

INCH-POUND

MIL-F-8975B  
 AMENDMENT 2  
 23 March 1994  
 SUPERSEDING  
 AMENDMENT 1  
 27 May 1988

## MILITARY SPECIFICATION

FASTENER, BLIND, HIGH STRENGTH, INSTALLATION FORMED  
 CORROSION RESISTANT STEEL, HEAT RESISTANT STEEL AND TITANIUM

This amendment forms a part of Military Specification MIL-F-8975, dated 29 September 1982, and is approved for use by all departments and agencies of the Department of Defense

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TABLE I. Delete title in its entirety and substitute:

"Tolerances on roundness and concentricity of heads, Type I, Class 1 & 2."

\* TABLE II: Delete in its entirety and substitute:

TABLE II. Visual inspection tabulation Type I, Class 1 &amp; 2.

Nominal Diameter	Spindle Position		Blind Head Dia (Min)		Collar Position
	"B" MAX (See Fig 1)	"C" MAX (See Fig 1)			"A" Max (See Fig 1)
	Class 1 and 2	Class 1 and 2	Class 1	Class 2	Class 1 and 2
5/32	.010	.010	.195	.235	.017
3/16	.010	.010	.238	.275	.022
1/4	.015	.015	.315	.350	.029
5/16	.020	.015	.373	.410	.037
3/8	.025	.020	.448	.485	.045

TABLE III: Delete in its entirety and substitute:

TABLE III. Mechanical properties (shear, tensile and tensile preload), Type I, Class 1 &amp; 2.

Nominal Diameter	Single Shear Strength (lbs min)		Tensile Strength (lbs min)		Tensile Preload (lbs min)	
	Class 1	Class 2	Class 1	Class 2	Class 1	Class 2
5/32	1,980	1,825	1,150	900	115	90
3/16	2,925	2,690	1,690	1,400	169	140
1/4	5,000	4,650	2,900	2,100	290	210
5/16	7,200	6,675	4,170	3,600	417	360
3/8	10,380	9,550	5,970	5,600	597	560

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TABLE IV: Delete in its entirety and substitute:

TABLE IV. Mechanical properties (tension-tension fatigue, sheet take-up and spindle retention),  
Type I, Class 1 and 2.

Nominal Diameter	Tension-Tension Fatigue Loads (lbs)				Sheet Take-Up (min)	Spindle Retention (lbs min)
	Class 1		Class 2		Class 1 & 2	Class 1 & 2
	High	Low	High	Low		
5/32	519	52	405	41	.012	575
3/16	760	76	630	63	.015	845
1/4	1300	130	945	95	.020	1,440
5/16	1875	188	1620	162	.025	2,080
3/8	2690	269	2520	252	.032	2,980

Amendment continued.

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\* Figure 1. Delete in its entirety and substitute:

