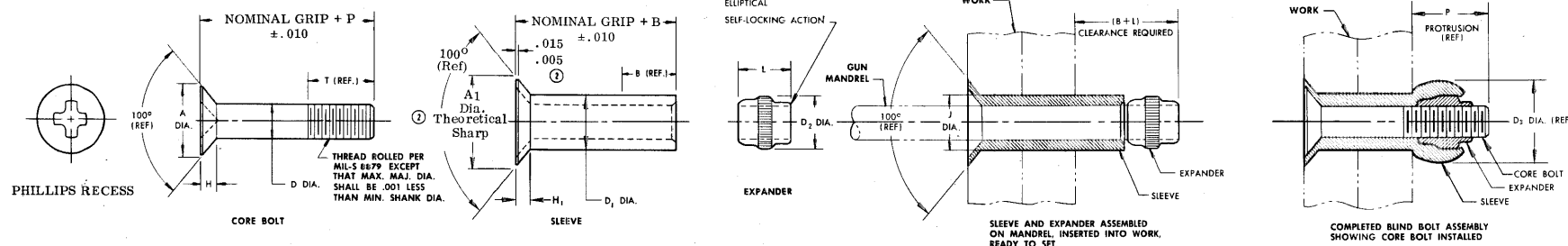




2600 SKYPARK DRIVE  
TORRANCE, CALIFORNIA 90509  
AREA CODE 213 • 775-3181 • 326-8110



BLIND BOLT ASSEMBLY		BB422 CORE BOLT								BB421 SLEEVE								BB341G EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A DIA.	D DIA.	H		T (REF.)	THREAD	FIRST DASH NUMBER	A <sub>1</sub> DIA.	B GRIP RANGE 0-3/4	B GRIP RANGE 3/4-1 1/4	B GRIP RANGE 1 1/4-1 3/4		D <sub>1</sub> DIA.	H <sub>1</sub>	DASH NUMBER	D <sub>2</sub> DIA.	L (LENGTH)	THREAD	J HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P	D <sub>2</sub> DIA. (REF.)
-5	5/32	-5	Phillips	.1879 .1831	.1120 .1100	.032 .029		.274	4-40UNJC-3A	-5	.2612 .2564	.210	.225			.169 .166	.039 .036	-5	.167	.153	4-40UNJC-3B	.173 .170	8 10 IN. LBS.	.208	.210
-6	3/16	-6	Phillips	.2289 .2241	.1240 .1220	.045 .042		.304	5-40UNJC-3A	-6	.3016 .2966	.250	.265	.330		.196 .193	.045 .042	-6	.194	.184	5-40UNJC-3B	.201 .197	10 14 IN. LBS.	.239	.253
-8	1/4	-8	Phillips	.2922 .2874	.1650 .1630	.054 .051		.397	8-32UNJC-3A	-8	.3948 .3898	.315	.330	.370		.257 .254	.058 .055	-8	.255	.245	8-32UNJC-3B	.264 .258	20 30 IN. LBS.	.316	.335

#### BB422 CORE BOLT

- GENERAL NOTES:
- Concentricity: Head to "D" diameter within .005 TIR.
  - Complete threads shall begin within two thread pitches maximum. Two thread pitch maximum may consist of incomplete thread and extrusion angle.
  - "H" is dimensioned from maximum "D" diameter.
- MATERIAL: A-286 high temperature alloy per AMS5731 or AMS5737.  
HEAT TREAT: 95,000 psi shear minimum at room temperature.  
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: BB422-6-12 = 3/16 nominal sleeve diameter, 3/4 mean assembly grip length.

#### BB421 SLEEVE

- GENERAL NOTES:
- Concentricity: Hole to "D<sub>1</sub>" diameter within .005 TIR. "D<sub>1</sub>" diameter to head within .005 TIR.
  - "H<sub>1</sub>" is dimensioned from maximum "D<sub>1</sub>" diameter.
- MATERIAL: Type A-286 meeting composition limits of the AMS specifications.  
HEAT TREAT: Heat treated to meet the requirements of AMS5736.  
CODE: First dash number indicates nominal diameter of sleeve in 32nds. Second dash number indicates mean assembly grip length (thickness of work) in 16ths.  
EXAMPLE: BB421-6-12 = 3/16 nominal sleeve diameter, 3/4 mean assembly grip length.

#### BB341G EXPANDER

- GENERAL NOTES:
- Threads per MIL-S-8879.
- MATERIAL: Type 431 stainless steel per Spec. QQ-S-763.  
HEAT TREAT: 125,000 psi shear minimum.  
FINISH: Silver plate per QQ-S-365, Grade B, .0002-.0004 thick.  
CODE: Dash number indicates diameter of Blind Bolt assembly in 32nds.  
EXAMPLE: BB341G-6 = 3/16 nominal diameter Blind Bolt Assembly.

#### BB518 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: BB518-5-12  
  - 3/4 Mean Assembly Grip Length
  - 3/16 Nominal Diameter Blind Bolt Assembly
Blind Bolt Assembly which includes:  
BB422 Core Bolt, BB421 Sleeve, and BB341G Expander

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

BLIND BOLT™ ASSEMBLY							
100° COUNTERSUNK SHEAR HEAD STYLE							
A-286 ALLOY							
DRAWN	DATE	APPROVAL	DATE	REVISION	DATE	DRAWING NUMBER	
AHS	12-10-69	R.T.	12-16-69	②	Shrode 8-1-72	BB518	

CODE IDENTIFICATION NO. 73197

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