



Huck-Spin® Lockbolt and BobTail® Lockbolt Pressure Charts

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Small Diameter Huck-Spin® Lockbolt (Inch)

| FASTENER | SIZE | TOOL | GRADE | PULL (PSI) | RETURN (PSI) |
|----------|-------------|-----------|-------|------------|--------------|
| HS | -10 (5/16") | 2580 | 5 | 2600 | 700 |
| HS | -12 (3/8") | HSSFT-M10 | 8 | 5500 | 4500 |

Large Diameter Huck-Spin® Lockbolt (Inch)

| FASTENER | SIZE | TOOL | PULL (PSI) | RETURN (PSI) |
|----------|------------|-----------|------------|--------------|
| HS | -16 (1/2") | HS24* | 5200 | 2700 |
| HS | -20 (5/8") | HS24* | 8300 | 4400 |
| HS | -16 (1/2") | HS37* | 3300 | 2000 |
| HS | -16 (1/2") | HS52 | 2500 | 1500 |
| HS | -20 (5/8") | HS52 | 4100 | 2800 |
| HS | -24 (3/4") | HS52 | 5100 | 3000 |
| HS | -32 (1") | HS52 | 7800 | 4000 |
| HS | -32 (1") | HS52 | 5200 *** | 1300 *** |
| HS | -16 (1/2") | HSSFT-M12 | 6800 | 6000 |
| HS | -20 (5/8") | HSSFT-M16 | 6800 | 4800 |
| HS | -16 (1/2") | 2624HS* | 3900 | 3000 |
| HS | -20 (5/8") | 2624HS* | 5750 | 3500 |
| HS | -24 (3/4") | 2624HS* | 7200 | 3500 |
| HS | -16 (1/2") | 3585PT | 2700 | 1500 |
| HS | -20 (5/8") | 3585PT | 4300 | 1500 |
| HS | -24 (3/4") | 3585PT | 5800 | 1700 |

Large Diameter Huck-Spin® Lockbolt (Metric)

| FASTENER | SIZE | TOOL | PULL (PSI) | RETURN (PSI) |
|----------|------|-----------|------------|--------------|
| HS | 12mm | HS24* | 4500 | 2400 |
| HS | 16mm | HS24* | 8300 | 4400 |
| HS | 12mm | HS37* | 3300 | 2000 |
| HS | 14mm | HS37* | 4000 | 3000 |
| HS | 12mm | HS52 | 2300 | 1300 |
| HS | 14mm | HS52 | 2700 | 1700 |
| HS | 16mm | HS52 | 4100 | 2800 |
| HS | 20mm | HS52 | 5200 | 3000 |
| HS | 12mm | HSSFT-M12 | 4800 | 4000 |
| HS | 14mm | HSSFT-M16 | 4600 | 4000 |
| HS | 16mm | HSSFT-M16 | 6800 | 4800 |
| HS | 12mm | 2624HS* | 2900 | 1900 |
| HS | 14mm | 2624HS* | 4600 | 3600 |
| HS | 16mm | 2624HS* | 5700 | 4500 |
| HS | 20mm | 2624HS* | 8200 | 7200 |
| HS | 12mm | 3585PT | 2300 | 700 |
| HS | 14mm | 3585PT | 2800 | 850 |
| HS | 16mm | 3585PT | 4300 | 1300 |
| HS | 20mm | 3585PT | 5800 | 1700 |

Notes: All pressures shown in charts are only starting points and may need to be adjusted up or down due to your specific application and tooling setup. Use chart pressures for both Installation and Removal.

Controller Swage pressure = Pull pressure on chart.

Rig pull pressure should be set 400psi higher than the Swage pressure on the controller.

* Tool obsolete - no longer available for sale. *** values based on grade 5 BobTail® fastener Huck-Spin® Pin with BobTail® Collar

