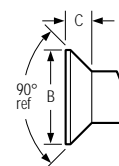
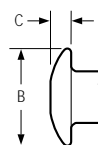
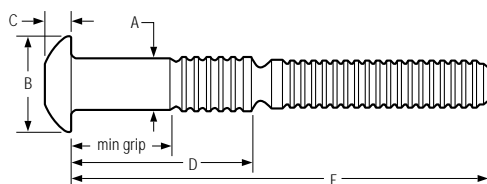
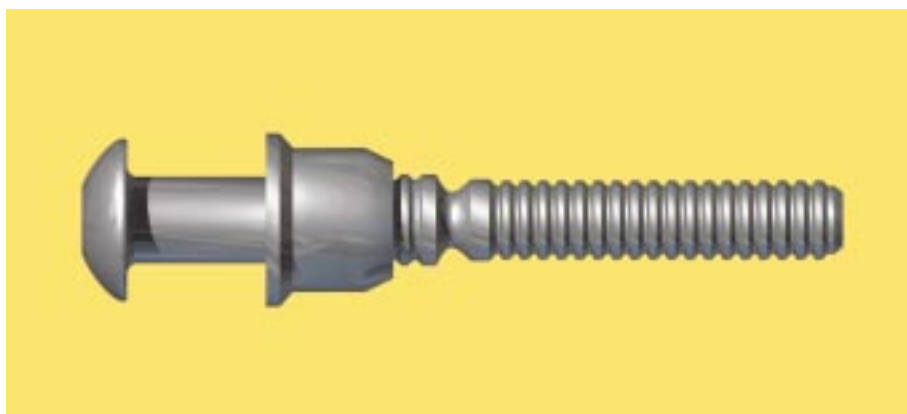


## C6L® LockBolt™

Vibration-resistant C6L® fasteners install with consistency and control. They resist loosening due to vibration and provide a high uniform clamp force. This is an excellent fastener for a wide range of structural applications.



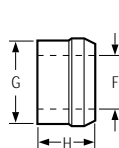
Brazier Head—C6LB

Truss Head—C6LT

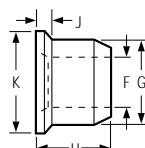
Flush Head—C6L90

### Pin Dimensions

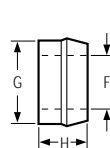
Dia. (No.)	Maximum Hole Size	Brazier Head (B)			Truss Head (T)		Flush Head (90)	
		A	B	C	B	C	B	C
<b>3/16</b> (6)	.203	.195 - .191	.394 - .356	.125 - .113	.469 - .406	.088 - .078	.354 - .328	.085 - .075
<b>1/4</b> (8)	.266	.259 - .254	.525 - .475	.152 - .136	.594 - .531	.115 - .103	.473 - .437	.113 - .101
<b>5/16</b> (10)	.328	.322 - .317	.656 - .594	.201 - .181	.797 - .703	.141 - .127	.589 - .547	.141 - .127
<b>3/8</b> (12)	.391	.385 - .380	.787 - .713	.248 - .223	.922 - .828	.168 - .152	.709 - .656	.168 - .152



LC/2LC



3LC



8LC

### Collar Dimensions

Collar Type	Part Number	Collar Diameter	F Diameter	G Diameter	H Length	J Dimension	K Diameter
Standard	2LC-R, 2LC-F, LC-I, 2LC-2CU	<b>3/16</b>	.187 - .196	.311 - .304	.220 - .260		
		<b>1/4</b>	.256 - .265	.409 - .402	.320 - .290		
		<b>5/16</b>	.304 - .312	.494 - .485	.380 - .350		
		<b>3/8</b>	.375 - .385	.600 - .590	.460 - .430		
Flange	3LC-2R, 3LC-F, 3LC-I, 3LC-2CU	<b>3/16</b>	.187 - .196	.311 - .304	.280 - .250	.062 - .031	.391 - .359
		<b>1/4</b>	.256 - .267	.409 - .402	.379 - .349	.078 - .047	.516 - .484
		<b>5/16</b>	.304 - .312	.507 - .498	.426 - .394	.094 - .062	.641 - .609
		<b>3/8</b>	.378 - .390	.610 - .599	.532 - .502	.125 - .062	.781 - .719
Low Profile	8LC-2R, 8LC-F, 8LC-I, 8LC-2CU	<b>3/16</b>	.187 - .196	.311 - .304	.162 - .132	.094	
		<b>1/4</b>	.256 - .265	.409 - .402	.202 - .172	.125	
		<b>5/16</b>	.304 - .312	.494 - .485	.255 - .225	.125	
		<b>3/8</b>	.375 - .385	.600 - .590	.295 - .310	.156	

Note: When using 3LC collars, add "J" dimension to thickness of material being fastened to determine grip number.

