

PART NUMBER	A DIA. REF.		A' DIA. MIN.		D DIA.		E DIA. MAX.		F WRENCH FLATS		G REF.		H REF.		L REF.		R RAD. MAX.		S MAX.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
MBF2013-5-()	.332 .325	8.43 8.25	.296	7.52	.1640 .1625	4.166 4.127	.1640	4.166	.085 .080	2.16 2.03	.017	0.43	.039	0.99	.450	11.43	.030	0.76	.009	0.229
MBF2013-6-()	.385 .378	9.78 9.60	.342	8.69	.1985 .1965	5.042 5.000	.1985	5.042	.113 .108	2.87 2.74	.027	0.68	.043	1.09	.558	14.17	.030	0.76	.011	0.279
MBF2013-7-()	.416 .409	10.57 10.39	.373	9.47	.2275 .2260	5.779 5.740	.2275	5.778	.121 .116	3.07 2.95	.035	0.89	.043	1.09	.650	16.51	.030	0.76	.011	0.279
MBF2013-8-()	.507 .499	12.88 12.67	.463	11.76	.2595 .2580	6.592 6.553	.2595	6.591	.135 .130	3.43 3.30	.055	1.40	.057	1.45	.692	17.58	.030	0.76	.011	0.279
MBF2013-9-()	.538 .530	13.66 13.46	.494	12.55	.2895 .2880	7.354 7.315	.2895	7.353	.152 .147	3.86 3.73	.065	1.65	.057	1.45	.815	20.70	.030	0.76	.011	0.279
MBF2013-10-()	.635 .626	16.13 15.90	.577	14.66	.3110 .3095	7.900 7.861	.3110	7.899	.152 .147	3.86 3.73	.070	1.78	.075	1.90	.892	22.66	.040	1.02	.014	0.356
MBF2013-11-()	.666 .657	16.92 16.69	.608	15.44	.3433 .3418	8.720 8.681	.3433	8.720	.185 .180	4.70 4.57	.075	1.90	.074	1.88	.941	23.90	.040	1.02	.015	0.381
MBF2013-12-()	.762 .752	19.35 19.10	.696	17.68	.3740 .3725	9.500 9.461	.3740	9.500	.185 .180	4.70 4.57	.080	2.03	.089	2.26	1.090	27.69	.040	1.02	.016	0.406

PART NUMBER	MIN AVAILABLE GRIP DASH NO.	INSTALLED DIMENSIONS						MECHANICAL PROPERTIES						V GAGE PROTRUSION		Ø W GAGE			
		RECOMMENDED HOLE SIZE		Ø J MIN.		K MAX.		BREAK-OFF LIMITS		TENSILE STRUCTURAL FAILURE MIN.		DOUBLE SHEAR MIN.						LOCKING TORQUE MIN.	
		INCH	mm	INCH	mm	INCH	mm	INCH	mm	LBS	N	LBS	N	IN-LBS	N-m	INCH	mm	INCH	mm
MBF2013-5-()	-150	.168 .165	4.27 4.19	.250	6.35	.300	7.62	+1.03 -0.00	+2.62 -0.00	900	4000	3150	14010	1.0	0.113	.0115 .0095	0.292 0.241	.2832 .2830	7.193 7.188
MBF2013-6-()	-150	.202 .199	5.13 5.05	.300	7.62	.350	8.89	+1.03 -0.00	+2.62 -0.00	1400	6230	4600	20460	1.5	0.170	.0140 .0114	0.356 0.289	.3272 .3270	8.311 8.306
MBF2013-7-()	-150	.231 .228	5.88 5.79	.350	8.89	.400	10.16	+1.03 -0.00	+2.62 -0.00	1600	7120	6050	26910	2.0	0.226	.0202 .0176	0.513 0.447	.3315 .3313	8.420 8.415
MBF2013-8-()	-150	.263 .260	6.68 6.60	.400	10.16	.450	11.43	+1.03 -0.00	+2.62 -0.00	2100	9340	7900	35140	2.5	0.282	.0180 .0151	0.457 0.384	.4320 .4318	10.973 10.968
MBF2013-9-()	-150	.293 .290	7.44 7.37	.450	11.43	.500	12.70	+1.03 -0.00	+2.62 -0.00	2600	11565	9800	43590	3.0	0.339	.0247 .0224	0.627 0.569	.4320 .4318	10.973 10.968
MBF2013-10-()	-200	.315 .312	8.00 7.92	.475	12.06	.550	13.97	+1.03 -0.00	+2.62 -0.00	3600	16010	11350	50480	3.5	0.400	.0227 .0201	0.577 0.511	.5389 .5385	13.688 13.678
MBF2013-11-()	-200	.347 .344	8.81 8.74	.525	13.33	.575	14.60	+1.03 -0.00	+2.62 -0.00	4400	19570	13850	61600	4.0	0.452	.0302 .0276	0.767 0.701	.5389 .5385	13.688 13.678
MBF2013-12-()	-250	.378 .375	9.60 9.52	.575	14.60	.625	15.87	+1.03 -0.00	+2.62 -0.00	5000	22240	16450	73170	4.0	0.452	.0255 .0228	0.648 0.579	.6532 .6528	16.591 16.581

MONOGRAM AEROSPACE FASTENERS
 a TriMas company
 3423 SOUTH GARFIELD AVENUE
 COMMERCE, CALIFORNIA 90040
 (323) 722-4760 FAX (323) 727-1029

