

TABLE I

PART NUMBER	Ø A		Ø A' MIN		Ø D		Ø E MAX		F WRENCH FLATS		(G)		(H)		(L)		R RAD MAX		S MAX		(T HEX ACROSS FLATS)	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
MBF2322-05-( )	.332 .325	8.43 8.25	.296	7.52	.1645 .1625	4.178 4.128	.1640	4.166	.086 .081	2.18 2.06	.058	1.47	.070	1.78	.625	15.875	.030	0.76	.015	0.38	.375	9.52
MBF2322-06-( )	.385 .378	9.78 9.60	.342	8.69	.1985 .1965	5.042 4.991	.1985	5.042	.104 .099	2.64 2.52	.058	1.47	.077	1.96	.675	17.145	.030	0.76	.019	0.48	.375	9.52
MBF2322-08-( )	.507 .499	12.88 12.67	.463	11.76	.2595 .2575	6.591 6.541	.2595	6.591	.135 .130	3.43 3.30	.058	1.47	.104	2.64	.900	22.860	.030	0.76	.020	0.51	.375	9.52

TABLE I (CONTINUED)

PART NUMBER	MIN AVAILABLE GRIP LENGTH	MAX AVAILABLE GRIP LENGTH	INSTALLED DIMENSIONS							MECHANICAL PROPERTIES						V (GAGE PROTRUSION)		Ø W (GAGE)		
			RECOM. 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	INCH	mm	LBS	N	LBS	N	IN-LBS	N-m	INCH	mm
MBF2322-05-( )	-150	-1000	.168 .165	4.27 4.19	.250	6.35	.370	9.40	+0.00 -0.030	+0.000 -0.762	900	4000	3150	14010	1.0	0.113	.0207 .0174	0.526 0.442	.2832 .2830	7.193 7.188
MBF2322-06-( )	-150	-1150	.202 .199	5.13 5.05	.300	7.62	.420	10.67	+0.00 -0.030	+0.000 -0.762	1400	6230	4600	20460	1.5	0.170	.0245 .0212	0.622 0.538	.3272 .3270	8.311 8.306
MBF2322-08-( )	-200	-1150	.263 .260	6.68 6.60	.400	10.16	.510	12.95	+0.00 -0.030	+0.000 -0.762	2100	9340	7900	35140	2.5	0.282	.0318 .0279	0.808 0.709	.4320 .4318	10.973 10.968

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

TITLE:  
**COMPO-LOK® 3 BLIND FASTENER FLUSH BREAK  
100° FLUSH TENSION HEAD  
FOR ADVANCED COMPOSITE MATERIAL &  
METALLIC STRUCTURES, A-286**

DRAWING NO:  
**MBF2322(-)(-)(-)**

DRAWN BY:  
**M. DOMINGUEZ**

APPROVED BY: *[Signature]*

MONOGRAM CAGE CODE:  
**98524**

ECN NO:  
**98524**

ECN DATE:

DRAWN DATE:  
**03/13/15**

CHECKED DATE:  
**3/20/15**

REP:  
**N/R**

SHEET 1 OF 2

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**APPLICABLE SPECIFICATIONS:**

PROCUREMENT SPECIFICATION: MBF2300  
 INSTALLATION AND INSPECTION SPECIFICATION: MBF2301  
 SPECIAL LUBE AND FINISH: MBF2002

**MATERIAL AND HEAT TREAT:**

NUT & SCREW: A-286 STAINLESS STEEL PER CHEMICAL REQUIREMENTS OF AMS5731, AMS5732, AMS5734 AND AMS5737. HEAT TREATED AS REQUIRED FOR PERFORMANCE.  
 SLEEVE: 304 STAINLESS STEEL PER AMS5369, HEAT TREATED AS REQUIRED FOR PERFORMANCE.  
 INSERT: ACETAL PER ASTM D4181.  
 DRIVE NUT: MILD STEEL.


**FINISH:**

( - ) NUT: PASSIVATE PER AMS2700.  
 ( L ) NUT: PASSIVATE PER AMS2700, ALUMINUM COAT PER NAS4006 CODE NC.  
 SLEEVE AND SCREW: PASSIVATE PER AMS2700, KAL-GARD ANN-RO #1013 CONVERSION COATING OPTIONAL.  
 INSERT: NONE  
 DRIVE NUT: COLOR GRAY

**LUBRICANT:**

DRY FILM LUBE PER THE CHEMICAL REQUIREMENTS OF MIL-PRF-4610 TYPE I OR EVERLUBE #812 PER MIL-PRF-81329, PARAFFIN WAX, OR CETYL ALCOHOL PER AS87132 (AS REQUIRED FOR PERFORMANCE).

**GENERAL NOTES:**

- EXAMPLE OF PART NUMBER:  
 MBF2322 ( ) - 06 - 100  

- 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.
- HEAD MARKINGS: MANUFACTURER'S IDENTIFICATION: MONOGRAM = "MI"  
 FASTENER IDENTIFICATION = "2322"  
 POSITION OPTIONAL
- 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.
- MAXIMUM RUNOUT FROM DRIVE NUT TO SCREW HEAD WHEN DRIVE NUT IS FULLY SEATED (G=0) FOR GRIPS UNDER/EQUAL -1000. FOR GRIPS LONGER THAN -1000 "TOL C" TBD.
- ALL OTHER DIMENSIONS ARE THE SAME AS IN TABLE I.
- INSTALLATION AND REMOVAL INFORMATION T.B.A.

2ND DASH NO (GRIP)	TABLE III			
	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



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 100° FLUSH TENSION HEAD  
 FOR ADVANCED COMPOSITE MATERIAL &  
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DRAWING NO: <b>MBF2322(-)(-)(-)</b>	
DRAWN BY: <b>M. DOMINGUEZ</b>	DRAWN DATE: <b>03/13/15</b>
APPROVED BY: 	CHECKER DATE: <b>3/20/15</b>
MONOGRAM GAGE CODE: <b>98524</b>	ECN NO: ECN DATE: <b>N/R</b>
SHEET 2 OF 2	

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