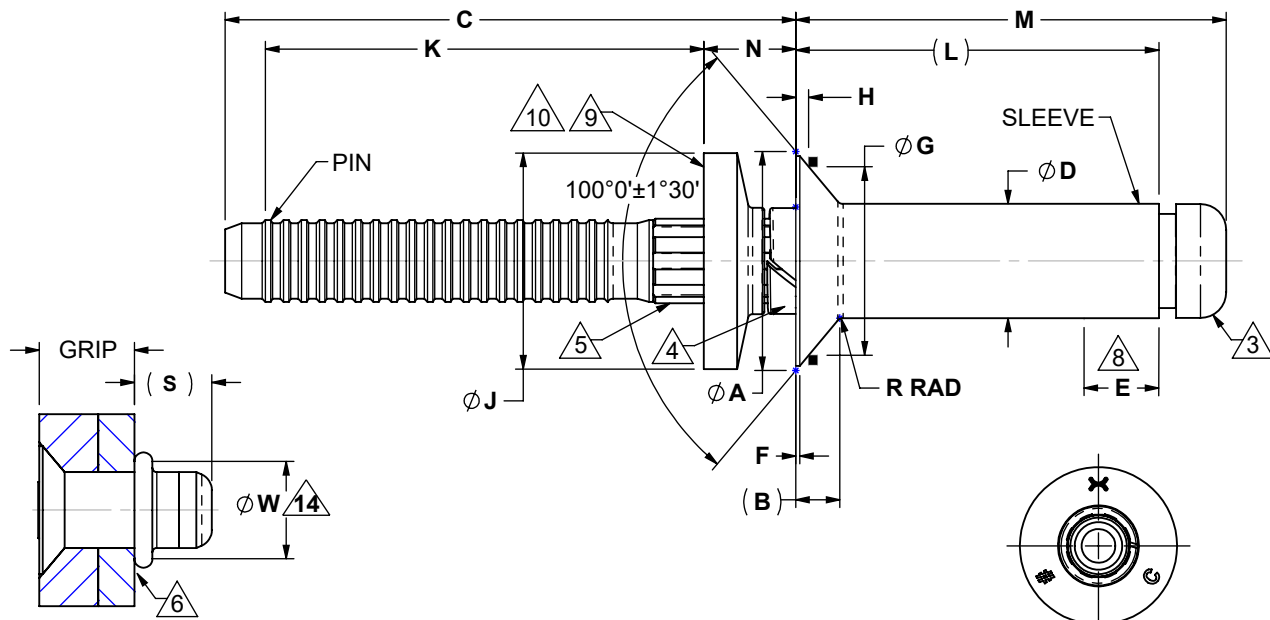




HOWMET FASTENING SYSTEMS
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Unimatic®
ADVANCED BLIND BOLT
ENGINEERING STANDARD



INSTALLED FASTENER

TABLE I

HEAD ID WITHOUT DRIVE WASHER ⁷

PART NUMBER	NOM DIA.	(Ø A) HEAD THEO. INTER.	(B) HEAD HEIGHT MAX	C MIN.	Ø D SLEEVE ±.001	E MAX	F MAX	Ø G GAGE ±.0001	H GAGE HEIGHT	J ±.005	K ±.030	N ±.060	R RAD. MAX.	(S) DESIGN REF	W MIN.	SINGLE SHEAR ¹ ²	TENSILE ¹	SPINDLE RET.	HOLE LIMITS +.003 -.000
UAB100-EU05-()	05	.333	.072	.844	.163	.300	.011	.2831	.0206 .0171	¹⁰	.800	.140	.010	.232	.223	1980	1150	575	.164
UAB100-EU06-()	06	.386	.080	.875	.198	.320	.013	.3271	.0243 .0205	.375	.830	.160	.015	.292	.270	2925	1690	845	.199
UAB100-EU08-()	08	.507	.105	1.000	.259	.370	.017	.4319	.0310 .0270		.975	.190	.020	.361	.355	5000	2900	1440	.260

- ¹ MINIMUM ULTIMATE SINGLE SHEAR AND TENSILE STRENGTHS IN POUNDS OF INSTALLED FASTENER.
- ² APPLIES TO GRIPS 05-04 MAX, 06-05 MAX, 08-06 MAX AND UP. IN SHORTER GRIPS, A TRUE COMPOSITE SHEAR TEST CANNOT BE OBTAINED.
- ³ TRIM FLASH NOT TO EXCEED .005 MAXIMUM LENGTH ABOVE HEAD OF PIN.
- ⁴ SOLID OR SPLIT LOCK COLLAR - MANUFACTURER'S OPTION. SPLIT NOT TO EXCEED .020 WIDTH.
- ⁵ KNURLED TO FACILITATE FASTENER ASSEMBLY. NOT PART OF THE INSTALLED FASTENER.
- ⁶ BLIND SIDE HEAD MAY BE INSTALLED ON 5° MAXIMUM SLOPE.
- ⁷ IDENTIFICATION: HUCK SYMBOL, "C" (MATERIAL) AND GRIP DASH NUMBER.
- ⁸ "E" LENGTH OF "ØD" MAY BE .002 UNDERSIZE.
- ⁹ DRIVE WASHER TO FACILITATE INSTALLATION ONLY. NOT PART OF THE INSTALLED FASTENER.
- ¹⁰ -05 DIA SIZE ALSO AVAILABLE WITH REDUCED O.D. DRIVE ANVIL OF .312 ±.005. SEE PART NUMBER EXAMPLES.

