



BLIND BOLT ASSEMBLY		BB305 CORE BOLT											BB333 SLEEVE											BB567 EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A DIA.	D DIA.	H	C	T (REF)	THREAD	O-RING DATA			FIRST DASH NUMBER	A ₁ DIA.	B GRIP RANGE 0-3/4	B GRIP RANGE 3/16-1 1/16	B GRIP RANGE 1 1/8-1 3/8	C ₁	D ₁ DIA.	H ₁	O-RING DATA			DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P	D ₂
										I.D.	W	PART NUMBER									I.D.	W	PART NUMBER								
-8	1/4	-8	Phillips #2	.3304 .3256	.1650 .1630	.069 .067	.0340 .0320	.397	8-32UNJC-3A	.151 .141	.027 .023	425005-5	-8	.5066 .5018	.315	.330	.370	.0695 .0675	.257 .254	.105 .103	.244 .234	.027 .023	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 .093	.0592 .0572	.498	12-28UNJF-3A	.215 .205	.027 .023	① 425007-6	-10	.6335 .6287	.380	.400	.420	.0800 .0780	.338 .335	.124 .122	.306 .296	.037 .033	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	.108 .106	.0723 .0703	.567	1/4-28UNJF-3A	.244 .234	.027 .023	425005-8	-12	.7604 .7556	.450	.450	.450	.1112 .1092	.390 .387	.155 .153	.369 .359	.037 .033	425005-12	-12	.383	.368	1/4-28UNJF-3B	.397 .391	125 150 IN. LBS.	.485	.510

BB305 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.
 - O-ring is assembled onto core bolt.
 - See BB167 Bolt Assembly for shortest grip length available.
- MATERIAL:** Type 431 stainless steel per Spec. AMS5628 and MIL-S-18732.
O-ring: Synthetic rubber per Spec. MIL-R-6855, Grade 60, Class I, II and III (combined).
- HEAT TREAT:** 125,000 psi shear minimum.
- 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:** BB305-8-12 = 8-32 Core Bolt for 1/4 nominal diameter sleeve, 3/4 mean assembly grip length.

BB333 SLEEVE

- GENERAL NOTES:**
- Concentricity: Hole to "D₁" diameter within .005 FIR. Head to "D₁" diameter within .005 FIR.
 - "H₁" is dimensioned from maximum "D₁" diameter.
 - O-ring is assembled onto sleeve.
 - See BB363 Bolt Assembly for shortest grip length available.
- MATERIAL:** Type 305 stainless steel per QQ-S-763.
O-ring: Synthetic rubber per Spec. MIL-R-6855, Grade 60, Class I, II and III (combined).
- 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:** BB333-8-12 = 1/4 nominal diameter sleeve, 3/4 mean assembly grip length.

BB567 EXPANDER

- NOTE:** 1. Threads per MIL-S-8879.
- MATERIAL:** PH13-SMo stainless steel per AMS5629.
- HEAT TREAT:** 125,000 psi shear minimum.
- FINISH:** Dry film lube per MIL-L-8937 and cetyl alcohol lube per Hi-Shear Spec. 305.
- CODE:** Dash number indicates Expander used in assembly.
- EXAMPLE:** BB567-12 = Expander for 1/4-28 bolt, dry film lube.

BB167 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:** BB167-8-12
- 3/4 Mean Assembly Grip Length
 - 1/4 Nominal Diameter Blind Bolt Assembly
 - Blind Bolt Assembly which includes: BB305 Core Bolt, BB333 Sleeve, and BB567 Expander
- Shortest grip lengths available are: BB167-8-3
-10-3
-12-4

TITLE					
BLIND BOLT™ ASSEMBLY					
SEALING TYPE 100° COUNTERSUNK MS24694 HEAD STYLE HI-TORQUE® AND PHILLIPS RECESSES					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
D. P. S. 8-30-73	8-31-73	<i>Sundeen</i>		②	D. P. S. 10-27-82
					BB167