

INCH-POUND

MIL-B-85604A  
 AMENDMENT 1  
 23 NOVEMBER 1999

## MILITARY SPECIFICATION

BOLT, NICKEL ALLOY 718, TENSION, HIGH STRENGTH,  
 (125) KSI  $F_{SU}$  AND KSI 220  $F_{TU}$ ), HIGH TEMPERATURE,  
 SPLINE DRIVE GENERAL SPECIFICATION FOR

This amendment forms a part of MIL-B-85604A, dated 25 JANUARY 1988, and is approved for use by all Departments and Agencies of the Department of Defense.

## PAGE 4

3.2 Delete and Substitute: "3.2 Qualification. The bolt manufacturer shall be responsible for conducting qualification tests and furnishing part drawings, certified qualification test reports (if required by the purchaser) and test samples. The bolts furnished under this specification shall be produced using the same manufacturing methods as those used to produce bolts that have passed qualification tests. The purchaser may apply any or all tests specified herein to any product represented as meeting this specification, at any time, to verify conformance.

## PAGE 14

4.3.1 Delete and Substitute: "4.3.1 Sampling Plan. Test samples shall be of the same material and manufactured by the same method as production parts. The number of bolts to be subjected to qualification tests shall be as specified in Table VI. Bolts shall have a grip length not less than 4 times the diameter.

## PAGE 15

4.3.2 Delete and Substitute: "4.3.2 Certified Test Report. The manufacturer shall maintain on file a certified test report showing that the manufacturer's product satisfactorily conforms to this specification. The test report shall include actual results of the tests specified herein, including photographs of macro- and micro- examinations. The manufacturer shall also maintain a dated drawing that completely describes the manufacturer's product. The drawing shall specify all dimensions and tolerances, material composition, coatings or platings applied, and heat treatment. The drawing shall also specify the manufacturer's part number for each size.

AMSC N/A

1 OF 2

FSC 5306

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MIL-B-85604A  
AMENDMENT 1

PAGE 15 AND 16

4.3.3 Delete and Substitute: "4.3.3 Retention of Qualification.  
"Requalification will be required in the event any change is made in the  
product design, construction, materials, method of manufacture, heat  
treatment, finish, lubricant, or manufacturer's part number or designation."

6.3 Delete and Substitute: "6.3 Qualification. Awards will be made  
only for products that meet the qualification requirements of this document  
at the time set for opening of bids. Bolts that have not been previously  
qualified via Government-certified qualification tests and reports may be  
acquired, provided that certified qualification test reports for these bolts  
are retained on file by the manufacturer along with the quality conformance  
inspection data, and they are made available to the buyer upon request."

PAGE 21

6.3.1 Delete entire paragraph

6.4.5 Delete entire paragraph

Custodians:

Army - AV  
Navy - AS  
Air Force - 11

Preparing Activity:

DLA-IS  
(Project 5306-2242)