DIMENSIONS IN INCHES

U	PER ECN 15394, ADDED NOTE 14.		Current Design Activity CAGE Code 0HDW7		PROCUREMENT SPEC T0106	DRAWN BY J. SCHLOBOHM CHECKED BY SIGNATURE ON FILE	
	ISSUED 12/8/2001	Unimatic® ADVANCED SERIES BLIND BOLT FASTENER, HIGH STRENGTH, PULL-TYPE, POSITIVE MECHANICAL LOCK, 100° FLUSH HEAD, A-286 CRES (95 KSI SHEAR) SINGLE ACTION, LARGE FOOT PRINT				UAB100-EU	
	REVISED 07/12/2023					SK12771	
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Δ OVERLAP MINIMUM GRIP FOR -.06 DIAMETER IS .140 AND -.08 DIAMETER IS NONE.

TABLE II

GRIP NUMBER TABULATION															
GRIP DASH NO.	OVERLAP GRIP MIN	DESIGN GRIP RANGE		OVERLAP GRIP MAX	05		GRIP DASH NO.	OVERLAP GRIP MIN	DESIGN GRIP RANGE		OVERLAP GRIP MAX	06		08	
		MIN.	MAX.		(L)	M MAX			MIN.	MAX.		(L)	M MAX	(L)	M MAX
02	NONE	.094	.157	.173	.336	.478	02	NONE	.120	.157	.173	.355	.521	-	-
03	.146	.156	.220	.236	.398	.540	03	NOTE 11	.156	.220	.236	.417	.583	.479	.645
04	.209	.219	.282	.298	.460	.603	04	.203	.219	.282	.298	.480	.646	.541	.707
05	.271	.281	.345	.361	.523	.665	05	.265	.281	.345	.361	.542	.708	.604	.770
06	.334	.344	.407	.423	.585	.728	06	.328	.344	.407	.423	.605	.771	.666	.832
07	.396	.406	.470	.486	.648	.790	07	.390	.406	.470	.486	.667	.833	.729	.895
08	.459	.469	.532	.548	.710	.852	08	.453	.469	.532	.548	.729	.895	.791	.957
09	.521	.531	.595	.611	.772	.914	09	.515	.531	.595	.611	.791	.957	.854	1.020
10	.584	.594	.657	.673	.835	.977	10	.578	.594	.657	.673	.854	1.020	.916	1.082
11	.646	.656	.720	.735	.898	1.040	11	.640	.656	.720	.735	.917	1.083	.979	1.145
12	.709	.719	.782	.798	.960	1.102	12	.703	.719	.782	.798	.979	1.145	1.041	1.207
13	.771	.781	.845	.860	1.023	1.165	13	.765	.781	.845	.860	1.042	1.208	1.104	1.270
14	.834	.844	.907	.923	1.085	1.227	14	.828	.844	.907	.923	1.105	1.271	1.166	1.332
15	.896	.906	.970	.985	1.148	1.290	15	.890	.906	.970	.985	1.168	1.334	1.229	1.395
16	.959	.969	1.032	1.048	1.210	1.352	16	.953	.969	1.032	1.048	1.230	1.396	1.291	1.457

TABLE III

UAB100-EU INSTALLED WEIGHT IN LBS (1000 pcs.)							
GRIP	5 DIA	6 DIA	8 DIA	GRIP	5 DIA	6 DIA	8 DIA
-02	2.45	3.97		-10	5.38	8.45	15.65
-03	2.79	4.63	9.14	-11	5.75	9.00	16.58
-04	3.16	5.18	10.05	-12	6.12	9.55	17.51
-05	3.53	5.72	10.99	-13	6.49	10.10	18.46
-06	3.90	6.27	11.92	-14	6.86	10.65	19.41
-07	4.27	6.81	12.85	-15	7.23	11.20	20.36
-08	4.64	7.36	13.78	-16	7.60	11.75	21.31
-09	5.01	7.91	14.71				