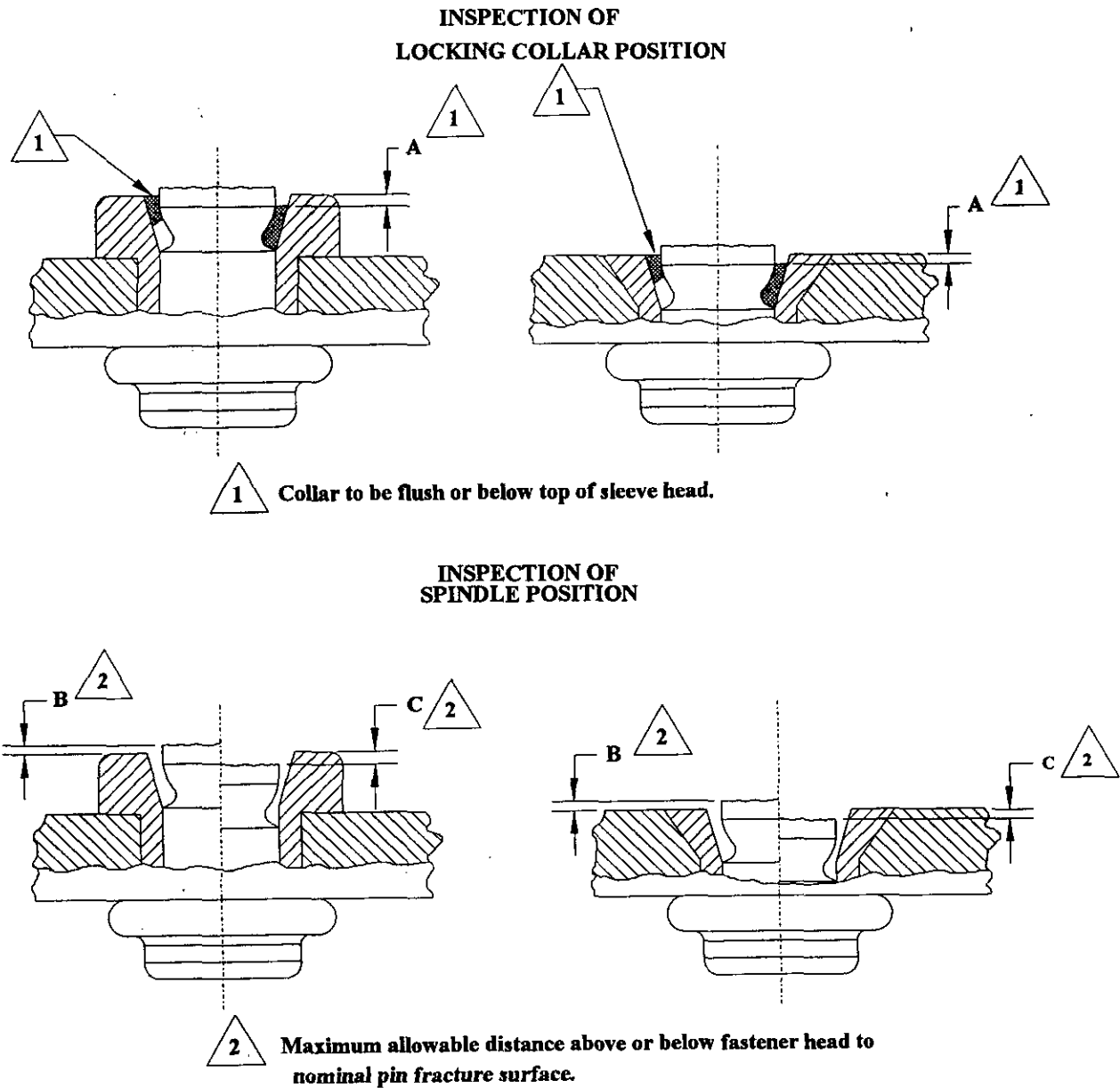


FIGURE 1. Visual inspection illustration, Type I.

Amendment continued:

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After line 7 add:

"MIL-F-8975/6 and /7 fasteners utilize single action (Non-Shifting) tooling:

MIL-F-8975/6 &7	Nominal Size (Diameter)	Huck Manufacturing Company Tool Part No. or Equal	Nose Assembly Part Number or Equal
* -05	5/32	223	99-680
* -05		230	99-680
-05		352	99-680
-05		206	99-904
-05		206	99-904-2
-05		609-1	99-853
-05		115	99-680
* -05		2400	99-680
* -06	3/16	223	99-681
* -06		230	99-681
-06		352	99-681
-06		206	99-905
-06		206	99-905-2
-06		609-1	99-854
-06		115	99-681
* -06		2400	99-681
* -08	1/4	115	99-951
-08		207	99-906
-08		245	99-591
-08		353	99-591
-08		354	99-591
-08		610-1	99-679
-08			99-838
-08			99-865
-08		611-1	99-682
-08		612-1	99-682
-08			99-838
-08			99-865
-08			99-838
-08			99-865
* -08	2500	99-591	
-08	4801	99-591	
-08	5901	H99-662	
* -10	5/16	116	99-663
-10		245	99-823
-10		4801	99-823
-10		5901	H99-663

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**NOTE:** The margins of this amendment are marked with an asterisk to indicate where changes (additions, modifications, corrections, deletions) from the previous amendment were made. *This was done as a convenience only and the government assumes no liability whatsoever for any inaccuracies in the notations. bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the past amendment.*

**Custodians:**

Army - AV  
Air Force - 99

**Review Activities:**

Army - AR, MI  
Navy - SH, OS  
Air Force - 82

**Preparing Activity:**

DLA - IS  
(Project No. 5320-0811)