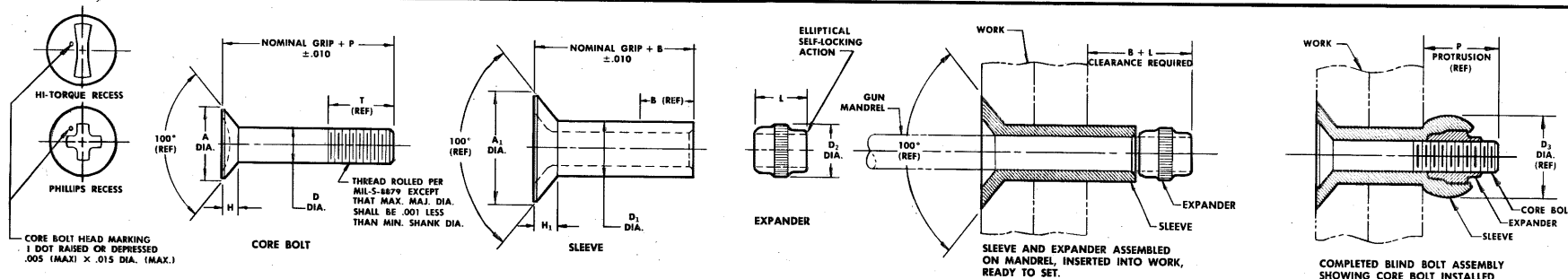




2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110



BLIND BOLT ASSEMBLY		BB307 CORE BOLT								BB339 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	A ₁ DIA.	B GRIP RANGE 0-¾	B GRIP RANGE 1⅜-1⅞	B GRIP RANGE 1¾-1⅞	B GRIP RANGE 1⅞-2¼	D ₁ DIA.	H ₁	DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P	D ₂ DIA. (REF)	BG1750	BG2500
-5	5/32	-5	Phillips #1	.2274 .2226	.1120 .1100	.048 .046	.208	.274	4-40UNJC-3A	-5	.3310 .3262	.210	.225	—		.169 .166	.0680 .0660	-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	.3813 .3765	.250	.265	.330		.196 .193	.0780 .0760	-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	.5066 .5018	.315	.330	.370		.257 .254	.1050 .1030	-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	.6335 .6287	.380	.400	.420		.338 .335	.1240 .1220	-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	.7604 .7556	.450	.450	.450		.390 .387	.1554 .1534	-12	.383	.368	1/4-28UNJF-3B	.397 .391	125 150 IN. LBS.	.485	.510	—	1450

BB307 CORE BOLT

GENERAL NOTES:

- Concentricity: Head to "D" diameter within .005 FIR.
- 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: 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: BB307-8-12 = 8-32 core bolt for 1/4 nominal diameter sleeve, 3/4 assembly grip length.

BB339 SLEEVE

GENERAL NOTES:

- Concentricity: Hole to "D₁" diameter within .005 FIR; "D₁" diameter to head within .005 FIR.
- "H₁" is dimensioned from maximum "D₁" diameter.

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: BB339-8-12 = 1/4 nominal diameter sleeve, 3/4 assembly grip length.

BB342 EXPANDER

GENERAL NOTES:

- 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 diameter of Blind Bolt assembly in 32nds.

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

BB369 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: BB369-8-12

- 3/4 Assembly Grip Length
- 1/4 Nominal Diameter Blind Bolt Assembly

Blind Bolt Assembly which includes: BB307 Core Bolt, BB339 Sleeve and BB342 Expander

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

TITLE					
BLIND BOLT™ ASSEMBLY					
100° COUNTERSUNK AN509 HEAD STYLE					
TITANIUM					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
LANDES	10-28-59	Schuster	10-28-59	①	11-12-73
Shrode					BB369

CODE IDENTIFICATION NO. 73197

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