**Large Diameter Huck-Spin® 2 Lockbolt (Inch)**

| FASTENER | SIZE | TOOL | PULL (PSI) | RETURN (PSI) |
|-----------------|-------------|-------------|-------------------|---------------------|
| HS2 | -16 (½") | HS37* | 2900 | 2000 |
| HS2 | -16 (½") | HS52 | 2000 | 1500 |
| HS2 | -20 (¾") | HS52 | 3500 | 2000 |
| HS2 | -24 (¾") | HS52 | 4600 | 2000 |
| HS2 | -16 (½") | HSSFT-M12 | 5500 | 3500 |
| HS2 | -20 (¾") | HSSFT-M16 | 5500 | 3300 |
| HS2 | -16 (½") | 2624HS* | 2700 | 1500 |
| HS2 | -20 (¾") | 2624HS* | 4400 | 1500 |
| HS2 | -24 (¾") | 2624HS* | 6500 | 2000 |
| HS2 | -16 (½") | 3585PT | 2100 | 1500 |
| HS2 | -20 (¾") | 3585PT | 3300 | 1500 |
| HS2 | -24 (¾") | 3585PT | 5000 | 1800 |

Large Diameter Huck-Spin® 2 Lockbolt (Metric)

| FASTENER | SIZE | TOOL | PULL (PSI) | RETURN (PSI) |
|-----------------|-------------|-------------|-------------------|---------------------|
| HS2 | 14mm | HS52 | 2500 | 1500 |
| HS2 | 16mm | HS52 | 3500 | 2000 |
| HS2 | 20mm | HS52 | 4800 | 1500 |
| HS2 | 14mm | HSSFT-M16 | 4400 | 2600 |
| HS2 | 16mm | HSSFT-M16 | 5500 | 3300 |
| HS2 | 14mm | 2624HS* | 3500 | 1500 |
| HS2 | 16mm | 2624HS* | 4400 | 1500 |
| HS2 | 20mm | 2624HS* | 6700 | 1900 |
| HS2 | 14mm | 3585PT | 2700 | 1500 |
| HS2 | 16mm | 3585PT | 3300 | 1500 |
| HS2 | 20mm | 3585PT | 5100 | 1500 |

Notes:

All pressures shown in charts are only starting points and may need to be adjusted up or down due to your specific application and tooling setup. Use chart pressures for both Installation and Removal.

Controller Swage pressure = Pull pressure on chart.

Rig pull pressure should be set 400psi higher than the Swage pressure on the controller.

* Tool obsolete - no longer available for sale.



Small Diameter BobTail® Lockbolt (Inch)

| FASTENER | SIZE | TOOL | GRADE 2 | | GRADE 5 | | GRADE 8 | | ALUM. | | STAINLESS | |
|----------|-------------|-----------|------------|--------------|------------|--------------|------------|--------------|------------|--------------|------------|--------------|
| | | | PULL (PSI) | RETURN (PSI) | PULL (PSI) | RETURN (PSI) | PULL (PSI) | RETURN (PSI) | PULL (PSI) | RETURN (PSI) | PULL (PSI) | RETURN (PSI) |
| BT | -06 (3/16") | 244BT | 43 | N/A | — | — | — | — | — | — | — | — |
| BT | -08 (1/4") | 244BT | 70 | N/A | 90 | N/A | — | — | 50 | N/A | — | — |
| BT | -10 (5/16") | 254BT | — | — | N/A | N/A | N/A | N/A | — | — | N/A | N/A |
| BT | -12 (3/8") | 254BT | 89 | N/A | N/A | N/A | N/A | N/A | — | — | N/A | N/A |
| BT | -12 (3/8") | 254BTS | 89 | N/A | N/A | N/A | N/A | N/A | — | — | N/A | N/A |
| BT | -10 (5/16") | 256BT | — | — | 65 | N/A | — | — | — | — | — | — |
| BT | -12 (3/8") | 256BT | 70 | N/A | 90 | N/A | — | — | — | — | 70 | N/A |
| BT | -06 (3/16") | 2480 | 1500 | 1000 | — | — | — | — | — | — | — | — |
| BT | -08 (1/4") | 2480 | 2400 | 1500 | 4100 | 1500 | — | — | 2000 | 1500 | — | — |
| BT | -10 (5/16") | 2503/2583 | — | — | 3600 | 1600 | — | — | — | — | 2900 | 1500 |
| BT | -12 (3/8") | 2503/2583 | 3400 | 1600 | 4500 | 2000 | 5400 | 2500 | 2750 | 1200 | 3400 | 1600 |
| BT | -12 (3/8") | SFBTT8 | 4600 | 2600 | 6000 | 3400 | 7200 | 4100 | — | — | 4600 | 2600 |

Small Diameter BobTail® Lockbolt (Metric)

| FASTENER | SIZE | TOOL | CLASS 8.8 | | CLASS 10.9 | | ALUM. | | STAINLESS | |
|----------|------|-----------|------------|--------------|------------|--------------|------------|--------------|------------|--------------|
| | | | PULL (PSI) | RETURN (PSI) | PULL (PSI) | RETURN (PSI) | PULL (PSI) | RETURN (PSI) | PULL (PSI) | RETURN (PSI) |
| BT | 10mm | 2503/2583 | — | — | 6200 | 3000 | — | — | — | — |

Notes:

All pressures shown in charts are only starting points and may need to be adjusted up or down due to your specific application and tooling setup. Use chart pressures for both Installation and Removal.

