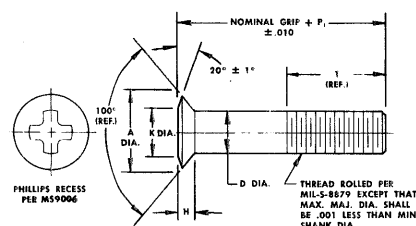
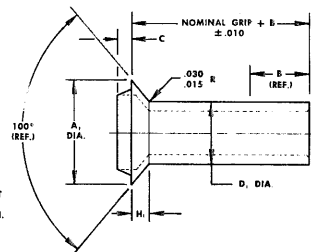




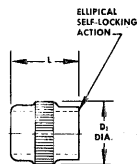
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110



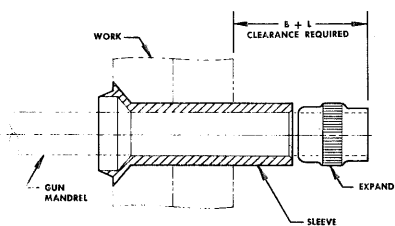
CORE BOLT



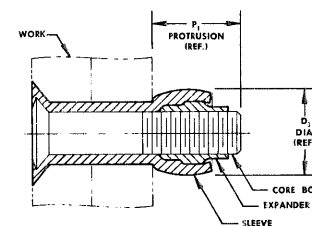
SLEEVE



EXPANDER



SLEEVE AND EXPANDER ASSEMBLED ON MANDREL, INSERTED INTO WORK, READY TO SET



COMPLETE BLIND BOLT ASSEMBLY WITH CORE BOLT INSTALLED, AND PROTRUDING FLANGE OF SLEEVE CRIMPED OVER TO RETAIN BOLT.

BLIND BOLT ASSEMBLY		BB315 CORE BOLT								BB136 SLEEVE						BB346G EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	A DIA.	D DIA.	H	K DIA.	P1	T (REF.)	THREAD	FIRST DASH NUMBER	A1 DIA.	B GRIP RANGE 0-3/4	C (REF.)	D1 DIA.	H1	DASH NUMBER	D2 DIA.	L (LENGTH)	THREAD	HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P1	D2 DIA. (REF.)
-5	5/32	-5	.2274 .2226	.1120 .1100	.048 .046	.130 .120	.208	.274	4-40UNJC-3A	-5	.2944 .2794	.210	.037	.169 .166	.0488 .0467	-5	.167	.153	4-40UNJC-3B	.173 .170	8 6 IN. LBS.	.208	.210

BB315 CORE BOLT

- NOTES: 1. Concentricity: Head to "D" diameter within .005 FIR.
2. Complete threads shall begin within two thread pitches maximum. Two thread pitch maximum may consist of incomplete thread and extrusion angle.
3. "H" is dimensioned from maximum "D" diameter.

MATERIAL: Type A-286 meeting composition limits of the AMS specifications.

HEAT TREAT: Heat treated to meet the requirements of AMS5735.

CODE: First dash number of core bolt indicates sleeve nominal diameter in 32nds. Second dash number indicates grip length (thickness of work) in 16ths.

EXAMPLE: BB315 -5-12 = 4-40 Core Bolt for 5/32 nominal diameter sleeve, 3/4 grip length.

BB136 SLEEVE

- NOTE: 1. Concentricity: Hole to "D" diameter within .005 FIR.
Head to "D1" diameter within .010 FIR.

① MATERIAL: Type CRES: 305 per QQ-S-763, 302 HQ, or 18-9 LW (ASTM A-493).

FINISH: Sandblast.

CODE: First dash number indicates nominal diameter of sleeve in 32nds. Second dash number indicates grip length (thickness of work) in 16ths.

EXAMPLE: BB136 -5-12 = 5/32 nominal diameter sleeve, 3/4 grip length.

BB346G EXPANDER

- NOTE: 1. Threads per MIL-S-8879.
2. Locking torque: 1/2 - 5 in. lb.

MATERIAL: Type 17-4PH stainless steel per AMS5643.

HEAT TREAT: 120,000 psi shear minimum.

FINISH: Silver plate per AMS2410C.

CODE: Dash number indicates nominal diameter of Blind Bolt Assembly in 32nds.

EXAMPLE: BB346G-5 = 4-40 Expander for use with 5/32 nominal diameter Blind Bolt Assembly.

FOR INSTALLATION INFORMATION SEE THE BACK SIDE

BB134 BOLT ASSEMBLY

CODE: First dash number indicates nominal diameter of Blind Bolt Assembly in 32nds. Second dash number indicates grip length (thickness of work) in 16ths.

EXAMPLE: BB134 -5-12

3/4 Grip Length.
5/32 Nominal Diameter
(Blind Bolt Assembly)
Blind Bolt Assembly which includes:
BB315 Core Bolt, BB136 Sleeve, and
BB346G Expander

U.S. Patent 2,959,999. Foreign patents issued.

