



BLIND BOLT ASSEMBLY		BB308 CORE BOLT								BB340 SLEEVE								BB342 EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION		INSTALLATION PRESSURE (psi) USING HI-SHEAR TOOLING	
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A DIA.	D DIA.	H	P	T (REF.)	THREAD	FIRST DASH NUMBER	A1 DIA.	B GRIP RANGE 0-3/4	B GRIP RANGE 1 1/16-1 1/8	B GRIP RANGE 1 1/8-1 1/2	B GRIP RANGE 1 1/2-2 1/4	D2 DIA.	H1	DASH NUMBER	D2 DIA.	L (LENGTH)	THREAD	HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P	D2 DIA. (REF.)	BG1750	BG2500
-5	5/32	-5	Phillips #1	.2274 .2226	.1120 .1100	.048 .046	.208	.274	4-40UNJC-3A	-5	.294 .274	.210	.225	—	.169 .166	.055 .045		-5	.167	.153	4-40UNJC-3B	.173 .170	8 10 IN. LBS.	.208	.210	500	250
-6	3/16	-6	Phillips #1	.2514 .2466	.1240 .1220	.053 .051	.239	.304	5-40UNJC-3A	-6	.315 .295	.250	.265	.330	.196 .193	.065 .055		-6	.194	.184	5-40UNJC-3B	.201 .197	10 14 IN. LBS.	.239	.253	700	350
-8	1/4	-8	Phillips #2	.3304 .3256	.1650 .1630	.069 .067	.316	.397	8-32UNJC-3A	-8	.412 .387	.315	.330	.370	.257 .254	.090 .080		-8	.255	.245	8-32UNJC-3B	.264 .258	20 30 IN. LBS.	.316	.335	1100	650
-10	5/16	-10	Hi-Torque #3	.4454 .4406	.2180 .2160	.095 .093	.414	.498	12-28UNJF-3A	-10	.530 .500	.380	.400	.420	.338 .335	.110 .100		-10	.328	.307	12-28UNJF-3B	.345 .339	50 80 IN. LBS.	.414	.438	1850	950
-12	3/8	-12	Hi-Torque #4	.5066 .5018	.2490 .2470	.108 .106	.485	.567	1/4-28UNJF-3A	-12	.615 .580	.450	.450	.450	.390 .387	.155 .145		-12	.383	.368	1/4-28UNJF-3B	.397 .391	125 150 IN. LBS.	.485	.510	—	1450

BB308 CORE BOLT

GENERAL 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: 6Al-4V titanium alloy per AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

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

EXAMPLE: BB308-8-12 = 8-32 core bolt for 1/4 nominal diameter sleeve, 3/4 assembly grip length.

BB340 SLEEVE

GENERAL NOTES: 1. Concentricity: Hole to "D" diameter within .005 FIR.
"D1" diameter to head within .010 FIR.

MATERIAL: Commercially pure titanium.

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

EXAMPLE: BB340-8-12 = 1/4 nominal diameter sleeve, 3/4 assembly grip length.

BB342 EXPANDER

GENERAL NOTES: 1. Threads per MIL-S-8879.

MATERIAL: 6Al-4V titanium alloy per AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

FINISH: Solid film lubricant.

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

EXAMPLE: BB342-8 = 1/4 nominal diameter Blind Bolt Assembly using 8-32 expander.

BB370 BOLT ASSEMBLY

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

EXAMPLE: BB370-8-12
3/4 Assembly Grip Length
1/4 Nominal Diameter Blind Bolt Assembly
Blind Bolt Assembly which includes: BB308 Core Bolt, BB340 Sleeve, and BB342 Expander

TITLE							
BLIND BOLT™ ASSEMBLY PROTRUDING HEAD STYLE TITANIUM							
DRAWN	DATE	APPROVED	DATE	REVISION	DATE	DRAWING NUMBER	
LANDES	10-28-97	Schuster	10-28-97	①	Shrode 11-12-93	BB370	

U.S. Patents 2,959,999; 2,677,985.
Foreign patents issued and pending.
"Hi-Torque" trademark.