



Howmet Fastening Systems
Tucson Operations
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Tucson, Arizona 85714 USA
Phone (520) 519-7400
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Ergo-Tech®
BLIND BOLT
ENGINEERING
STANDARD

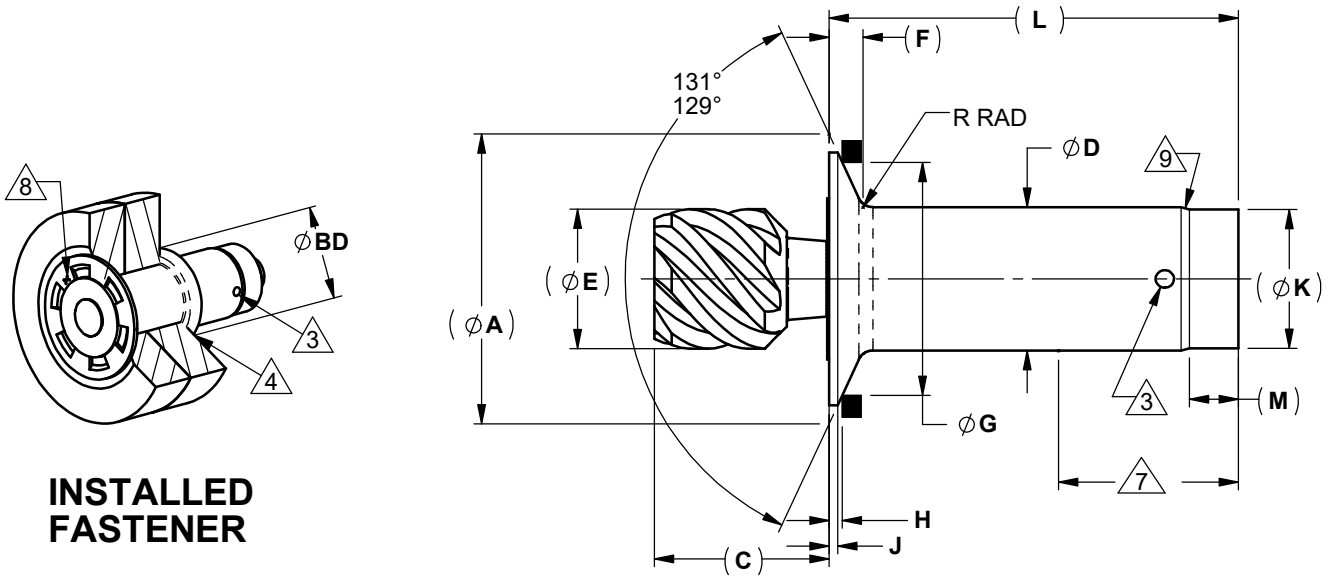


TABLE I

PART/DIA DASH NO.	Ø A THEO INTER REF	J MAX	(C) DRIVER LENGTH REF	Ø D SHANK	(Ø E) SPLINE REF	(F) HEAD HEIGHT REF	R RADIUS MAX	Ø G GAUGE	H GAUGE HEIGHT	SINGLE SHEAR LBS (MIN)	TENSILE LBS (MIN)	(Ø K) LEAD-IN	(M) REF	Ø BD MIN.		RECOMMENDED INSTALLATION HOLE SIZES
														5	EXTENDED GRIP	
ER2315-05	.3351	.012	.250	.1635 .1625	.180	.041	.025	.2560 .2558	.0200 .0170	2005	1400	.157	.060	.205		.167 .164
ER2315-06	.3868	.015	.250	.1895 .1885	.180	.047	.030	.2982 .2980	.0222 .0192	2690	1600	.183	.065	.238		.193 .190
ER2315-08	.5068	.015	.300	.2495 .2485	.235	.061	.030	.4050 .4048	.0253 .0223	4650	3000	.243	.085	.313		.253 .250

DIMENSIONS IN INCHES

AD	ECN 15318 ER2315-05 ADDITION		Current Design Activity CAGE Code OHDW7		PROCUREMENT SPEC T0108	DRAWN BY J. SCHLOBOHM	CHECKED BY SIGNATURE ON FILE
	ISSUED 11/28/2007	BLIND BOLT FASTENER, HIGH STRENGTH, FRICTION THREAD LOCK, THREADED, 130° FLUSH SHEAR HEAD, CLOSE TOLERANCE SHANK, TITANIUM/A286 (95 KSI SHEAR)				ER2315	
REVISIED 04/21/2023					SK12825		
PAGE 1 OF 4							

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TABLE II

GRIP NUMBER TABULATION △10						
GRIP DASH NO.	DESIGN GRIP RANGE		OVERLAP MAX GRIP △6	-05 DIA	-06 DIA	-08 DIA
	MIN.	MAX.		(L)	(L)	(L)
△11 -02	.077	.125	.133	.451	-	-
-02	.084	.125	.133	-	.482	-
-03	.126	.187	.195	.513	.544	.649
-04	.188	.250	.258	.576	.607	.711
-05	.251	.312	.320	.638	.669	.774
-06	.313	.375	.383	.701	.732	.836
-07	.376	.437	.445	.763	.794	.899
-08	.438	.500	.508	.826	.857	.961
-09	.501	.562	.570	.888	.919	1.024
-10	.563	.625	.633	.951	.982	1.086
-11	.626	.687	.695	1.013	1.044	1.149
-12	.688	.750	.758	-	1.107	1.211
-13	.751	.812	.820	-	1.169	1.274
-14	.813	.875	.883	-	1.232	1.336
-15	.876	.937	.945	-	-	1.399