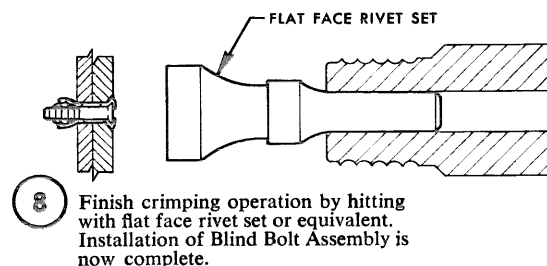
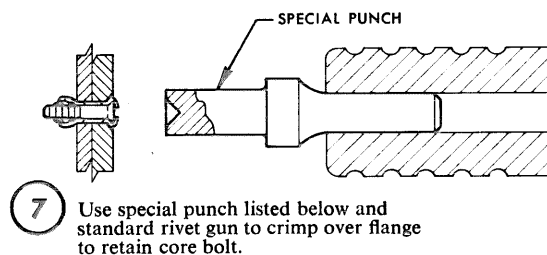
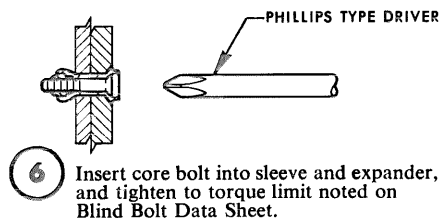
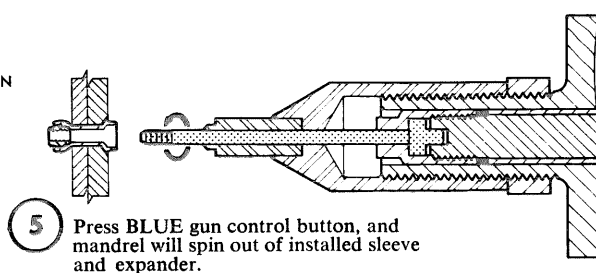
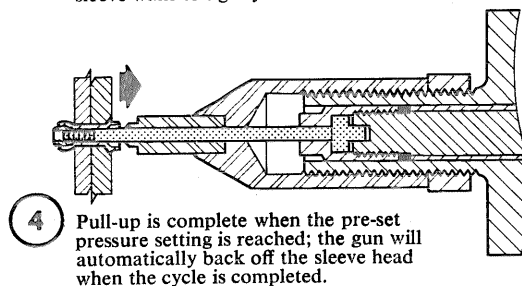
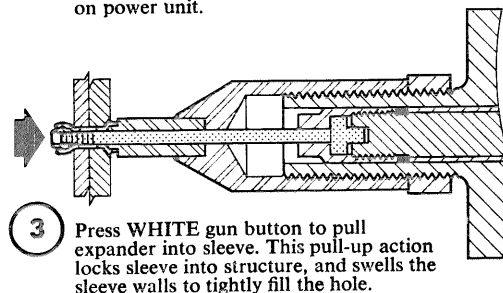
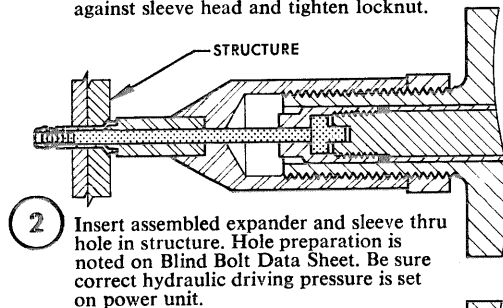
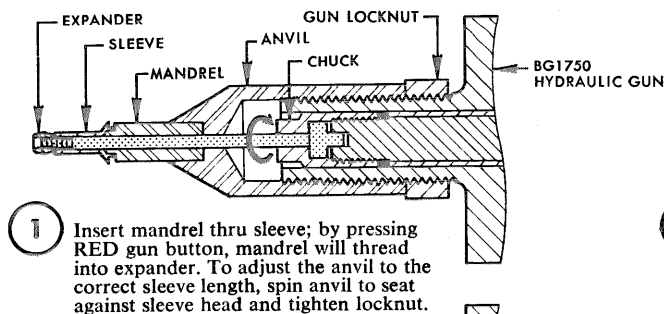
TITLE					
BLIND BOLT™ ASSEMBLY					
100° COUNTERSUNK MS20426 HEAD					
RETAINING STYLE					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
Shade	9-11-73	Shade	9-11-73	3	D. P. S.
					3-20-79
DRAWING NUMBER					BB134

CODE IDENTIFICATION NO. 73197

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BB134

TOOLING & INSTALLATION PROCEDURE FOR INSTALLING BB134 BLIND BOLT™ ASSEMBLY



PART NUMBER ORDER CHART

BLIND BOLT ASSEMBLY		DRIVING TOOLS			CORE BOLT DRIVER	PUNCH		HYDRAULIC GUN	INSTALLATION PRESSURE	
FIRST DASH NO.	NOM. DIA.	ANVIL	CHUCK	MANDREL		.498 SHANK	.401 SHANK		AIR PRESSURE PSI	EQUIVALENT LOAD IN POUNDS
-5	5/32	A50-5	C1-5	M1-5	Phillips #1	BBP3-5	BBP4-5	BG1750	500	900

NECESSARY ITEMS FOR A COMPLETE INSTALLATION ASSEMBLY:

- 1 Anvil
- 1 Chuck
- 1 Mandrel
- 1 Core Bolt Driver
- 1 Punch
- 1 Hydraulic Gun
- 1 Rivet Gun
- 1 Flat Face Rivet Set or Equivalent
- 1 Power Unit
- 110V Electrical Outlet (For Using BP4000 Power Unit Only)
- 90 psi Air Supply (For Using BP3000 and BP7000 Power Units)



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2-109922-1
Printed in U.S.A.
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