When the 918 or 918-5 rig is used and pull pressure from charts above are equal to or below 2500 psi, the relief valve (128904) is required. If the BobTail® Controller (128441) is to be used, Please refer to controller manual for details.



Large Diameter BobTail® Lockbolt (Inch)

| FASTENER | SIZE | TOOL | GRADE 5 | | GRADE 8 | |
|----------|----------|--------------|------------|--------------|------------|--------------|
| | | | PULL (PSI) | RETURN (PSI) | PULL (PSI) | RETURN (PSI) |
| BT | -16 (½") | BTT25 | 3200 | 2000 | 4300 | 2400 |
| BT | -20 (⅝") | BTT35 | 3700 | 2600 | 4600 | 3400 |
| BT | -16 (½") | BTT35LS | 2300 | 1700 | 3100 | 2300 |
| BT | -20 (⅝") | BTT35LS | 3700 | 2600 | 4600 | 3400 |
| BT | -24 (¾") | BTT35LS | 5200 | 3700 | 7000 | 5100 |
| BT | -24 (¾") | BTT57 | 3200 | 2000 | 4300 | 2800 |
| BT | -28 (⅞") | BTT57 | 4300 | 2600 | 5600 | 3400 |
| BT | -32 (1") | BTT57 | 5700 | 3500 | 7000 | 4500 |
| BT | -16 (½") | SFBTT15 | 4300 | 1900 | 5700 | 2600 |
| BT | -16 (½") | SF20/SFBTT20 | 3400 | 1700 | 4500 | 2300 |
| BT | -20 (⅝") | SF20/SFBTT20 | 5400 | 2600 | 6700 | 3400 |
| BT | -24 (¾") | SF32/SF32L | 5400 | 2800 | 7200 | 3800 |
| BT | -24 (¾") | SFBTT32-24 | 4500 | 2100 | 6000 | 2800 |
| BT | -24 (¾") | SF46/SFBTT46 | 3600 | 2100 | 4800 | 3000 |
| BT | -28 (⅞") | SF46/SFBTT46 | 4800 | 2800 | 6200 | 3800 |
| BT | -32 (1") | SF46/SFBTT46 | 6400 | 3800 | 7800 | 4800 |
| BT | -16 (½") | 2620 | 3600 | 1500 | 4800 | 1500 |
| BT | -16 (½") | 2624 | 2100 | 1500 | 2800 | 1500 |
| BT | -20 (⅝") | 2624 | 3300 | 1500 | 4200 | 1500 |
| BT | -16 (½") | 2624HS | 2100 | 1500 | 2800 | 1500 |
| BT | -20 (⅝") | 2624HS | 3300 | 1500 | 4200 | 1200 |
| BT | -16 (½") | 2628* | 1500 | 1500 | 2100 | 1500 |
| BT | -20 (⅝") | 2628* | 2700 | 1500 | 3300 | 1500 |
| BT | -24 (¾") | 2628* | 3400 | 1500 | 5000 | 1500 |
| BT | -16 (½") | 3585 | 1500 | 1500 | 2100 | 1500 |
| BT | -20 (⅝") | 3585 | 2700 | 1500 | 3300 | 1500 |
| BT | -24 (¾") | 3585 | 3400 | 1500 | 5000 | 1500 |
| BT | -16 (½") | 3585PT | 1500 | 1500 | 2100 | 1500 |
| BT | -20 (⅝") | 3585PT | 2700 | 1500 | 3300 | 1500 |
| BT | -24 (¾") | 3585PT | 3400 | 1500 | 5000 | 1500 |

Notes:

All pressures shown in charts are only starting points and may need to be adjusted up or down due to your specific application and tooling setup. Use chart pressures for both Installation and Removal.

