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Composi-Lok Blind Bolts: Types, Hole, Grip Code and the Flush Break

Types · ASNA numbers · hole and drill · grip code · installation

Hole and drill by diameter code, ASNA0012

Code	Nominal	Fastener	Hole	Drill
-05	5/32 in	0.1645 in (4.178 mm†)	0.165–0.168 in (4.191–4.267 mm†)	#19 (0.1660 in; 4.22 mm)
-06	3/16 in	0.1985 in (5.041 mm†)	0.199–0.202 in (5.054–5.130 mm†)	#7 (0.2010 in; 5.11 mm)
-08	1/4 in	0.2595 in (6.591 mm†)	0.260–0.263 in (6.604–6.680 mm†)	G (0.2610 in; 6.63 mm)

Key points

- **Drive-nut blind bolt** of the Jo-Bolt family, for composite structure.
- **Composi-Lok II** stem does not break flush; **Composi-Lok 3** does.
- **ASNA0012 / 0013** Composi-Lok type; **ASNA302 / 303** Radial-Lok type, titanium.
- **Grip code** is the maximum grip in thousandths of an inch (ASNA0012).
- **Hole:** 0.165 to 0.168 in for code 05.

Step by step

1. Drill from the hole table; deburr the hole edges.
2. Choose the grip code from the stack.
3. Insert, tool over the screw and nut.
4. Hold the nut, turn the screw until it breaks.
5. Shave only a Composi-Lok II where flush is required.

SOURCES · FAA-H-8083-31B, Aviation Maintenance Technician Handbook, Airframe, chapter 4 · ASNA0012, ASNA0013, ASNA302 and ASNA303 standard sheets

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Educational reference only, not approved data. Always consult the applicable SRM, AMM, or AC 43.13-1B and your certifying authority.