

FED. SUPPLY CLASS

5320

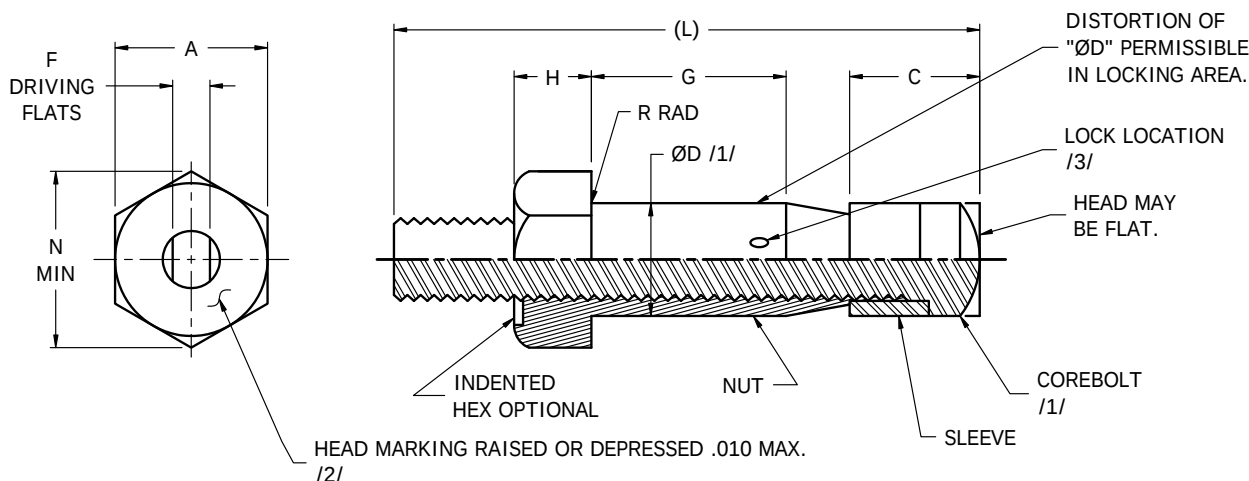


FIGURE 1 – BLIND FASTENER

TABLE I – SIZES AND DIMENSIONS

DASH NO.	NOM DIA	A	C MAX	ØD	F DRIVING FLATS	H MAX	ØJ MAX	K MAX	N MIN	R RAD	DOUBLE SHEAR STRENGTH LBF MIN	TENSILE STRENGTH LBF MIN
5	.1635	.244 .250	.287	.1645 .1625	.086 .081	.096	.244	.257	.272	.025 .020	4,680	1,350
6	.1980	.312 .305	.326	.1990 .1970	.104 .099	.113	.300	.288	.340	.030 .020	6,900	2,100
8	.2590	.375 .429	.360	.2600 .2580	.135 .130	.135	.384	.320	.409	.035 .030	11,800	3,650
10	.3105	.437 .429	.440	.3115 .3095	.152 .147	.160	.427	.396	.479	.045 .035	17,000	5,200
12	.3735	.500 .491	.539	.3745 .3725	.185 .180	.190	.516	.473	.548	.045 .035	24,500	7,500

MATERIAL:

NUT & COREBOLT: 5% CHROME STEEL – H-11 (UNS T20811) PER AMS6487.

SLEEVE: NICKEL ALLOY – X-750 (UNS N07750) PER AMS5667 OR AMS5582, OR A286 (UNS S66286) PER AMS5732, AMS5737 OR AMS5731.

HEAT TREATMENT:

NUT & COREBOLT: 48-53 HRC.

① COMPLETELY REVISED

THE INITIAL RELEASE OF THIS DOCUMENT SUPERSEDES MIL-F-81177/3. PART NUMBERS REMAIN M81177/3.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
PROCUREMENT SPECIFICATION NASM81177	TITLE FASTENERS, BLIND, HIGH STRENGTH, INSTALLATION FORMED, THREADED, SELF-LOCKING, PROTRUDING HEAD, 450 °F, ALLOY STEEL, 112 KSI Fsu	CLASSIFICATION PART STANDARD NASM81177/3 SHEET 1 OF 3

FINISH:

NUT & COREBOLT: CADMIUM PLATE PER NAS672 WITH SUPPLEMENTARY CHROMATE TREATMENT PER AMS-QQ-P-416 COLOR NUT BLACK.
SLEEVE: CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 2.

LUBRICATION:

LUBRICANT LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE.
CETYL ALCOHOL PER AS87132, LAURIC ACID, WWM CARBO-WAX, DRY FILM LUBE AS5272, TYPE I.

EXAMPLE OF PART NUMBER:

M81177/3-XX-XX

GRIP LENGTHS IN 16THS (SEE TABLE II)

BODY DIAMETER IN 32NDS (SEE TABLE I)

BASIC PART NUMBER

NOTES:

- /1/ OUTSIDE DIAMETER OF HEAD OF COREBOLT AND OUTSIDE DIAMETER OF SLEEVE SHALL BE NOT GREATER THAN MAXIMUM "ØD".
- /2/ HEAD MARKING SHALL CONSIST OF THE MANUFACTURER'S IDENTIFICATION AND THE NUMERALS "250".
- /3/ LOCKING FEATURE SHALL BE VISIBLE IN THIS AREA.
- (4) DESIGN AND USAGE LIMITATIONS – THESE BLIND FASTENERS SHALL BE USED IN ACCORDANCE WITH THE LIMITATIONS OF NASM81177/1.
- (5) TOOLING FOR INSTALLATION PER NASM81177 – APPENDIX B.
- (6) DIMENSIONS IN INCHES AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- (7) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (8) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (9) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- (10) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

① COMPLETELY REVISED

REVISION
1
NASM81177/3
SHEET 2



Documents

Document Sharing Hub