When the 918 or 918-5 rig is used and pull pressure from charts above are equal to or below 2500 psi, the relief valve (128904) is required.

If the BobTail® Controller (128441) is to be used, please refer to the controller manual for details.

* Tool obsolete - no longer available for sale.



Large Diameter BobTail® Lockbolt (Metric)

| FASTENER | SIZE | TOOL | GRADE 8.8 | | GRADE 10.9 | |
|----------|------|--------------|------------|--------------|------------|--------------|
| | | | PULL (PSI) | RETURN (PSI) | PULL (PSI) | RETURN (PSI) |
| BT | 12mm | BTT25 | 3000 | 1800 | 3900 | 2400 |
| BT | 14mm | BTT25 | 4200 | 2600 | 4900 | 3100 |
| BT | 16mm | BTT35 | 3700 | 2600 | 4600 | 3400 |
| BT | 12mm | BTT35LS | 2200 | 1500 | 2800 | 2100 |
| BT | 14mm | BTT35LS | 3000 | 2200 | 3500 | 2600 |
| BT | 16mm | BTT35LS | 3700 | 2600 | 4600 | 3400 |
| BT | 20mm | BTT35LS | — | — | 7200 | 5300 |
| BT | 20mm | BTT57 | 2600 | 1800 | 4500 | 2900 |
| BT | 27mm | BTT60 | — | — | 7300 | 6400 |
| BT | 12mm | SFBTT15 | 4000 | 1700 | 5100 | 2300 |
| BT | 14mm | SFBTT15 | 5500 | 2500 | — | — |
| BT | 12mm | SF20/SFBTT20 | 3200 | 1500 | 4000 | 2100 |
| BT | 14mm | SF20/SFBTT20 | 4400 | 2200 | 5100 | 2600 |
| BT | 16mm | SF20/SFBTT20 | 5400 | 2600 | 6700 | 3400 |
| BT | 20mm | SFBTT32-M20 | 4200 | 2000 | 6200 | 3100 |
| BT | 20mm | PR3318 *** | 4200 | 2000 | 6200 | 3100 |
| BT | 20mm | SF32/SF32L | 5100 | 2700 | 7500 | 4100 |
| BT | 20mm | SF46 | 3400 | 2000 | 4800 | 3000 |
| BT | 24mm | SF46 | — | — | 7400 | 4500 |
| BT | 27mm | SF60 | — | — | 7700 | 4500 |
| BT | 12mm | 2620 | 3400 | 1500 | 4300 | 1500 |
| BT | 12mm | 2624/2624HS | 2000 | 1500 | 2500 | 1500 |
| BT | 14mm | 2624/2624HS | 2700 | 1500 | 3200 | 1500 |
| BT | 16mm | 2624/2624HS | 3300 | 1500 | 4200 | 1500 |
| BT | 12mm | 2628* | 1500 | 1500 | 1900 | 1500 |
| BT | 14mm | 2628* | 2100 | 1500 | 2400 | 1500 |
| BT | 16mm | 2628* | 2600 | 1500 | 3200 | 1500 |
| BT | 20mm | 2628* | — | — | 5000 | 1500 |
| BT | 12mm | 3585 | 1500 | 1500 | 1900 | 1500 |
| BT | 14mm | 3585 | 2100 | 1500 | 2400 | 1500 |
| BT | 16mm | 3585 | 2700 | 1500 | 3200 | 1500 |
| BT | 20mm | 3585 | — | — | 5000 | 1500 |
| BT | 12mm | 3585PT | 1500 | 1500 | 1900 | 1500 |
| BT | 14mm | 3585PT | 2100 | 1500 | 2400 | 1500 |
| BT | 16mm | 3585PT | 2600 | 1500 | 3200 | 1500 |
| BT | 20mm | 3585PT | — | — | 5000 | 1500 |
| BT | 14mm | HS37* | 2900 | 1500 | 3400 | 1500 |
| BT | 16mm | HS52 | 2400 | 1500 | 4600 | 1500 |

Notes:

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When the 918 or 918-5 rig is used and pull pressure from charts above are equal to or below 2500 psi, the relief valve (128904) is required.

If the BobTail® Controller (128441) is to be used, please refer to the controller manual for details.

*** PR3318 is the controller version of the SFBTT32-M20.

* Tool obsolete - no longer available for sale.



Notes



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