



Howmet Fastening Systems
 Tucson Operations
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 Tucson, Arizona 85714 USA
 Phone (520) 519-7400
 Fax (520) 519-7454

Ergo-Tech®
BLIND BOLT
ENGINEERING
STANDARD

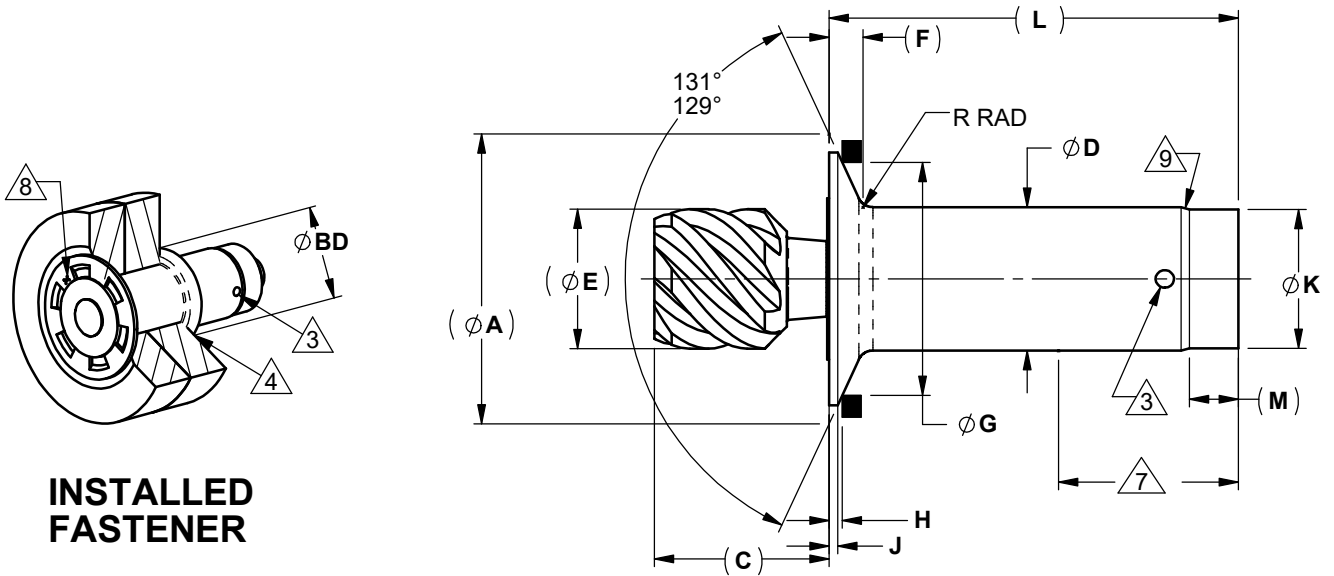


TABLE I

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	TENSILE	Ø K LEAD-IN	(M) REF	Ø BD MIN. EXTENDED GRIP	RECOMMENDED INSTALLATION HOLE SIZES
										SHEAR LBS (MIN)	LBS (MIN)				
ER2315-06	.3868	.015	.250	.1895 .1885	.180	.047	.025	.2982 .2980	.0222 .0192	2690	1600	.1830 .1804	.065	.238	.193 .190
ER2315-08	.5068	.015	.300	.2495 .2485	.235	.061	.025	.4050 .4048	.0253 .0223	4650	3000	.2430 .2404	.085	.313	.253 .250

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DIMENSIONS IN INCHES

AC	ECN 15069 TABLE REFORMATTING		Current Design Activity CAGE Code OHDW7		PROCUREMENT SPEC T0108	DRAWN BY J. SCHLOBOHM
	ISSUED 11/28/2007	REVISSED 05/15/2022	BLIND BOLT FASTENER, HIGH STRENGTH, FRICTION THREAD LOCK, THREADED, 130° FLUSH SHEAR HEAD, CLOSE TOLERANCE SHANK, TITANIUM/A286 (95 KSI SHEAR)			CHECKED BY SIGNATURE ON FILE
PAGE 1 OF 4					ER2315	
				SK12825		




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








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TABLE II

GRIP NUMBER TABULATION 					
GRIP DASH NO.	DESIGN GRIP RANGE		OVERLAP MAX GRIP 	-06 DIA	-08 DIA
	MIN.	MAX.		(L)	(L)
 -02	.084	.125	.133	.482	-
-03	.126	.187	.195	.544	.649
-04	.188	.250	.258	.607	.711
-05	.251	.312	.320	.669	.774
-06	.313	.375	.383	.732	.836
-07	.376	.437	.445	.794	.899
-08	.438	.500	.508	.857	.961
-09	.501	.562	.570	.919	1.024
-10	.563	.625	.633	.982	1.086
-11	.626	.687	.695	1.044	1.149
-12	.688	.750	.758	1.107	1.211
-13	.751	.812	.820	1.169	1.274

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

DIMENSIONS IN INCHES

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REVISED	05/15/2022				SK12825	
PAGE	2 OF 4					

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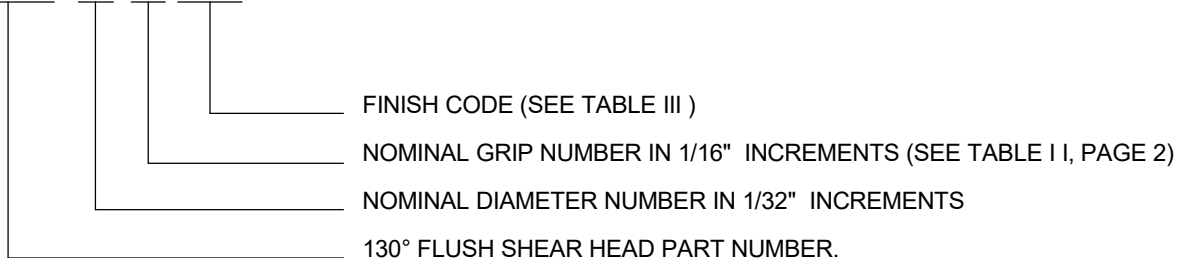
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TABLE III

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 SUPERSESSON AVAILABLE.
- 13. THIS FINISH IS INACTIVE FOR NEW DESIGN AND PROCURMENT AFTER 03/01/2022
- 14. THE ACN FINISH IS SUPERSESSON 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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TABLE IV

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

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