- △1 SINGLE SHEAR TESTING SHALL BE IN ACCORDANCE WITH THE REQUIREMENTS OF NASM 1312 -20 AND APPLIES TO GRIPS 05-05 MIN, 06-06 MIN, AND 08-07 MIN AND LONGER.
 TENSILE STRENGTH TESTING SHALL BE IN ACCORDANCE WITH THE REQUIREMENTS OF NASM 1312 - 8 AND APPLIES TO GRIPS 05-05 MAX, 06-07 MAX, AND 08-08 MAX AND LONGER.
- △2 DIMENSIONS ARE IN INCHES AND ARE TO BE MET AFTER FINISH.
- △3 3 INDENTATIONS 120° APART TO PROVIDE THREAD LOCK.
- △4 BLIND SIDE HEAD MAY BE INSTALLED ON 5° MAXIMUM SLOPE.
- △5 THE AVERAGE SMALLEST AND LARGEST OBSERVED VALUES ON THE SAME SPECIMEN SHALL BE EQUAL TO OR GREATER THAN THE STATED MINIMUM.
- △6 EXTENDED GRIP "BD MIN" VALUE APPLIES TO A PART DRIVEN .008" ±.002" OVER THE DESIGN MAXIMUM GRIP. SEE GRIP TABLE II ON PAGE 2.
- △7 SLEEVE DIA. MAY BE UP TO .0003" OVERSIZE IN BAND ANNEAL ZONE WHICH EXTENDS FROM BLIND END APPROX:- 06 DIA. (.525"), -08 DIA. (.635")

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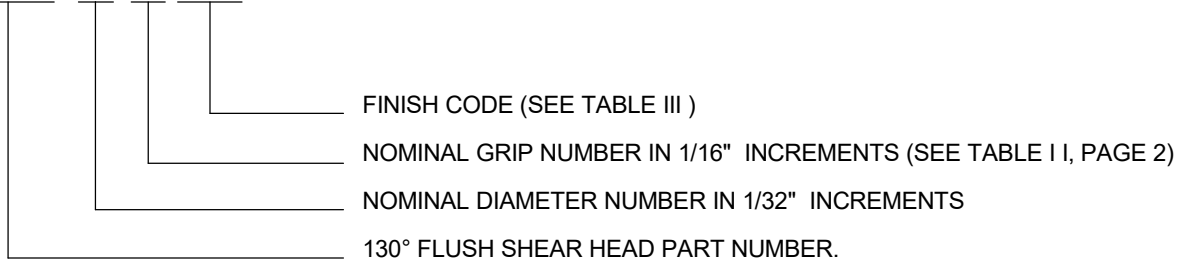
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TABLE III

FINISH CODE	MATERIAL		FINISH		PROCUREMENT SPECIFICATION
	NUT BODY	CORE BOLT	NUT BODY	CORE BOLT	
NONE	A286 CRES PER CHEMICAL COMPOSITION AMS 5737 OR AMS 5732	6Al-4V TITANIUM PER AMS 4967 OR AMS 4928	PASSIVATE PER AMS2700 TYPE 2 OR 8	INCOTEC TEC-LUBE DRY FILM LUBE PER AS5272 OR EQUIVALENT	T0108
D 12.			IVD ALUMINUM COAT PER MIL-DTL-83488, TYPE II, CLASS 3 AND EN6118		
AC 13. 16.			CHROMATED ALUMINUM PIGMENTED COATING PER NAS4006 AND EN4473		
ACN 14. 16.			NON-CHROMATED ALUMINUM PIGMENTED COATING PER NAS4006 AND EN4473		
ACP 12.			CHROMATED ALUMINUM PIGMENTED COATING PER NAS4006 AND EN4473 WITH INCOTECH WCA-9P (PINK)		
ACPD 12.			CHROMATED ALUMINUM PIGMENTED COATING PER NAS4006 AND EN4473 WITH INCOTECH WCA-9P (PINK)		T0108 AND DGQT 1.8.2.0028

NUMBER KEY:

ER2315 - XX - XX XXXX



- 12. THIS FINISH IS INACTIVE FOR NEW DESIGN AND PROCURMENT. NO SUPERSESSION AVAILABLE.
- 13. THIS FINISH IS INACTIVE FOR NEW DESIGN AND PROCURMENT AFTER 03/01/2022
- 14. THE ACN FINISH IS SUPERSESSION FOR THE AC FINISH CODE
- 15. NOTE: CETYL ALCOHOL LUBE PER AS87132 MAY BE APPLIED TO COMPONENTS (AT MFR'S OPTION)
- 16. NOTE: COMPLETE COVERAGE OF SLEEVE INTERNAL FEATURES IS NOT REQUIRED. OVERSPRAY ONTO THE INTERNAL FEATURES IS ACCEPTED

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	ISSUED 11/28/2007	REVISIED 04/21/2023	PAGE 3 OF 4	CHECKED BY SIGNATURE ON FILE
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TABLE IV

INSTALLED WEIGHT (LBS/1000)			
DIAMETER	GRIP	WEIGHT	ADDER
-05 (.164)	-02	2.04	.259
-06 (.190)	-02	2.91	.350
-08 (.250)	-02	6.12	.598

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