Note: When using 8LC collars, subtract "J" dimension from thickness of material being fastened to determine grip number.

Note: Use collars and pins together as shown in "Values" tables, or contact HUCK.

**Grip Data 3/16 and 1/4 diameter**

Grip No.	Grip Min	Range Max	6 (3/16) Dia		8 (1/4) Dia	
			D $\pm$ 1/32	E+1/8,-0	D $\pm$ 1/32	E+1/8,-0
2	.063	.188	.394	1.404	.485	1.520
3	.125	.250	.457	1.466	.548	1.583
4	.188	.313	.519	1.529	.610	1.645
5	.250	.375	.582	1.591	.673	1.708
6	.313	.438	.644	1.654	.735	1.770
7	.375	.500	.707	1.716	.798	1.833
8	.438	.563	.769	1.779	.860	1.895
9	.500	.625	.832	1.841	.923	1.958
10	.563	.688	.894	1.904	.985	2.020
11	.625	.750	.957	1.966	1.048	2.083
12	.688	.813	1.019	2.029	1.110	2.145
13	.750	.875	1.082	2.091	1.173	2.208
14	.813	.938	1.144	2.154	1.235	2.270
15	.875	1.000	1.207	2.216	1.298	2.333
16	.938	1.063	1.269	2.279	1.360	2.395
17	1.000	1.125	1.332	2.341	1.423	2.458
18	1.063	1.188	1.394	2.404	1.485	2.520
19	1.125	1.250	1.457	2.466	1.548	2.583
20	1.188	1.313	1.519	2.529	1.610	2.645

Note: "Grip" is actual thickness of material to be fastened—contact HUCK for grips not shown.

Note: C6L90 is not available in grip 2 for 3/16 and 1/4 diameters and grip 4 for 3/8 diameter.

**Grip Data 5/16 and 3/8 diameter**

Grip No.	Grip Min	Range Max	10 (5/16) Dia		12 (3/8) Dia	
			D $\pm$ 1/32	E+1/8,-0	D $\pm$ 1/32	E+1/8,-0
4	.125	.375	.749	1.910	.809	2.121
6	.250	.500	.874	2.035	.934	2.246
8	.375	.625	.999	2.160	1.059	2.371
10	.500	.750	1.124	2.285	1.184	2.496
12	.625	.875	1.249	2.410	1.309	2.621
14	.750	1.000	1.374	2.535	1.434	2.746
16	.875	1.125	1.499	2.660	1.559	2.871
18	1.000	1.250	1.624	2.785	1.684	2.996
20	1.125	1.375	1.749	2.910	1.809	3.121

**Installed Values <sup>1</sup> in Nominal Grip (lbs.)**

	Pin: Collar:	6061 Aluminum (F) LC-I or 3LC-I	2024 Aluminum (C) 2LC-F or 3LC-F	Carbon Steel 2LC-R or 3LC-R	CRES (U) 2LC-2CU or 3LC-2CU
<b>3/16</b>	Shear	775	1050	1725	2000
	Tensile	530	1000	1650	1455
	Clamp	350	550	1025	1025
<b>1/4</b>	Shear	1375	1875	3050	3550
	Tensile	975	1800	3000	3750
	Clamp	620	950	1805	1805
<b>5/16</b>	Shear	2125	2925	4725	5525
	Tensile	1550	2850	4600	4250
	Clamp	965	1500	2810	2810
<b>3/8</b>	Shear	3050	4200	6825	7950
	Tensile	2400	4200	6500	6100
	Clamp	1380	2200	4020	4020

<sup>1</sup> Minimum installed values (pounds) in nominal grip



## Material and Finish

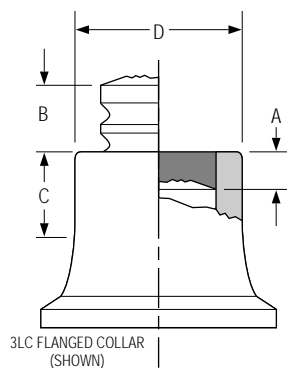
	Material	Finish
Pin	Carbon Steel (R)	Carbon Steel—none (plain black)
	2024 Aluminum Alloy (C)	2024 Aluminum Alloy—Anodize per MIL-A-8625 or chemical surface treatment per MIL-C-5541 (Manufacturer's option)
	6061 Aluminum Alloy (F)	6061 Aluminum Alloy—None
	CRES Steel (U)	CRES Steel—None
Collar	Low Carbon Steel (R) or (2R)	Carbon Steel—Zinc plated, Wax Film Lubricated
	6061 Aluminum Alloy—Heat treated (F)	Aluminum Alloy—None, Wax Film Lubricated
	6061 Aluminum Alloy (I)	CRES Steel—None, Wax Film Lubricated
	CRES Steel (CU)	Wax Film Lubricated

## Inspection Data

A properly installed HUCKBOLT Fastener will possess the dimensional characteristics shown in the chart. Should the dimensions "A" or "B" exceed the indicated values, the fastener is being used out-of-grip. A "C" dimension less than the values specified is an indication of incomplete swage. A "D" dimension exceeding the specified values is an indication of an incorrect or worn anvil on the installation tool.

