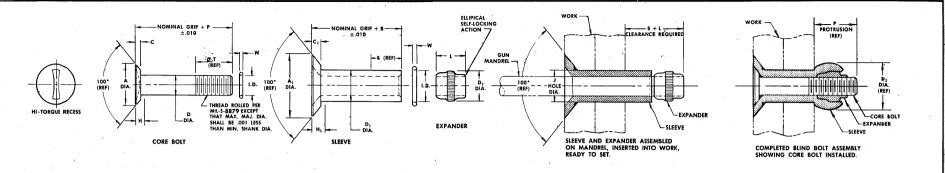
2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509 AREA CODE 213 · 775-3181 · 326-8110



BLIND ASSE	BLIND BOLT ASSEMBLY BB141 CORE BOLT							BB142 SLEEVE									BB415 EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION								
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	DIA.	D DIA.	н	С	T (REF)	THREAD	O. I. D.	RING I	PART NUMBER	FIRST DASH NUMBER	A ₁ DIA.	B GRIP RANGE 0-3/4	GRIP RANGE	B GRIP RANGE 11/4-15/6	C ₁	D ₁	H ₁	I.D.	P-RING I	PART NUMBER	DASH NUMBER	D ₂	(LENGTH)	THREAD	J HOLE DIA.	CORE BOLT INSTALLATION TORQUE	Р	D ₃
												NUMBER			0-3/4	13/16-11/16	11/6-1%						NOMBER								
-8	1/4	-8	Hi- Torque #2	. 3304	.1650 .1630	.069	.0340	. 397	8-32UNJC-3A	. 151 . 141	.023	420000-0		.5066 .5018	. 315	. 330	.370	.0695		.105	.244	.027	425005-8	-8	. 255	. 245	8-32UNJC-3B	. 264 . 258	20 30 IN. LBS.	. 316	. 335
-10	5/16	-10	Hi- Torque #3	. 4454 . 4406	.2180 .2160	.095	.0592 .0572	.498	12-28UNJF-3A	. 215	.027	① 425007-6	-10	.6335 .6287	. 380	.400	. 420	.0800 .0780		.124	.306	.037	425005-10	-10	. 328	. 307	12-28UNJF-3B	. 345 . 339	50 80 IN, LBS.	. 414	438
-12	3/8	-12	Hi- Torque #4	.5066 .5018	.2490 .2470		.0723 .0703		1/4- 28UNJF-3A	.244	.027	425005-8	-12	. 76 04 . 75 5 6	.450	.450	.450	.1112		. 155 . 153	.369 .359	.037	425005-12	-12	.383	.368	1/4- 28UNJF-3B	.397 .391	125 150 IN. LBS.	.485	.510
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BB141	CORE	BOLT

GENERAL NOTES: 1. Concentricity: Head to "D" diameter within .005 FIR.

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.

4. O-ring is assembled onto core bolt.

5. See BB140 Bolt Assembly for shortest grip length available.

MATERIAL: A-286 per AMS5731.

O-ring: Synthetic rubber per Spec. MIL-R-6855, Grade 60, Class I, II and III (combined).

HEAT TREAT: 95,000 psi shear minimum.

Hi-Kote 1 and cetyl alcohol CODE:

First dash number of core bolt indicates sleeve nominal diameter in 32nds. Second dash number indicates mean

assembly grip length (thickness of work) in 16ths.

EXAMPLE: BB141-8-12 = 8-32 Core Bolt for 1/4 nominal diameter sleeve, 3/4 mean assembly grip length.

BB142 SLEEVE

GENERAL NOTES: 1. Concentricity: Hole to "D1" diameter within .005 FIR. "D1" diameter to head within . 005 FIR.

"H1" is dimensioned from maximum "D1" diameter.

3. O-ring is assembled onto sleeve.

4. See BB140 Bolt Assembly for shortest grip length

available.

MATERIAL: A-286 per AMS5731.

O-ring: Synthetic rubber per Spec. MIL-R-6855, Grade 60,

Class I, II and III (combined).

FINISH: Hi-Kote 1

First dash number indicates nominal diameter of sleeve in CODE 32nds. Second dash number indicates mean assembly grip

length (thickness of work) in 16ths.

EXAMPLE: BB142-8-12 = 1/4 nominal diameter sleeve, 3/4 mean assembly grip length.

BB415 EXPANDER

EXAMPLE:

GENERAL NOTES: 1. Threads per MIL-S-8879. MATERIAL: Type A-286 per AMS5731.

HEAT TREAT: 110,000 psi shear minimum. FINISH: BB415-() = Solid film lube per MIL-L-8937.

BB415AP-() = Hi-Kote 1 and cetyl alcohol. CODE Dash number indicates expander used in assembly.

BB415-8 = Expander for 1/4 nominal diameter blind bolt assembly.

BB140 BOLT ASSEMBLY

CODE: First dash number indicates nominal diameter of Blind Bolt Assembly in 32nds. Second dash number indicates mean assembly grip length (thickness of

work) in 16ths.

EXAMPLE: BB140-8-12

- 3/4 Mean Assembly Grip Length - 1/4 Nominal Diameter Blind Bolt Assembly

Blind Bolt Assembly which includes: BB141 Core Bolt, BB142 Sleeve, and BB415 Expander

BB140AP-()-() = Same as example except with Expander BB415AP.

Shortest grip lengths available are: BB140-8-3 -10-3

-12-4

TITLE BLIND BOLT™ ASSEMBLY

SEALING TYPE 100° COUNTERSUNK AN509 HEAD STYLE A-286 — HI-TORQUE RECESS

DATE APPROVED DATE REVISION D. P. S. 9-11-73 9-11-73 Timassen

DATE DRAWING NUMBER D. P. S. 10-27-82