TITLE:
BLIND FASTENER, LOW PROFILE 130° FLUSH HEAD FOR ADVANCE COMPOSITE MATERIAL TITANIUM

DRAWING NO:
MBF2013()-()-()
 DRAWN BY:
G.MARTINEZ
 DRAWN DATE:
8/9/13
 APPROVED BY:
 CHECKED DATE:

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MONOGRAM
 CAGE CODE: **98524**
 ECN NO: **13-0224**
 ECN DATE: **8/9/13**
 REV: **AG**
 SHEET 1 OF 2

APPLICABLE SPECIFICATIONS:
 PROCUREMENT SPECIFICATION: MBF2000.
 INSTALLATION AND INSPECTION SPECIFICATION: MBF2001.
 SPECIAL LUBE AND FINISH: MBF2002.
 PART NUMBER ASSIGNMENT: MBF2004.

MATERIAL AND HEAT TREAT:

NUT: 6AI-4V TITANIUM ALLOY PER MIL-T-9047 STA OR AMS4928 OR AMS4967 HEAT TREATED PER MIL-H-81200 TO 95 KSI SHEAR STRENGTH MINIMUM. MAXIMUM HYDROGEN CONTENT 125 PPM.
 SCREW: A286 CRES PER AMS5731, AMS5732 OR AMS5737 HEAT TREATED TO 175 KSI TENSILE MINIMUM.
 SLEEVE: 304 STAINLESS STEEL PER AMS5639, FULLY ANNEALED.
 INSERT: ACETAL PER ASTM-D4181.

FINISH:

(-) NUT: KAL-GARD ANN-R0 #1012 CONVERSION COATING OR PHOSPHATE FLOURIDE PER MONOGRAM SPECIFICATION PS741, MAY BE USED AT MANUFACTURER'S OPTION.
 SLEEVE AND SCREW: PASSIVATE PER ASTM-A-967-96, KAL-GARD ANN-R0 #1013 CONVERSION COATING OPTIONAL.
 INSERT: NONE

LUBRICANT:

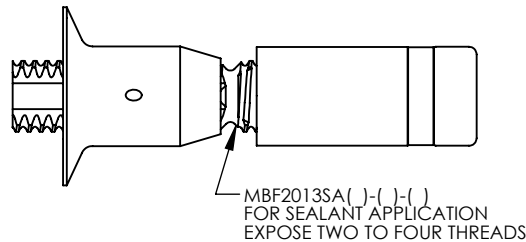
SOLID FILM LUBRICANT PER AS5272 TYPE I OR MIL-PRF-81329, PARAFFIN WAX, OR CETYL ALCOHOL PER AS87132 (AS REQUIRED FOR PERFORMANCE).

GENERAL NOTES:

- EXAMPLE OF PART NUMBER:
 MBF2013 () - 6 - 300

- LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120° APART ON THE PERIPHERY OF THE NUT COMPONENT AND APPROXIMATELY .040" ABOVE INTERSECTION OF THE NUT NOSE ANGLE AND O.D.
- COMPOSI-LOK FASTENERS WITH SELECTED COMBINATIONS OF THE ABOVE LUBRICANTS AND FINISHES ARE SPECIALLY CODED AND MAY BE SUBSTITUTED FOR EQUIVALENT NON-CODED PARTS AT MANUFACTURER'S OPTION. SEE INTERCHANGEABILITY SPECIFICATION MBF2007.

- DISTORTION SHALL NOT PREVENT INSERTION OF THE FASTENER INTO A RING GAUGE OF LENGTH EQUAL TO ONE DIAMETER AND HOLE DIAMETER EQUAL TO A MINIMUM RECOMMENDED HOLE. FORCE FOR INSERTION SHALL NOT EXCEED 5.0 POUNDS.



2ND DASH NO. (GRIP)	GRIP RANGE			
	MIN GRIP		MAX GRIP	
	INCH	mm	INCH	mm
100	.050	1.27	.100	2.54
150	.100	2.54	.150	3.81
200	.150	3.81	.200	5.08
250	.200	5.08	.250	6.35
300	.250	6.35	.300	7.62
350	.300	7.62	.350	8.89
400	.350	8.89	.400	10.16
450	.400	10.16	.450	11.43
500	.450	11.43	.500	12.70
550	.500	12.70	.550	13.97
600	.550	13.97	.600	15.24
650	.600	15.24	.650	16.51
700	.650	16.51	.700	17.78
750	.700	17.78	.750	19.05
800	.750	19.05	.800	20.32
850	.800	20.32	.850	21.59
900	.850	21.59	.900	22.86
950	.900	22.86	.950	24.13
1000	.950	24.13	1.000	25.40
1050	1.000	25.40	1.050	26.67
1100	1.050	26.67	1.100	27.94
1150	1.100	27.94	1.150	29.21
1200	1.150	29.21	1.200	30.48
1250	1.200	30.48	1.250	31.75
1300	1.250	31.75	1.300	33.02
1350	1.300	33.02	1.350	34.29
1400	1.350	34.29	1.400	35.56
1450	1.400	35.56	1.450	36.83
1500	1.450	36.83	1.500	38.10
1550	1.500	38.10	1.550	39.37
1600	1.550	39.37	1.600	40.64
1650	1.600	40.64	1.650	41.91
1700	1.650	41.91	1.700	43.18

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 FOR ADVANCE COMPOSITE MATERIAL
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