Because of design margin built into the fastener and peculiar field installation conditions, fail-

ure of an installed fastener to meet the specified dimensional criteria is not necessarily an indication of an improperly installed assembly. Conversely, a HUCKBOLT pin installed in a properly prepared hole with the recommended single cycle driving tool, which swages the lock collar material into the locking grooves of the pin and breaks off the pintail at the breakneck groove, will always possess at least the minimum guaranteed strength characteristics when the dimensional limits specified are met.

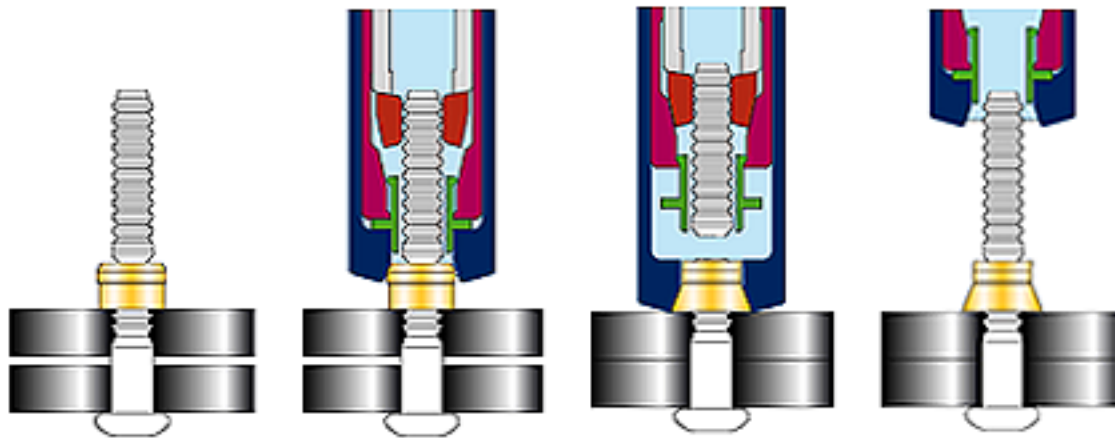


Nominal Size	A Max Grip	B Min Grip	C Min	D Dia Max
3/16	.078	.125	.172	.276
1/4	.078	.156	.250	.364
5/16	.141	.219	.281	.454
3/8	.125	.281	.344	.522

## Installation Tooling

Dia.	Installation Tool	Nose Assembly	Type	Use
3/16	230	99-999	Pneudraulic	Maintenance & Repair
	2025	99-999	Pneudraulic	Maintenance & Repair
	212	99-999	Pneudraulic	Production
	2480	99-999	Hydraulic	Production
1/4	230	99-1000	Pneudraulic	Maintenance & Repair
	2025	99-1000	Pneudraulic	Maintenance & Repair
	212	99-1000	Pneudraulic	Production
	2480	99-1000	Hydraulic	Production
5/16	246	99-99-245	Pneudraulic	Production
	2580	99-99-245	Hydraulic	Production
3/8	246	99-100-245	Pneudraulic	Production
	2580	99-100-245	Hydraulic	Production

## Installation Sequence



[Click Here to view animation of installation sequence](#)

## Part Number Identification

### C6L LockBolt Pins

**C6L B - R 8 - 4 G**

- Finish: G = zinc
- Grip Range: (See Grip Data Chart)
- Diameter: in 1/32" increments
- Material: R = carbon steel, C = 2024 alum. alloy, F = 6061 alum. alloy, U = CRES steel
- Style: T = truss head, B = brazier head, 90 = flush head

### C6L LockBolt Collars

**2 LC - R 8 G**

- Finish: G = zinc
- Diameter: in 1/32" increments
- R = carbon steel, F = 6061 alum. alloy heat treated, I = 6061 alum. alloy, CU = CRES steel
- Lock Collar
- Type: 2 = standard, 3 = flange

*Note: C120L (Grade 5) available at special request.  
Contact your HUCK representative for stainless steel capped and special finishes not published.*

