THE END OF THE FULL CYCLINDRICAL PORTION OF SHANK.

3 DIMENSIONS FOR GAGE PROTRUSION (H) SHALL BE INSPECTED IN ACCORDANCE WITH BOEING DOCUMENT D–11805.

4 ULTIMATE TENSILE STRENGTH – VALUES CALCULATED FROM BASIC STRENGTH AND STRESS AREA OF THREAD PER H28.

ULTIMATE DOUBLE SHEAR – MIN VALUES WHEN TESTED IN JIG PER D2–2860 VALUES ARE CALCULATED FROM BASIC SHEAR STRENGTH AND NOM. SHANK AREA.

5 PHILLIPS RECESS PER MS9006. SEE INACTIVATION NOTE UNDER USAGE AND APPLICATION INFORMATION.

6 NOMINAL LENGTH EQUALS NOMINAL GRIP PLUS “T”.

7 BREAK EDGES ROLLED OR CUT CHAMFER OPTIONAL.

8 UNF–3A THREADS PER MIL–S–8879. SEE INACTIVATION NOTE UNDER USAGE AND APPLICATION INFORMATION.

9 CONCENTRICITY – CONICAL SURFACE OF HEAD TO “D” DIA WITHIN .003 TIR.

10 SEE CODING UNDER USAGE AND APPLICATION INFORMATION.

PROCUREMENT SPECIFICATION

MIL–S–7839 AS APPLICABLE. AMS7479 SHALL APPLY TO CRES BOLTS EXCEPT MATERIAL IS LIMITED TO AMS5735.

MATERIAL

NO LETTER	–	STEEL, CORROSION AND HEAT RESISTANT PER SPECIFICATION AMS5721 (19–9DL) OR AMS5735 (A286).
K	–	COPPER–BERYLLIUM PER SPECIFICATION QQ–C–530, CONDITION A, OR K MONEL PER SPECIFICATION QQ–N–286, CLASS A.
C	–	CORROSION AND HEAT RESISTANT STEEL (A286) PER AMS5735, THREADS ROLLED AFTER AGING.

HEAT TREATMENT

(AFTER HEADING):

COPPER BERYLLIUM	–	600°F ± 5°F FOR 3 HOURS MINIMUM TENSILE STRESS 140,000 PSI.
K MONEL	–	1080°F ± 10°F FOR 8 HOURS MINIMUM TENSILE STRESS 140,000 PSI.

FINISH

STEEL	–	NONE
COPPER–BERYLLIUM AND K MONEL	–	CADMIUM PLATE PER SPECIFICATION QQ–P–416, TYPE I, CLASS 3.

SURFACE TEXTURE

(AA MAX PER ASA B46.1) SHANK AND BEARING SURFACE OF HEAD 63, ALL OTHER SURFACES 125.

HEAD MARKING

BACB30BF PLUS NUMBER DESIGNATING NOMINAL DIAMETER AND VENDORS SYMBOL, PLUS MATERIAL CODE LETTER. DEPRESSED .010 MAX, ARRANGEMENT OPTIONAL.

PROCUREMENT

MAY BE PROCURED FROM ANY AVAILABLE SATISFACTORY SOURCE.

USAGE AND APPLICATION INFORMATION

CORROSION AND HEAT RESISTANT STEEL BOLTS MAY BE USED IN ELEVATED TEMPERATURE APPLICATION. COPPER BERYLLIUM OR K MONEL BOLTS ARE INTENDED FOR APPLICATIONS REQUIRING BOLTS OF LOW MAGNETIC PERMEABILITY.

CODING

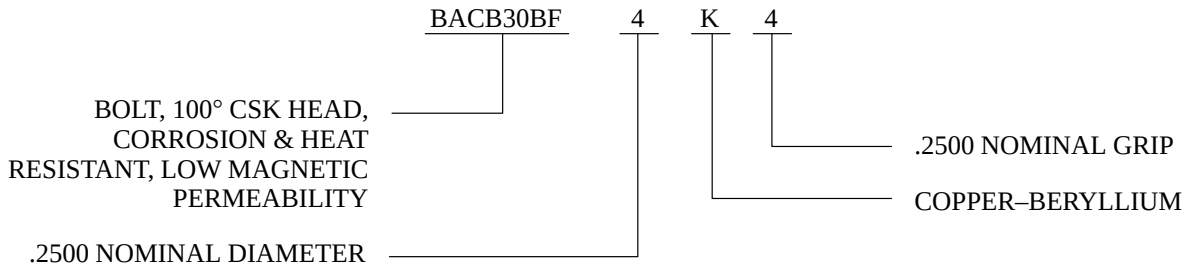
THE FIRST NUMBER DESIGNATES NOMINAL DIAMETER IN .0625–INCH INCREMENTS.

NO LETTER FOLLOWING FIRST NUMBER DESIGNATES STEEL, CORROSION AND HEAT RESISTANT PER AMS5721 (19–9DL) OR AMS5735 (A286).

LETTER “K” FOLLOWING FIRST NUMBER DESIGNATES COPPER–BERYLLIUM MATERIAL.

LETTER “C” FOLLOWING FIRST NUMBER DESIGNATES CORROSION AND HEAT RESISTANT STEEL (A286) PER AMS5735, THREADS ROLLED AFTER AGING.

EXAMPLE OF PART NUMBER



BCAC

BACB30BF BOLTS ARE INACTIVE PROCUREMENT AFTER 1 JUL 67. SEE D–590 SUBSTITUTION LIST.

BMAC

SEE BACB30LR FOR BOLTS WHICH MAY BE PROCURED AND USED IN LIEU OF BACB30BF BOLTS.

SEE D–590 INDEX BOOK FOR GENERAL INFORMATION ON THE USE OF PART STANDARDS (PREFACE AND NOTICES), AND FOR SUBSTITUTION CLASS DEFINITION (SUBSTITUTION LIST).