

INCH-POUND

MIL-B-8831B  
AMENDMENT 2  
19 JUNE 1998

MILITARY SPECIFICATION

BOLT, 180 KSI Ftu AND 108 KSI Fsu,  
450 DEG F PROTRUDING AND FLUSH HEAD,  
GENERAL SPECIFICATION FOR

This amendment forms a part of Military Specification MIL-B-8831B, dated 23 August 1982, and is approved for use by all Departments and Agencies of the Department of Defense.

Page 3

3.2 Delete and substitute: "3.2 Qualification. This paragraph intentionally blank."

3.2.1 Delete and substitute: "3.2.1 Retention of Qualification. This paragraph intentionally blank."

Page 8

4.1 Delete and substitute: "4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements as specified herein."

Page 9

4.2 Delete and substitute: "Classification of inspections. The examination and testing of bolts shall be classified as quality conformance inspection."

4.3 Delete and substitute: "4.3 Qualification inspections. This paragraph intentionally blank."

4.3.1 Delete and substitute: "Sampling size. This paragraph intentionally blank."

TABLE VI. Delete in its entirety.

4.3.2 Delete and substitute: "4.3.2 Retention of Qualification. This paragraph intentionally blank."

4.4 Delete and substitute: "4.4 Quality conformance inspections. The quality conformance inspections shall consist of the tests listed in 4.5. The purchaser may apply any or all tests specified herein to any production lot of fasteners, at any time, to verify conformance."

MIL-B-8831B

Page 10

TABLE VII. Delete in its entirety.

Page 13

Add 4.5.3.2.2.1 Shear strength (for sleeve bolts). The sleeve shall be removed and the bolt taper shall be ground to the smallest diameter before the test is conducted. The double shear strength test shall be conducted in accordance with MIL-STD-1312, Test 13.

4.5.3.2.3 Delete in its entirety and substitute the following paragraphs:

4.5.3.2.3 Fatigue strength. Bolts in accordance with MS14157, MS21134, and MS21250 shall be tested as specified in 4.5.3.2.3.2. Bolts having a grip length less than two times the diameter need not be fatigue tested, and acceptance for these bolts is on the basis of their tensile strength.

4.5.3.2.3.1 Fatigue strength (for sleeve bolts). The bolt with the expandable sleeve installed at the bolt head shall be used for this test. Cracks in the sleeve will not constitute failure of the bolt. Bolts having a grip length less than two times the diameter need not be fatigue tested, and acceptance for these bolts is on the basis of their tensile strength. Bolts shall be tested as specified in 4.5.3.2.3.2.

4.5.3.2.3.2 Fatigue strength testing method. The method of testing and fixture requirements shall be in accordance with MIL-STD-1312, Test 11. The fatigue loading applied to bolts shall be tension-tension. The fatigue test shall be conducted at room temperature. The fatigue loading applied to the respective bolts shall conform to table IV.

Page 14

4.5.3.9 Change title to "4.5.3.9 Sleeve expansion (sleeve bolts only)."

Page 16

6.3 Delete and substitute: "6.3 Qualification. This paragraph intentionally blank."

Custodians:

Army - AV

Navy - AS

Air Force - 11

Preparing Activity:

DLA-IS

(Project 5306-2049)