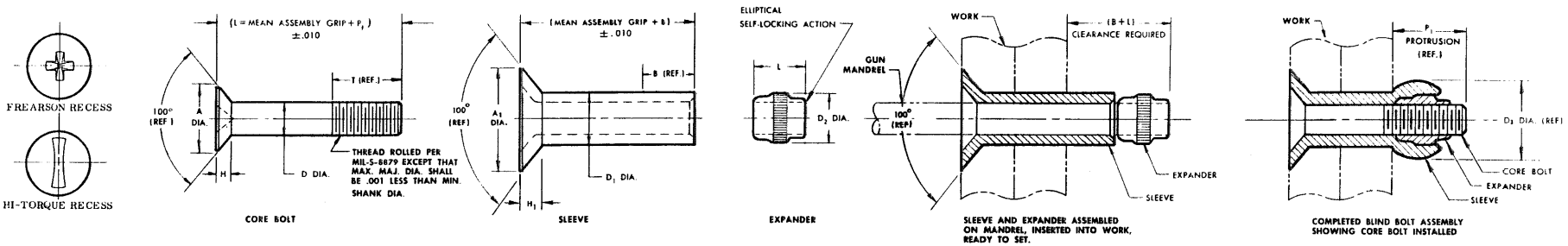
LISI AEROSPACE – Please refer to Central Documentation Website to check validity

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



BLIND BOLT ASSEMBLY		BB309 CORE BOLT								BB335 SLEEVE								BB341G EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A DIA.	D DIA.	H	P_1	T (REF)	THREAD	FIRST DASH NUMBER	A_1 DIA.	B GRIP RANGE 0-¾	B GRIP RANGE 13/16-1 11/16	B GRIP RANGE 1 ½-1⅝		D_1 DIA.	H_1	DASH NUMBER	D_2 DIA.	L (LENGTH)	THREAD	HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P_1	D_2 DIA. (REF)
-5	5/32	-5	Frearson	.2274 .2226	.1120 .1100	.048 .046	.208	.274	4-40UNJC-3A	-5	.3310 .3262	.210				.169 .166	.0680 .0660	-5	.167	.153	4-40UNJC-3B	.173 .170	8 10 IN. LBS.	.208	.210
-6	3/16	-6	Frearson	.2514 .2466	.1240 .1220	.053 .051	.239	.304	5-40UNJC-3A	-6	.3813 .3765	.250				.196 .193	.0780 .0760	-6	.194	.184	5-40UNJC-3B	.201 .197	10 14 IN. LBS.	.239	.253
-8	1/4	-8	Frearson	.3304 .3256	.1650 .1630	.069 .067	.316	.397	8-32UNJC-3A	-8	.5066 .5018	.315	.330			.257 .254	.1050 .1030	-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	.414	.498	12-28UNJF-3A	-10	.6335 .6287	.380	.400	.420		.338 .335	.1240 .1220	-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	.485	.567	1/4-28UNJF-3A	-12	.7604 .7556	.450	.450	.450		.390 .387	.1554 .1534	-12	.383	.368	1/4-28UNJF-3B	.397 .391	125 150 IN. LBS.	.485	.510

BB309 CORE BOLT

GENERAL NOTES:
1. Concentricity: Head to "D" diameter within .005 TIR.
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: A-286 high temperature alloy per AMS5731 or AMS5737.
HEAT TREAT: 95,000 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: BB309-6-12 = 3/16 nominal sleeve diameter, 3/4 mean assembly grip length.

BB335 SLEEVE

GENERAL NOTES:
1. Concentricity: Hole to "D_1" diameter within .005 TIR. "D_1" diameter to head within .005 TIR.
2. "H_1" is dimensioned from maximum "D_1" diameter.

MATERIAL: Type A-286 per AMS5731.
CODE: First dash number indicates nominal diameter of sleeve in 32nds. Second dash number indicates mean assembly grip length (thickness of work) in 16s.
EXAMPLE: BB335-6-12 = 3/16 nominal sleeve diameter, 3/4 mean assembly grip length.

BB341G EXPANDER

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

MATERIAL: Type AISI 431 stainless steel.
HEAT TREAT: 125 ksi shear minimum
FINISH: Silver plate per QQ-S-365, Grade B, .0002—.0004 thick.
CODE: Dash number indicates nominal diameter of Blind Bolt Assembly in 32nds.
EXAMPLE: BB341G-6 = 3/16 nominal diameter Blind Bolt Assembly.

BB365 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: BB365-6-12
- 12 — 3/4 Mean Assembly Grip Length
- 6 — 3/16 Nominal Diameter Blind Bolt Assembly
- BB365 — Blind Bolt Assembly which includes: BB309 Core Bolt, BB335 Sleeve, and BB341G Expander

U.S. Patent 2,959,999. Foreign patents issued. Hi-Torque® trademark.

TITLE
BLIND BOLT™ ASSEMBLY
100° COUNTERSUNK AN509 HEAD STYLE
A-286 ALLOY

DRAWN	DATE	APPROVED	DATE	REVISION	DATE	DRAWING NUMBER
J.W.Q.	11-5-59	MMA	11-3-59	14	Vargas 2-10-76	BB365

BB365

CODE IDENTIFICATION NO. 73197

© 1976, Hi-Shear Corporation