DIMENSIONS IN INCHES

U	PER ECN 15394, ADDED NOTE 14.		Current Design Activity CAGE Code 0HDW7		PROCUREMENT SPEC T0106	DRAWN BY J. SCHLOBOHM	CHECKED BY SIGNATURE ON FILE	
	ISSUED 12/8/2001	Unimatic® ADVANCED SERIES BLIND BOLT FASTENER, HIGH STRENGTH, PULL-TYPE, POSITIVE MECHANICAL LOCK, 100° FLUSH HEAD, A-286 CRES (95 KSI SHEAR) SINGLE ACTION, LARGE FOOT PRINT						UAB100-EU
	REVISED 07/12/2023							SK12771
PAGE 2 OF 3								

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TABLE I V

FINISH CODE	MATERIAL			FINISH			LUBE 12.
	SLEEVE	PIN	LOCK COLLAR	SLEEVE	PIN	LOCK COLLAR	
NONE	A-286 CRES AMS 5737	A-286 CRES AMS 5737	A-286 CRES AMS 5737 OR 316 CRES AMS5690	PASSIVATE AMS2700 & AMS-QQ-P-35	PASSIVATE AMS2700 & AMS-QQ-P-35	PASSIVATE AMS2700 & AMS-QQ-P-35	OPTIONAL
D	A-286 CRES AMS 5737	A-286 CRES AMS 5737	A-286 CRES AMS 5737 OR 316 CRES AMS5690	ALUMINUM COAT MIL-DTL-83488	PASSIVATE AMS2700 & AMS-QQ-P-35	PASSIVATE AMS2700 & AMS-QQ-P-35	OPTIONAL
CD	A-286 CRES AMS 5737	A-286 CRES AMS 5737	A-286 CRES AMS 5737 OR 316 CRES AMS5690	CAD. PLATE AMS-QQ-P-416 TYPE II CLEAR DICHROMATE CLASS 2	PASSIVATE AMS2700 & AMS-QQ-P-35	PASSIVATE AMS2700 & AMS-QQ-P-35	OPTIONAL
AC 13.	A-286 CRES AMS 5737	A-286 CRES AMS 5737	A-286 CRES AMS 5737 OR 316 CRES AMS5690	ALUMINUM PIGMENTED COATING PER NAS4006 AND BMS 10-85	PASSIVATE AMS2700 & AMS-QQ-P-35	PASSIVATE AMS2700 & AMS-QQ-P-35	OPTIONAL
ACN 13.	A-286 CRES AMS 5737	A-286 CRES AMS 5737	A-286 CRES AMS 5737 OR 316 CRES AMS5690	NON-CHROMATE ALUMINUM PIGMENTED COATING PER NAS4006 AND EN4473	PASSIVATE AMS2700 & AMS-QQ-P-35	PASSIVATE AMS2700 & AMS-QQ-P-35	OPTIONAL

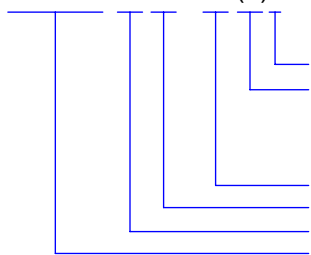
12. LUBRICATION- WHEN LUBRICATED, PARTS SHALL BE LUBRICATED PER AS5272, AS87132 OR LOX COMPATIBLE DRY FILM LUBRICANT. (MANUFACTURER'S OPTIONS)

13. COMPLETE COVERAGE OF SLEEVE INTERNAL FEATURES IS NOT REQUIRED. OVER SPRAY ONTO THE INTERNAL FEATURES IS ACCEPTABLE

14. THE AVERAGE READING OF THE SMALLEST & LARGEST OBSERVED VALUE ON THE SAME SPECIMEN MUST BE EQUAL TO OR GREATER THAN THE STATED MINIMUM DIAMETER.

HUCK PART NUMBER EXAMPLE:

UAB100-EU06 - 04()R



CODE "R" FOR REDUCED DRIVE ANVIL DIAMETER ON -05 DIA SIZE ONLY
NO CODE DENOTES PASSIVATION TREATMENT
"CD" CODE DENOTES CADMIUM PLATING WITH CLEAR CHROMATE
"D" CODE DENOTES ALUMINUM (IVD) COATING
"AC" CODE DENOTES HIKOTE AND PASSIVATION
GRIP NUMBER IN 16th INCHES.
SHANK DIAMETER CODE, SEE TABLE I
MATERIAL DESIGNATOR - A286.
Unimatic® ADVANCED SERIES BLIND BOLT FASTENER, HIGH STRENGTH, PULL-TYPE,
POSITIVE MECHANICAL LOCK, 100° FLUSH HEAD, EXPANDED BULB.
LARGE FOOT PRINT. DRIVE WASHER INCLUDED.

DIMENSIONS IN INCHES

U	PER ECN 15394, ADDED NOTE 14.		Current Design Activity CAGE Code 0HDW7	PROCUREMENT SPEC T0106	DRAWN BY J. SCHLOBOHM	CHECKED BY SIGNATURE ON FILE
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	REVISED	07/12/2023				
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