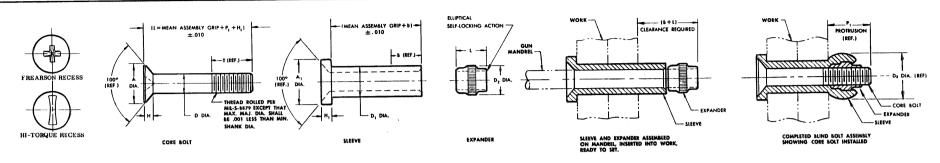


2600 SKYPARK DRIVE TORRANCE. CALIFORNIA 90509 AREA CODE 213 . 775-3181 . 326-8110



BLIND	BOLT MBLY	BB316 CORE BOLT								BB336 SLEEVE								BB341G EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A DIA.	D DIA.	н	P ₁	T (REF)	THREAD	FIRST DASH NUMBER	Aı DIÄ.	B GRIP RANGE 0-1/4	B GRIP RANGE 12/16-71/16	B GRIP RANGE 11/4-11/4		D ₁ DIÅ.	H ₃	DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P ₁	D ₃ DIA. (REF)
-5	5/32	-5	Frearson	. 2274	.1120		. 208	. 274	4-40UNJC-3A	-5	.294 .274	. 210				.169 .166	.055	-5	. 167	.153	4-40UNJC-3B	.173 .170	8 10 IN. LBS.	. 208	. 210
-6	3/16	-6	Frearson	. 2514	.1240	.053	.239	.304	5-40UNJC-3A	-6	.315	. 250				.196 .193	.065 .055	-6	.194	.184	5-40UNJC-3B	.201 .197	10 14 IN. LBS.	. 239	. 253
-8	1/4	-8	Frearson	.3304	.1650	.069	.316	.397	8-32UNJC-3A	-8	.412	.315	. 330			. 257 . 254	.090	-8	. 255	. 245	8-32UNJC-3B	. 264 . 258	²⁰ IN. LBS.	. 316	. 335
-10	5/16	-10	Hi- Torque	. 4454	.2180 .2160	. 095	.414	.498	12-28UNJF-3A	-10	.530	.380	.400	.420		.338	.110	-10	.328	.307	12-28UNJF-3B	.345 .339	⁵⁰ IN. LBS. 80	. 414	. 438
-12	3/8	-12	#3 Hi- Torque	.5066	.2490	.108	. 485	. 567	1/4-28UNJF-3A	-12	.615	. 450	. 450	.450		.390 .387	. 155 . 145	-12	. 383	.368	1/4-28UNJF-3B	.397 .391	125 IN. LBS. 150	. 485	. 510
	ļ		#4	.5016	.2410	1100																			
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		1	1	1	1	1	1	l		1	i	1	1	l	l	l					<u> </u>	<u> </u>	<u> </u>		

BB316 CORE BOLT

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

Complete threads shall begin within two thread pitches 2. 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. 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: BB316-6-12 = 3/16 nominal sleeve diameter, 3/4 mean assembly grip length.

BB336 SLEEVE

GENERAL NOTES: 1. Concentricity: Hole to "D" diameter within .005 TIR. " D_1 " diameter to head within .010 TIR.

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 16ths.

EXAMPLE: BB336-6-12 = 3/16 nominal sleeve diameter, 3/4 mean assembly grip length.

BB341G EXPANDER

HEAT TREAT:

GENERAL NOTES: 1. Threads per MIL-S-8879.
MATERIAL: Type AISI 431 stainless steel. 125 ksi shear minimum.

@FINISH:

Silver plate per AMS 2410, .0003 - .0005 thick, CODE: Dash number indicates nominal diameter of Blind Bolt

Assembly in 32nds.

EXAMPLE: BB341G-6 = 3/16 nominal diameter Blind Bolt Assembly.

BB366 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: BB366-6-12 - 3/4 Mean Assembly Grip Length -3/16 Nominal Diameter Blind **Bolt Assembly** Blind Bolt Assembly which includes:

BB316 Core Bolt, BB336 Sleeve, and BB341G Expander

TITLE BLIND BOLTTM ASSEMBLY PROTRUDING HEAD STYLE
A286 ALLOY J.W. Q. *-357 D. P. S. **BB366**

11-3-59

Hi-Torque U.S. Patents 3,540,342; 3,453,972. International Patents Granted. "Hi-Torque" is a Registered Trademark, and "Blind Bolt" is a Trademark of Hi-Shear Corporation.

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